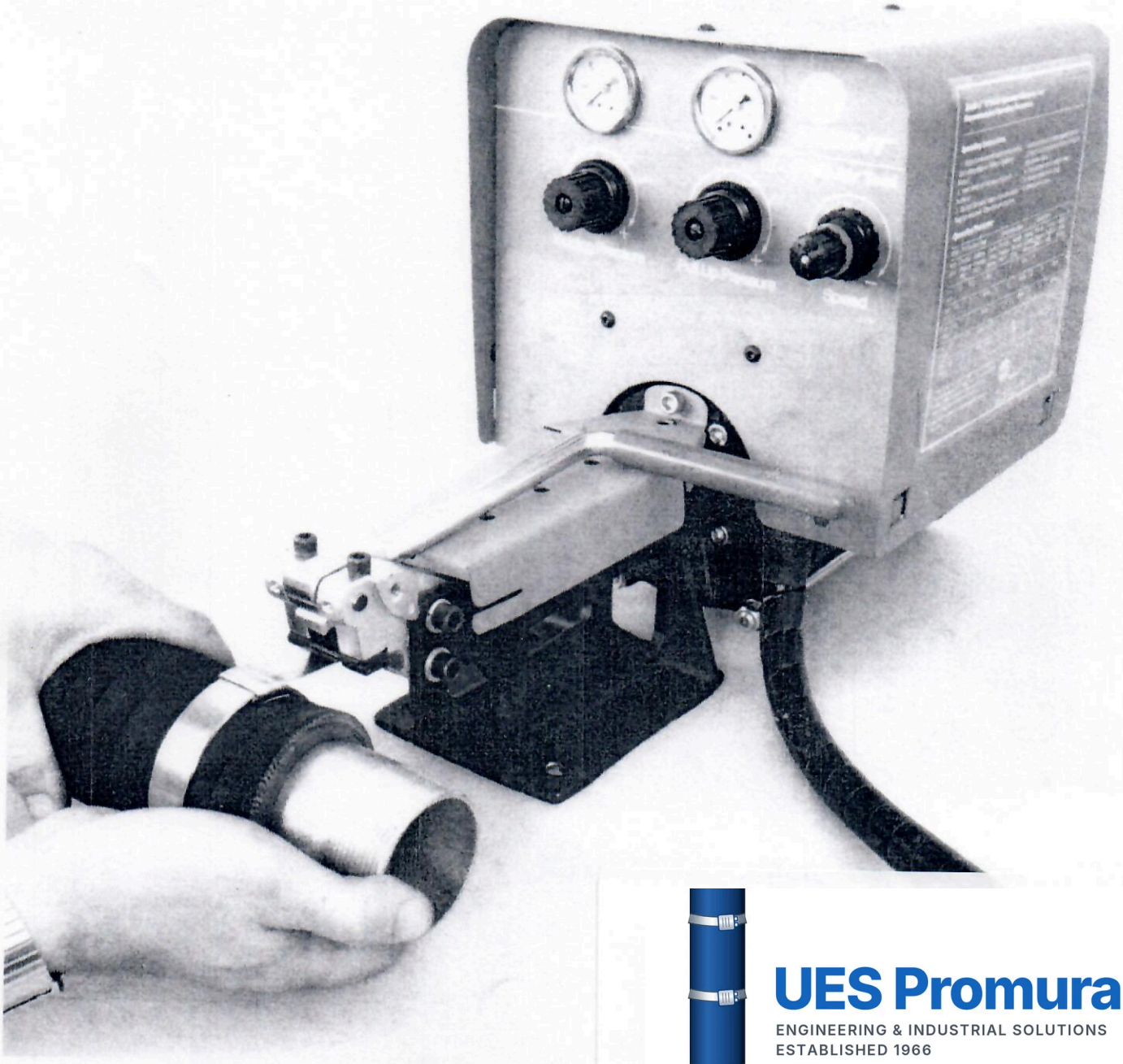
BAND-IT®

S750 Air Tool

Operators Manual



UES Promura

ENGINEERING & INDUSTRIAL SOLUTIONS
ESTABLISHED 1966

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Introduction

The Band-It S750 Air Tool is designed for volume production clamping of all widths of Band-It Jr. Preformed clamps.

With proper maintenance and using the recommended clamps, the Band-It S750 Air Tool will give many years of good service.

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S750 Air Tool Specifications

Air Line Requirements

Safety Procedures

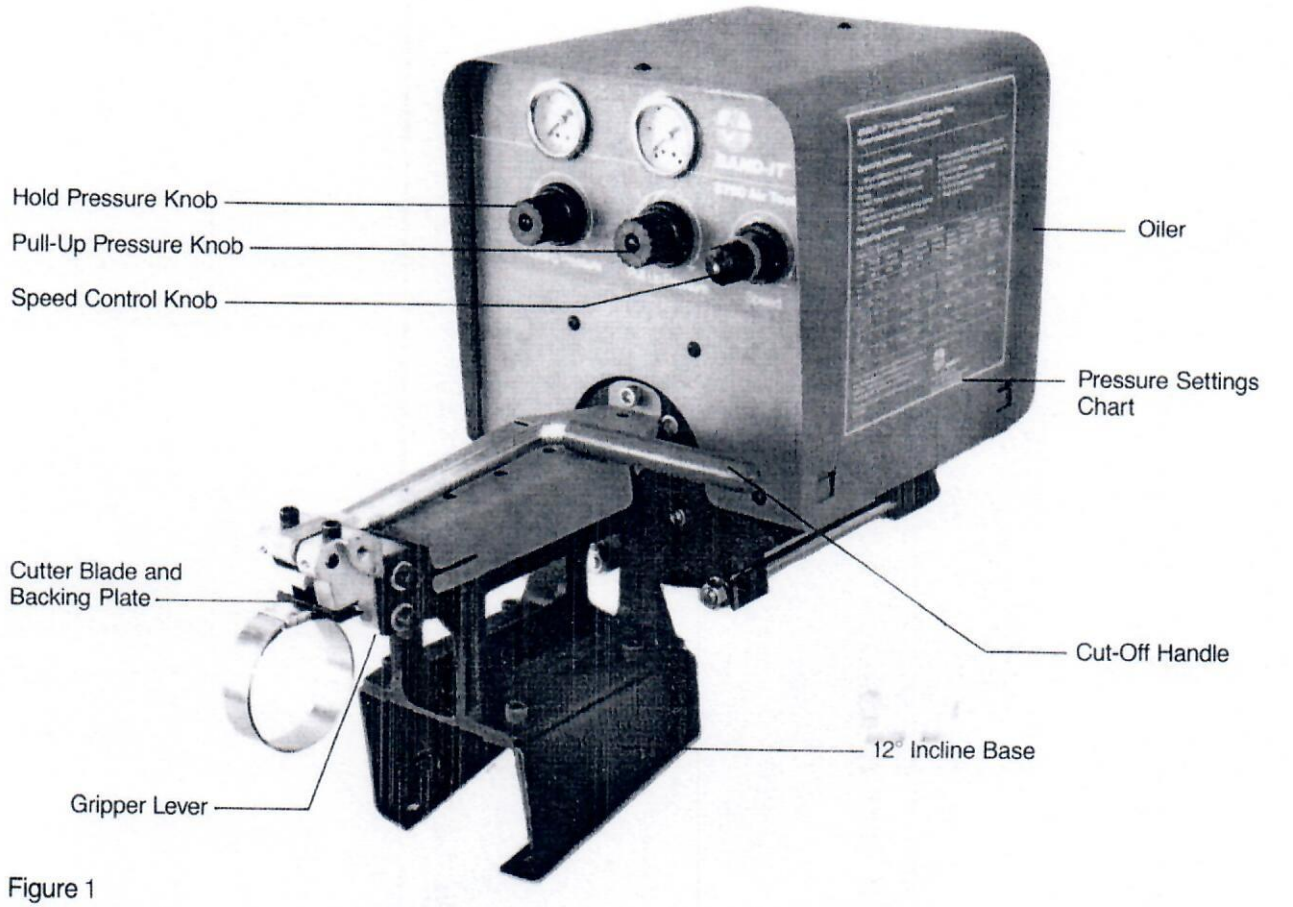
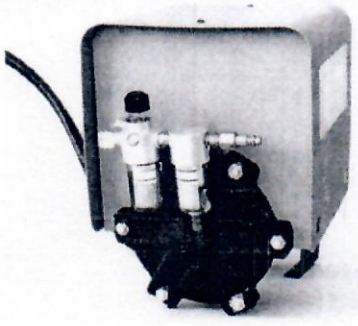


Figure 1

Air Line Requirements

Air Line Pressure: 100 PSI Minimum, 150 PSI Maximum
Consumption: 3-5 CFM
Line Size: ¼" I.D. Minimum
Connection: ¼" N.P.T.
Filter/Lubricator: Located in Air Supply in back of Air Tool.
Lubricant: SAE 10 Wt. Non-Detergent Motor Oil

