

Product Description	Rev.	D Minimum Supplied	D Maximum Recovered	T Supplied	W Maximum Supplied	Minimum Substrate Diameter ⁵	Nominal Clamping Force (lbs) ⁶
BHE0651-0074	-	0.651	0.619	.074±.003	0.115	0.629	760
BHE1041-0074	-	1.041	0.987	.074±.003	0.115	1.003	760
BHE1061-0074	-	1.061	1.006	.074±.003	0.115	1.022	760
BHE1090-0074	-	1.090	1.032	.074±.003	0.115	1.049	760
BHE1172-0074	-	1.172	1.110	.074±.003	0.115	1.128	760
BHE1192-0074	-	1.192	1.128	.074±.003	0.115	1.146	760
BHE1217-0074	-	1.217	1.153	.074±.003	0.115	1.171	760
BHE1302-0074	-	1.302	1.233	.074±.003	0.115	1.253	760
BHE1321-0074	-	1.321	1.251	.074±.003	0.115	1.271	760
BHE1431-0074	-	1.431	1.356	.074±.003	0.115	1.377	760
BHE1451-0074	-	1.451	1.375	.074±.003	0.115	1.396	760
BHE1508-0074	-	1.508	1.439	.074±.003	0.115	1.462	760
BHE1515-0084	-	1.515	1.444	.084±.003	0.125	1.467	970
BHE1544-0084	-	1.544	1.462	.084±.003	0.130	1.485	970
BHE1550-0057	-	1.550	1.487	.057±.003	0.086	1.510	450

NOTES:

- 1 Ring material: heat-to-recover NiTi, Intrinsic Alloy H.
- 2 To prevent premature recovery, do not expose rings to temperatures above 113°F (45°C) prior to installation.
- 3 Rings begin to shrink at just over 113°F and are almost fully shrunk by 212°F (100°C). However, they require heating to 330°F (165°C) to build their full clamping force. Use a controlled heating method to insure the rings are heated to 330°F or higher. Rings can be supplied with temperature indicating paint spots that change color at 330°F. Add a "P" suffix to the part number if the paint is desired.
- 4 Do not heat rings above 572°F (300°C) during installation, or afterward, to avoid the possibility of stress relaxation.
- ⁵To ensure consistent performance, the substrate should have the dimensions and rigidity to hold the installed ring diameter to this size, or larger. (For a minimum unresolved recovery of 1.5%)

- ⁶This is a nominal radial clamping force for design purposes, equal to the ring-to-substrate contact area times the contact pressure. The actual force applied by a ring is a function of installation method, substrate material and geometry, and operating temperatures. The force decreases with decreasing temperature and with decreasing substrate diameter. Testing is required to qualify performance in specific applications.
- ⁷"I" and "J" suffix rings have an insulating coating which is .0005" to .005" thick. Type "I" rings have a coating coverage angle, Ø, of 45° to 150°. Type "J" rings have a coating coverage angle, Ø, of 90° to 150°. Coating adds to dimensions T & W. D is unchanged. Coating is used when installing rings by direct electrical resistance heating. Consult Installation Procedure, PD 003.
- 8 Dimensions are in inches.
UniLok is a trademark of Intrinsic Devices, Inc.

Intrinsic Devices, Inc.

2353 Third Street
San Francisco, CA 94107-3108
tel: 415 252-5902 fax: 415 252-1624

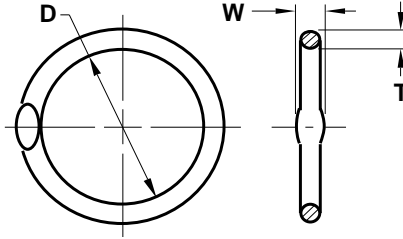
intrinsicdevices.com

CAGE Code 08CE6

Product Document

**UniLok, Circular Section, Welded,
Heat-To-Recover, English Units**

Drawing ID	Rev.	Date	Page
PD BHE	-	4/1/19	1 of 2



Product Description	Rev.	D Minimum Supplied	D Maximum Recovered	T Supplied	W Maximum Supplied	Minimum Substrate Diameter ⁵	Nominal Clamping Force (lbs) ⁶
BHE1562-0084	-	1.562	1.480	.084±.003	0.130	1.503	970
BHE1674-0084	-	1.674	1.586	.084±.003	0.130	1.611	970
BHE1692-0084	-	1.692	1.604	.084±.003	0.130	1.629	970
BHE1756-0074	-	1.756	1.685	.074±.003	0.115	1.711	760
BHE1895-0100	-	1.895	1.812	.100±.004	0.144	1.841	1380
BHE1933-0084	-	1.933	1.839	.084±.003	0.130	1.868	970
BHE1951-0084	-	1.951	1.857	.084±.003	0.130	1.886	970
BHE2185-0074	-	2.185	2.091	.074±.003	0.111	2.124	760
BHE2610-0057	-	2.610	2.490	.057±.003	0.089	2.528	450
BHE2820-0084	-	2.820	2.692	.084±.003	0.130	2.734	970
BHE3000-0039	-	3.000	2.860	.039±.002	0.059	2.904	210
BHE4050-0100	-	4.050	3.860	.100±.004	0.140	3.920	1380
BHE4678-0074	-	4.678	4.458	.074±.003	0.115	4.526	760
BHE5157-0031	-	5.157	4.920	.031±.002	0.047	4.994	130
BHE5900-0084	-	5.900	5.613	.084±.003	0.130	5.698	970
BHE6575-0031	-	6.575	6.258	.031±.002	0.047	6.352	130
BHE7000-0031	-	7.000	6.665	.031±.002	0.047	6.765	130
BHE7100-0031	-	7.100	6.780	.031±.002	0.047	6.882	130

Intrinsic Devices, Inc.

2353 Third Street
 San Francisco, CA 94107-3108
 tel: 415 252-5902 fax: 415 252-1624

intrinsicdevices.com

CAGE Code 08CE6

Product Document

**UniLok, Circular Section, Welded,
 Heat-To-Recover, English Units**

Drawing ID	Rev.	Date	Page
PD BHE	-	4/1/19	2 of 2