INSTALLATION INSTRUCTIONS FOR SERIES LK

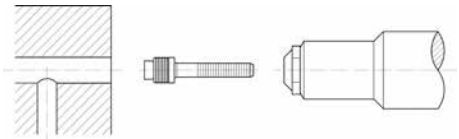

Fig. 1

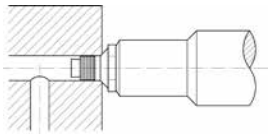

Fig. 2

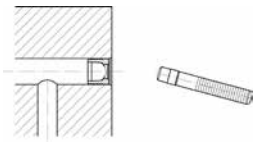

Fig. 3

DRILLED HOLE

1. The drilled hole must be within the tolerance shown on the dimensional sheets.
   In base materials with high hardness or hardened materials:
   - < 280HB the bore tolerance should be 0 / + 0.12
   - ≥ 280HB the bore tolerance should be +0.05 / + 0.15
2. Holes must be round within 0.05 mm.
3. With hard materials the bore roughness should be from R_z = 10–30 µm for best results.
4. Longitudinal rifles and spiral grooves should be avoided. These influence the sealing effectiveness.
5. The bore must be free of oil, grease and chips.

SETTING PROCEDURE

- Insert the plug in the tool, ensuring that the sleeve is against the nosepiece (Fig. 1).
- After inserting the plug into the hole activate the tool to expand the plug.
- The mandrel will break apart when the proper tension has been reached (Fig. 2 and 3).

Note:

- The assembly of KOENIG EXPANDER® plugs should only be done in a **clean working area**.
- The sleeve and mandrel of **the plug should not be cleaned, lubricated or have sealant (compound) applied**.

TOOLS

For trouble free installation of KOENIG EXPANDER® plugs use the tools and appropriate components according to the data sheet.

PLUG REMOVAL

With KOENIG EXPANDER® plugs LK Series plug removal is possible.

PROCEDURE:

- Drive the mandrel from the sleeve with a punch.
- Drill out the sleeve and remove the mandrel.
- Bore the hole to the **next larger Expander diameter** per the data sheet.
- Clear chips, remnants of the sleeve and oil and grease from the bore.
- Inspect bore to confirm that it meets all requirements.
- Install a new KOENIG EXPANDER®.

Note:

After plug removal always install the next larger size plug.