Procedure 2003: Installation of Boss™ 755 and 850 Piggyback Clamps

effective 08/15

Selection
☐ 2. Refer to Procedure 3000: Criteria for Sufficient Fit of a Boss™ Clamp (page 39).

Preparation
☐ Install the 750 or 850 clamp using Procedure 2002: Installation of Boss™ 6 Bolt Clamp (page 17).

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. Position the holes in each segment of the piggyback clamp over the pigtails of the 750 or 850 clamp just installed.
☐ 2. Tighten the bolts by hand until there is equal thread engagement on all six nuts and they are snug.

Tip: Use the socket to aid hand tightening process.

☐ 3. Using a torque wrench, tighten bolts to the recommended torque value listed in the current DPL (Dixon® Price List). Note: Torque values for steel nuts and bolts are based upon "dry bolts". Lubricant on bolts will adversely effect clamp performance.

Tighten nuts on bolts in the following sequence. See illustration below.

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.

☐ 4. Retighten bolts on 750 or 850 clamp as per 'a' through 'g' above.
☐ 5. Retighten bolts on 755 or 850A piggyback clamp as per 'a' through 'g' above.
☐ 6. Repeat until all 12 bolts are tightened to recommended torque. Clamp bolts are designed to bend during tightening. This 'bending' allows the clamp to conform to the hose circumference.

☐ 8. Test the assembly using Procedures 4000: General Hydrostatic Testing Information (page 50) and 4001: Hydrostatic Testing (page 51).