



# AIRCRAFT MAINTENANCE MANUAL

## V-BAND CLAMPS - MAINTENANCE PRACTICES

EFFECTIVITY: ALL

### 1. General

- A. This section gives the procedures to install V-band clamps.
- B. The procedure for installation of each duct gives the specified V-band clamp.
- C. The procedures in this section are given in the sequence below. The tasks identified with (♦) are part of the Scheduled Maintenance Requirements Document (SMRD).

TASK NUMBER	DESCRIPTION	EFFECTIVITY
20-10-10-910-801-A	V-BAND CLAMPS - INSTALLATION	ALL



EMB145 - EMB135

AIRCRAFT  
MAINTENANCE MANUAL

TASK 20-10-10-910-801-A

EFFECTIVITY: ALL

2. V-BAND CLAMPS - INSTALLATION

A. General

- (1) This task gives the procedure to install V-band clamps on the aircraft.

B. Zones and Accesses

Not Applicable

C. Tools and Equipment

ITEM	DESCRIPTION	PURPOSE	QTY
Commercially available	Torque wrench	To measure the torque	
Commercially available	Nonmetallic mallet	To tap the V-band clamp	

D. Auxiliary Items

Not Applicable

E. Consumable Materials

SPECIFICATION (BRAND)	DESCRIPTION	QTY
MIL-L-19538	Acrylic Nitrocellulose Gloss Lacquer	AR

F. Expandable Parts

Not Applicable

G. Persons Recommended

QTY	FUNCTION	PLACE
1	Does the task	Near the V-band clamp that you will install

H. Preparation

*SUBTASK 841-002-A*

- (1) Make sure that you use the specified V-band clamp part number.

NOTE: Even though the fit can be good, the operating conditions require the correct V-band clamp installation.

- (2) Check if the V-band clamp is not damaged. If necessary, replace-it.
- (3) Check if the flanges that you will attach are not damaged. If necessary, replace the ducts.
- (4) Check if the flanges agree with the seal that you will use.

**CAUTION: MAKE SURE THAT THE DUCTS THAT YOU WILL ATTACH ARE ALIGNED WITH EACH OTHER. YOU CANNOT USE V-BAND CLAMPS TO PULL FLANGES INTO ALIGNMENT.**

- (5) To eliminate misalignment, loosen all adjacent tubing supports.

**I. Installation of V-band Clamps**

**SUBTASK 910-002-A**

- (1) Slip the V-band clamp over the flanged tube end.
- (2) Install the seal, if applicable, and align the flanges.
- (3) Place the V-band clamp on the aligned flanges.
- (4) Tighten the nut to approximately 70% of the specified torque in the manual.

**NOTE: On two-latch assemblies, torque both latches equally.**

- (5) Make sure that the V-band clamp engages equally over the flanges.
- (6) Make sure that the alignment of the flanges is correct.
- (7) Lightly tap the V-band clamp around its circumference with a nonmetallic mallet to distribute band tension.

**NOTE: In case of restrict access, tap the V-band clamp where possible.**

- (8) As torque increases toward 100% of the specified value, lightly tap again around the outer periphery as necessary to prevent unequal loading.

**CAUTION: DO NOT OVERTORQUE THE V-BAND CLAMP TO STOP JOINT LEAKAGE. IF YOU FIND A LEAK, DO A CHECK FOR INCORRECT ASSEMBLY, INCORRECT TORQUE OR DAMAGE TO FLANGES OR SEAL.**

- (9) After you torque the V-band clamp to 100% of specified torque, retap around the band and retorque once more to the specified value.
- (10) Mark the nut and bolt assembly with acrylic gloss lacquer for inspection purposes.

**J. Follow-on**

**SUBTASK 842-002-A**

- (1) Adjust and tighten tubing supports as required.
- (2) Do a leakage test as specified in the procedure for installation of each duct.

