Installation Instructions for EIS-RST, RSO & LRST Sealing and Orifice Plugs "patent pending"
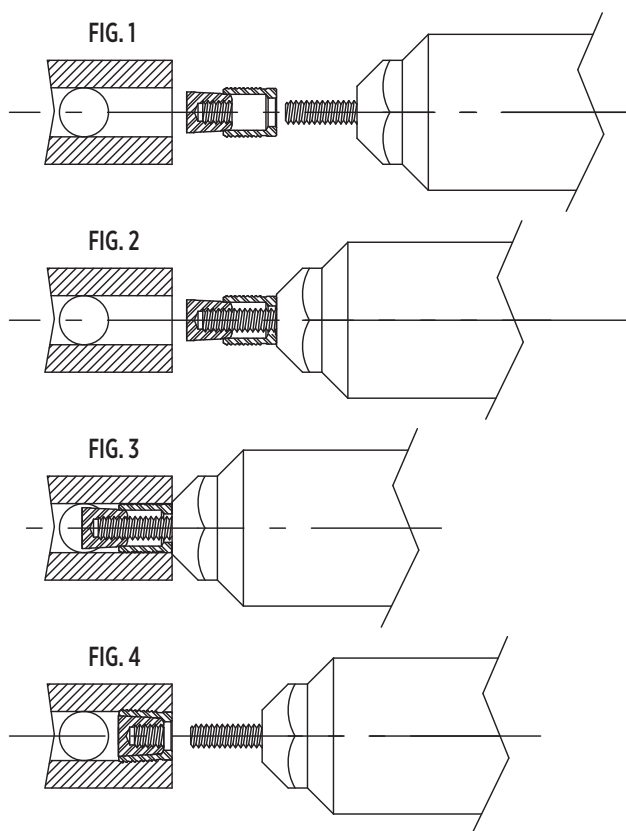
Hole Preparation

- 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 RST or RSO Series Sealing Plugs are designed to be used as received. Do not clean or lubricate the plug or the pin. **(Fig. 1)**

- Push the threaded arbor against the EIS Pullplug "patent pending". The arbor will automatically thread into the sealing plug. **(Fig. 2)**

- Insert the plug into the hole. Be sure the nose piece is pushed against the workpiece and is perpendicular. **(Fig. 3)**

- Activate the tool to expand the plug. The threaded arbor will pull the pin to a preset depth and then automatically and unscrew itself from the pin **(Fig. 4)**

- Be sure to purchase the correct installation tool for each plug size selected.

FIG. 1

FIG. 2

FIG. 3

FIG. 4

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 RST or RSO Series Pullplug.

- Be sure to remove all chips, plug remnants and any grease or oil from the hole.

- Install a new EIS RST or RSO Series Pullplug.