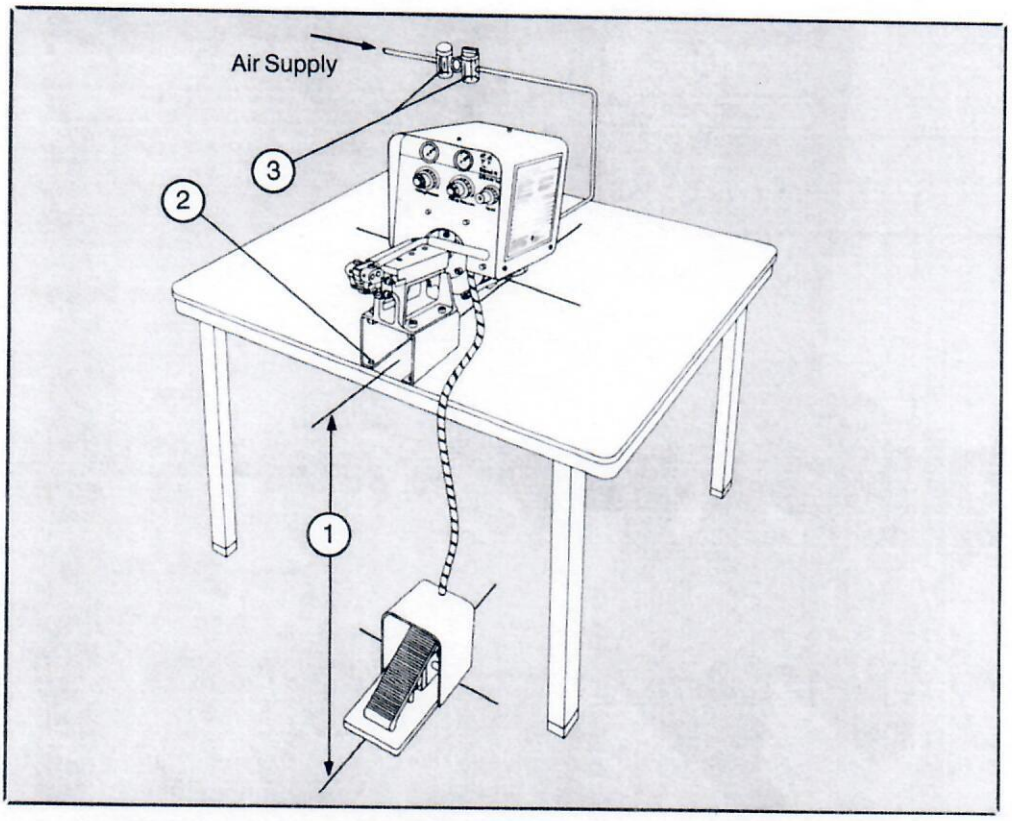


Safety Procedures

1. Familiarize yourself with operating procedures before operating the S750 Air Tool.
2. Do not operate tool without cover in place.
3. Use only recommended Band-It preformed clamps.
4. Do not exceed recommended pressure settings. Excess pressure may cause sudden clamp failure during application or result in an unsafe clamp.
5. Always keep fingers clear of clamp during application.
6. Disconnect air supply before servicing air tool.
7. Tool must be firmly mounted (see Installation Instructions, Page 4).
8. Safety glasses or goggles should be worn when applying clamps.
9. Always keep tool in good operating condition.

Inspection and Installation

Inspection
When removing foot control and tool from shipping carton, check for shipping damage which should be reported to the carrier.



Installation
1. Recommended table height is 34" to 40". This is the optimum range for applying clamps to most items. Make sure the side clearance is adequate for items to be clamped.

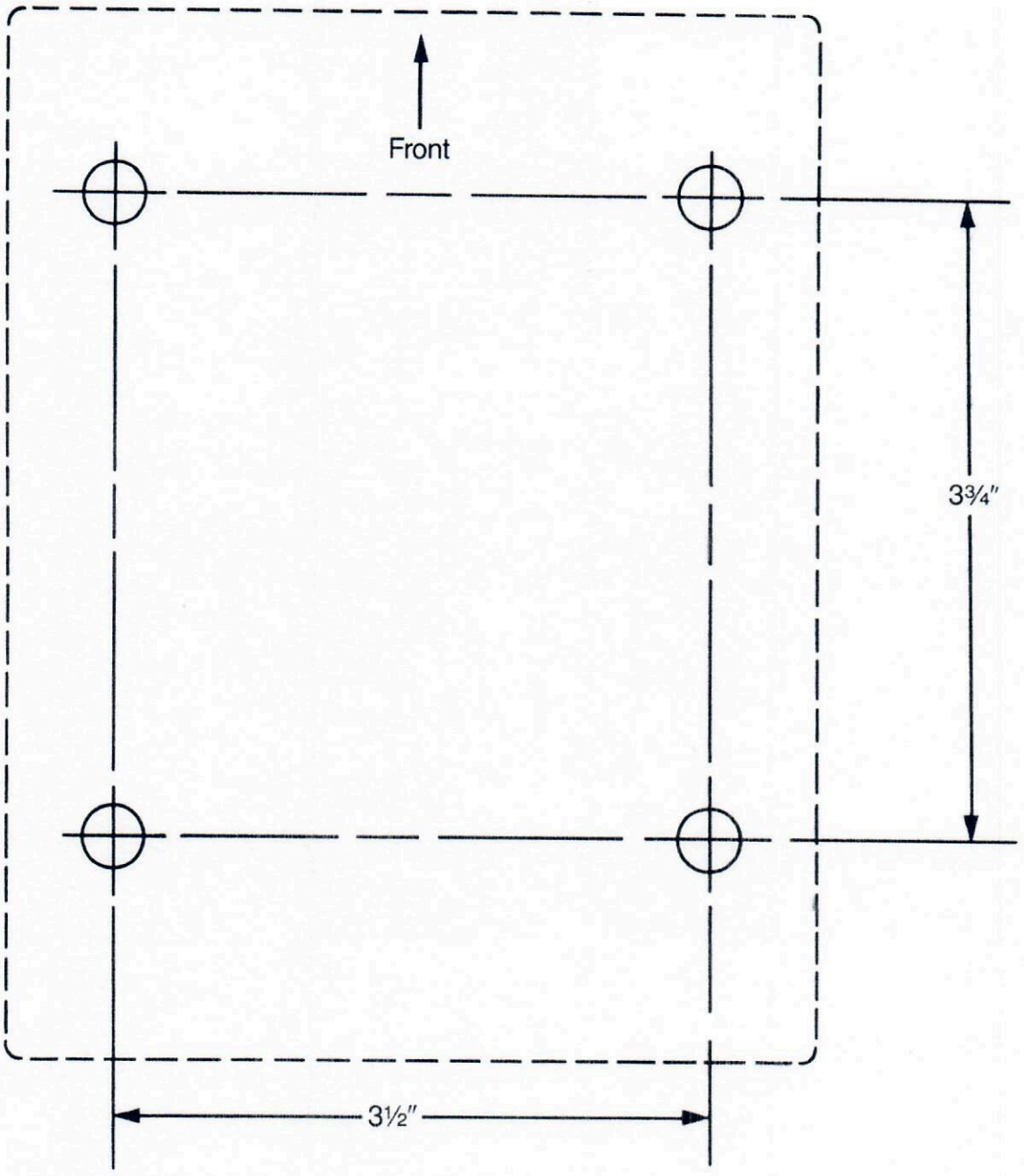
2. The S750 Air Tool must be firmly secured to work bench. Use 5/16" diameter fastening hardware (not supplied with air tool). Air tool may be mounted at a 12° angle using the inclined base (as shown) or horizontally by mounting base casting directly to surface. Both mounting patterns are identical. Refer to Figure 3, Mounting Template.

3. The incoming air supply must come through a filter/lubricator, located no more than 30' from the air tool.

Use of the S750 Air Tool without a filter/lubricator voids the warranty.

Mounting Template

Figure 3



- S750 Air Tool must be firmly secured!
- Use 5⁄16″ fastening hardware.
- Do Not use S750 Air Tool without a filter/lubricator.

S750 Operating Pressure Chart

Speed Control Setting

Operating Pressure Chart

BAND-IT® S750 Air Operated Clamping Tool Recommended Operating Pressures

Operating Instructions

1. Set pull pressure and speed control setting. Set holding pressure. Refer to Operators Manual.
2. Insert clamp tail into nose of tool with buckle up.
3. Depress toe end of treadle to tension clamp. Keep toe end down. When pressure drops to holding pressure roll clamp upwards to cutting position. Pull cut off lever to lock and cut clamp.
4. Depress heel end of treadle to reset.
5. Remove scrap end of clamp.
6. Keep cover in place.

Operating Pressures

Width	201 Stainless Steel			316 Stainless Steel			Carbon Steel		
Inch (mm)	Pull Up Pressure* (PSI)	Holding Pressure (PSI)	Speed Control Setting	Pull Up Pressure* (PSI)	Holding Pressure (PSI)	Speed Control Setting	Pull Up Pressure* (PSI)	Holding Pressure (PSI)	Speed Control Setting
1/4 (6.4)	15	4	Blue	15	4	Blue	—	—	—
3/8 (7.5)	25	5	White	20	5	White	25	6	Blue
1/2 (12.7)	40	6	White	35	6	White	40	7	White
5/8 (15.9)	50	7	Red	40	7	Red	50	8	White
3/4 (19.1)	60	8	Red	50	8	Red	60	9	Red

*Note: These are maximum recommended pressures. It may be necessary to reduce pressure and speed control settings. Refer to operator's manual for further operations and maintenance instructions.

Only Band-It Clamps are recommended for use in this tool.

Manufactured in U.S.A. by:

BAND-IT

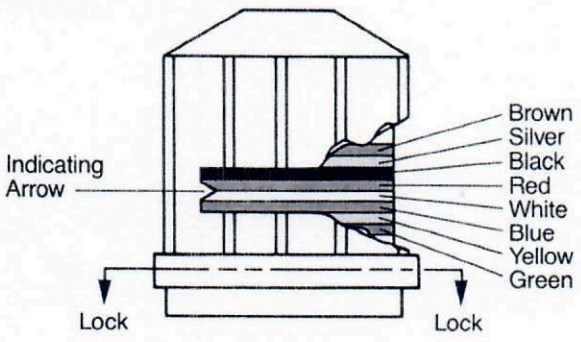
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Figure 4

Speed Control Setting

Figure 5



Operation and Setting Controls

Refer to Figure 4 or cover decal for recommended pressure settings.

