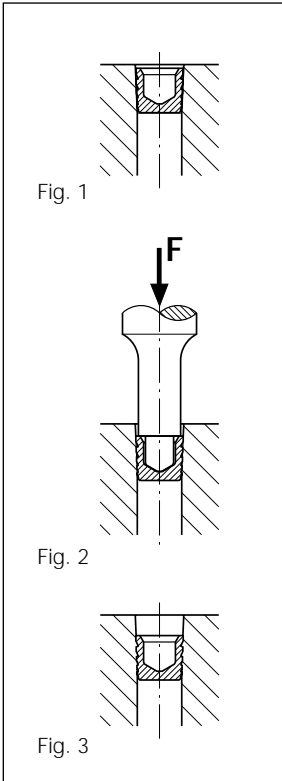


Installation Instruction LP Series

Drilled Hole

- The drilled hole must be within the tolerances shown on the dimensional sheets.
- The cone rate 1:12 must be kept as per specification sheet.
- 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

- With the setting hole facing out, the LP-plug is inserted in the cone bore. The top sleeve should not be above the surface of the base material (Fig. 1).
- The LP-plug can now be pressed in with the setting tool. Corresponding approximate values for stroke S are from the table below (Fig. 2).
- Installed LP-plug (Fig. 3).

Note:

- Use the proper size setting tool for the KOENIG-Expander according to the data sheet.
- Through washing of the LP-plugs before installation, higher setting force might occur.

Press

- It is preferred to limit travel when using a press because insertion force is difficult to control.
- Recommended setting speed is 5 mm/sec.

The KOENIG-Expander assuring an optimum orientation, it works perfectly with automatic processing.

Plug Removal

With KOENIG-Expander LP Series plug removal is possible. The plug can be drilled out with a high speed steel drill.

Procedure:

1. Drill out, in one process, to the next larger diameter, nominal diameter d_4 according to the data sheet.
2. Drill the taper hole with a reamer up to diameter d_3 according to the data sheet.
3. Clear chips, remnants of the sleeve, and oil and grease from the bore.
4. Install a new KOENIG-Expander.

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

Installation Chart

Series LP 900 -		040	050	060	070	080	090	100	120
S (mm) ± 0.25	Stroke (average value)	1.0	1.3	1.3	1.5	1.8	1.8	2.0	2.0
in steel, grey cast, nodulized cast iron in aluminium wrought alloy, aluminium-cast material									

