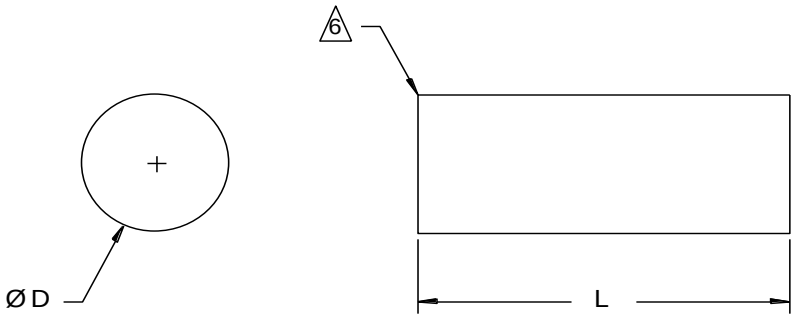
INTRINSIC

Expanding Pin



Product Description	Rev.	D Maximum Supplied	D Minimum Recovered	L Supplied	Recommended Hole Diameter 5	Nominal Radial Force (lbs) 7
PHE0125-0250	-	0.125	0.1275	0.250 ± .005	0.125 / 0.1265	3000
PHE0125-0375	-	0.125	0.1275	0.375 ± .008	0.125 / 0.1265	4500
PHE0125-0500	-	0.125	0.1275	0.500 ± .01	0.125 / 0.1265	6000
PHE0250-0150	-	0.250	0.2551	0.150 ± .005	0.250 / 0.2532	3500
PHE0250-0218	-	0.250	0.2551	0.218 ± .005	0.250 / 0.2532	5100
PHE0250-0250	-	0.250	0.2551	0.250 ± .005	0.250 / 0.2532	5900
PHE0308-0150	-	0.308	0.3146	0.150 ± .005	0.308 / 0.3122	4350
PHE0308-0273	-	0.308	0.3146	0.273 ± .006	0.308 / 0.3122	7900
PHE0308-0300	-	0.308	0.3146	0.300 ± .006	0.308 / 0.3122	8700
PHE0308-0575	-	0.308	0.3146	0.575 ± .01	0.308 / 0.3122	16700

NOTES:

1 Pin material: heat-to-recover NiTi, Intrinsic Alloy H.

2 To prevent premature recovery, do not expose pins to temperatures above 113°F (45°C) prior to installation.

3 Pins must be heated to 330°F (165°C) to insure full stress generation.

4 Do not heat pins above 572°F (300°C) during installation, or afterward, to avoid the possibility of stress relaxation.

5 To ensure consistent performance, the hole diameter should not exceed the maximum given, along the length where the pin will be installed.

6 End corners will be rounded with a radius of less than 10% of the pin diameter.

7 This is the nominal outward radial force developed by the pin, equal to the pin-to-substrate contact area times the nominal contact pressure, 30,000 psi. This is for initial design purposes. The actual radial pressure applied by a pin is a function of the substrate material and geometry and the operating temperatures. The contact pressure decreases with decreasing temperature and with increasing hole diameter. Qualification testing should take this into account.

8 Surface finish on Ø D, 32 Ra maximum

9 Dimensions are in inches.

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Product Document

Expanding Pin

Heat-To-Recover, English Units

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