Rule: Always approach pull-up pressure setting from below and hold pressure setting from above recommended value.

1. Set speed control to blue for calibration. See Figure 5, Page 6.

2. Set pull-up pressure: pull knob and turn clockwise to recommended pull-up pressure. Approach pressure setting from *below* by *increasing* pressure.

3. Set holding pressure:
a. With foot pedal at rest, increase pressure until it is above recommended setting.
b. Slowly lower pressure by turning knob counterclockwise to recommended setting.
c. Check pressure setting by cycling tool until hold pressure gauge stops. Pressure setting must be approached from *above* by *lowering* pressure.

4. With foot treadle still depressed, verify all settings and adjust if necessary.

5. Reset cylinder by drepessing heel end of foot treadle. Remove foot.

6. Set speed control to recommended color setting.

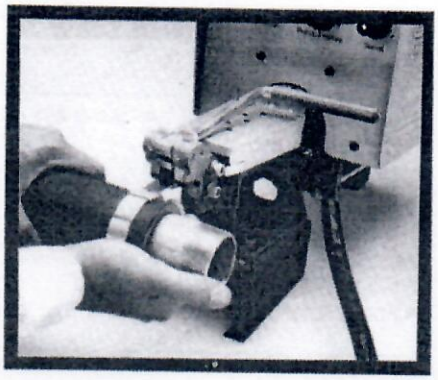
7. Repeat steps 3, 4, and 5. At pressure kickdown, verify all settings and adjust if necessary.

Caution!

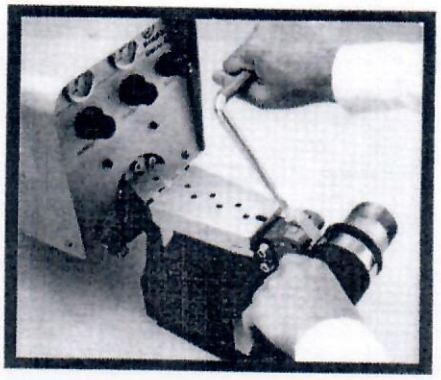
8. Always allow air to completely exhaust after resetting tool and before pull-up. Failure to let air completely exhaust may result in clamps not pulling up tight.

9. Drip-Rate is verified by cycling the machine. If one drop falls in sight glass within 10-25 cycles, the lubricator is correctly adjusted.

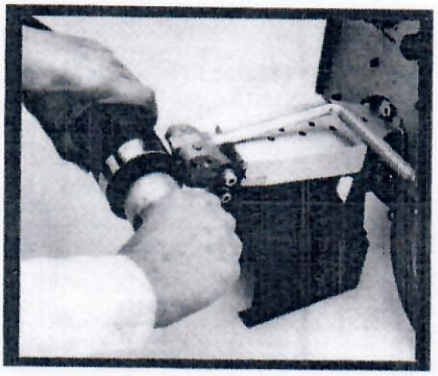
Clamp Application



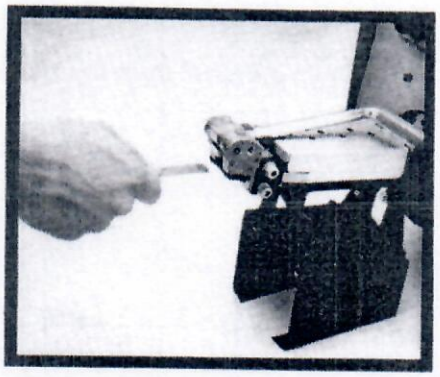
1. Insert clamp tail into nose of tool with buckle on top.



3. With clamp in full roll-up position, making sure shear hook is engaged onto buckle, pull cut-off lever to lock and complete clamp.



2. Depress toe end of foot pedal to tension clamp, keep toe end down. When pressure drops to holding pressure, roll clamp up.



4. Depress heel end of foot pedal and remove scrap end of clamp.

IMPORTANT ADVICE AND WARNING TO USER.
READ BEFORE APPLYING CLAMPS.

When clamping a hose end, remember that a tighter clamp keeps the fitting more secure, but excess tension could damage the hose. Fitting stem must have prominent barbs for proper retention inside the hose, but must not be sharp to prevent cutting into the hose. Hose, fitting and clamp must be compatible with each other and the working environment used in. If in doubt consult the hose or fitting manufacturer or call Band-It.

Clamping objects other than hose require similar precautions.

CAUTION: Improperly tightened clamps may result in dangerous hose assemblies, which could cause injuries or property damage.

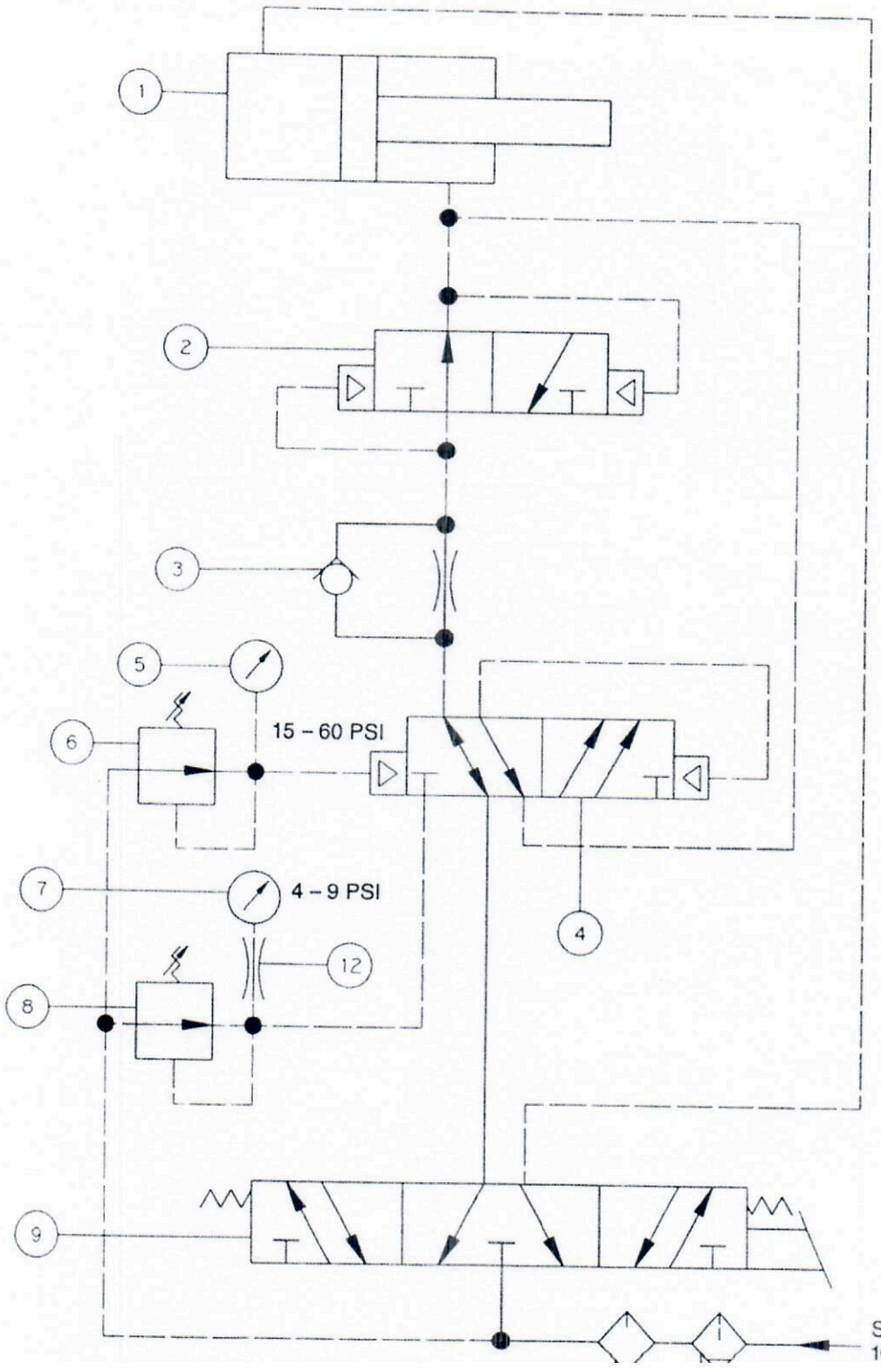
CAUTION: Abuse or use of a hose outside the manufacturers recommended conditions may cause it to quickly deteriorate and become a safety hazard. This could result in serious injury or property damage. Inspect and test hose assemblies frequently. Repair or replace at the slightest sign of damage or deterioration.

