



Product Description	Rev.	D Minimum Supplied	D Maximum Recovered	T Supplied	W Maximum Supplied	Minimum Substrate Diameter ⁵	Nominal Clamping Force (N) ⁶
BHM1653-0188	-	16.53	15.73	1.88±0.08	2.93	15.99	3380
BHM2644-0188	-	26.44	25.07	1.88±0.08	2.93	25.48	3380
BHM2695-0188	-	26.95	25.55	1.88±0.08	2.93	25.96	3380
BHM2767-0188	-	27.67	26.23	1.88±0.08	2.93	26.65	3380
BHM2977-0188	-	29.77	28.19	1.88±0.08	2.93	28.65	3380
BHM3027-0188	-	30.27	28.66	1.88±0.08	2.93	29.12	3380
BHM3092-0188	-	30.92	29.28	1.88±0.08	2.93	29.75	3380
BHM3307-0188	-	33.07	31.32	1.88±0.08	2.93	31.82	3380
BHM3355-0188	-	33.55	31.78	1.88±0.08	2.93	32.29	3380
BHM3635-0188	-	36.35	34.44	1.88±0.08	2.93	34.99	3380
BHM3686-0188	-	36.86	34.92	1.88±0.08	2.93	35.48	3380
BHM3830-0188	-	38.3	36.56	1.88±0.08	2.93	37.13	3380
BHM3848-0213	-	38.48	36.68	2.13±0.08	3.18	37.26	4310
BHM3921-0213	-	39.21	37.15	2.13±0.08	3.31	37.73	4310
BHM3937-0145	-	39.37	37.77	1.45±0.08	2.19	38.36	2000

NOTES:

- Ring material: heat-to-recover NiTi, Intrinsic Alloy H.
- To prevent premature recovery, do not expose rings to temperatures above 45°C prior to installation.
- Rings begin to shrink at just over 45°C and are almost fully shrunk by 100°C. However, they require heating to 165°C to build their full clamping force. Use a controlled heating method to insure the rings are heated to 165°C or higher. Rings can be supplied with temperature indicating paint spots that change color at 165°C. Add a "P" suffix to the part number if the paint is desired.
- Do not heat rings above 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 .01 to .13 mm 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 mm.

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Intrinsic Devices, Inc.

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

intrinsicdevices.com

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Product Document

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

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