Procedure 2000: Installation of Boss™ 2 Bolt Clamp

*Tip: Use this procedure for Air King Clamp installation*

**Selection**
- 1. Select the proper Boss™ clamp using procedure 1000: Boss™ Clamp Selection (page 5).
- 2. Refer to Procedure 3000: Criteria for Sufficient Fit of a Boss™ Clamp (page 39).

**Preparation**
- Prepare the hose using Procedure 1100: General Preparation Instructions (pages 9-10).

**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.
- 3. When installing stainless steel bolts and nuts, the use of anti-seize or anti-galling lubricant is advised. A light coat is required on the bolt threads to prevent thread galling and artificial torque reading.
- 4. Torque values for brass and steel nuts and bolts are based upon "dry bolts". *Lubricant on bolts will adversely effect clamp performance.*
- 5. After assembly of Boss™ clamps, Dixon® advises checking the torque setting once a day for the first week, once a week for the first month, once a month thereafter.

**Process**
- 1. Insert shank into hose. Refer to step 9 of Procedure 1100: General Preparation Instructions (pages 9-10).
- 2. Place the stem in a vise:
  - a. For male stems, tighten the vise on the hex.
  - b. For female stems (wing nut), place a spud in the vise, tighten, and then thread the wing nut onto the spud.
- 3. Position the clamp gripping fingers behind the stem collar. See illustration below.
- 4. Tighten the bolts by hand until there is equal thread engagement. When hose OD (Outside Diameter) is at or near clamp maximum range, starting of nuts on bolts may require squeezing clamp halves in a vise.
  *Tip: Use the socket to aid hand tightening process.*
- 5. Using a torque wrench, tighten bolts to the recommended torque value listed in the current DPL (Dixon® Price List).
  Tighten nuts on bolts in the following sequence. See illustration below.
  - a. Front bolt, one full turn.
  - b. Opposite side bolt, one full turn.
  - c. Repeat 'a' and 'b' until all bolts are tightened. Clamp bolts are designed to bend during tightening. This "bending" allows the clamp to conform to the hose circumference.