



Selection

- Select the proper "Boss" clamp using Procedure 1000 ("Boss" Clamp Selection).

Preparation

- Prepare the hose using Procedure 1100 (General Preparation Instructions).

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.

Process:

- 1. Insert shank into hose.
- 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. See illustration above.
- 4. Tighten the bolts by hand until there is equal thread engagement. When hose O.D. is at or near clamp maximum range, starting of nuts on bolts may require squeezing clamp halves in a vise.
- 5. Using a torque wrench tighten bolts to the recommended torque value listed in the current DPL. Torque values are based upon "dry bolts". Lubricant on bolts will adversely effect clamp performance. Bolt tightening sequence:
 - a. Back bolt, 1 full turn.
 - b. Front bolt, 1 full turn.
 - c. Snug by hand, nuts on opposite side of bolts just tightened.
 - d. Opposite side back bolt, 1 full turn.
 - e. Opposite side front bolt, 1 full turn.
 - f. Snug by hand, nuts on opposite side of bolts just tightened.
 - 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) and Procedure 3001 (Bolt Clamp Inspection).
- 7. Test assembly using Procedure 4000 (General Hydrostatic Testing Information) and 4001 (Hydrostatic Testing).

Assembled By: _____ Tested By: _____ Reference No. _____
 Assembled Date: _____ Test Date: _____