

# DBS-CG1 BANDING TOOL CALIBRATION FIXTURE

**SEE PAGE 3 FOR IMPORTANT INFORMATION CONCERNING  
LIMITED WARRANTY, AND LIMITATION OF LIABILITY.**

## INTRODUCTION

The DBS-CG1 is a self contained test fixture for use in the calibration of DBS-1100 and DBS-1200 (Section 2.0) and PBT1100 and PMBT1200 (section 3.0) banding tools. (Reference individual tool Datasheets for additional information).

### 1.0 CHECKING TOOL CALIBRATION

- 1.1 Place the banding tool calibration fixture (P/N DBS-CG1) in a position where the dial of the gage is facing the operator as shown in Figure 1.
- 1.2 Place the cam handle in the locked position.
- 1.3 Make sure that the "-15" adaptor insert is installed in the tool (supplied with tool)
- 1.4 Insert a piece of unused banding material (with buckle cut off) 3 to 4 inches long through the adaptor plate until it passes beyond the teeth of the gripper jaws and stops. Check engagement of band by pulling on it a few times.
- 1.5 Insert the other end of the band into the nose of the banding tool until engaged.
- 1.6 Activate the banding tool as described in tool Datasheet. Activate tool while guiding tool nose into adaptor plate until tool reaches maximum tension (see tool Datasheet).
- 1.7 Read the position of the indicating needle on the gage. This value represents the maximum tension in lbs. of the tool for that pull. Tool calibration should be  $150 \pm 10.0$  lbs. for the DBS-1100 and PBT1100, and  $72 \pm 10.0$  lbs. for the DBS-1200 and PMBT1200. Should tool calibration be incorrect, proceed to Section 2.0 DBS-1100 or DBS-1200, or Section 3.0 PBT1100 or PMBT1200, but only after completing this Section 1.0.
- 1.8 Release the pressure of the gage by slowly moving cam handle to the release position and the gage needle reads zero.
- 1.9 Push the gripper jaws cam lever clockwise then pull the band from the calibration fixture.
- 1.10 The band may now be removed from the tool.

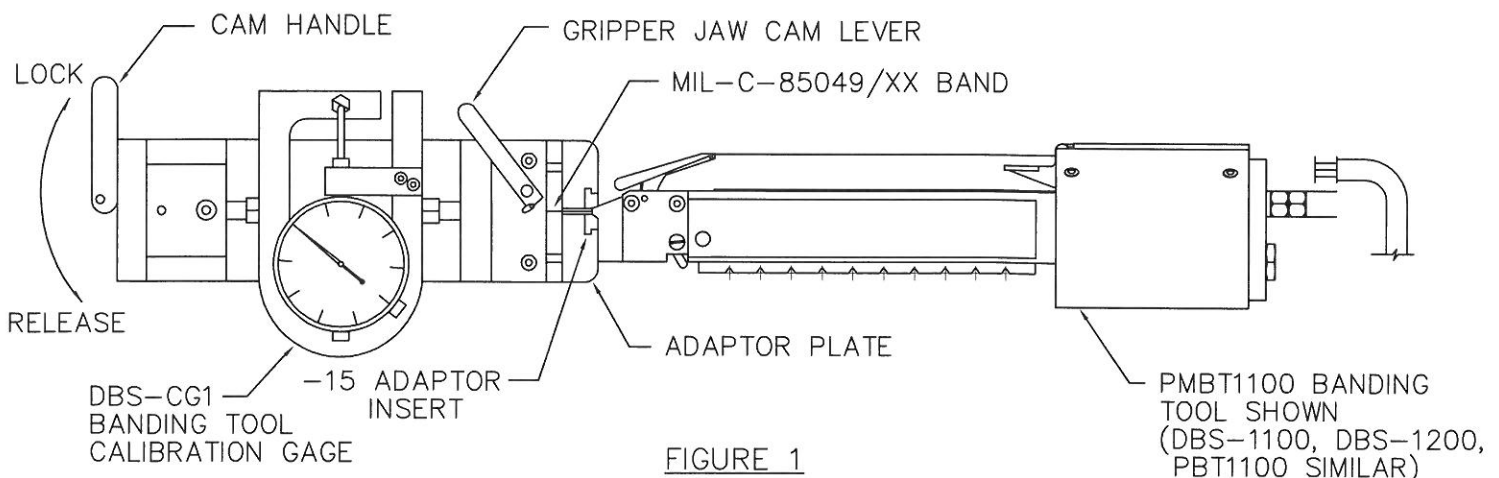


FIGURE 1

## 2.0 ADJUSTING TOOL CALIBRATION (DBS-1100 or DBS-1200)

- 2.1 Remove adjustment cover screws and adjustment cover with a 3/32" hex wrench (see Figure 2).
- 2.2 Adjust tool calibration with adjustment wrench (P/N DBS-1100-32). To increase tension, turn adjustment screw clockwise. To decrease tension, turn adjustment screw counterclockwise (see Figure 3).
- 2.3 Check adjustment calibration as described in section 1.0.
- 2.4 If adjustment did not bring tool within proper calibration, repeat steps 2.1 through 2.3 until calibrated correctly.
- 2.5 Replace adjustment cover and adjustment cover screws.

