

Procedure 2201	Installation of Double Bolt Clamps (with saddles)	Revision 4-04
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Selection:

- 1. Select the correct Double Bolt Clamp from the Clamp Section of the current Dixon Price List (DPL).
- 2. *Consult Dixon when using on hose having a helical wire.*

Preparation

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

Notes:

- 1. Periodic bolt re-tightening is necessary due to "Cold-Flow" that is present in all rubber hoses.
- 2. Double Bolt Clamps (including their nuts and bolts) are for a single use only! Once removed, discard.

Process

- 1. Insert the coupling into the hose.
- 2. Place the clamp(s) into the proper position.
 - a. Lettering detail (ex: DIXON V & C) should face the same direction for all clamps.
 - b. When using multiple clamps, offset the saddles to prevent line leak. For 2 clamps - saddle centers at 90°, for 3 clamps - saddle centers at 60° and for 4 clamps - saddle centers at 90°.
 - c. The clamp must be perpendicular to the hose body. Uneven bolt tightening may result in a clamp that is angled and has sealing and retention problems.
- 3. Install the clamp as follows:
 - a. Position the saddles so they are fully under the clamp halves.
 - b. Hand-tighten both nuts equally.
 - c. Using a permanent marker, place a mark near the nut on one of the bolt lugs.
 - d. Tighten that nut one full turn.
 - e. Tighten the opposite side nut one full turn.
 - f. Continue tightening nuts one turn at a time alternating back and forth until the saddles no longer move freely.
 - g. Using a hammer and punch, reposition the saddles so they are fully under the clamp halves. Position the saddle loop (where the bolt goes through) slightly off center towards the bolt head.
- 4. Continue tightening nuts alternating back and forth until both are tightened to recommended torque value listed on Double Bolt Clamp page of current DPL (Dixon Price List). **Note:** Torque values are based upon "dry bolts". Lubricating bolts will adversely effect clamp performance. Use a torque wrench. The bolts will bend during tightening. This allows the clamp to work properly.
- 5. An excessive amount of bolt past the nut may be removed by using bolt cutters or a hack saw.
- 6. For assemblies using multiple clamps, repeat Step 2 through 5.
- 7. Inspect results using Procedure 3001 (Bolt Clamp Inspection).
- 8. Test assembly using Procedure 4000 (General Hydrostatic Testing Information) and Procedure 4001 (Hydrostatic Testing).

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