

DBS-1200 MANUAL BANDING TOOL

DMC DANIELS
MANUFACTURING
CORPORATION
DATASHEET

**SEE PAGE 2 FOR IMPORTANT INFORMATION CONCERNING
LIMITED WARRANTY, AND LIMITATION OF LIABILITY.**

APPLICATION

EMI/RFI bands meeting AS85049/128 Rev. A and other OEM standards. The Daniels DBS-1200 Series Manual Banding Tools comply with all performance requirements set forth in AS85049/128 Rev. A.

INTRODUCTION

The Daniels DBS-1200 (M81306/2-01B) Manual Banding Tool is primarily designed for termination of EMI/RFI shielding materials.

1.0 OPERATION

- 1.1 Insert the mechanical band into the DBS-1200 Banding Tool at least 1.75 inches, the band loop shall be oriented on the upper side of the tool's nose (see Figure 1). Actuate the movable handle of the tool one complete stroke to insure that the band has been captured by the gripping mechanism. The band must be double-looped as shown in Figure 6.

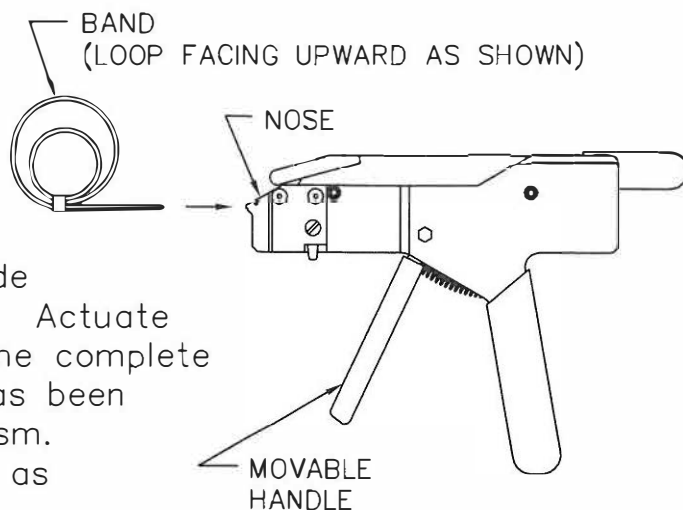


FIGURE 1

- 1.2 Position the connector and the shield assembly through the band allowing the connector to be on the left side of the tool.
- 1.3 Orientate the shield terminations under the band while actuating the movable handle of the tool. Continue tool actuation until the band is snug and tool resistance is felt, then release the movable handle and actuate the handle one full stroke thus locking the movable handle (locking occurs at the predetermined poundage). DO NOT ATTEMPT TO PULL THE HANDLE OF THE TOOL OPEN. WHEN THE BAND IS CUT, THE MOVABLE HANDLE WILL OPEN AUTOMATICALLY.

- 1.4 At any point in the operation prior to the locking of the movable handle, the band may be loosened or removed by disengaging the retention pawl as shown in Figure 2. When actuating the retention pawl, apply a force on the band away from the tool to remove or loosen the band.

