

INSTALLATION INSTRUCTION FOR SERIES MB

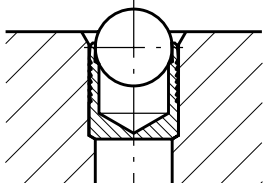


Fig. 1

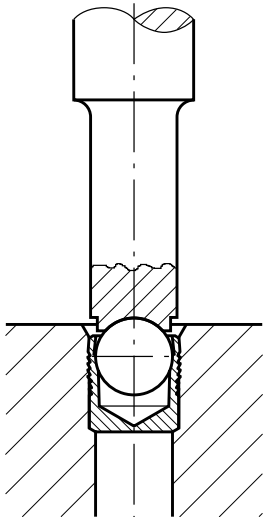


Fig. 2

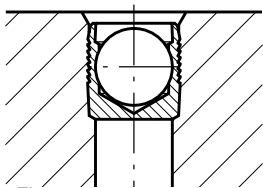


Fig. 3

DRILLED HOLE

- › The drilled hole must be within the tolerances shown on the preceding dimensional sheets.
- › The counterbored hole (d_2) must be properly sized for the through hole (d_3) according to 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

- › With the ball facing out the KOENIG-EXPANDER® is inserted in the counterbored hole. The top sleeve should not be above the surface of the base material (Fig. 1).
- › With only a slight or no counterbore, the base of the sleeve must be adequately supported during installation.
- › The ball can now be pressed in until the top of the ball is below the edge of the sleeve (Fig. 2 and 3). Corresponding approximate values for stroke S as well as the dimensions X are from the Table below.

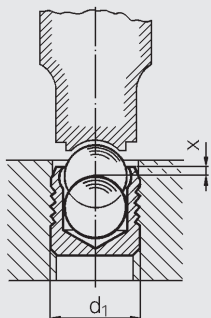
Note:

- › Use the proper size setting tool for the KOENIG-EXPANDER® according to the data sheet.
- › Cleaning/degreasing of plugs before installation, only spray cleaning with air drying allowed. (No dipping and vacuum drying).

PRESS

Small quantities or single parts can be installed with a hammer and setting tool. Installation can also be done with an arbor press. It is preferred to limit stroke travel when using a press because insertion force is difficult to control. KOENIG-EXPANDER® plugs are also ideal for automated installation because they are problem free.

INSTALLATION CHART



		Series MB 600 / MB 700 / MB 850													
d1 (mm)		3	4	5	6	7	8	9	10	12	14	16	18	20	22
S (mm)	Stroke (approx. values)	1,2	1,5	2,0	2,5	3,0	3,5	4,0	4,5	5,5	6,35	7,0	8,0	9,0	10,0
X (mm)	Position of top of ball relative to top of sleeve $\pm 0,2$	0,4	0,2	0,4	0,4	0,4	0,3	0,4	0,4	0,4	0,4	0,6	0,6	0,8	0,8

		Series MB 600 Inch-Version						
d1 (in)		.093	.125	.156	.187	.218	.250	.281
S (in)	Stroke (approx. values)	.031	.047	.059	.079	.094	.109	.118
X (in)	Position of top of ball relative to top of sleeve	Flush to .012 below the sleeve						