Procedure 2102: Installation of Pre-Formed Band Clamps Using Punch Style Tool and Air King™ Hose Shank Couplings

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Selection
☐ Select the proper pre-formed band clamp using Procedure 1001: Pre-formed Band Clamp Selection (page 6).

Preparation
☐ 1. Prepare and mark the hose using Procedure 1100: General Preparation Instructions (pages 9-10).
☐ 2. Refer to Procedure 2101: Installation of Pre-formed Band Clamps Using Punch Style Tool (page 21).

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: General Preparation Instructions (page 10) 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. Refer to step 9 of Procedure 1100: General Preparation Instructions (pages 9-10).
   a. For single clamp installations on ⅜” and ½” couplings:
      1) Position the clamp midway between mark on hose and hose end.
      2) Tension the clamp.
   b. For double clamp installations on ¾” and 1” couplings:
      1) Position the first clamp just inside (hose end side) mark on hose.
      2) Tension the clamp.
      3) Position the second clamp midway between the clamp just installed and the hose end.
      4) Tension the clamp.
   c. For double clamp installation on ⅝” coupling:
      1) Position the first clamp just inside (hose end side) mark furthest away from hose end.
      2) Tension the clamp.
      3) Position the second clamp just inside (hose end side) mark closest to hose end.
      4) Tension the clamp.
☐ 4. Test the assembly using Procedures 4000: General Hydrostatic Testing Information (page 50) and 4001: Hydrostatic Testing (page 51).