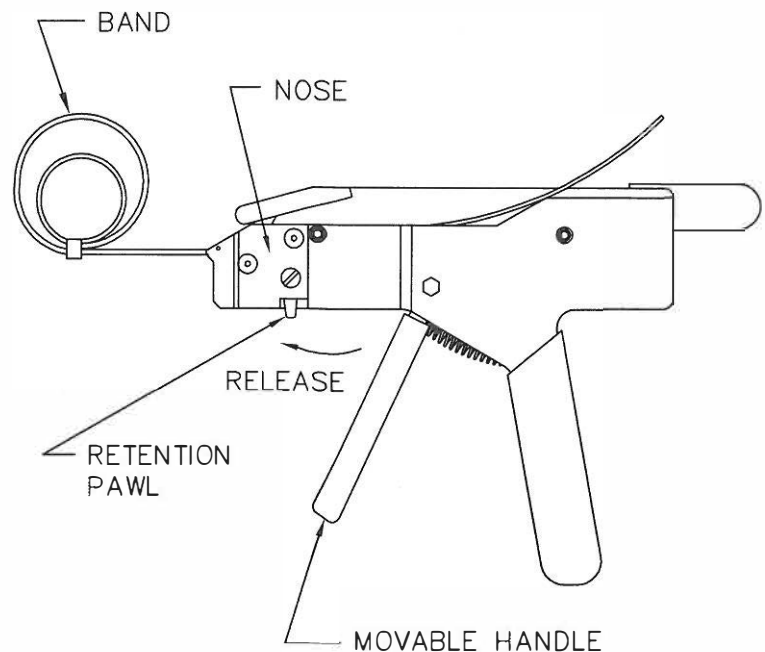


FIGURE 2

LIMITATION OF LIABILITY

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DMC (Daniels Manufacturing Corporation) warrants each new product sold by it to be free from defects in material and workmanship under normal use and service. DMC's obligation under this warranty is limited to the free correction or, at DMC's option, the refund of the purchase price of any such product which proves defective in normal service within ninety (90) days after delivery to the first user, provided that the product is returned to DMC with all transportation charges prepaid and which shall appear to DMC's satisfaction, after DMC's inspection, to have been defective in material or workmanship. This warranty shall not cover any damage to any product which, in the opinion of DMC, was caused by normal wear, misuse, improper operation, tampering, neglect or accident. This warranty is in lieu of all other warranties express or implied. No warranty, express or implied, is made or authorized to be made or assumed with respect to products of Daniels Manufacturing Corporation other than those herein set forth.

- 1.5 To complete the termination, the band must be bent 90° by lifting the cutter lever upwards (Figure 3), and then cut by depressing the cutter lever downwards (Figure 4). WHEN THE CUTTING OPERATION HAS STARTED IT MUST BE COMPLETED PRIOR TO ANY FURTHER MOVEMENT OF THE BAND IN THE TOOL.

NOTE: PREMATURE RELEASE OF THE MOVABLE HANDLE DURING THE BENDING CYCLE IS ACCEPTABLE.

WARNING: WORN CUTTER BLADE REQUIRES ADDITIONAL PRESSURE TO OPERATE AND MAY DAMAGE THE TOOL, OR MAY RESULT IN ACCIDENT OR INJURY. REPLACE CUTTER BLADE PERIODICALLY.

- 1.6 Remove excess band material from the tool by pulling away.

- 1.7 The cut off tab (Figure 5) must be rolled over 180° in a manner which will prevent slippage (Figure 6).

NOTE: DMC RECOMMENDS THE USE OF DBS-R05 ROLLOVER TOOL. SLIPPAGE MAY OCCUR IF ROLLOVER EXCEEDS 180° (Figure 7).

