

## Procedure 2301: Installation of Dixon® Menders

effective 02/08

### **Selection**

- 1. Select a mender based on hose ID (Inside Diameter). See current DPL (Dixon® Product List) for restrictions.
- 2. Select the correct style and size of clamp (pre-formed, band and buckle, double bolt). For pre-formed band clamps refer to Procedure 1001: Pre-formed Band Clamp Selection (page 6).

### **Notes**

- 1. If the mender is to repair a damaged section of hose, cut 12" away from each side of the damaged area.
- 2. If the damage was the result of hose rupture due to excessive pressure, extreme temperature or incompatibility between the hose tube and the product being conveyed, replace the hose with one appropriate for the application. Do not use a mender.

### **Preparation**

- 1. Prepare and mark the hose using Procedure 1100: General Preparation Instructions (pages 9-10).
- 2. Mark the middle of the mender.

### **Process**

- 1. Insert the mender up to its midpoint into one piece of the hose.
- 2. Place the clamp(s) in its/their proper position.
- 3. Based on the style of clamp and installation method selected, use one of the following:
  - a. Procedure 2100: Installation of Pre-Formed Band Clamp Using Pneumatic Roll-Over Tool (page 20).
  - b. Procedure 2101: Installation of Pre-Formed Band Clamp Using Punch Style Tool (page 21).
  - c. Procedure 2103: Installation of Pre-Formed Band Clamp Using Screw-Action Tool with Roll-Over Tool Attachment (page 23).
  - d. Procedure 2104: Installation of Clamp-It Band and Buckle Using Screw-Action Tool (page 24).
  - e. Procedure 2201: Installation of Double Bolt Clamps, with saddles (page 26).
- 4. Insert the other end of the mender into the other piece of hose. Hose ends should make contact.  
*Note:* If pre-formed band clamps are used, then they must be slid over the hose ends before the mender is inserted.
- 5. Place the clamp(s) in its/their proper position.
- 6. Install clamp(s) using the same procedure as used in step 3.
- 7. Check work using Procedure 3000: Criteria for Sufficient fit of Boss™ Clamp (page 49), 3001: Bolt Clamp Inspection (page 49-50) or 3002: Band Clamp Inspection (page 52).
- 8. Test assembly using Procedure 4000: General Hydrostatic Testing Information (page 60) and Procedure 4001 Hydrostatic Testing (page 61).