



### Preparation:

- 1. Install the B49 clamp using Procedure 2002 (Installation of Boss 6 Bolt Clamp).
- 2. Consider Procedure 3000 (Criteria for Sufficient Fit of a Boss Clamp).

### Notes:

- 1. Use a torque wrench. Tighten bolts to the recommended torque value listed in Boss Fittings section of current Dixon Price List (DPL).
- 2. Torque values are based upon "dry bolts". Lubricating bolts will adversely effect clamp performance.
- 3. Clamp bolts are designed to bend during tightening. This "bending" allows the clamp to conform to the hose circumference.
- 4. Periodic bolt re-tightening is necessary due to "Cold-Flow." It is present in all rubber hoses.
- 5. Boss clamps (including nuts and bolts) are for a single use only! Once removed, discard.

### Process:

- 1. Position each segment of the piggyback clamp 5/8" away from the B49 clamp just installed.
- 2. Offset the piggyback segments so that their center aligns with the gap between the B49 segments.
- 3. Tighten the bolts by hand until there is equal thread engagement on all six nuts.
- 4. Tighten the nuts on the 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.
  - h. Retighten bolts on B49 clamp as per steps "a" through "g" above.
  - i. Retighten bolts on B49-2 piggyback clamp as per steps "a" through "g" above.
  - j. Repeat steps "h" and "i" above until all twelve bolts are tightened to recommended torque.
- 5. Inspect results using Procedure 3000 (Criteria for Sufficient Fit of a Boss Clamp) and Procedure 3001 (Bolt Clamp Inspection).
- 6. Test assembly using Procedure 4000 (General Hydrostatic Test Information) and 4001 (Hydrostatic Testing).

Assembled By: \_\_\_\_\_ Tested By: \_\_\_\_\_ Reference No. \_\_\_\_\_  
 Assembled Date: \_\_\_\_\_ Test Date: \_\_\_\_\_