

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.

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: General Preparation Instructions for illustration.
- 2. Insert the coupling. Refer to step 9 of Procedure 1100: General Preparation Instructions.
- 3. Adjust the air tool regulator to its proper setting.
Note: 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.
- 4. Use 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.
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°
- 5. Inspect results using Procedure 3002: Band Clamp Inspection.
- 6. Test the assembly using Procedures 4000: General Hydrostatic Testing Information and 4001: Hydrostatic Testing.