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

effective 06/16

Selection
☐ 2. Refer to Procedure 3000: Criteria for Sufficient Fit of a Boss™ Clamp (page 49).

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." Caution: Lubricant on bolts will adversely affect clamp performance.
☐ 5. After assembly of Boss™ clamps, Dixon® advises checking the torque setting daily for the first week, weekly for the first month and monthly 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® Product 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. Turn bolt #1 one full turn.
   b. Turn bolt #2 one full turn.
   c. Turn bolt #3 one full turn.
   d. Turn bolt #4 one full turn.
   e. Turn bolt #5 one full turn.
   f. Turn bolt #6 one full turn.
   g. Repeat ‘a’ to ‘f’ until all bolts are tightened to recommended torque.
☐ 4. Re-tighten bolts on B49 clamp, as per ‘a’ through ‘g’ above.
☐ 5. Re-tighten 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.
☐ 7. Inspect results using Procedure 3000: Criteria for Sufficient Fit of a Boss™ Clamp (page 49) and Procedure 3001: Bolt Clamp Inspection (pages 50-51).
☐ 8. Test the assembly using Procedure 4000: General Hydrostatic Testing Information (page 60) and Procedure 4001: Hydrostatic Testing (page 61).