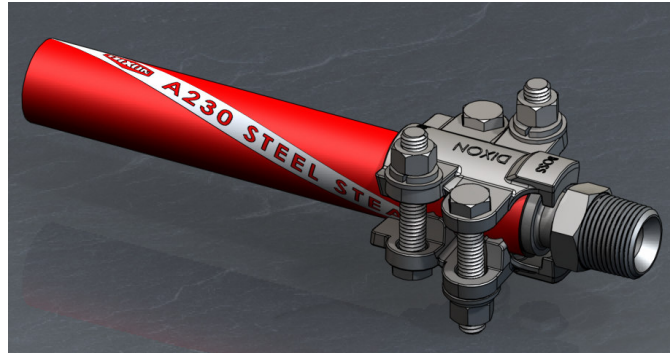


Standard Operating Procedure

ASSEMBLY OF RBU9-4 3/4" STAINLESS STEEL BOSS CLAMP



NOTE

The following SOP is an assembly procedure for the RBU9-4 – 3/4" Stainless Steel 'Boss' clamp and is intended for use with 'Boss' hose tails.

Prior to assembly it will be necessary to measure the Outside Diameter of the hose (using a diameter tape) to ensure it is within the specified range of the clamp.

The acceptable range for the RBU9-4 Boss Clamp is Ø30.2 - Ø33.3mm. Hose which does not measure within this range should not be used in the assembly.

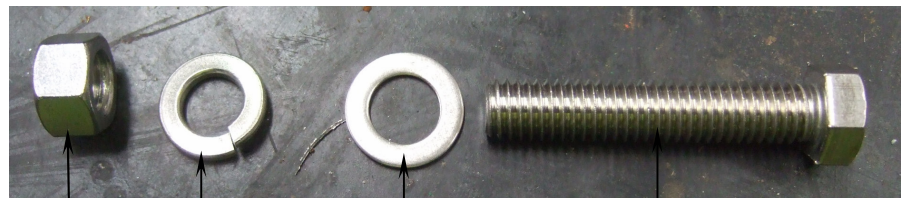
COMPONENTS

The RBU9-4 – 3/4" Stainless Steel Boss Clamp comprises of:

| COMPONENT DESCRIPTION | QUANTITY |
|--|----------|
| Clamp Half SS316 | 2 |
| 3/8" UNC x 2" Hex Head Set Screw SS316 | 4 |
| 3/8" Flat Washer SS316 | 4 |
| 3/8" Spring Washer SS316 | 4 |
| 3/8" UNC Nut SS316 | 4 |



Clamp Half



Nut

Spring Washer

Flat Washer

Bolt/Screw

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Assembly

1. Apply a small amount of a suitable lubricant to the end of each bolt as shown below in Fig 1.



Fig 1

The type of lubricant used will be dependant on the application that the assembly is to be used in. For example if the assembly is to be used in sanitary conditions, a non-toxic lubricant must be used and is at the discretion of the user. The purpose of the lubricant is to prevent 'galling' of the Stainless Steel components when the nuts and bolts are tightened.

Lubricant must be used as the galling will affect the torque between the nut and bolt leading to an ineffective clamp assembly, creating a potentially dangerous situation.

2. Position the two clamp halves as shown (Fig 2.) over the hose/tail and insert bolts, washers & nuts in the order shown in Fig 2.

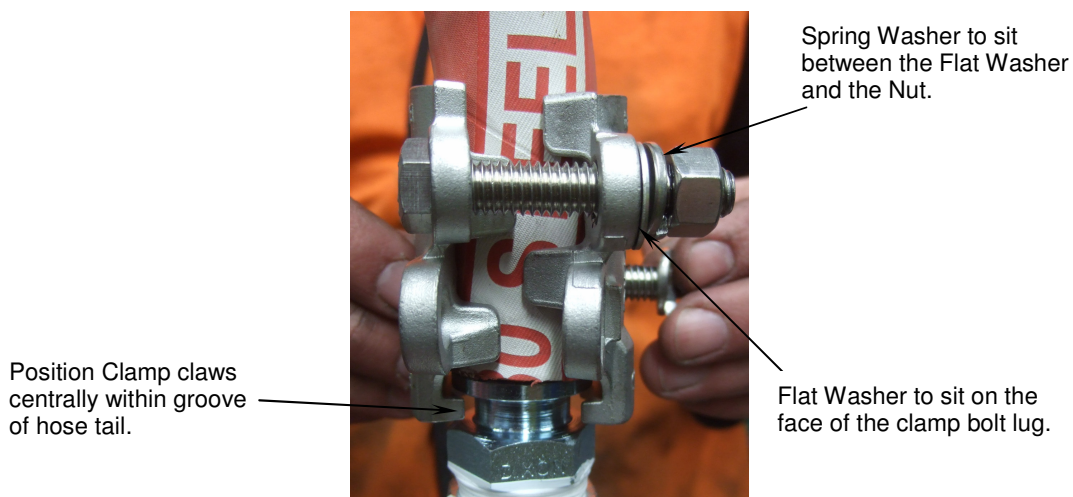
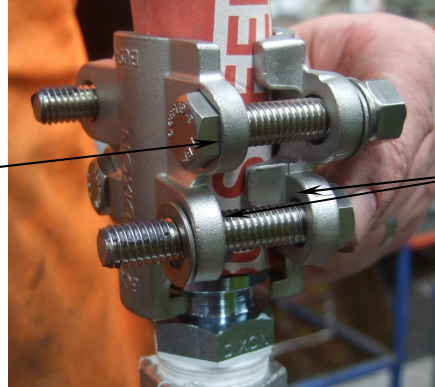


