

Procedure 2103	Installation of Pre-Formed Band Clamps Using Screw-Action Tool with Roll-Over Tool Attachment	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. Secure the screw-action tool in a vise. Position it so that the tightening handles are on the right.
- 4. Install the rollover attachment onto the screw-action tool head. Make sure that the cutting lever is facing the operator.
- 5. Use the Screw-action tool as follows:
 - a. Rotate the tightening handles counter clockwise until the Pulling Dog head contacts the tool head.
 - b. Insert the clamp tail through the slot on Rollover Tool until clamp buckle contacts tool head.
 - c. Pre-tension the clamp by pushing down on Pulling Dog Lever.
 - d. Rotate tightening handles clockwise. Continue rotating handles until the Pulling Dog Lever can be released without band slippage.
 - e. Insert the hose through clamp and into its proper position.
 - f. Rotate tightening handles clockwise until the clamp has been properly tensioned. **Note:** Testing is the only to know for sure if the proper tension has been achieved. However, as a visual indicator, the clamp O.D. will be less then the hose O.D.
 - g. **Note:** If tool runs out of stroke before clamp is tight; rotate handles counter clockwise, slide the Pulling Dog Head until it contacts screw-action tool head, push down on the Pulling Dog Lever and rotate the handles clockwise until clamp is properly tensioned. **Caution:** Bend excessive clamp tail away from tool handles to avoid being cut by sharp edges.
 - h. Rotate handles counter clockwise (no more than one full turn) while rolling the hose towards the operator. Continue rotating hose until clamp buckle engages cutting bar of attachment tool.
 - i. Quickly pull the cutting lever towards the operator.
 - j. Remove the clamp tail from the Pulling Dog.
 - k. 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°.
- 6. Inspect results using Procedure 3002 (Band Clamp Inspection).
- 7. Test the assembly using Procedures 4000 (General Hydrostatic Testing Information) and 4001 (Hydrostatic Testing).

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