

Procedure 2100	Installation of Pre-Formed Band Clamps Using Pneumatic Roll-Over Tool	Revision 5-04
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Selection:

- Select the proper Pre-formed Band Clamp using Procedure 1001 (Pre-formed Band Clamp Selection).

Preparation:

- Prepare and mark the hose using Procedure 1100 (General Preparation Instructions).

Process:

- 1. Slide the clamp(s) over the hose end. **Note:** For hoses having a helical wire make certain that the clamp tail and the helical wire are pointing in the same direction. Refer to Procedure 1100 for illustration.
- 2. Insert the coupling.
- 3. Adjust the air tool regulator to its proper setting. **Note:** Always follow the tool manufacturer's recommendations for pull-up and holding pressure settings on the air tool regulator. These settings are based on band width and band material. Proper settings are essential for satisfactory clamp performance.
- 4. Use Air Tool as follows:
 - a. Activate tool-tensioning stroke. Tool will tension clamp until "pull-up" pressure is achieved.
 - b. Relieve pressure on tool until holding pressure is achieved.
 - c. Roll up the hose until the clamp buckle engages the cutting tool.
 - d. Quickly pull on the cutting tool handle to snap the clamp tail.
 - e. Reverse the air tool and remove the clamp tail.
 - f. For assemblies using multiple clamps, repeat the process. **Note:** When multiple clamps are used, clamp buckles must be offset to prevent a leak path. 2 Clamps - Buckles at 180°. 3 Clamps - Buckles at 120°. 4 Clamps - Buckles at 90°.
- 5. Inspect results using Procedure 3002 (Band Clamp Inspection).
- 6. Test assembly using Procedures 4000 (General Hydrostatic Testing Information) and 4001 (Hydrostatic Testing).

Assembled By: _____ Tested By: _____ Reference No. _____
 Assembled Date: _____ Test Date: _____