Troubleshooting

Problem	Probable Cause	Correction
1. Sharp or scarred edges on clamp. Metal deposits on underside of tail at buckle edge.	Loose or broken cutter blade/backing plate. Sharp edge on cutter blade due to wear.	Make certain all fasteners are tight. Replace any broken or chipped blades. Hone sharp edge to a smooth radius.
2. Tail is broken at approximately 45°. Clamp material stretched or thinned at break.	Pull-up pressure set higher than recommended.	Reduce pull-up pressure to the recommended maximum or slightly lower. Apply clamp and adjust it if necessary.
3. Clamp tail breaks during roll-up.	Holding pressure set higher than recommended. Roll-up is attempted before pressure has dropped to appropriate level.	Reduce holding pressure to the recommended maximum or slightly lower. Apply clamp and adjust if necessary. Wait with roll-up until after kick down occurs.
4. Clamp pulls in a jerky manner.	Pull-up pressure set lower than recommended.	Increase pull-up pressure.
	Clamp not inserted properly.	Make sure clamp is straight and level when inserting.
	Band gripper pin loose.	Tighten set screw.
	Pull-up cylinder needs lubrication.	Check filter/lubricator and add oil if necessary.
5. Clamp pulls but does not lock.	Holding pressure set higher than recommended.	Reduce holding pressure to the recommended maximum or slightly lower. Apply clamp and adjust if necessary.
6. Clamp tail slips in band gripper lever.	Broken or worn teeth on band gripper lever.	Replace band gripper lever.
	Spring stretched out.	Replace spring.
	Tripper plate stuck due to dirt or lack of lubrication.	Clean and/or relubricate.
7. Clamp tail catches as tool resets.	Clamp tail does not align properly during reset.	Operate the tool and keep the foot control valve depressed. Reach under piston rod and locate band gripper lever. Rotate lever toward clamp head and allow tail to fall from tool. If tail remains stuck, use pliers to grasp tail and carefully remove. Release foot control. (Never position fingers anywhere but on gripper lever and keep foot control valve depressed.)
8. Tool doesn't cut-off clamp.	Loose or broken cutter blade.	Tighten or replace cutter blade.
	Improper holding pressure.	Adjust holding pressure to recommended level.
	Improper pressure on incoming air supply.	Check and adjust incoming air supply. Note: Minimum supply pressure is 100 PSI.
9. Tool takes excessive time for clamp pull-up.	Air leak from loose connection or worn parts.	Tighten loose connections and/or replace worn parts.
10. Clamp tail cannot be inserted into tool.	Tripper plate may be broken or binding.	Adjust or replace tripper plate.
11. 1/4 or 3/8 clamp is pulled up but will not tighten.	Back-up plate installed backwards.	Turn back-up plate around.
	Buckle wedges between cutter and back-up plate.	Install special 1/4-3/8 back-up plate (J859) or 1/4-1/4 (J861).

If the problem persists, contact UES Promura on +61 3 9547 5833.

Schematic—S750 Air Tool



Parts List

Description	Find No.
Cylinder, Pull Up	1
Valve, Quick Exhaust	2
Valve, Flow Control	3
Valve, Double Air Piloted	4
Gauge, 0-100 PSI	5
Regulator, Pull Up	6
Gauge, 0-15 PSI	7
Regulator, Holding	8
Valve, Foot	9
Lubricator	10
Filter	11
Restrictor	12

——— 3/8" O.D. Tube

— — — 1/4" O.D. Tube

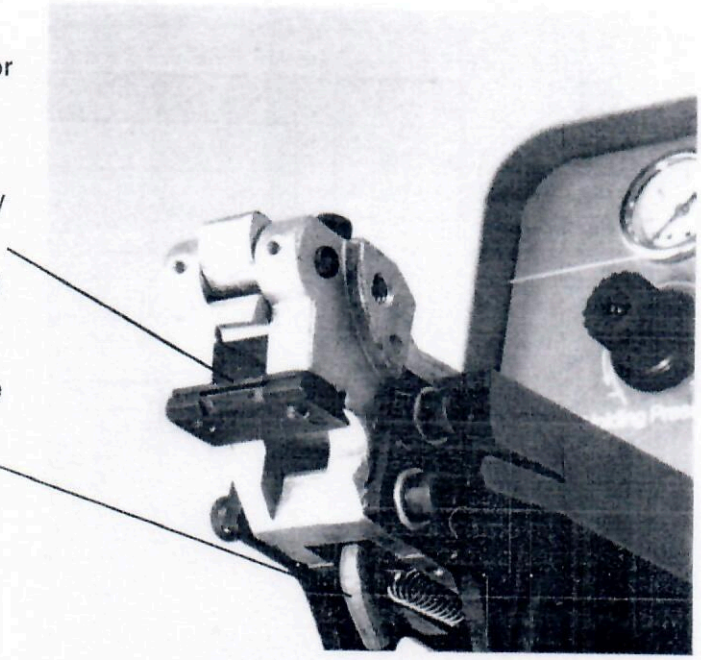
Maintenance

1. For best results and proper functioning of the air tool, a filter/lubricator must be used on the air supply or in line within 30 feet of the air tool. The warranty is voided if a filter/lubricator is not used.

2. Before using air tool, check to see that the blade and backing plate are fully tight. Loose bolts can easily cause breakage of blade and backing plate.

Cutter blade and back-up plate edges must be kept clean and free of metal shavings. Hone smooth at first sign of clamp gouging.

3. Clean gripper occasionally. Particles and dirt on the gripper lever can cause it to slip off the clamp tail. To remove gripper lever, slacken off set screw and tap out pin.



The Band-It S750 Air Tool, although durable, does need periodic maintenance and repair. If this tool needs a minor repair or complete overhaul (listed below), it should be sent to UES Promura for repair support.

Minor Repair

1. Test and inspect tool to determine source of problem.
2. Clean exterior of tool.
3. Replace worn or damaged, external expendable parts.
4. Adjust, test and inspect.

Parts replaced are invoiced at current parts prices.

Overhaul

1. Totally dismantle tool and clean all parts.
2. Refinish external parts such as castings, cylinder, etc.
3. Inspect all parts for wear and damage. Replace as needed.
4. Replace all expendable parts such as gaskets, O-rings.
5. Reassemble, adjust, test and inspect.

Expendable parts replaced at no extra charge. All other parts replaced are invoiced at current parts prices.

Maintenance Check List

Warranty



Maintenance Check List

Component	Check	Action	Frequency
Clamp Head	Check for loose mounting screws.	Tighten all screws and fasteners.	Daily
Cutter Blade and Backing Plate	Check to see if blade is loose or has any broken or chipped edges.	Tighten all screws and fasteners. Replace if necessary.	Daily
Filter/Lubricator	Check for build-up of dirt, etc. Check for low, contaminated or discolored lubricant.	Fill with SAE 10 wt. oil. Drain and clean with soap and water. Refill with SAE 10 wt.	Every 2,000 clamps
Eccentric Lever	Check for build-up of dirt, etc., in teeth.	Remove and clean with small pointed object, knife blade, etc.	Every 2,000 clamps
Cylinder	Check for build-up of dirt, contaminants on piston rod seals.	Clean with soap and warm water.	6 Months
Tripper Plate	Check for build-up of dirt, contaminants, etc.	Clean and apply type G-N lubricant or equivalent.	6 Months
Air Exhaust Mufflers	Check for build-up of dirt, contaminants, etc.	Remove and clean with non-flammable degreaser.	6 Months

Warranty

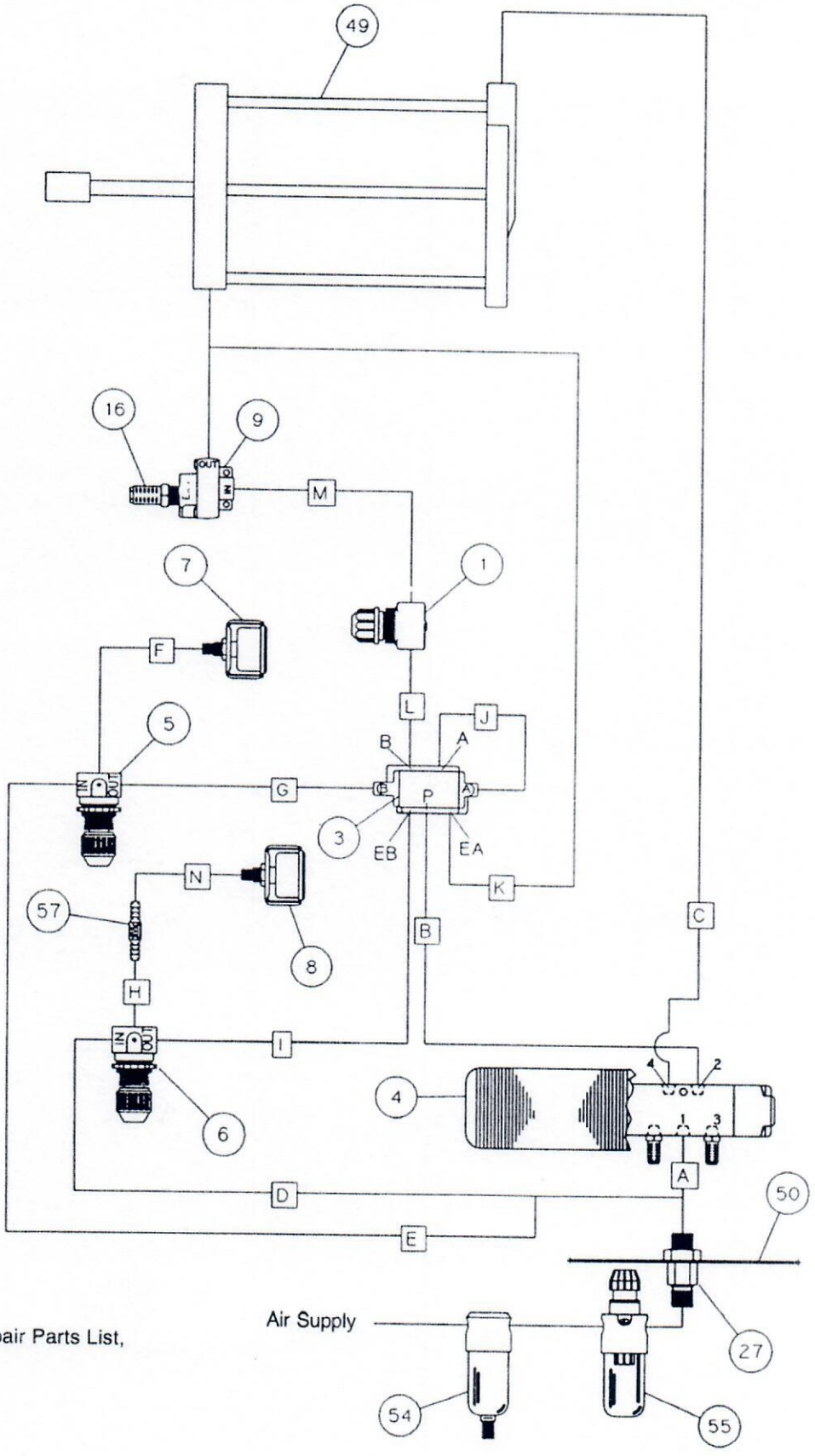
Band-It tools are warranted against defective workmanship and/or materials for a period of one year from date of purchase. This warranty is void if the tools are altered or abused in any manner, including lack of lubrication, or used for any purpose or in any way not specifically covered by the instructions packed with each tool.

