

Selection:

- 1. Measure the hose O.D.
- 2. Select the clamp that has a nominal size closest to the hose O.D.
- 3. See current DPL (Dixon Price List) for nominal size selection.
- 4. The clamp selected must be able to slide over the hose O.D. after stem insertion.

Preparation:

- 1. Prepare the hose using Procedure 1100 (General Preparation Instructions).
- 2. Determine the proper number of Pinch-on Clamps required:
 - a. For pronounced shanks use the same number of clamps as there are marks on the hose.
 - b. For symmetrical shanks 3/8" and below, 1 clamp.
 - c. For symmetrical shanks 1/2" to 1", 2 clamps.

Process:

1. Slide the correct number of clamps over the hose end.
2. Insert the coupling.
3. For **Single Ear Clamps**:
 - a. Position clamp(s) over shank.
 - b. Pinch clamp-ear as tight as possible without shearing clamp.
 - c. Check clamp-ear. If both sides of clamp-ear touch, the clamp is too large. Remove clamp and install next smaller clamp.
 - d. For multiple clamp installations repeat the process.
4. For **Double Ear Clamps**:
 - a. Position clamp(s) over shank.
 - b. Pinch one clamp ear as tight as possible (both sides of clamp ear touch).
 - c. Pinch other clamp ear as tight as possible without shearing clamp.
 - d. Check clamp ears as follows:
 1. The first ear that was pinched may open slightly. This is acceptable.
 2. If both ears close completely, clamp is too large. Remove clamp and install next smaller clamp.
 - e. For multiple clamp installations, repeat the process.
5. Test assembly using Procedure 4000 (General Hydrostatic Testing Information) and 4001 (Hydrostatic Testing).

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