Procedure 2004: Installation of Boss™ B49-2 Piggyback Clamps

Selection

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

Preparation


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 affect 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 B49 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 affect 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 B49 clamp as per 'a' through 'g' above.
☐ 5. Retighten bolts on B49-2 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).