

Product Description	D Minimum Supplied	D Maximum Recovered	T Supplied	W Maximum Supplied	Minimum Substrate Diameter <sup>△5</sup>	Nominal Clamping Force (lbs) <sup>△6</sup>
BHE0398-0074	0.398	0.378	.074±.003	0.115	0.385	760
BHE0417-0074	0.417	0.397	.074±.003	0.115	0.404	760
BHE0461-0074	0.461	0.439	.074±.003	0.115	0.446	760
BHE0480-0074	0.480	0.457	.074±.003	0.115	0.465	760
BHE0523-0031	0.523	0.501	.031±.002	0.050	0.509	133
BHE0524-0074	0.524	0.498	.074±.003	0.115	0.507	760
BHE0544-0074	0.544	0.517	.074±.003	0.115	0.526	760
BHE0587-0074	0.587	0.558	.074±.003	0.115	0.568	760
BHE0607-0074	0.607	0.577	.074±.003	0.115	0.587	760
BHE0651-0074	0.651	0.619	.074±.003	0.115	0.629	760
BHE0671-0074	0.671	0.638	.074±.003	0.115	0.649	760
BHE0719-0074	0.719	0.691	.074±.003	0.115	0.702	760
BHE0783-0074	0.783	0.743	.074±.003	0.115	0.756	760
BHE0803-0074	0.803	0.762	.074±.003	0.115	0.775	760
BHE0831-0074	0.831	0.790	.074±.003	0.115	0.803	760

**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.
- △5 To 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%)

- △6 This 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<sup>®</sup> is a registered trademark of Intrinsic Devices, Inc.

**Intrinsic Devices, Inc.**

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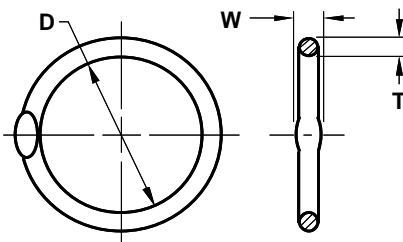
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CAGE Code 08CE6

*Product Document*

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

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BHE0845-0074	0.845	0.809	.074±.003	0.115	0.822	760
BHE0913-0074	0.913	0.866	.074±.003	0.115	0.880	760
BHE0932-0074	0.932	0.885	.074±.003	0.115	0.899	760
BHE0961-0074	0.961	0.911	.074±.003	0.115	0.926	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
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	1370
BHE1933-0084	1.933	1.839	.084±.003	0.130	1.868	970
BHE1951-0084	1.951	1.857	.084±.003	0.130	1.890	970
BHE2610-0057	2.610	2.502	.057±.003	0.089	2.540	450
BHE2820-0084	2.820	2.692	.084±.003	0.130	2.733	970
BHE4678-0074	4.678	4.458	.074±.003	0.115	4.526	760
BHE5900-0084	5.900	5.613	.084±.003	0.130	5.699	970
BHE7000-0031	7.000	6.665	.031±.002	0.047	6.765	133
BHE7100-0031	7.100	6.780	.031±.002	0.047	6.882	133
BHE7125-0100	7.125	6.780	.100±.004	0.140	6.883	1380

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