

INSTALLATION INSTRUCTIONS FOR SERIES SK / SKC

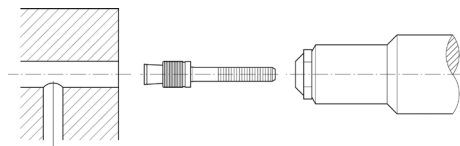


Fig. 1

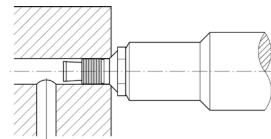


Fig. 2

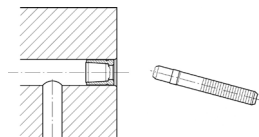


Fig. 3

DRILLED HOLE

- The drilled hole must be within the tolerances shown on the preceding data sheets.
- In base materials with low hardness or soft materials:
 - < 110 HB the bore tolerance should be 0/+0.08
 - > 110 HB the bore tolerance should be 0/+0.12
- 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 < 150 HB $R_z = 4 - 30 \mu\text{m}$ is allowed
- Longitudinal rifles and spiral grooves should be avoided. These influence the sealing effectiveness.
- The bore must be free of oil, grease and chips.

SETTING PROCEDURE

- Insert the plug in the tool, making sure that the sleeve is against the nosepiece (Fig. 1).
- After inserting the plug into the hole (ensuring the tool is flush to the work surface) 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® SK / SKC 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.