

INSTALLATION INSTRUCTION FOR SERIES MB

PLUG REMOVAL

With KOENIG-EXPANDER® MB Series removal of the plug is possible. The plug can be drilled out with a carbide tipped drill or with a high speed steel drill.

MB 600-030 to 140	Ball HB ~200	High Speed Steel Drill
MB 600-093 A	Ball HRC ~ 55	Carbide Tipped Drill
MB 600-125 A to 281 A	Ball HB ~200	High Speed Steel Drill
MB 700-030 to 220	Ball HRC ~ 45	Carbide Tipped Drill
MB 850-030 to 220	Ball HRC ~ 45	Carbide Tipped Drill

Procedure:

- › To Expander-Diameter 6 mm or .250 inch:
Drill out, in one process, to the **next larger diameter** according to the data sheet.
- › Expander-Diameter over 6 mm or .250 inch:
Drill out in several steps with last step to the **next larger diameter** according to the data sheet.
- › Clear chips, remnants of the sleeve, and oil and grease from the bore.
- › Inspect bore to confirm that it meets all requirements.
- › Install a new KOENIG-EXPANDER®.

Note:

After plug removal always use the next larger size plug.