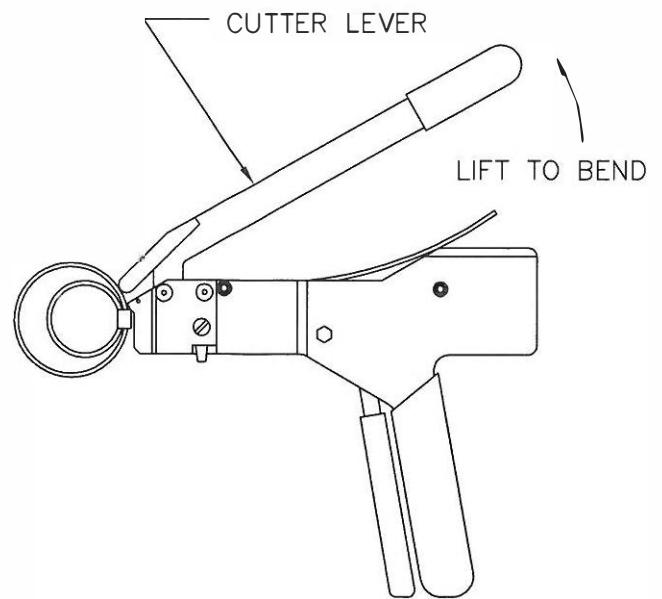


FIGURE 3

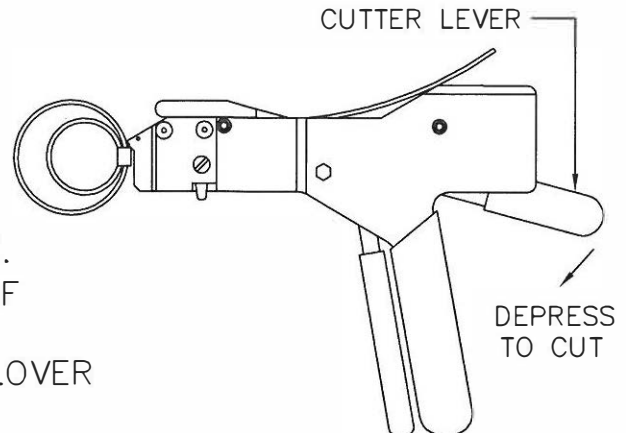


FIGURE 4

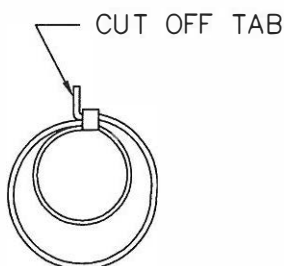


FIGURE 5



FIGURE 6

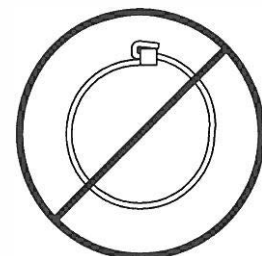


FIGURE 7

2.0 BAND TENSION VERIFICATION

2.1 Checking Band Tension on the tool

- 2.1.1 Place the verification inspection fixture DBS-CG3 (M81306/2-02F) and the manual banding tool so that they may be oriented as shown in Figure 8.
- 2.1.2 Insert a flat band through the band insertion slot of verification inspection fixture until it extends completely through the fixture and the band buckle is resting against the backstop.
- 2.1.3 Insert the band into the nose of the banding tool as described in paragraph 1.1.
- 2.1.4 Repeatedly actuate the movable handle. As you approach the fixture use short strokes until the band is snug. Then use one full stroke and the movable handle will lock.
- 2.1.5 Insert the go member of the Go/No-Go (G752) gage into the gage verification slot of the verification inspection fixture. If the Go member does not insert freely, the tool is exerting excessive force. Likewise, if the No-Go member freely enters the gage verification slot, the tool is below the minimum force limit. If tension adjustment is required, see section 2.2 .
- 2.1.6 To separate, actuate the cutter lever.
- 2.1.7 Remove spent band pieces from both the verification inspection fixture and the banding tool.

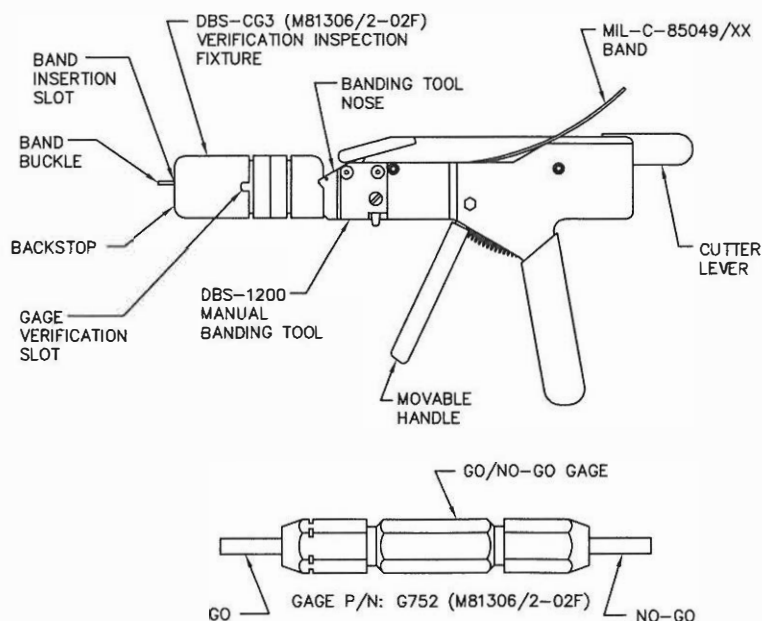


FIGURE 8

2.2 ADJUSTING TOOL TENSION

- 2.2.1 Remove adjustment cover screws and adjustment cover with a 3/32" hex drive wrench (Figure 9).

