

## HD2 HOSE CLAMP ASSEMBLY PROCEDURE

This Procedure is designed to aid in the assembly of PT Coupling Company HD2 Clamp Assembly's onto mating PT Coupling Company HD2 Hose Shanks. Using this procedure will help to ensure a proper connection with the hose shank and clamp sections.

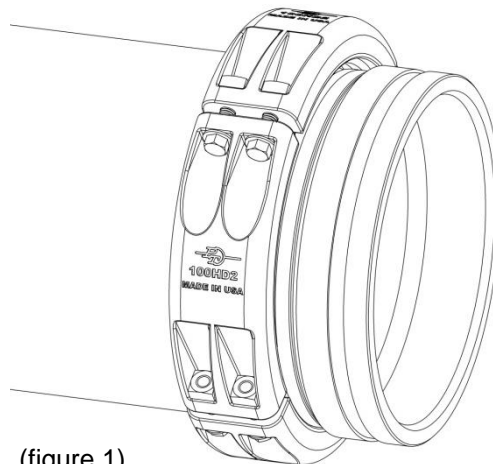
PT Coupling HD2 Clamp Assemblies will only work with lay flat hose and a PT Coupling Company HD2 Hose shank.

Your PT Coupling Company HD2 Clamp Assembly kit should include:

|                                                                                                                                                                                               |                                                                                                                                                                                                  |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <p><b>60HD2 Clamp Assembly (Item 50560)</b></p> <p>-----</p> <p>3 - 60HD2 Clamp Sections<br/>6 - 3/8" x 2" Long Grade 5 Bolts<br/>6 - 3/8" Square Nuts<br/>6 - 3/8" Flat Washers</p>          | <p><b>80HD2 Clamp Assembly (Item 50510)</b></p> <p>-----</p> <p>4 - 80HD2 Clamp Sections<br/>8 - 3/8" x 2" Long Grade 5 Bolts<br/>8 - 3/8" Square Nuts<br/>8 - 3/8" Flat Washers</p>             |
| <p><b>100HD2 Clamp Assembly (Item 50511)</b></p> <p>-----</p> <p>4 - 100HD2 Clamp Sections<br/>8 - 7/16" x 2 1/4" Long Grade 5 Bolts<br/>8 - 7/16" Square Nuts<br/>8 - 7/16" Flat Washers</p> | <p><b>120HD2 Clamp Assembly (Item 50524)</b></p> <p>-----</p> <p>5 - 120HD2 Clamp Sections<br/>10 - 7/16" x 2 1/4" Long Grade 5 Bolts<br/>10 - 7/16" Square Nuts<br/>10 - 7/16" Flat Washers</p> |

Step 1 - Squarely cut hose and insert it onto the fitting hose shank until the hose bottoms out and is square against stop.

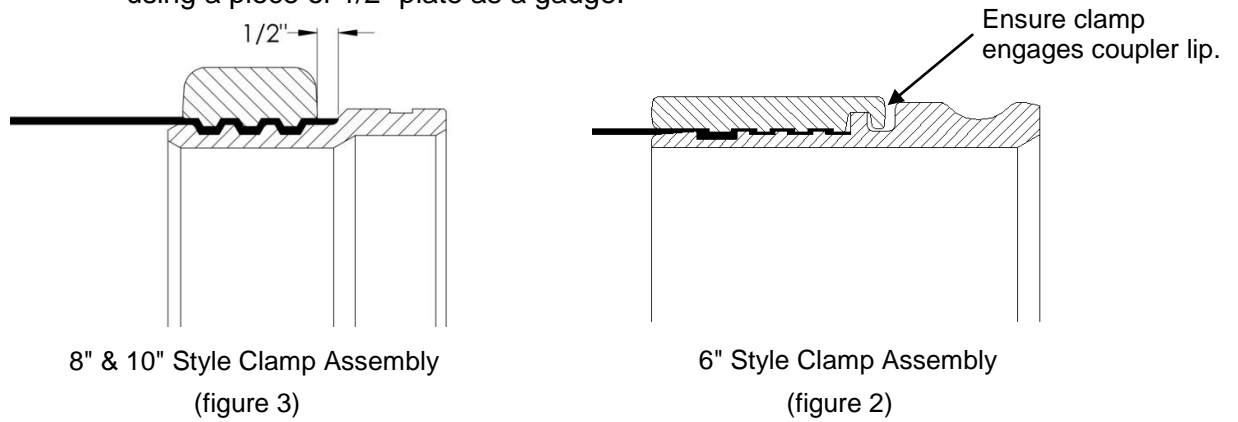
Step 2 - Loosely assemble the clamp sections around the hose shank. Insert bolts with washers through round bolt area of clamp. Insert square nut into square area of clamp (see figure 1).



(figure 1)



**Step 3** - Before bolting down clamp assembly make sure it is properly located in relation to hose shank. For 6" style this is achieved by simply ensuring the clamp lip engages the coupling lock ring (see figure 2). For 8" 10", and 12" this is achieved by measuring the distance between the hose stop and side of clamp section. The distance should be approximately 1/2" on all clamp sections (see figure 3). This can easily be achieved by using a piece of 1/2" plate as a gauge.



**Step 4** - Using a socket wrench sequentially tighten clamp segments maintaining equal distance between clamp segments. Torque bolts to recommended torque rating listed below

| Torque Recommendations |            |
|------------------------|------------|
| 6" & 8" Style          | 25 ft. lbs |
| 10" & 12 Style         | 30 ft. lbs |

To ensure proper connection clamp segments must be as equally spaced as possible.

### **⚠ WARNING**

Over tightening of bolts could result in clamp and bolt failure. Clamp and bolt failure could result in spill or injury to personnel.

**Step 5** - To maintain your hose system it is recommended to periodically check the torques on the bolts. This will help ensure a safe and leak free hose connection.