



Bolt Tightening Sequence for Dixon Boss Clamps

Note:

1. The correct size Boss clamp must be used.
2. Bolts in Boss clamps are designed to bend as they are tightened. This allows the clamp to conform to the hose outside diameter.
3. Always tighten bolts to their specified torque value. This torque value can be found on the pages 88-89.
4. Periodic re-tightening of bolts is required due to "cold flow" phenomenon present in all rubber hoses.
5. Boss Clamps are for single use only! Once removed they are to be discarded.

2 Bolt Dixon Boss Clamp Bolt Tightening Sequence

Using a torque wrench, begin tightening the bolts as follows:

- a) First bolt (nut facing assembler) 1 full turn.
- b) Second bolt (opposite first bolt) 1 full turn.
- c) Repeat procedure "a" and "b" until both bolts have reached the recommended torque.
- d) Remove assembly from vise.

4 Bolt Dixon Boss Clamp Bolt Tightening Sequence

Using a torque wrench, begin tightening the bolts as follows:

- a) Back bolt (bolt with nut facing assembler that is furthest away from gripping finger) 1 full turn.
- b) Front bolt (bolt with nut facing assembler that is closest to gripping finger) 1 full turn.
- c) Snug by hand (if bolts are loose) nuts on opposite side of bolts just torqued.
- d) Opposite side back bolt (bolt with nut facing assembler furthest away from gripping finger) 1 full turn.
- e) Opposite side front bolt (bolt with nut facing assembler closest to gripping finger) 1 full turn.
- f) Snug by hand (if bolts are loose) nuts on opposite side of bolts just torqued.
- g) Repeat above procedure "a" through "f" until all of the bolts have reached the recommended torque.
- h) Remove assembly from vise.

6 Bolt Dixon Boss Clamp Bolt Tightening Sequence

Using a torque wrench, begin tightening the bolts as follows:

- a) Back bolt (bolt with nut facing assembler that is furthest away from gripping finger) having "X" near it one full turn.
- b) Front bolt (bolt with nut facing assembler that is closest to gripping finger) of same segment one full turn.
- c) Moving to clamp segment to the left of the one just tightened, snug bolts by hand (if bolts are loose).
- d) Back bolt to one full turn.
- e) Front bolt one full turn.
- f) Moving to clamp segment to the left of the one just tightened, snug bolts by hand (if bolts are loose).
- g) Back bolt one full turn.
- h) Front bolt one full turn.
- i) Repeat above procedure "a" through "h" until all of the bolts have reached the recommended torque.
- j) Remove assembly from vise.