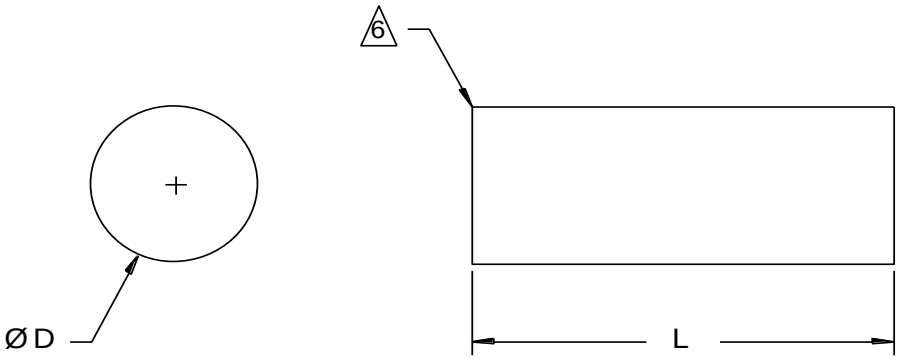
INTRINSIC

# Expanding Pin




| Product Description | Rev. | D Maximum Supplied | D Minimum Recovered | L Supplied | Recommended Hole Diameter 5 | Nominal Radial Force (lbs) 7 |
|---|---|---|---|---|---|---|
| PHM0318-0635 | - | 3.175 | 3.238 | 6.35 ± .14 | 3.175 / 3.214 | 13300 |
| PHM0318-0953 | - | 3.175 | 3.238 | 9.53 ± .21 | 3.175 / 3.214 | 20000 |
| PHM0318-1270 | - | 3.175 | 3.238 | 12.70 ± .26 | 3.175 / 3.214 | 26700 |
| PHM0635-0381 | - | 6.350 | 6.479 | 3.81 ± .14 | 6.350 / 6.432 | 15600 |
| PHM0635-0554 | - | 6.350 | 6.479 | 5.54 ± .14 | 6.350 / 6.432 | 22700 |
| PHM0635-0635 | - | 6.350 | 6.479 | 6.35 ± .14 | 6.350 / 6.432 | 26200 |
| PHM0782-0381 | - | 7.823 | 7.990 | 3.81 ± .14 | 7.823 / 7.93 | 19300 |
| PHM0782-0693 | - | 7.823 | 7.990 | 6.93 ± .16 | 7.823 / 7.93 | 35100 |
| PHM0782-0762 | - | 7.823 | 7.990 | 7.62 ± .16 | 7.823 / 7.93 | 38700 |
| PHM0782-1461 | - | 7.823 | 7.990 | 14.61 ± .26 | 7.823 / 7.93 | 74300 |

*NOTES:*

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

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

3 Pins must be heated to 165°C to insure full stress generation.

4 Do not heat pins above 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, 207 MPa. 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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| ***PD PHM*** | *G* | *7/10/2017* | *1 of 1* |