Any performance data published in Band-It literature is based on laboratory tests which cannot duplicate conditions that may be encountered in field installations. Such conditions may vary results substantially from those shown, such as abuse in handling and installation; failure to follow recommended handling and installation practices; abnormal environmental conditions; neglect of operating condition of Band-It tools or non-recommended combinations of Band-It products. Band-It cannot be responsible for performance characteristics resulting from such variables. Representations by any person of performance data other than as set forth herein or otherwise in writing by Band-It are unauthorized and are utilized at customer's risk.

This is Band-It's sole warranty and is in lieu of all other warranties, expressed or implied, which are hereby excluded, including in particular all warranties of merchantability or fitness for a particular purpose. Band-It shall not be liable for any loss, damage or expenses directly or indirectly related to the use of its tools or from any other cause or for consequential damages. It is expressly understood that Band-It is not responsible for damage or injury caused to other products, property, or persons, by reason of the use of its tools.

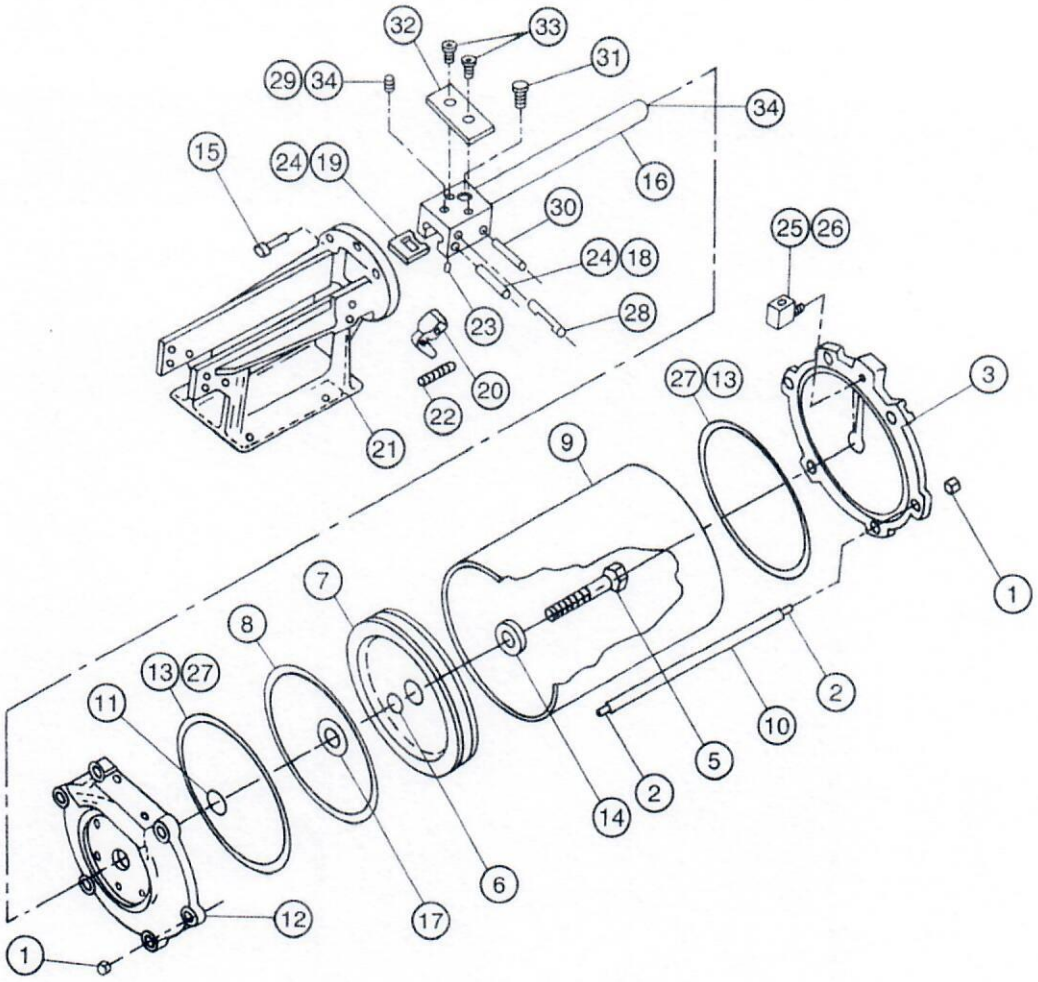
S750 Air Flow Diagram

Legend	Find No.
Valve, Flow Control	1
Valve, Double Air Piloted	3
Valve, Foot	4
Regulator, Pull Up	5
Regulator, Holding	6
Gauge, 0-100 PSI	7
Gauge, 0-15 PSI	8
Valve, Quick Exhaust	9
Muffler, Air Exhaust	16
Adapter Bulkhead	27
Cylinder, Pull Up	49
Panel, Rear	50
Filter	54
Lubricator	55
Restrictor	57
Tubing	□



Note: Refer to S750 Air Group Repair Parts List, Page 15, for Find Numbers.

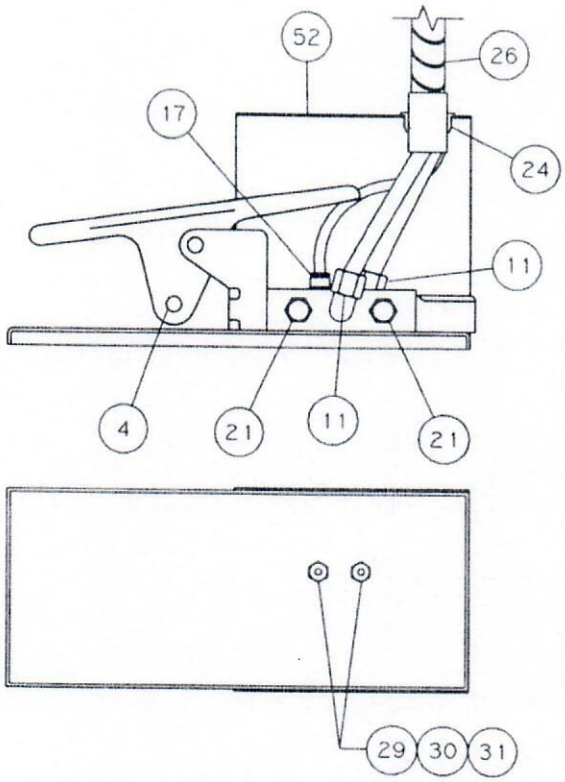
Tool Base and Air Cylinder



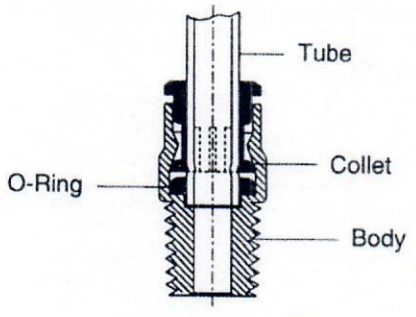
Tool Base and Air Cylinder Repair Parts List

Qty.	Part No.	Description	Find No.
8	J67687	Nut, Hex $^{3}/_{8}$-24	1
		Compound, High Strength	2
1	S47987	Cover Assembly, Cylinder Rear	3
1	S44987	Bolt, Hex Head ½-13 x 2-½	5
1	S45587	O-Ring, ½ Dia.	6
1	S44687	Piston, Cylinder	7
1	J63287	O-Ring, Piston	8
1	J60767	Tube, Cylinder	9
6	J62187	Bolt, Cylinder Tie	10
1	J63187	O-Ring, Piston Rod	11
1	S21877	Head, Pull-Up Cylinder Front	12
2	J66687	Gasket, Cylinder	13
1	S45687	Washer, Flat $^{17}/_{32}$ I.D. x 1-$^{1}/_{16}$ O.D.	14
10	J90987	Screw Soc. HD. $^{5}/_{16}$ - 18 x $^{7}/_{8}$ Lg.	15
1	S45389	Rod Assem., Piston	16
1	S44887	Spacer, Stroke Limiting	17
1	S21587	Pin, Clamp Tail Gripper	18

Qty.	Part No.	Description	Find No.
1	S45087	Plate, Clamp Tail Gripper Trip	19
1	S45187	Gripper, Clamp Tail	20
1	S21789	Base, Tool	21
1	S52687	Spring, Clamp Tail Gripper Return	22
1	J64887	Screw, Soc. HD. Set #10-32 x $^{3}/_{16}$	23
		Lubricant, Moly Paste	24
1	S48387	Elbow, ¼ NPTM x ¼ NPT FM	25
		Compound, Teflon Filled Sealant	26
		Compound, Gasket & Sealing	27
1	J66487	Pin, Clamp Tail Gripper Back-Up	28
1	J65487	Screw, Soc. HD. Set $^{5}/_{16}$-24 x $^{3}/_{8}$	29
1	J61187	Pin, $^{1}/_{8}$ x 1 - $^{3}/_{8}$ Spring	30
1	J67287	Screw, Soc. Head Cap. ¼ - 28 x ½	31
1	J61967	Plate, Rod Guide	32
8	S48087	Screw, Socket, Button H.D., 10-32 x $^{3}/_{8}$	33
		Compound Medium Locking	34



