

# INSTALLATION INSTRUCTIONS FOR SERIES LK

## 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  $0 / + 0.12$
  - $\geq 280HB$  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  $R_z = 10\text{--}30\ \mu\text{m}$  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.

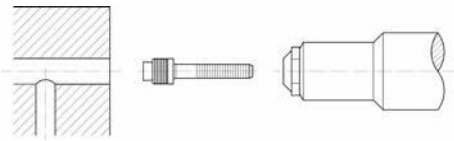


Fig. 1

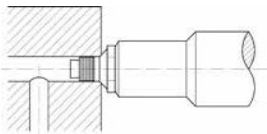


Fig. 2

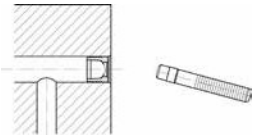


Fig. 3

## 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.