

		8		7		6			
F	supp No.	material no.			A	B	E		
		processing and surface treatment acc. to STAB-Spec.			overall length	thread length	length without end-fitting stud		
	10006248 Tab. XVI optimized	10006248 Tab. X	10028959 Tab. I						
	(a) version 1	(a) version 1	(b) version 2						
	93	597551	597551	597551	180.0	10	170.0		
	94	637225	637225	637225	168.0	12	156.0		
	95	884112	884112	884112	246.0	10	236.0		
E	96	893911	893911	893911	240.0	12	228.0		
	97	927849	927849	927849	648.0	12	636.0		
	98	963699	963699	963699	256.5	12	244.5		
	99	964177	964177	964177	564.0	12	552.0		
	100	044506	044506	044506	222.0	12	210.0		
	101	047374	047374	047374	417.0	12	405.0		
	102	064104	064104	064104	522.0	10	512.0		
D	103	064821	064821	064821	498.0	10	488.0		
	104	065777	065777	065777	258.0	10	248.0		
	105	066255	066255	066255	339.0	10	329.0		
	106	069840	069840	069840	402.0	10	392.0		
	107	071035	071035	071035	228.0	10	218.0		
	108	075576	075576	075576	111.0	10	101.0		
	110	101866	101866	101866	192.0	10	182.0		
C	111	106646	106646	106646	105.0	10	95.0		
	112	147037	147037	147037	345.0	10	335.0		
	113	147515	147515	147515	330.0	10	320.0		
	114	147993	147993	147993	135.0	10	125.0		
	115	149905	149905	149905	198.0	6	192.0		

- (c) before grinding:
Hardness depth and hardness test
acc. to STAB-Spec. 10258370
- (d) tolerances: $^{+0,2}_{-0,1}$ after turning
 $\pm 0,3$ after straightening
 $\pm 0,3$ after nisliding
- (e) threaded stud rough-turned dim. $\varnothing 7,14_{-0,06}$
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

AIAG COI-standards acc. to STAB-Spec. 10027692

DE: X	EN: X	ES: X	IT:	PR:	FR:	RO: X	CAD created document handwritten changes not permitted
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new	$\phi 5^{-0,02}_{-0,12}$	span. version created no technical change, no new first sample required
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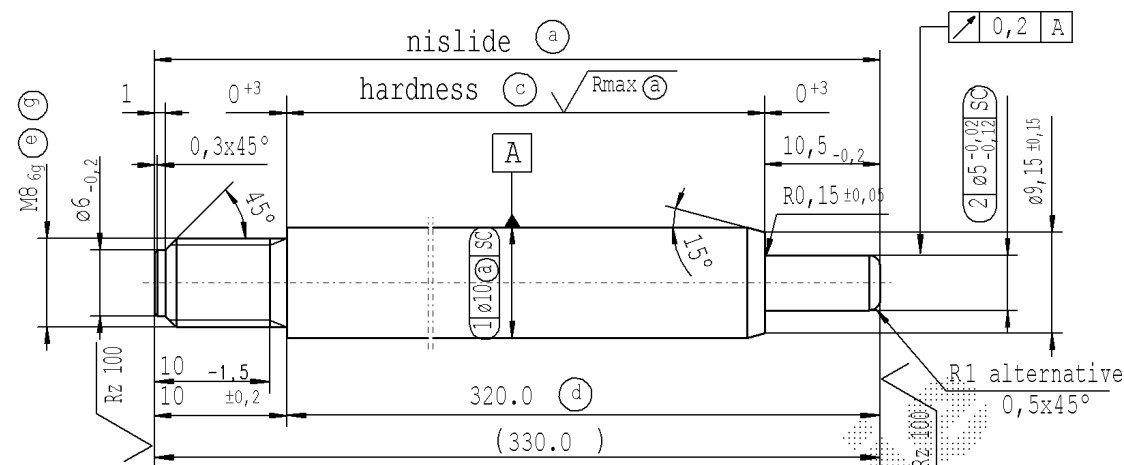
old	$\varnothing 5 \begin{smallmatrix} -0,020 \\ -0,120 \end{smallmatrix}$
-----	--

Field	-
Date/Name	07.02.2024 Jablonski

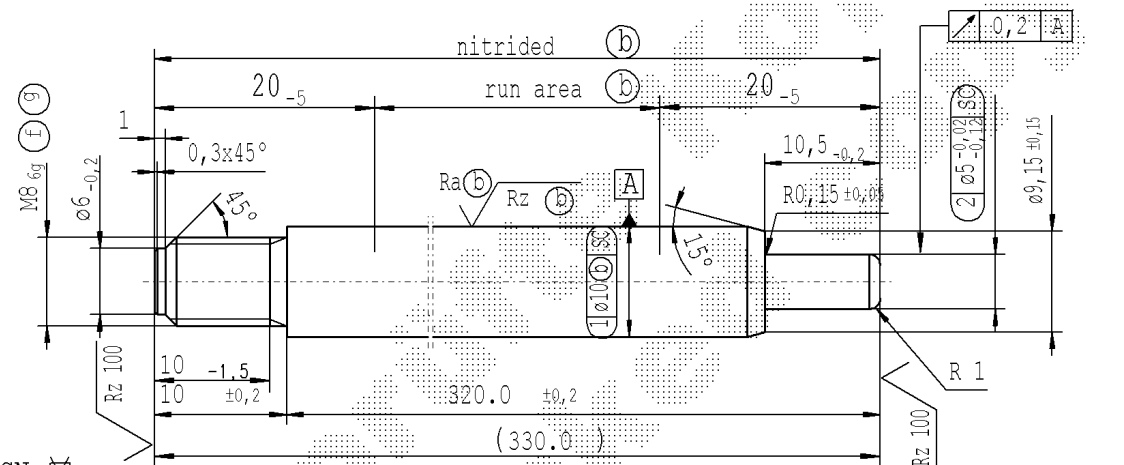
Chg. No.	730447
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Rev.	5
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version 1 (only self-manufacturing) * material: 010715



version 2 (only external production) * material: 1.1193 S45C JISG 4051, for ZS-RO alt. 183844 (C35EC)



ZS	CN	☒
ZS	RO	☒

thread tolerances acc. to DIN ISO 965-3

approved lengths: 50-600 mm

$$\sqrt{R_{z\ 25}} \left(\sqrt{R_{z\ 100}} \sqrt{R_{\max}} \textcircled{a} \sqrt{R_z} \textcircled{b} \right) \begin{matrix} \swarrow +0,2 \\ \searrow -0,2 \end{matrix}$$

sheet 5
of 11

Environmental protection acc. to STAB-Spec. 10005649

All dimensions are

	Marking of special characteristics
--	------------------------------------

in mm	
Coales	

according to STAB-Spec. 1027

Scale: (Original DIN A3)	2:1	Dimensions without tolerances DIN ISO 2768-mK
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	Document No.:	

10166619

Material No.:

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Material:

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Edge tolerances acc. to DIN ISO 137

Surface finish: DIN EN ISO 1302

Replaces:

STADIUM

PISTON ROD