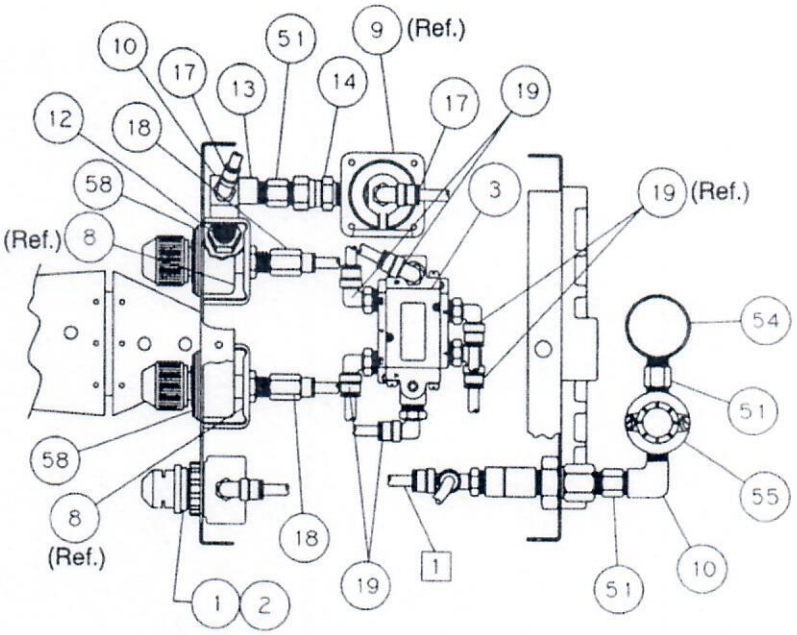
Foot Control

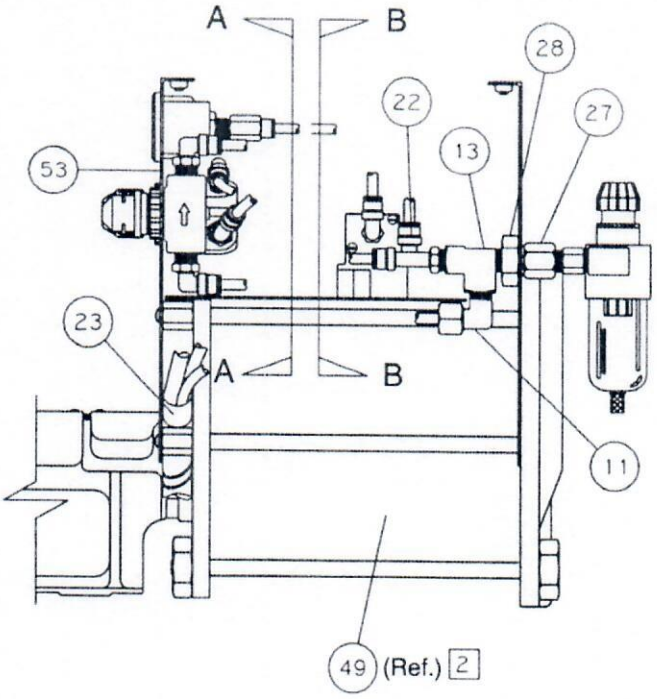


View C [1]

Push-In Fitting

To disconnect tubing from fitting, depress the collet ring with two fingers and withdraw tube. To connect tubing to fitting, push tube in.



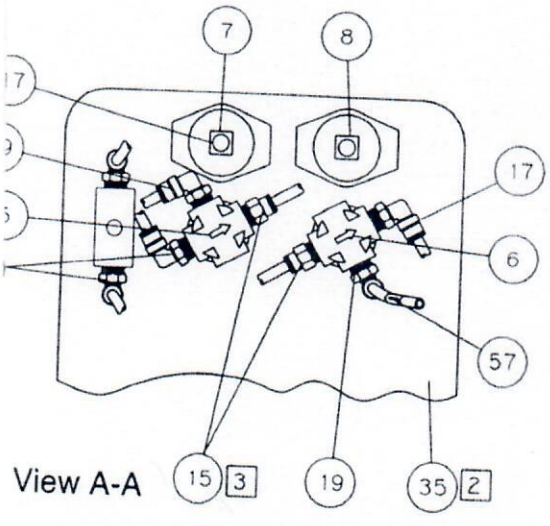


Side View

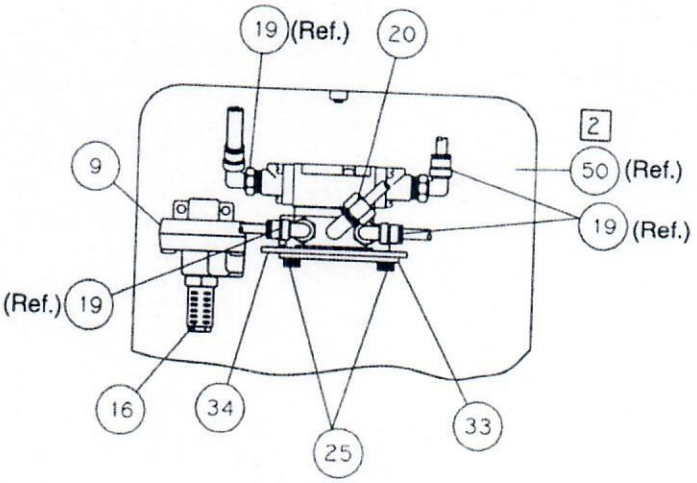
S750 Air Group Repair Parts List

Qty.	Part No.	Description	Find No.
1	S47087	Valve, Flow Control	1
1	S50287	Ring, Panel Mount for PC	2
1	S47187	Valve, Double Air Piloted	3
1	S47387	Valve, Foot	4
1	S47487	Regulator, Pull Up	5
1	S47587	Regulator, Holding	6
1	S47687	Gauge, 0-100 PSI	7
1	S47787	Gauge, Holding	8
1	S49987	Valve, Quick Exhaust	9
3	S48387	Elbow, 90° Street	10
3	S36887	Elbow, Male 90°	11
1	S48487	Bushing, Reducer	12
2	S37487	Tee, Street	13
1	G00689	Swivel Union, M x F	14
3 [3]	S48687	Connector, Male	15
1	S53287	Muffler, Air Exhaust	16
7	S48787	Elbow, Male 90°	17
2	S48887	Connector, Female	18
8	S48987	Elbow, Male 90°	19
1	S36787	Elbow, Male 90°	20
2	S11787	Muffler, Air Exhaust	21

Qty.	Part No.	Description	Find No.
1	S49287	Run Tee, Male	22
1	S49387	Clamp, Hose .812 D	23
1	S51787	Grommet, Hose 2.938"	24
2	S25187	Screw, ¼-20 x ⅝	25
1	S51987	Hose Assy., S750 Air Tool	26
1	S46787	Adapter, Bulkhead	27
1	S48187	Nut, Hex Jam ¾-16	28
2	S32687	Soc. Hd. Cap Scr. ¼-20 x 1¾"	29
2	S26387	Washer, Lock, Spr. Med. ¼	30
2	S32787	Nut, Hex, ¼-20	31
Ref.	S46487	Spacer, Valve Mount	33
1	S46387	Valve Mount	34
Ref.	S46088	Panel, Front	35
Ref.		Cylinder, Pull Up	49
Ref.	S46188	Panel, Rear	50
3	S37387	Nipple, Hex, ¼ NPT	51
1	S46888	Guard, Foot Valve	52
1	P06386	Label, Front	53
1	S52587	Filter, ¼ NPT	54
1	S50687	Lubricator, ¼ NPT	55
1	S86287	Restrictor, .010 Orifice	57
2	S51387	Ring, Panel Mount, Reg.	58



View A-A



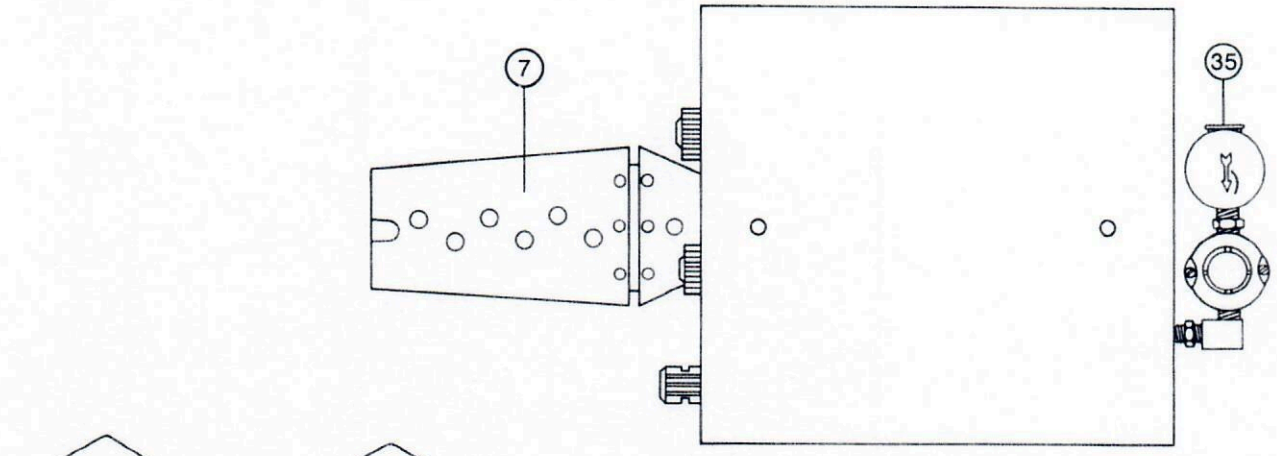
View B-B

*Please Note: All internal tubes are made of bulk tube part number R00608. When ordering individual tubes, give part number, 4.D letter on tube and length. See View C.

