

Plugs

INFO-Products

EXPANDER

INFO Anchorage Principle

INFO Installation Lengts High Pressure Systems

INFO Installation Lengts Low Pressure Systems

Dichtstopfen SK

SK 550 / Standard

Hülse: Einsatzstahl, gebläut

Stift: Vergütungsstahl

Spez. Oelfilm

Hülse und Stift vormontiert

Geeignet für automatisierte Verarbeitung

Sealing Plugs SK

INFO Pressure Performance

INFO Installation Instruction

SK 550 / Standard

Sleeve: Case Hardening Steel

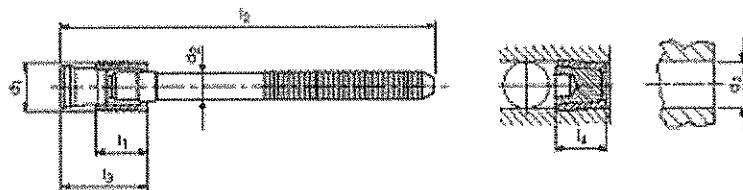
Gun metal-finish

Mandrel: Heat treatable steel

Special oil film lubrication

One piece construction

Ideal for automated high production requirements



d ₁ Expander Ø	l ₁	d ₂	l ₂	l ₃ max.	l ₄ max.	d ₃ + 0,12 0	Type	+ IP	
4,0	4,5	2,50	39	9,0	6,5	4,0	SK550-040	100	1000
5,0	5,5	3,00	41	10,0	7,5	5,0	SK550-050	100	1000
6,0	6,5	3,40	43	12,0	8,0	6,0	SK550-060	100	500
7,0	7,5	4,10	38	14,0	9,0	7,0	SK550-070	100	500
8,0	8,5	4,20	40	15,0	10,5	8,0	SK550-080	100	500
9,0	9,5	4,50	43	17,0	11,0	9,0	SK550-090	100	250
10,0	10,5	4,75	45	19,0	12,5	10,0	SK550-100	100	250

Top

Plugs

[INFO-Products](#)

EXPANDER

[INFO Anchorage Principle](#)

[INFO Installation Lengts High Pressure Systems](#)

[INFO Installation Lengts Low Pressure Systems](#)

Dichtstopfen SK

SK 552 / Stift lang

Hülse: Einsatzstahl, gebläut

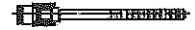
Stift: Vergütungsstahl

Spez. Oelfilm

Hülse und Stift vormontiert

Geeignet für automatisierte Verarbeitung

Sonder-Typ: Stift 30 mm verlängert



Sealing Plugs SK

[INFO Pressure Performance](#)

[INFO Installation Instruction](#)

SK 552 / Long Mandrel

Sleeve: Case Hardening Steel

Gun metal-finish

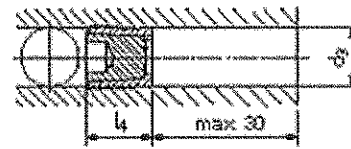
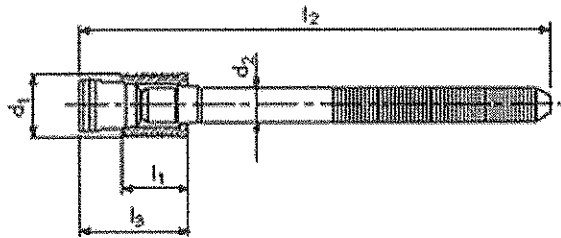
Mandrel: Heat treatable steel

Special oil film lubrication

One piece construction

Ideal for automated high production requirements

Special Type: Mandrel 30 mm longer



d ₁ Expander Ø	l ₁	d ₂	l ₂	l ₃ max.	l ₄ max.	d ₃ + 0,12 0	Type	+ IP	
4,0	4,5	2,50	69	9,0	6,5	4,0	SK552-040	100	1000
5,0	5,5	3,00	71	10,0	7,5	5,0	SK552-050	100	500
6,0	6,5	3,40	73	12,0	8,0	6,0	SK552-060	100	500
7,0	7,5	4,10	68	14,0	9,0	7,0	SK552-070	100	250
8,0	8,5	4,20	70	15,0	10,5	8,0	SK552-080	100	250
9,0	9,5	4,50	73	17,0	11,0	9,0	SK552-090	50	100
10,0	10,5	4,75	75	19,0	12,5	10,0	SK552-100	50	100

[Top](#)

KOENIG expander®



Pressure Performance

Series SK	Base material of the Installation						
	① ETG-100	② C15PB	③ EN-GJL-250	④ EN-GJS-500-7	⑤ AlCuMg2	⑥ AlMgSiPb	⑦ G-AISI7Mg
ø 4-10	1'600 bar / 23'200 psi 500 bar / 7'200 psi					1'400 bar / 20'300 psi 450 bar / 6'500 psi	
Hole	Tolerance	0 / +0,12 mm					
	Roughness	Rz 10-30µm			Anchorage in base metal		

If SK plugs are used to keep channels separated, allowable working pressure on the insertion side is reduced by 50%.

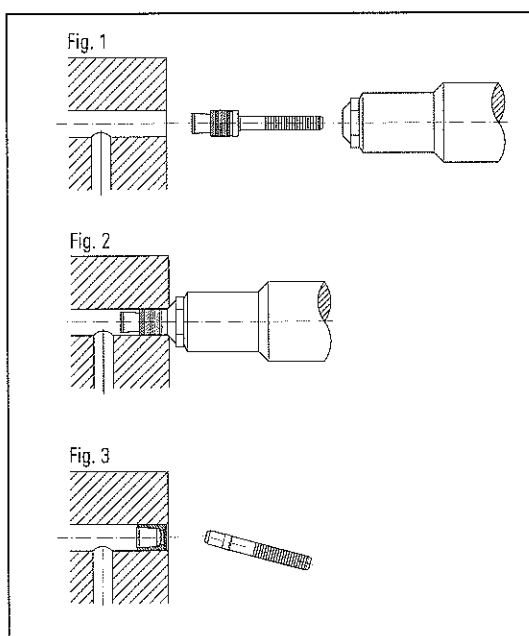
Proof Pressure Test ©

Max. allowable Working Pressure = Nominal Pressure

Installation Instruction SK Series

Drilled Hole

- The drilled hole must be within the tolerances shown on the preceding data sheets.
- Holes must be round within 0.05 mm.
- With hard materials the bore roughness should be from $R_z = 10\text{--}30\ \mu\text{m}$ 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 (making sure 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-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-Expander SK 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.