Procedure 2103: Installation of Pre-Formed Band Clamps Using Screw-Action Tool with Roll-Over Tool Attachment
effective 06/16

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

Preparation
☐ Prepare and mark the hose using Procedure 1100: General Preparation Instructions (pages 9-10).

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. Testing is the only to know for sure if the proper tension has been achieved. However, as a visual indicator, the clamp OD (Outside Diameter) will be equal to or less than the hose OD.
☐ 3. 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.
☐ 4. 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°

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).
☐ 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.
   g. 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.
☐ 7. Test the assembly using Procedures 4000: General Hydrostatic Testing Information (page 50) and 4001: Hydrostatic Testing (page 51).

Tip: Always wear leather gloves to avoid cuts from sharp edges.