Procedure 2100: Installation of Pre-Formed Band Clamps Using Pneumatic Roll-Over Tool

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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. 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.
☐ 3. 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° and 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. Adjust the air tool regulator to its proper setting.
☐ 4. Use the 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.
☐ 5. Inspect results using Procedure 3002: Band Clamp Inspection (page 52).