

Procedure 2102	<b>Installation of Pre-Formed Band Clamps Using Punch Style Tool and Air King Hose Shank Couplings</b>	Revision 4-04
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**Selection:**

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

**Preparation:**

- 1. Prepare and mark the hose using Procedure 1100 (general Preparation Instructions).
- 2. Be familiar with Procedure 2101 (Installation of Pre-formed Band Clamps Using Punch Style Tool)

**Notes:**

- 1. 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. Never grasp the knob of a punch style tool with a closed fist.
- 3. Testing is the only way to know for sure that proper tension has been achieved.
- 4. When the Knobbed Lever will not go to the full down position, move the Pulling Dog Lever to release the Knobbed Lever.
- 5. Use a hammer or mallet with a malleable iron or brass head.
- 6. When multiple clamps are used, clamp buckles must be offset to prevent a leak path.

**Process:**

- 1. Slide the clamp(s) over the hose end.
- 2. Insert the coupling.
  - For single clamp installations on 3/8" & 1/2" couplings:**
    - a. Position the clamp midway between mark on hose and hose end.
    - b. Tension the clamp.
  - For double clamp installations on 3/4" & 1" couplings:**
    - a. Position the first clamp just inside (hose end side) mark on hose.
    - b. Tension the clamp.
    - c. Position the second clamp midway between the clamp just installed and the hose end.
    - d. Tension the clamp.
  - For double clamp installation on 5/8" coupling:**
    - a. Position the first clamp just inside (hose end side) mark furthest away from hose end.
    - b. Tension the clamp.
    - c. Position the second clamp just inside (hose end side) mark closest to hose end.
    - d. Tension the clamp.
- 3. Inspect results using Procedure 3002 (Band Clamp Inspection)
- 4. Test the assembly using Procedures 4000 (General Hydrostatic testing Information) and 4001 (Hydrostatic Testing).

Assembled By: \_\_\_\_\_ Tested By: \_\_\_\_\_ Reference No. \_\_\_\_\_  
 Assembled Date: \_\_\_\_\_ Test Date: \_\_\_\_\_