

| Product Description | Rev. | D Minimum Supplied | D Maximum Recovered | T Supplied | W Maximum Supplied | Minimum Substrate Diameter ⁵ | Nominal Clamping Force (lbs) ⁶ |
|---------------------|------|--------------------|---------------------|------------|--------------------|---|---|
| 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 |
| BHE1562-0084 | - | 1.562 | 1.480 | .084±.003 | 0.130 | 1.503 | 970 |

NOTES:

- Ring material: heat-to-recover NiTi, Intrinsic Alloy H.
- To prevent premature recovery, do not expose rings to temperatures above 113°F (45°C) prior to installation.
- 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.
- 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.
 - Dimensions are in inches.
- UniLok is a trademark of Intrinsic Devices, Inc.

Intrinsic Devices, Inc.

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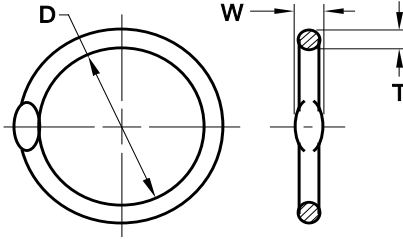
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CAGE Code 08CE6

Product Document

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

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|---------------------|--------------------|---------------------|------------|--------------------|---|---|
| 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 |
| 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 |
| BHE7125-0100 - | 7.125 | 6.780 | .100±.004 | 0.140 | 6.883 | 1380 |

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