



Selection:

- Use 755 "Piggyback" Clamp for 750 Boss Clamp. Use 850A "Piggyback" clamp for 850 Boss clamp.

Preparation:

- Install the 750 or 850 clamp using Procedure 2002 (Installation of Boss 6 Bolt Clamp).

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. Position the holes in each segment of the piggyback clamp over the pigtails of the 750 or 850 clamp just installed.
- 2. Tighten the bolts by hand until there is equal thread engagement on all six nuts and they are snug.
- 3. 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. Tighten nuts on bolts in the following sequence. See illustration above.
 - a. Bolt "1" one full turn.
 - b. Bolt "2" one full turn.
 - c. Bolt "3" one full turn.
 - d. Bolt "4" one full turn.
 - e. Bolt "5" one full turn.
 - f. Bolt "6" one full turn.
 - g. Repeat "a" to "f" until all bolts are tightened to recommended torque.
- 4. Retighten bolts on 750 or 850 clamp as per "a" through "g" above.
- 5. Retighten bolts on 755 or 850A piggyback clamp as per "a" through "g" above.
- 6. Repeat until all twelve bolts are tightened to recommended torque. Clamp bolts are designed to bend during tightening. This "bending" allows the clamp to conform to the hose circumference.
- 7. Inspect results using Procedure 3000 (Criteria for Sufficient Fit of a Boss Clamp) and Procedure 3001 (Bolt Clamp Inspection).
- 8. Test assembly using Procedure 4000 (General Hydrostatic Testing Information) and 4001 (Hydrostatic Testing).

Assembled By: _____

Tested By: _____

Reference No. _____

Assembled Date: _____

Test Date: _____