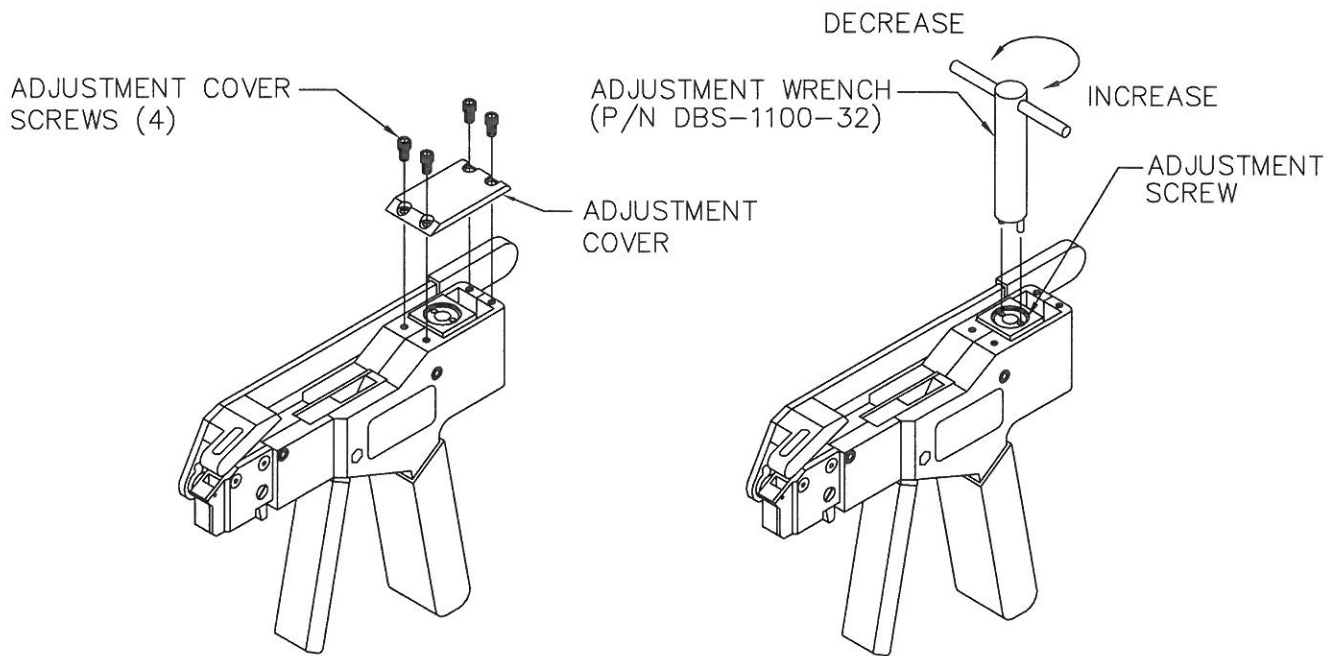


FIGURE 2

FIGURE 3

## 3.0 ADJUSTING TOOL CALIBRATION (PBT1100 or PMBT1200)

- 3.1 Set input air supply to 90-120 psi (6.2-8.3 BAR).
- 3.2 Adjust regulator subassembly (see Figure 4) through adjustment access hole using a flat blade screwdriver - clockwise to increase reading and counter-clockwise to decrease reading.
- 3.2 Check adjustment as described in Section 1.0.

- 3.4 Reading on regulator subassembly should fall within green range of pressure gage when banding tool calibration gage of DBS-CG1 is reading correct tension value.

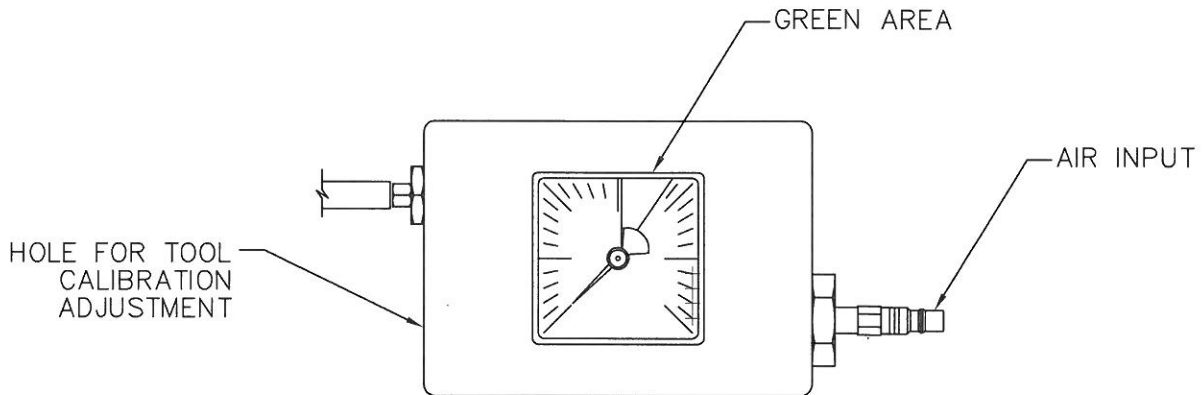


FIGURE 4

DMC offers complete refurbishing and recalibration services.

DMC specially engineers and manufactures complete tool kits to satisfy individual customer requirements, such as total aircraft support, general shop maintenance or production, on board ship and vehicle service, etc.

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