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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

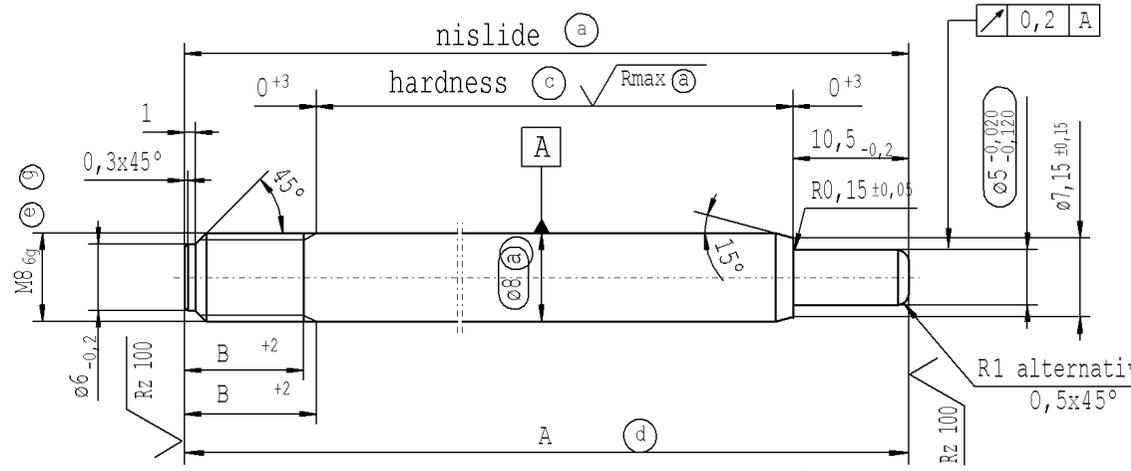
(d) tolerances:  $\pm 0,2$  after turning;  
 $\pm 0,3$  after straightening;  
 $\pm 0,3$  after nisliding

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

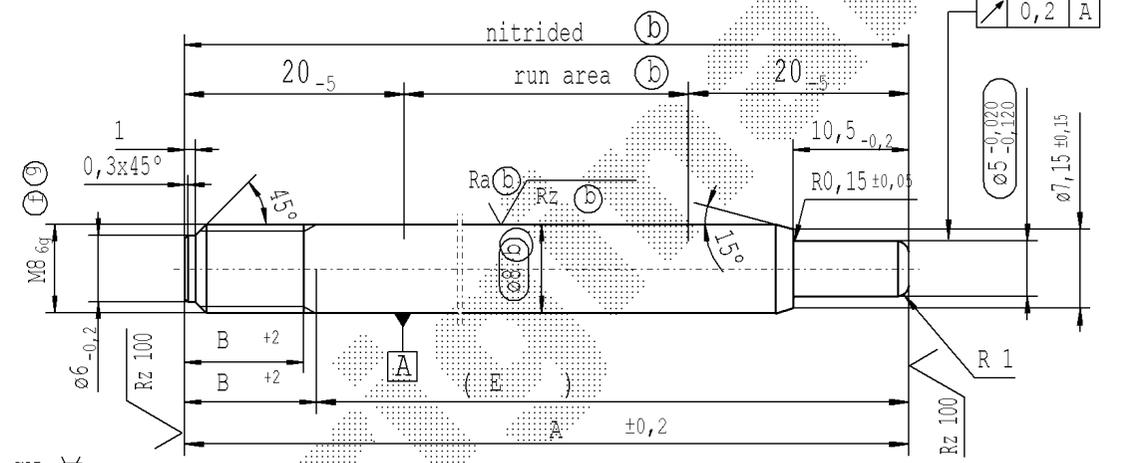
(f) rough-turned dim.  
thread roll tolerance 6e

(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) |  |       |   |  |  |                                       |  | Drawn by  | 05.03.2014    | Höfer    |
| old  | 10156666;   |     |     |   |  |       |   |  |  |                                       |  | Checked   | 26.07.2023    | Klinkner |
| Field  | Pos. 126 + 127;   |     |     |   |  |       | D/1-5   |  |  | Edge tolerances acc. to DIN ISO 13715 | Scale: (Original DIN A3) 2:1   | Dimensions without tolerances                                       | Document No.: |          |
| Date/Name                                      | 05.04.2023 Donat  |     |     | 26.07.2023 Jablonski                          |  |       |   |  |  | Surface finish DIN EN ISO 1302        | We reserve all rights to this document, to any patents or patent registrations related hereto, and to the duplication, retransmission by third parties and misc. use. Any use of this document is not permitted without the written consent of STABILUS. |   |               | 10210124 |
| Chg. No.                                       | 721662  |     |     | 724814  |  |       |   |  |  | Replaces:                             | Material No.:  |   |               |          |
| Rev.   | 8   |     |     | 9   |  |       |   |  |  | <b>STABILUS</b>                       | <b>PISTON ROD</b>  |   |               |          |