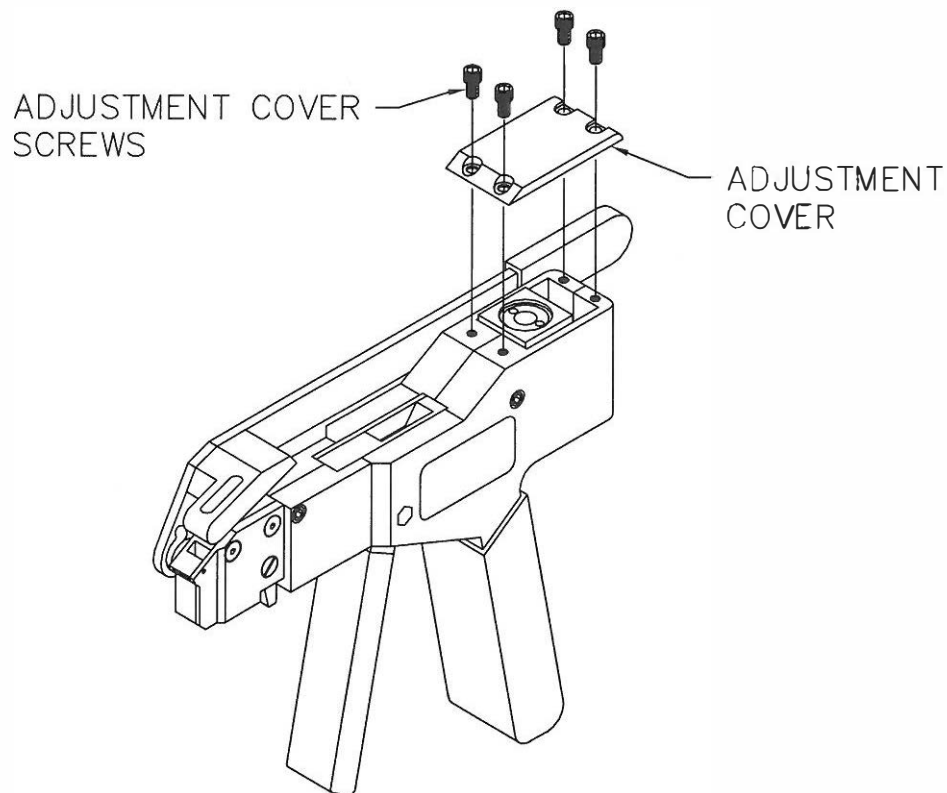


FIGURE 9

- 2.2.2 Adjust tool tension with adjustment wrench (DBS-1100-32).
To increase tension, turn adjustment screw clockwise. To decrease tension, turn adjustment screw counterclockwise (see Figure 10).
Tension should be set at 72 ± 10 lb.
- 2.2.3 Check adjusted tension as described in section 2.1.
- 2.2.4 If adjustment did not bring the tool within proper adjustment, repeat steps 2 and 3 until adjusted correctly.
- 2.2.5 Replace adjustment cover and adjustment cover screws.

