

INSTALLATION INSTRUCTIONS FOR SERIES LK

DRILLED HOLE

- 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 $0/+0.12$
 - ≥ 280 HB the bore tolerance should be $+0.05/+0.15$
- Holes must be round within 0.05 mm.
- With hard materials the bore roughness should be from $R_z = 10 - 30 \mu\text{m}$ for best results.
- With soft materials < 80 HB $R_z = 4 - 30 \mu\text{m}$ is allowed
- Longitudinal rifles, spiral grooves and cavities should be avoided. These influence the sealing effectiveness.
- The bore must be free of oil, grease and chips.

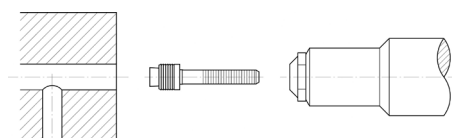


Fig. 1

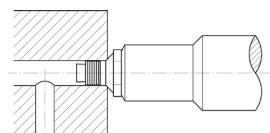


Fig. 2

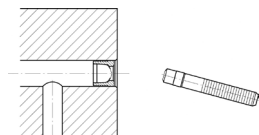


Fig. 3

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.