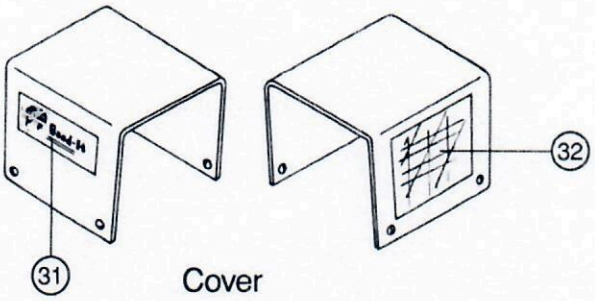
See Assembly Drawing.

Third Male Connector (15) Mounted to Item (25) on Page 13.

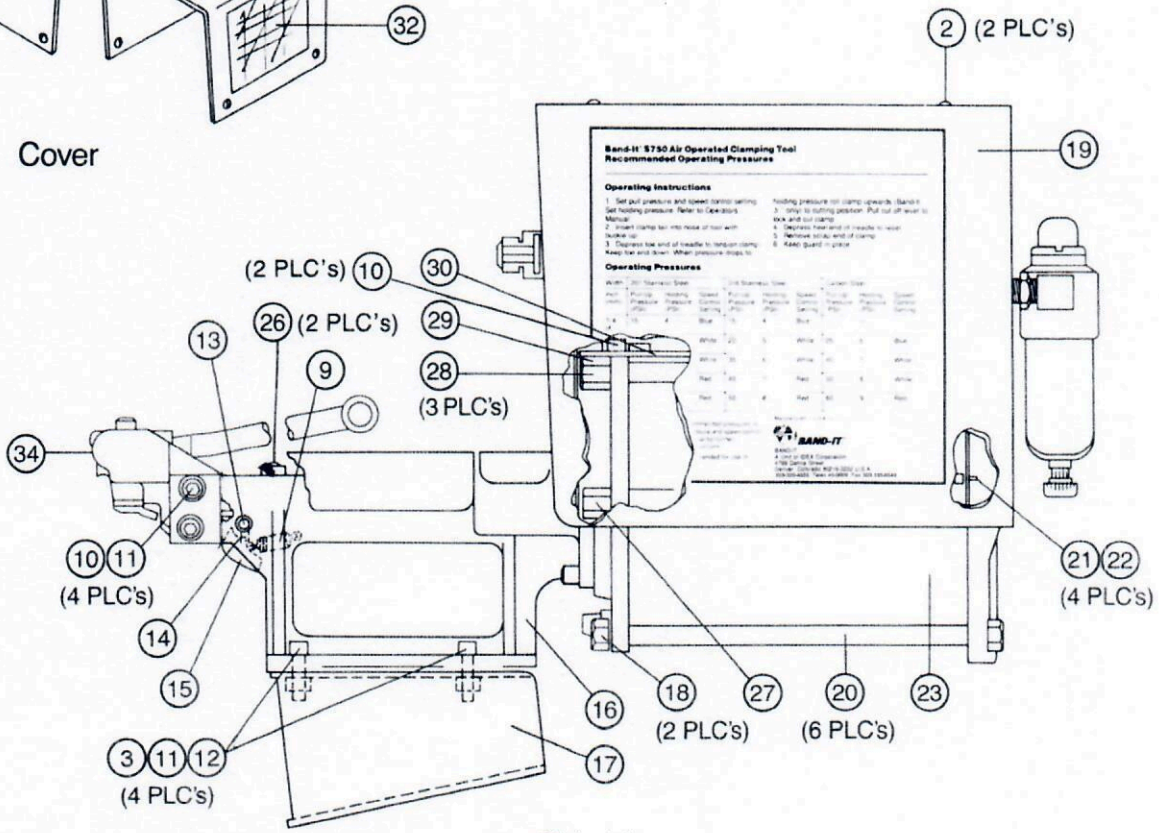
S750 Assembly



Top View



Cover

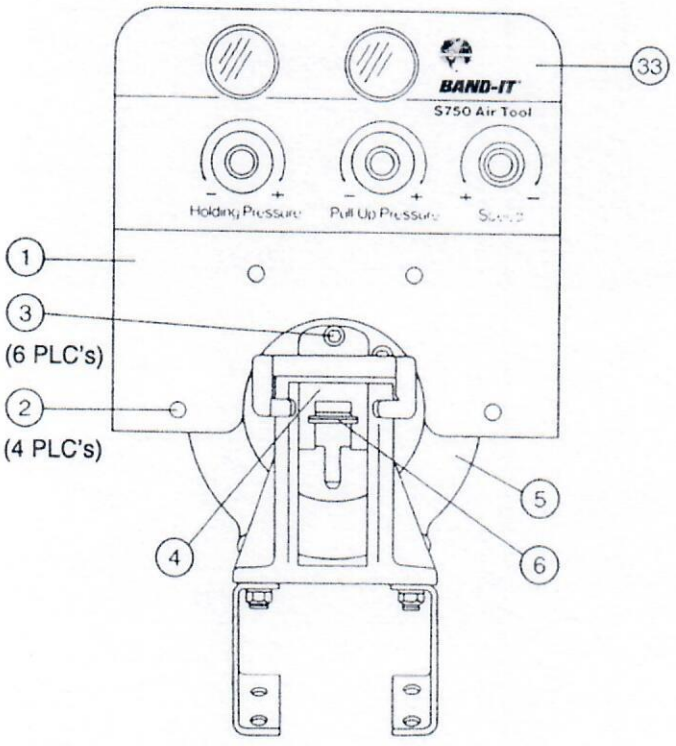


Side View

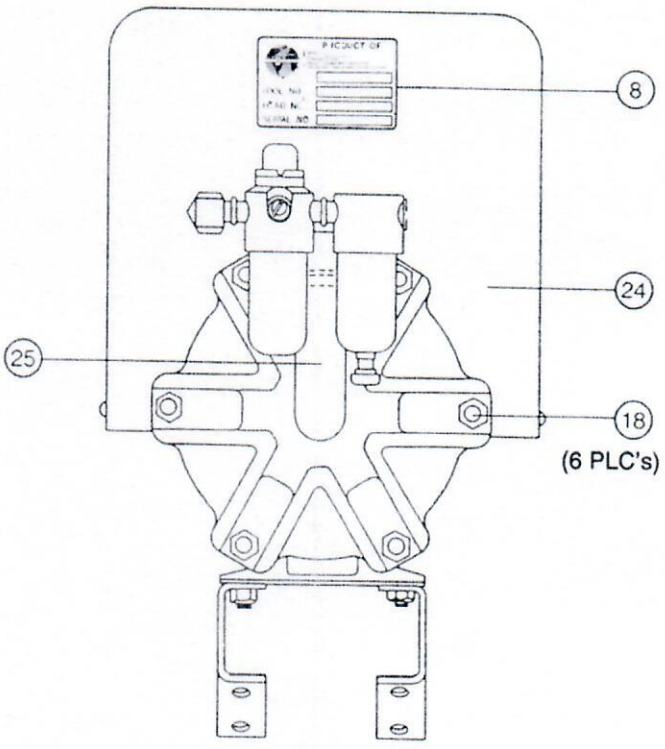
S750 Assembly Repair Parts List

Qty.	Part No.	Description	Find No.
1	S46088	Panel, Front	1
8	S48087	Screw, Socket, Button Hd., 10-32 x ⅜	2
10	J90987	Screw, 5/16-18 x ⅞	3
1	S45389	Rod Assembly, Piston	4
1	S21877	Head, Cylinder Front	5
1	S45087	Plate, Tripper	6
1	S45888	Slide Cover Assembly	7
1	S31787	Decal, Name Plate	8
1	S52687	Spring, Gripper Closing	9
6	S10487	Screw, 5/16-18 x ⅝	10
8	J66587	Washer, Lock, 5/16 I.D.	11
4	G92188	Nut, Hex, 5/16-18	12
1	S21587	Pin, Eccentric Lever	13
1	J64887	Set Screw, 10-32 x 3/16	14
1	S45187	Gripper, Band, Machined	15
1	S21789	Base, Machined	16
2	S46987	Base, Inclined	17
12 1/16	S37787	⅜ O.D. Poly Tubing (FT)	

Qty.	Part No.	Description	Find No.
8	J67687	Nut, Hex ⅜-24	18
1	S46288	Cover	19
6	J62187	Bolt, Cylinder	20
4	J68587	Screw, Soc. Hd., 8-32 x ⅜	21
4	S34187	Washer, Plain, #8	22
1	J60767	Cylinder, Steel	23
1	S46188	Panel, Rear	24
1	S47987	Cover, Assy., Final Details, Cyl. Rear	25
1	J61967	Plate, Rod Guide	26
1	S46687	Nut, Spacer, Short	27
3	S46587	Nut, Spacer, Long	28
1	S46487	Spacer, Valve Mount	29
Ref.	S46387	Valve Mount	30
1	P06486	Decal, Band-It, Large	31
1	P06586	Decal, Recommended Pressures, S750	32
Ref.	P06386	Label, Front Panel, S750	33
1	S18059	Jr. Preformed Clamp Head Assy.	34
1	S42387	¼ Plug	35
15 1/16	R00608	¼ O.D. Nylon Tubing - 1 See Page 14	



