

Procedure 2002: Installation of Boss™ 6 Bolt Clamp

effective 06/16



Selection

- 1. Select the proper Boss™ clamp using Procedure 1000: Boss™ Clamp Selection (page 5).
- 2. Refer to Procedure 3000: Criteria for Sufficient Fit of a Boss™ Clamp (page 49).

Preparation

- Prepare the hose using Procedure 1100: General Preparation Instructions (pages 9-10).

Notes

- 1. Periodic bolt re-tightening is necessary due to "cold-flow" present in all rubber hoses.
- 2. Boss™ clamps (including nuts and bolts) are for a single use only! Once removed, discard. 
- 3. When installing stainless-steel bolts and nuts, the use of anti-seize or anti-galling lubricant is advised. A light coat is required on the bolt threads to prevent thread galling and artificial torque reading.
- 4. Torque values for brass and steel nuts and bolts are based upon "dry bolts." *Caution: Lubricant on bolts will adversely affect clamp performance.* 
- 5. After assembly of Boss™ clamps, Dixon® advises checking the torque setting daily for the first week, weekly for the first month and monthly thereafter.

Process

- 1. Insert shank into the hose. Refer to step 9 of Procedure 1100: General Preparation Instructions (pages 9-10).
- 2. Place the stem in a vise:
 - a. For male stems, tighten the vise on the hex.
 - b. For female stems (wing nut), place a spud in the vise, tighten and then thread the wing nut onto the spud.
- 3. Position the clamp gripping fingers behind the stem collar.
- 4. Tighten the bolts by hand until there is equal thread engagement on all six nuts and they are snug.

Tip: Use the socket to aid hand tightening process.
- 5. Using a torque wrench, tighten bolts to the recommended torque value listed in the current DPL (Dixon® Product List). Tighten nuts on bolts in the following sequence. See illustration below.
 - a. Turn bolt #1 one full turn.
 - b. Turn bolt #2 one full turn.
 - c. Turn bolt #3 one full turn.
 - d. Turn bolt #4 one full turn.
 - e. Turn bolt #5 one full turn.
 - f. Turn bolt #6 one full turn.
 - g. Repeat 'a' to 'f' until all bolts are tightened. Clamp bolts are designed to bend during tightening. This "bending" allows the clamp to conform to the hose circumference.
- 6. Inspect results using Procedure 3000: Criteria for Sufficient Fit of a Boss™ Clamp (page 49) and Procedure 3001: Bolt Clamp Inspection (pages 50-51).
- 7. Test the assembly using Procedure 4000: General Hydrostatic Testing Information (page 60) and Procedure 4001: Hydrostatic Testing (page 61).

