

Procedure 2202	<b>Installation of Flat Seal Couplings</b>	Revision 4-04
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**Selection:**

1. Flat Seal Couplings are for lay flat hose and Single Jacket Fire Hose with a wall thickness between 5/64" and 3/16".
2. Flat Seal Couplings are designed for use with Flat Seal clamps only.

**Preparation:**

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

**Process:**

- 1. Insert the coupling. For couplings with female thread, allow 1/16" of the shank to show past the hose end.
- 2. Place the clamp on the hose:
  - a. For male couplings it should contact the stem hose stop.
  - b. On female couplings it should be even with the hose end.
  - c. For clamps 3" and below, the lettering detail (ex: DIXON V&C) should be facing away from the threads.
  - d. For 4" and 6" clamps with gripping fingers, the fingers must be positioned behind the stem collar.
- 3. Position hose creases under body (center) of clamp halves and hand-tighten both nuts equally.
- 4. Using a permanent marker, mark the clamp body near one of the nuts, and tighten that nut one full turn.
- 5. Tighten the opposite side nut one full turn.
- 6. Continue tightening nuts alternating back and forth until both are tightened to recommended torque as listed on the Flat Seal Coupling page of the current Dixon Price List (DPL). **Note:** Torque values are based upon "dry bolts". Lubricant on bolts will adversely effect clamp performance. Use a torque wrench. Periodic bolt re-tightening is necessary.
- 7. Test assembly using Procedure 4000 (General Hydrostatic Testing Information) and 4001 (Hydrostatic Testing).

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