

The print-out is not subject to the modification service.

CONFIDENTIAL! Intended for internal and supplier use

EN

Ident. Doc.:

supp No.	material no.				A	B
	processing and surface treatment acc. to STAB-Spec.				overall length	thread length
	10006248 Tab. XVI optimized	10006248 Tab. V	10006248 Tab. X	10028959 Tab. I		
	(a) version 1	(a) version 1	(a) version 1	(b) version 2		
44	463232		463232	463232	102.0	10
45	464427		464427	464427	123.0	10
46	483786		483786	483786	183.0	6
47	484742		484742	484742	180.0	10
48	486176		486176	486176	144.0	10
49	488566		488566	488566	261.0	10
50	490956		490956	490956	537.0	10
51	491673		491673	491673	90.0	10
52	492151		492151	492151	165.0	10
53	505774		505774	505774	309.0	10
54	511271		511271	511271	157.5	10
55	528479		528479	528479	231.0	10
56	600179		600179	600179	174.0	10
57	600657		600657	600657	120.0	10
58	602808		602808	602808	216.0	10
59	608066		608066	608066	252.0	10
60	611651		611651	611651	234.0	10
61	614758		614758	614758	143.5	10
62	615236		615236	615236	158.0	10
63	632922		632922	632922	237.0	10

(c) before grinding:  
Hardness depth and hardness test acc. to STAB-Spec. 10258370

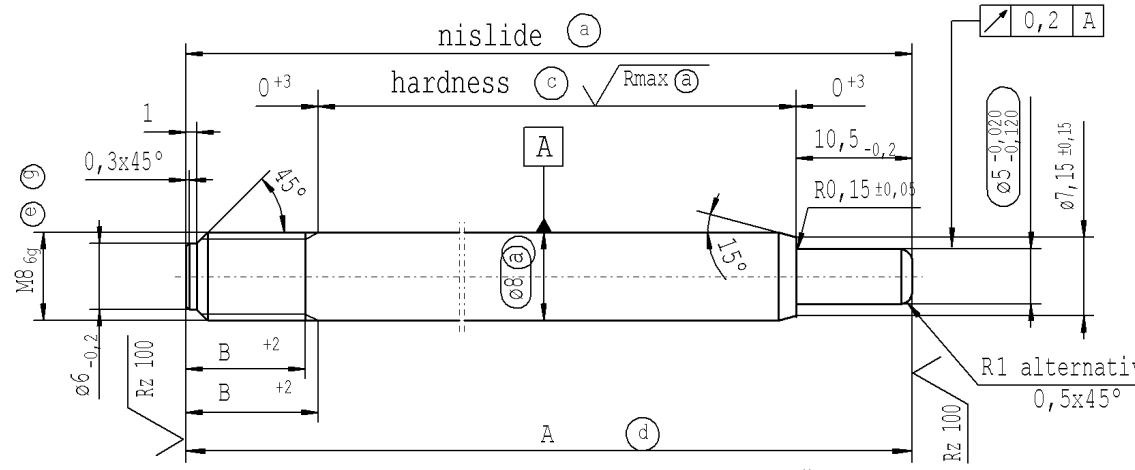
(d) tolerances:  $\pm 0,2$  after turning;  
 $\pm 0,3$  after straightening;  
 $\pm 0,3$  after nisliding

(e) threaded stud rough-turned dim.  $\phi 7,14_{-0,06}$   
thread roll tolerance 6e  
thread tolerances acc. to DIN ISO 965-3

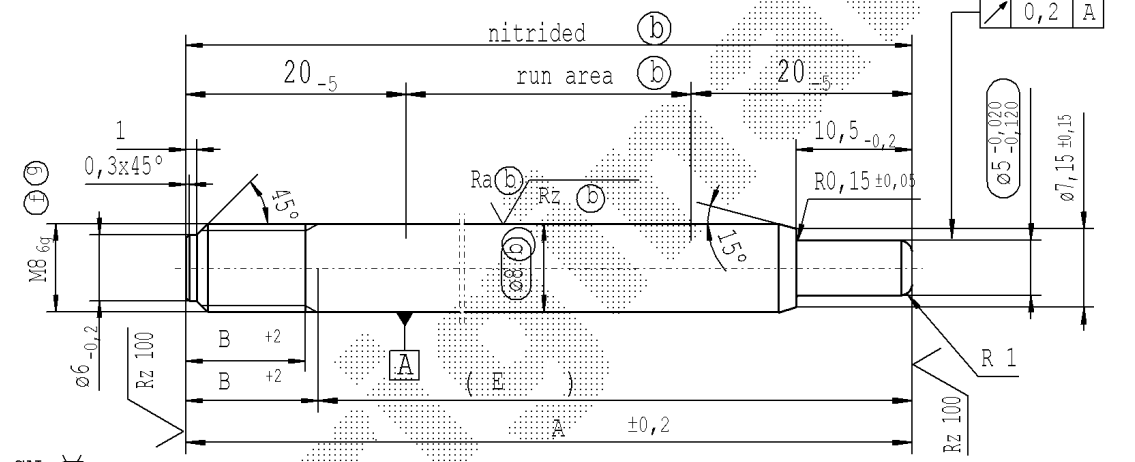
(f) rough-turned dim.  
thread roll tolerance 6e

(g) In the final condition, the actual profile of the thread must not exceed the maximum material limit for the tolerance zone position h at any point

version 1 (only self-manufacturing) \* material: 010731



version 2 (only external production) \* material: 1.1193 S45C JISG 4051, for ZS-RO alt. 184083 (C35EC)



ZS CN   
ZS RO

thread tolerances acc. to DIN ISO 965-3 approved lengths: 100-600 mm

$\sqrt{Rz 25}$  ( $\sqrt{Rz 100}$   $\sqrt{Rmax (A)}$   $\sqrt{Ra (B)}$   $\sqrt{Rz (B)}$ )  $\pm 0,2$   $\pm 0,2$

sheet 3  
of 7

AIAG CQI-standards acc. to STAB-Spec. 10027692					Environmental protection acc. to STAB-Spec. 10005649										
DE: X	EN: X	ES:	IT:	PR:	FR:	RO: X	CAD created document; handwritten changes not permitted			Material: *	All dimensions are in mm	Marking of special characteristics according to STAB-Spec. 10270932	Date	Name	
new	10210124; no technical change, no new first sample required				version 2 ...., for ZS-RO alt. 184083 (C35EC)						Scale: (Original DIN A3) 2:1	Dimensions without tolerances	Drawn by	05.03.2014	Höfer
old	10156666;										DIN ISO 2768-mK	Checked	26.07.2023	Klinkner	
Field	Pos. 126 + 127;										Document No.: 10210124				
Date/Name	05.04.2023 Donat				26.07.2023 Jablonski						Material No.:				
Chg. No.	721662				724814										
Rev.	8				9										
							<b>STABILUS</b>			<b>PISTON ROD</b>					