

Procedure 2203: Installation of Pinch-On Clamps

effective 02/08

Selection

- 1. Measure the hose OD (Outside Diameter).
- 2. Select the clamp that has a nominal size closest to the hose OD.
- 3. See current DPL (Dixon® Product List) for nominal size selection.
- 4. The clamp selected must be able to slide over the hose OD after stem insertion.

Preparation

- 1. Prepare the hose using Procedure 1100: General Preparation Instructions (pages 9-10).
- 2. Determine the proper number of pinch-on clamps required:
 - a. For pronounced shanks use the same number of clamps as there are marks on the hose.
 - b. For symmetrical shanks $\frac{3}{8}$ " and below; 1 clamp.
 - c. For symmetrical shanks $\frac{1}{2}$ " to 1"; 2 clamps.

Process

- 1. Slide the correct number of clamps over the hose end.
- 2. Insert the coupling. Refer to step 9 of Procedure 1100: General Preparation Instructions (pages 9-10).
- 3. *For single ear clamps:*
 - a. Position the clamp(s) over the shank.
 - b. Pinch the clamp ear as tight as possible without shearing the clamp.
 - c. Check the clamp ear. If both sides of the clamp-ear touch, then the clamp is too large. Remove the clamp and install the next smaller clamp.
 - d. For multiple clamp installations, repeat the process.
Note: Make sure the clamp ears are not lined up.
- 4. *For double ear clamps:*
 - a. Position the clamp(s) over the shank.
 - b. Pinch one clamp ear as tight as possible (both sides of clamp ear touch).
 - c. Pinch the other clamp ear as tight as possible without shearing the clamp.
 - d. Check clamp ears as follows:
 - 1. The first ear that was pinched may open slightly. This is acceptable.
 - 2. If both ears close completely, the clamp is too large. Remove clamp and install the next smaller clamp.
 - e. For multiple clamp installations, repeat the process.
Note: Make sure the clamp ears are not lined up.
- 5. Test assembly using Procedure 4000: General Hydrostatic Testing Information (page 60) and Procedure 4001: Hydrostatic Testing (page 61).