Installation Instructions for EIS-RS Sealing Plugs

FIG. 1

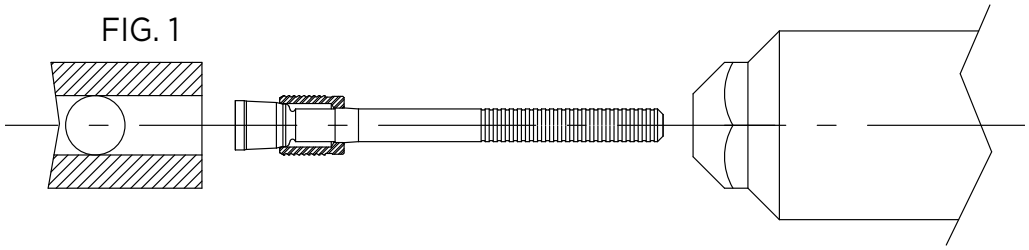


FIG. 2

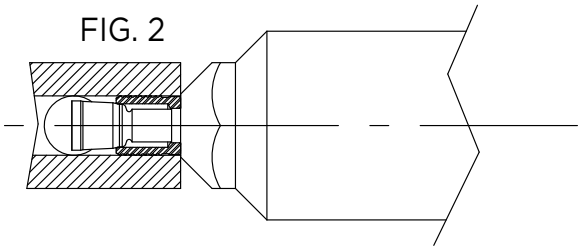
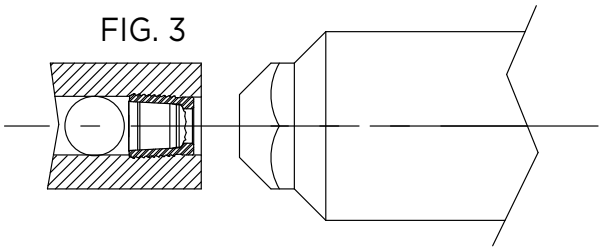


FIG. 3



Hole Preparation

- Use the catalogue sheet for the product you are installing to determine the correct drilled hole **(D3)** size and tolerance.
- Hole roundness must be held to within 0.05mm.
- Bore roughness must be between R_Z (RMS) 10 - 30 μm especially for hard materials.
- Avoid spiral or longitudinal grooves as these may affect plug performance.
- Be sure each bore is clean and free from any and all cutting oils, chips, etc.

Installation Procedure

- Always work in a clean work area.
- EIS RS Series Sealing Plugs are designed to be used as received. Do not clean or lubricate the plug or mandrel.
- Insert the mandrel into the tool. Be sure the plug is against the nose piece. **(Fig. 1)**
- Insert the plug into the hole. Be sure the nose piece is pushed against the workpiece and is perpendicular. **(Fig. 2)**
- Activate the tool to expand the plug. The mandrel will break free when the plug has fully expanded. **(Fig. 3)**
- Be sure to purchase the correct installation tool for each plug size selected.

Removal

- Using a punch, drive the expansion pin out of the plug.
- Drill out the plug and remove the expansion pin.
- Drill the hole for the next larger size EIS RS Series Sealing Plug.
- Be sure to remove all chips, plug remnants and any grease or oil from the hole.
- Install a new EIS RS Sealing Plug.

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Certified ISO/TS 16949-2009 RoHS Compliant

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