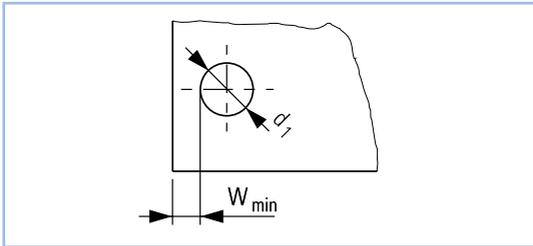


Wall thickness/Distance from edge

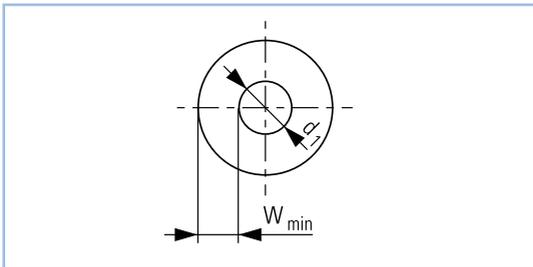
Distance to external wall:



As the radial expansion of the KOENIG EXPANDER® sleeve occurs, the base material in which it will be anchored plastically deforms. The resultant strength, as well as the hydraulic pressure and temperature service conditions depending on the expander type and characteristics of the base material, require minimum wall thickness, or distance from edge.

The guideline values for minimum wall thickness and distance from edge [W_{min}] express these influencing factors. At these minimum values, only slight deformation on the exterior profile of the base material of less than 20 μm is likely. This does not affect the function of the KOENIG EXPANDER®. Below the guideline values [W_{min}] the possibility of overloading the base material exists, which can adversely influence the function of the KOENIG EXPANDER®. In such cases tests must be conducted.

Distance to exterior wall:



Guideline values W_{min} for wall thickness and distance from edge

KOENIG EXPANDER® diameters **Series MB / SK / HK and LP:**

$d_1 = 4 \text{ mm: } W_{min} = f_{min} \times d_1$

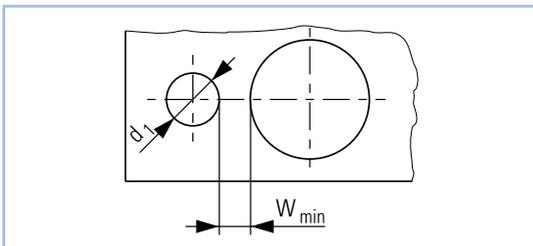
$d_1 < 4 \text{ mm: } W_{min} = f_{min} \times d_1 + 0,5 \text{ mm}$

KOENIG EXPANDER® diameters **Series LK:**

$d_1 = 5 \text{ mm: } W_{min} = f_{min} \times d_1$

$d_1 = 4 \text{ mm: } W_{min} = f_{min} \times d_1 + 0,5 \text{ mm}$

Wall thickness between bores:



Description	Base material of the installation							
	1	2	3	5	6	7	8	
	ETG-100	C15Pb	EN-GJS-600-3	EN-GJL-250	AlCu4Mg1	AlMgSiPb	G-AISi7Mg	
Avg. tensile strength R _m [N/mm ²]	1000	560	650	300	480	340	260	
Minimum elongation A5 [%]	6	10	3	0,3	8	8	2	
Avg. ultimate strength R _p 0,2 [N/mm ²]	900	300	425	200	380	290	220	
KOENIG EXPANDER® Series	Factor f _{min.}							
MB 600	0,6	0,8	0,8	1	0,8	1	1	
MB 600 Inch-Version	0,6	0,8	0,8	1	0,8	1	1	
MB 700	0,6	0,8	0,8	1	0,8	1	1	
MB 850	0,5	0,6	0,6	1	0,6	1	1	
CV 173	0,6	0,6	0,7	0,8	0,7	0,8	0,8	
CV 588	0,6	0,8	0,8	1	0,8	1	1	
SK Ø 4 – 12	0,5	0,6	0,6	1	0,8	1	1	
SKC Ø 4	0,4	0,5	0,5	1	0,8	0,9	0,9	
SKC Ø 5	0,4	0,5	0,5	1	0,8	0,8	0,8	
SKC Ø 6	0,5	0,6	0,7	1	0,9	1	1	
SKC Ø 7	0,5	0,7	0,7	1,2	1,2	1,2	1,2	
HK Ø 4 – 10	0,4	0,5	0,5	0,8	0,5	0,8	0,8	
LP	0,3	0,3	0,3	0,5	0,4	0,5	0,5	
LK 600	0,4	0,5	0,5	0,8	0,7	0,7	0,7	
LK 950	0,3	0,3	0,4	0,6	0,5	0,5	0,5	
Factor f _{min.} Ø x.12 mm								
SKC Ø 4	0,4	0,4	0,4	1	0,7	0,8	0,8	
SKC Ø 5	0,4	0,4	0,4	1	0,7	0,7	0,7	
SKC Ø 6	0,4	0,5	0,6	1	0,8	0,9	0,9	
SKC Ø 7	0,4	0,6	0,6	1	0,9	0,9	0,9	

