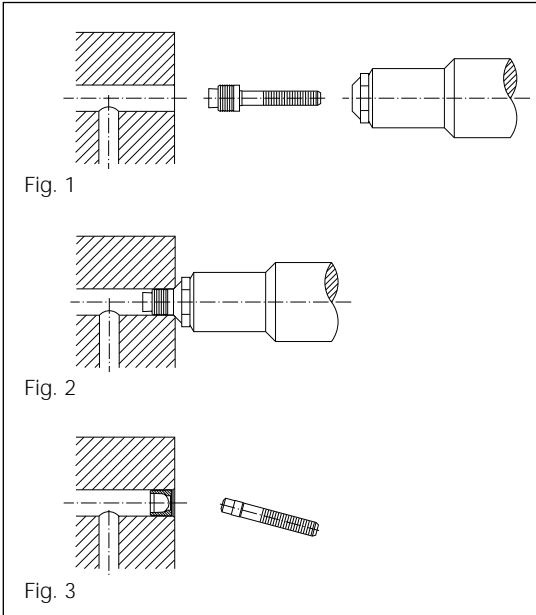


Installation Instruction LK Series

Drilled Hole

- The drilled hole must be within the tolerances shown on the dimensional sheets.
- 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.
- 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 activate the tool to expand the plug. The mandrel will break apart when the proper tension has been reached (Fig. 2 & 3).

Note:

- The assembly of KOENIG-Expanders should only be done in a **clean working area**.
- Sleeve and mandrel of the plug should not be **cleaned or lubricated**.

Tools

For trouble free installation of KOENIG-Expanders use the tools and appropriate components according to the data sheet.

Plug Removal

With KOENIG-Expanders LK Series plug removal is possible.

Procedure:

1. Drive the mandrel from the sleeve with a punch.
2. Drill out the sleeve and remove the mandrel.
3. Bore the hole to the **next larger Expander diameter** per the data sheet.
4. Clear chips, remnants of the sleeve and oil and grease from the bore.
5. Install a new KOENIG-Expander.

Note: After plug removal always install the next larger size plug.