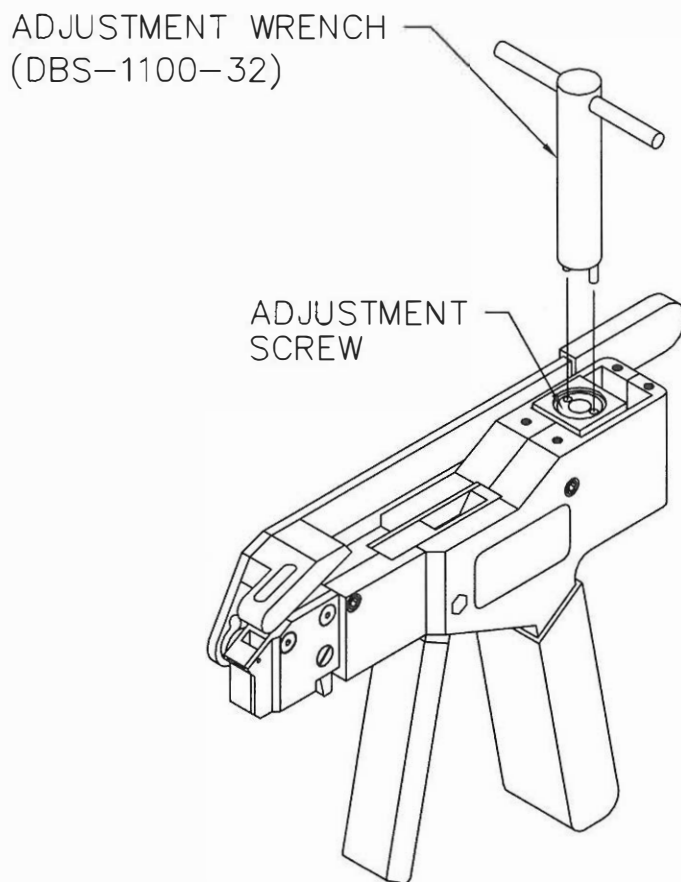
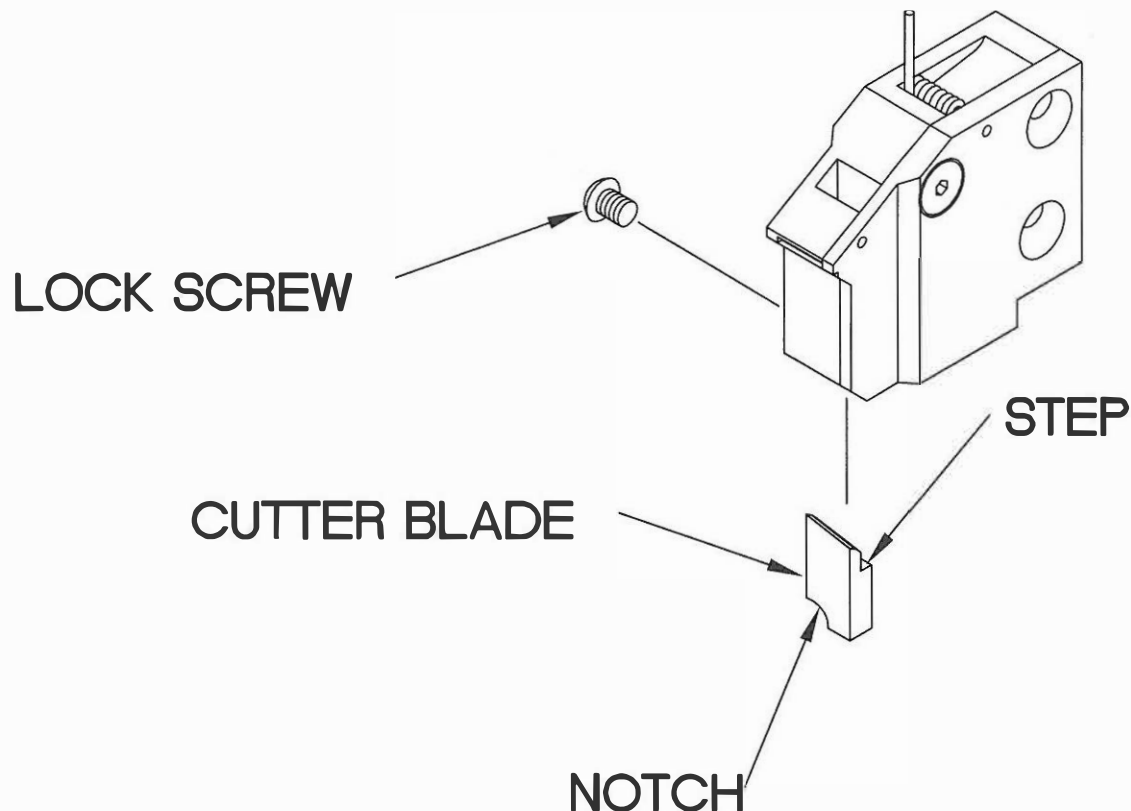


FIGURE 10

3.0 BLADE CHANGE PROCEDURE

- 3.1 Loosen lock screw, located as shown below
- 3.2 Raise Cutter lever to complete upright position
- 3.3 At this point blade will be free to fall from tool nose.
If blade does not fall, use a probe to free the blade.
- 3.4 With blade removed, inspect blade cavity for any debris.
Remove debris. Lubricate blade with a light coat of machine oil.
- 3.5 To reinstall blade, raise cutter lever again to complete upright position, insert blade as shown below, lower cutter lever and tighten lock screw.