Required installation lengths

d_N	Series MB			Series SK		Series SKC		Series HK		Series LP		Series LK		Threaded plugs DIN 908	
	d_1	l_3 min.	l_4 min*	d_1	l_4 max.	d_1	l_4 max.	d_1	l_4 max.	d_1	l_2 min.	d_1	l_4 max.	d_1	l_4 max.
2	3	3,4	5												
3	4	3,8	5,5					3	7						
4	5	5,3	7	4	6,5	4	6,5	4	8	4,4	7	4	4		
5	6	6,3	8,5	5	7,5	5	7,5	5	9,5	5,4	8	5	4,8	M8x1,5	11,5
6	7	7,3	9,5	6	8	6	8,5	6	10	6,4	8,5	6	5,3	M8x1,5	11,5
7	8	8,3	11	7	9	7	9,5	7	11	7,4	8,5	7	5,8	M10x1,5	12
8	9	9,8	12,5	8	10,5			8	11,5	8,45	9,5	8	6,8	M10x1,5	12
9	10	10,8	13,5	9	11			9	13	9,6	10	9	6,8	M12x1,5	16
10	12	12,8	16	10	12,5			10	13,5	10,65	11	10	6,8	M12x1,5	16
12	14	14,5	18	12	16,5					12,75	12	12	7,8	M14x1,5	16,5
14	16	16,5	20									14	8,7	M16x1,5	16,5
16	18	18,5	22,5									16	11,5	M18x1,5	17,5
18	20	21,5	25,5									18	13	M20x1,5	19,5
20	22	24,5	28,5											M22x1,5	19,5

d_N = Given nominal bore/system bore size

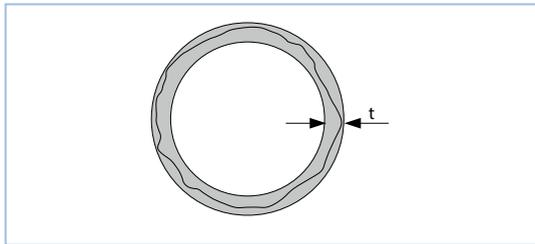
***Installation lengths series MB**

The required installation length (l_4) min. for **MB plugs** is for base materials with hardness greater than HB = 90. For softer materials, deeper installation is required.

Roundness tolerance

Roundness tolerance

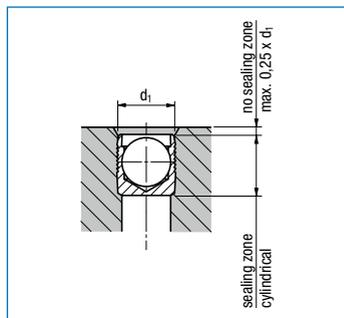
To ensure reliable functioning of the KOENIG EXPANDER® with regard to pressure performance and to ensure leak tight sealing, a **roundness tolerance of $t = 0,05 \text{ mm}$** . By using a double lipped twist drill, the called out hole and roundness tolerances are reached. Better tolerances, particularly for larger diameter holes, can be held by using a triple lipped twist drill.



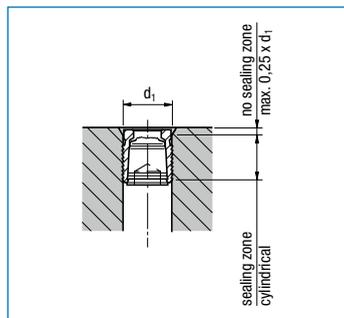
Conicity of the bore

Within the effective sealing area of the KOENIG EXPANDER®, the bore must be according to the dimensional sheets. The bore lead in can be chamfered up to a depth of **$0,25 \times d_1$** (**LK: $0,15 \times d_1$**) because this area has no significant effect on the sealing function.

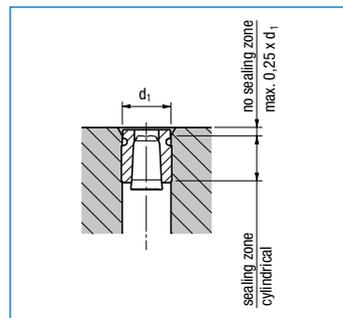
Series MB/CV



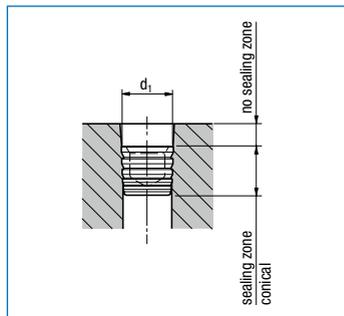
Series SK/SKC



Series HK



Series LP



Series LK