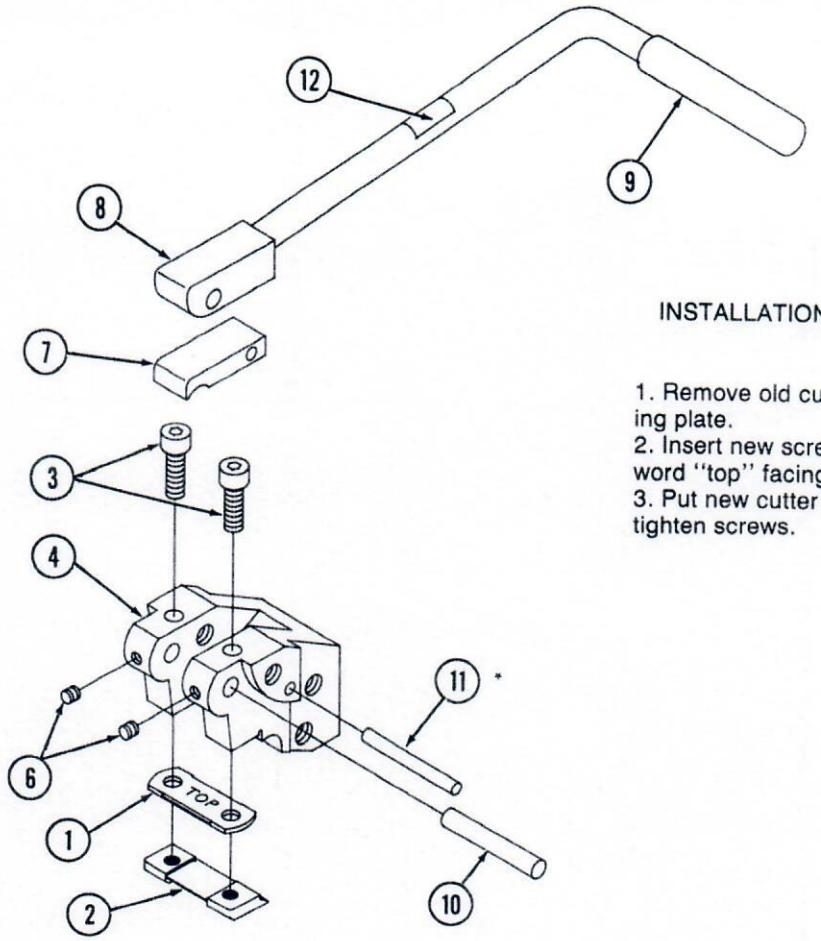
Front View



Rear View

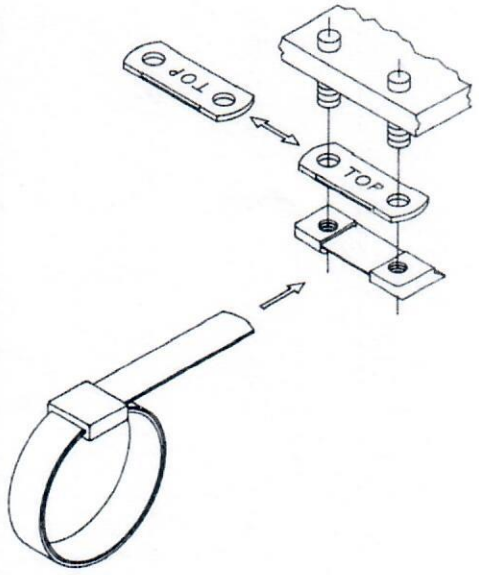
Band-It Jr.® Preformed Clamp Head

Repair Parts List Catalog Number S180



INSTALLATION INSTRUCTIONS FOR CUTTER BLADE AND BACKING PLATE

1. Remove old cutter blade screws, cutter blade and backing plate.
2. Insert new screws and put on new backing plate with word "top" facing up (either direction) as shown.
3. Put new cutter blade on with slot facing up as shown and tighten screws.



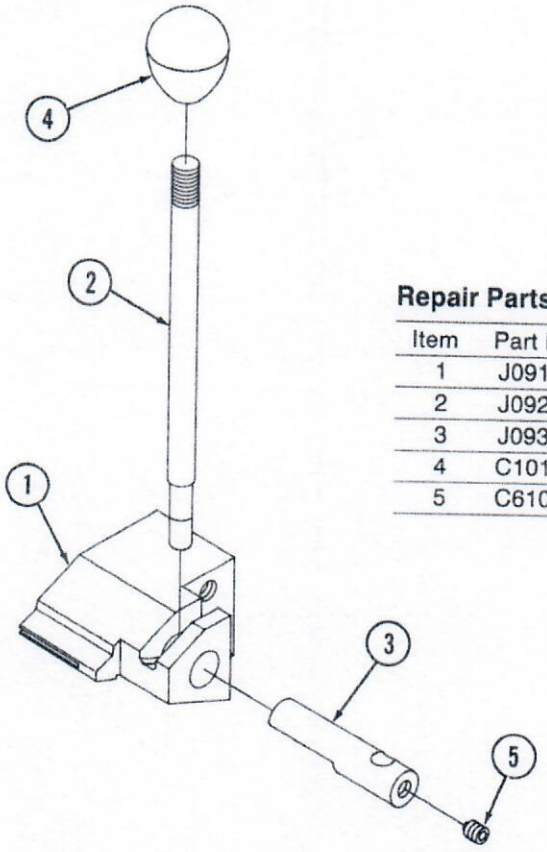
Band-It Jr.® Preformed Clamp Head
Repair Parts List Catalog Number S180

Item	Part No.	Description	Qty.
1	J85687	Backing Plate	1
2	J85787	Cutter Blade	1
3	S18787	Screw, Soc. Head Cap, 1/4-28 x 1.75	2
4	S51287	Head, Jr. Preformed Clamp	1
6	J64887	Screw, Set, #10-32 x 3/16	2
7	J00587	Shear Hook	1
8	S11589	Handle Assembly	1
9	S18487	Grip, Handle Cover	1
10	S52987	Pin, Pivot, Cam	1
*11	J90887	Pin, Pivot, Shear Hook	1
12	S18687	Decal, Warning	1
Kits			
—	J86099	1/4-3/8 Cutter Blade/Backing Plate	—
—	J86599	1/4-1/4 Cutter Blade/Backing Plate	—
—	J92099	Standard Cutter Blade/Backing Plate	—

* Shear Hook Pivot Pin to be retained by using medium strength Blue Loctite Compound 242 or equivalent.

Option — Band and Buckle Head

Catalog Number J090



Repair Parts List

Item	Part No.	Description	Qty.
1	J09187	Head	1
2	J09287	Handle, Cutter Bar	1
3	J09387	Cutter Bar	1
4	C10187	Ball, Plastic	1
5	C61087	Set Screw, 1/4-28 x 5/16 long	1

Application Instructions

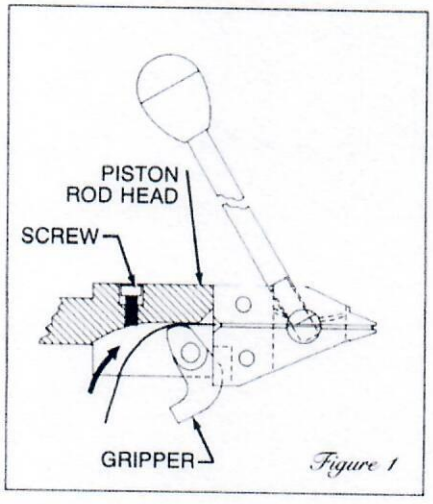
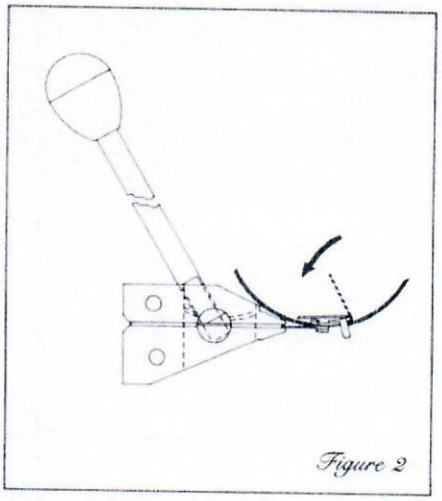
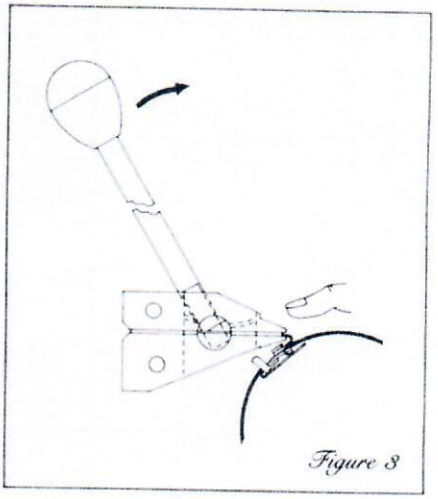


Figure 1

STEP 1
Back out screw to clear band path. Pull band from carton. Insert band end between piston rod and gripper through back of band and buckle head as shown in Figure 1.


Figure 2

STEP 2
Insert band end through buckle opening twice as shown in Figure 2. Fold band end over approx. 1/2 inch longer than buckle length. Pull up clamp per page 10 instructions.


Figure 3

STEP 3
Rotate clamped assembly down to a complete stop, hold thumb on bent band area as shown in Figure 3. Pull handle to cut band. Move clamped assembly away from tool and fold buckle ears over to retain band cut end.



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