

INSTALLATION INSTRUCTIONS FOR SERIES LP

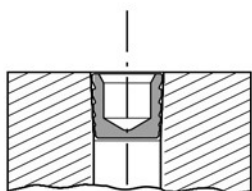


Fig. 1

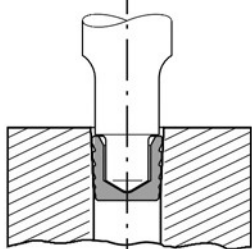


Fig. 2

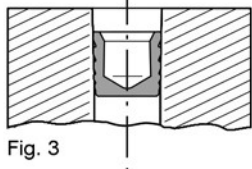


Fig. 3

DRILLED HOLE

- The drilled hole must be within the tolerances shown on the dimensional sheets.
- A 1:12 cone rate must be maintained as per the 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.
- A higher setting force might occur if the LP plugs are washed before installation.

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® ensures an optimum orientation, it works perfectly with automatic processing.

PLUG REMOVAL

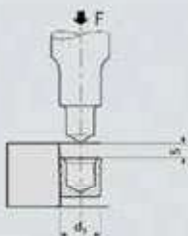
With KOENIG EXPANDER® LP Series plug removal is possible. The plug can be drilled out with a high speed steel drill.

PROCEDURE:

- Drill out, in one process, to the next larger diameter, nominal diameter d4 according to the data sheet.
- Drill the taper hole with a reamer up to diameter d3 according to the data sheet.
- Clear chips, remnants of the sleeve, and oil and grease from the bore.
- Install a new KOENIG EXPANDER®.

Note:

After plug removal always install the next larger size plug.



INSTALLATION CHART

		Series LP 900							
	X [mm]	4	5	6	7	8	9	10	12
S [mm]	Stroke	1,0	1,3	1,3	1,5	1,8	1,8	2,0	2,0
	±0,25								
	(average value)								

In steel, gray cast nodulized cast iron, aluminum wrought alloy, aluminum-cast material