Fig 2

Standard Operating Procedure

ASSEMBLY OF RBU9-4 3/4" STAINLESS STEEL BOSS CLAMP

Head of bolt to sit within the bolt stop recess to prevent bolt from turning as the nuts are tightened.



Ensure gap between clamp halves remains even on both sides of the clamp assembly throughout the tightening procedure.

Fig 3

3. Tighten all four nuts equally to 'finger tight' ensuring the clamp is positioned correctly and also that the clamp is not closed more on one side than the other. Refer Fig 3.
4. Using a suitable torque wrench, set the torque to 21lbf/ft – 28Nm.

In a sequence as shown in Fig 4; gradually tighten the nuts approximately 1/4 - 1/2 turn at a time until the torque is reached, ensuring that the clamp is tightening evenly on both sides.

Due to 'Cold Flow' of the rubber hose, it will be necessary to re-check the torque of each nut in sequence a number of times to ensure an even force is applied at each fastening point of the clamp.

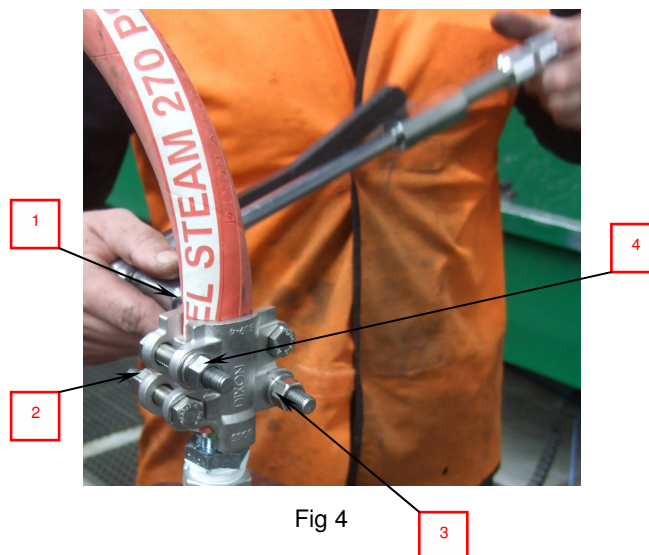
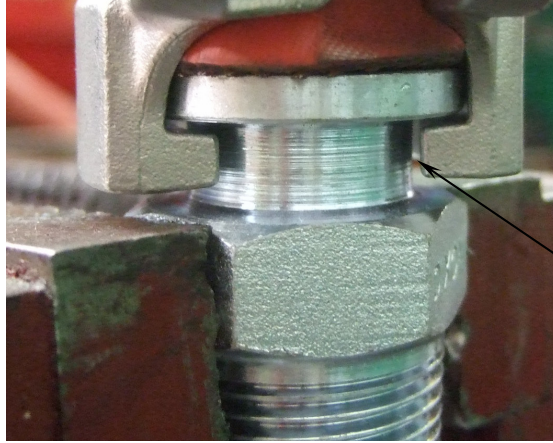


Fig 4

Standard Operating Procedure

ASSEMBLY OF RBU9-4 3/4" STAINLESS STEEL BOSS CLAMP



Ensure a gap remains between the claw of the clamp and the groove of the hose tail.

Fig 5

- When clamp is tightened fully, ensure a gap is present between the claw of the clamp and the groove of the hose tail.

If the claw fouls on the groove of the hose tail, the clamping force on the hose will be compromised, causing an ineffective assembly and a potentially dangerous situation.

Safety

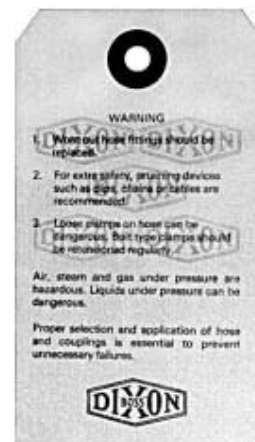
WARNING:

- Worn-out hose fittings should be replaced.
- Loose clamps on hose can be dangerous
- Bolt type clamps should be re-tensioned regularly.
- For extra safety, retaining devices such as clips, chains or cables must be used.

DIXON strongly recommends the use of a safety tag or warning label on all hose assemblies. For example Safety tag Part no. DWL100 or Safety tape Part no. DSTW.



DSTW



DWL100