



Removal Instructions for EIS-11, EIS-31 and EIS-33 Series Expansion Plugs

Removing EIS-11, EIS-31 and EIS-33 Series Sealing Plugs requires simple machining operations using ordinary shop tools. The removal procedure involves drilling and tapping the steel expander ball and the sealing plug. Removal after machining can be accomplished by using a long standard bolt with a striker similar to a slide hammer

Removal Procedure

- Drill and tap threads into the steel ball (see chart below)
- Thread a standard bolt with a striker into the steel ball and pull out of the EIS Plug
- Drill and tap threads into the I.D. of the EIS Plug (see chart below)
- Thread a standard bolt with a striker into the EIS Plug and pull out of the hole
- After removal always use the next larger diameter EIS Sealing Plug (see catalogue pages for available sizes)

Removal Chart

Recommended Drill and Taps for Metric EIS Sealing Plug Removal									
Metric Drills and Taps					Inch Drills and Taps				
EIS Plug Dia.	Ball Drill	Ball Tap	EIS Plug Drill	EIS Plug Tap	EIS Plug Dia.	Ball Drill	Ball Tap	EIS Plug Drill	EIS Plug Tap
3 mm	1.75 mm	M2.2 x .45	1.75 mm	M2.2 x .45	3 mm	49	2-56	49	2-56
4 mm	2.1 mm	M2.5 x .45	2.6 mm	M3 x .50	4 mm	42	4-40	42	4-40
5 mm	2.1 mm	M2.5 x .45	2.6 mm	M3 x .50	5 mm	42	4-40	42	4-40
6 mm	3.0 mm	M3.5 x .60	4.5 mm	M5 x .80	6 mm	7/64"	6-32	7/64"	6-32
7 mm	3.0 mm	M3.5 x .60	5.5 mm	M6 x .50	7 mm	28	8-32	28	8-32
8 mm	4.5 mm	M5 x .80	6.5 mm	M7 x .75	8 mm	20	10-32	20	10-32
9 mm	4.5 mm	M5 x .80	7.5 mm	M8 x 1.00	9 mm	20	10-32	20	10-32
10 mm	6.3 mm	M7 x .75	8.0 mm	M9 x 1.00	10 mm	13/64"	1/4-20	13/64"	1/4-20
12 mm	6.3 mm	M7 x .75	10.5 mm	M11 x 1.00	12 mm	13/64"	1/4-20	13/64"	1/4-20
14 mm	7.4 mm	M8 x .75	7.4 mm	M8 x .75	14 mm	J	5/16-24	J	5/16-24
16 mm	7.4 mm	M8 x .75	7.4 mm	M8 x .75	16 mm	J	5/16	J	5/16
18 mm	7.4 mm	M8 x .75	7.4 mm	M8 x .75	18 mm	J	5/16	J	5/16
20 mm	7.4 mm	M8 x .75	7.4 mm	M8 x .75	20 mm	J	5/16	J	5/16
22 mm	7.4 mm	M8 x .75	7.4 mm	M8 x .75	22 mm	J	5/16	J	5/16

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