4.0 FIELD REPLACEABLE COMPONENTS

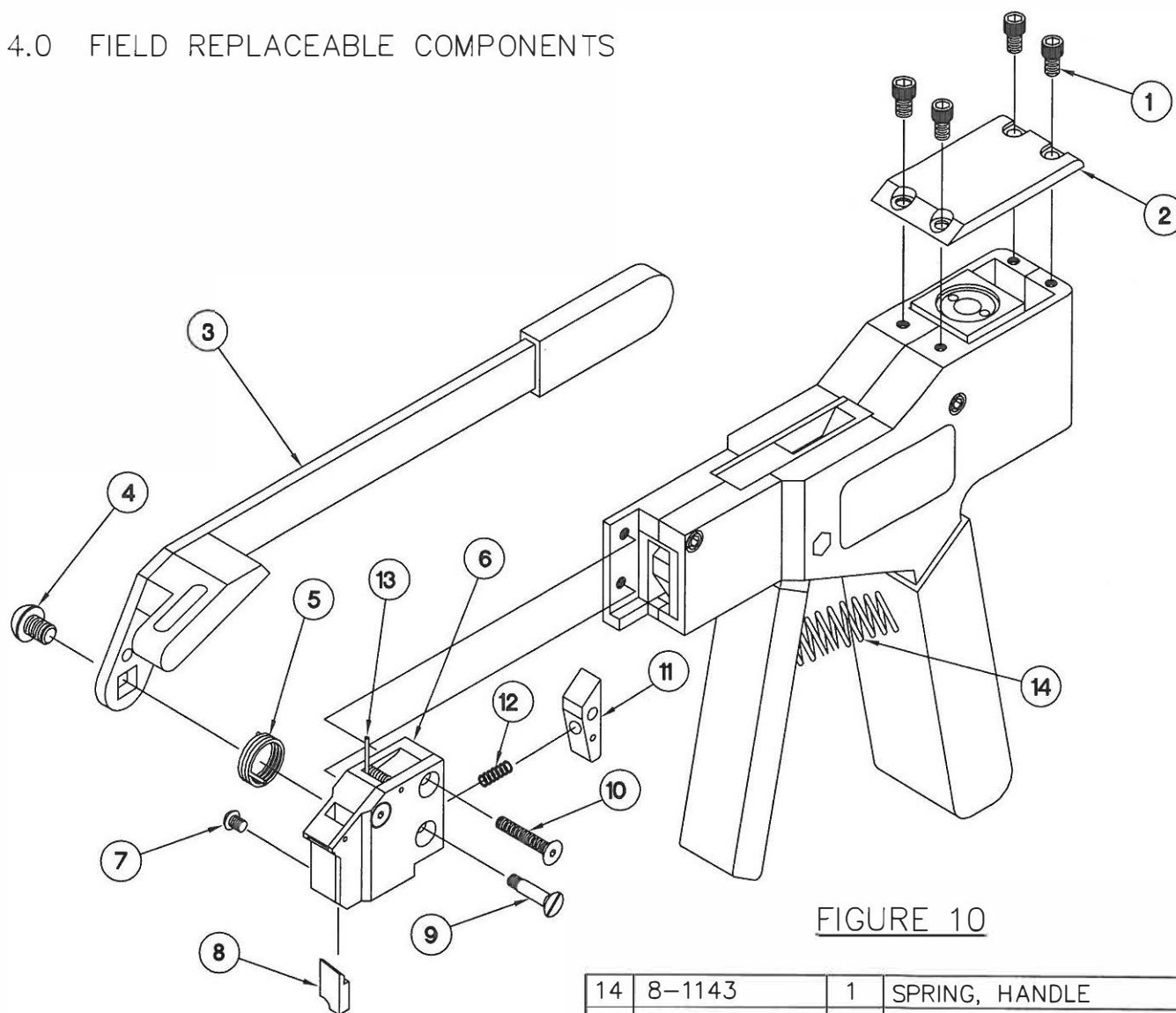


FIGURE 10

14	8-1143	1	SPRING, HANDLE
13	8-1163	1	SPRING, STOP
12	8-1129	1	COMPRESSION SPRING
11	DBS-1100-15	1	RETENTION PAWL
10	1-1032	1	FLAT HEAD SCREW
9	1-1592	1	SHOULDER SCREW
8	DBS-1100-7	1	CUTTER BLADE
7	1-1131	1	STOP SCREW
6	DBS-1200-6SA	1	NOSE SUB ASSEMBLY
5	8-1131	1	TORSION SPRING
4	1-1244	1	COVER LEVER SCREW
3	DBS-1100-12SA	1	CUTTER LEVER SUB ASSEMBLY
2	DBS-1100-3	1	ADJUSTMENT COVER
1	1-1143	4	ADJUSTMENT COVER SCREW
ITEM	PART NO.	QTY.	DESCRIPTION



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