



The Right Connection®

25 Ton Ram Operating Instructions

Section 1

External Swaging of Standard Holedall



Dixon

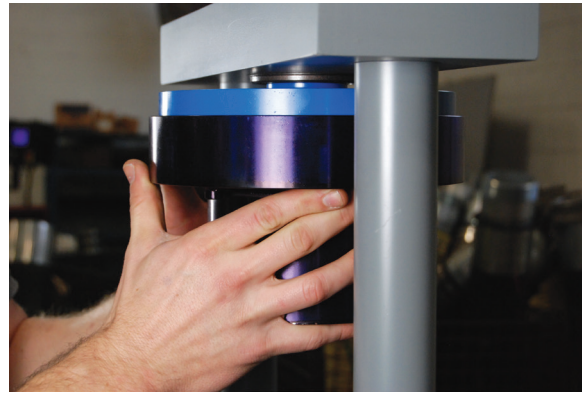
800 High Street • Chestertown, MD 21620

ph: 877•963•4966 fax: 800•283•4966

dixonvalve.com

1

Before you begin, make sure the ram is fully retracted. Install **25PUSH400** (also referred to as the pusher hat) onto the main pusher plate. This is required for all standard Holedall fittings. Make sure the bolt holes align with the ½" bolts and wing nuts supplied



2

Insert Die Holders into the Die Bed Plate as follows:

- a) **DH9-004** - Master Die Holder to hold all of the other die holders.
- b) **DH9-004-1** - Die Holder for 4" I.D. hoses only.
- c) **DH6-003** - Die Holder for 1¼" - 3" I.D. hose dies (fits into **DH9-004**).
- d) **DH3-001** - Die Holder for ¼" - 1" I.D. hose dies (**DH6-003** and **DH9-004** also required).

Secure the Die Holders with the tie down bars supplied.



3

Select the proper pusher for the I.D. of the hose. The pusher should be the same size as the stem. There are separate pushers required for 1¼" through 3" I.D. hose. Insert the selected pusher into the **25PUSH400** and secure it with the set screws provided.

For Unirange (1" and below) remove the **25PUSH400** and install the **25PUSH100** as well as the correct pusher for the size of Unirange coupling. There is a separate pusher for each Unirange assembly size.



4

Accurately measure the hose O.D. with a diameter tape. Each end of the hose should be measured to guarantee the correct ferrule and die selection.

Select the correct ferrule and die based upon the hose free O.D. just measured from the die chart.

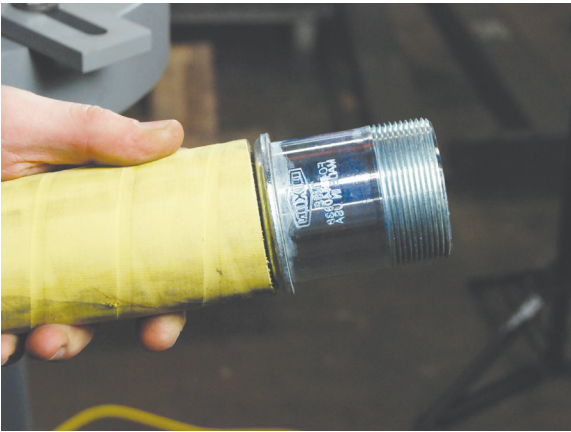


5



Ensuring that the hose end is cut square, chamfer the I.D. of the hose $\frac{1}{8}$ " at a 45° angle (this is to relieve hose end flare of rubber tube hoses during stem insertion). If the hose is to be static grounded, follow hose manufacturers procedure for proper static grounding.

6



Lubricate the I.D. of the hose and the O.D. of the stem with Dixon® lubricant or equivalent. Insert the stem all the way into the hose until the ring on the stem comes in contact with the end of the hose.

7



Slide the ferrule over the stem and over the O.D. of the hose until the turned over portion of the ferrule rests on the ring of the stem.

8a



Lubricate the outside of the ferrule with Crisco® (recommended) or a high viscosity oil or heavy duty grease.

8b

Lubricate the I.D. of the die halves with Crisco® (recommended) or a high viscosity oil or heavy duty grease.



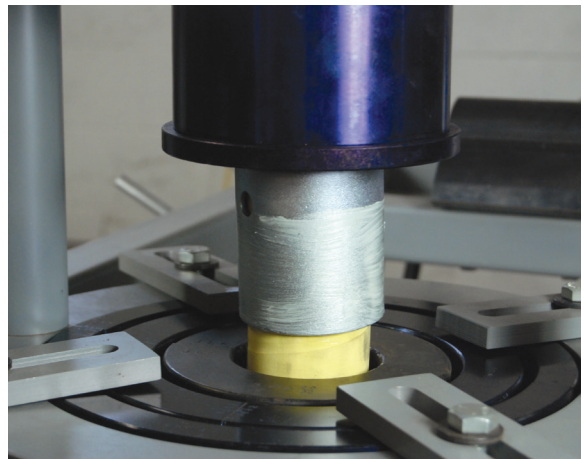
9

Insert the hose fitting assembly through the bottom of the ram (between the die holders) far enough to allow room to install the die halves into the die holder. After installing the die halves, push the hose up into the pusher until the ferrule comes in contact with the pusher.



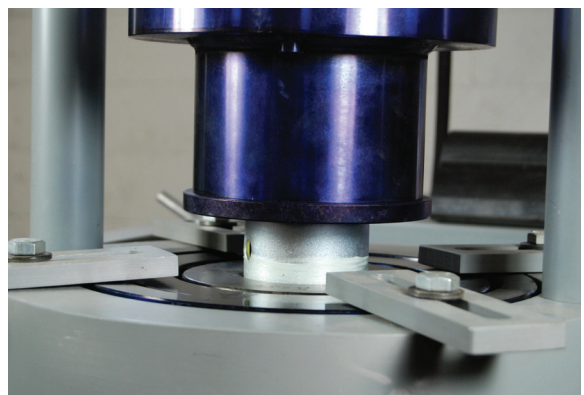
10

"Jog" the ram by quickly depressing and releasing the "on" button on the remote control switch, (or by depressing the foot pedal) until the ferrule enters the opening of the die. Let the ferrule enter the die slowly, making sure the end of the ferrule does not hit the top of the die. Make sure that the stem and ferrule are held securely against the pusher until the swaging process has begun.

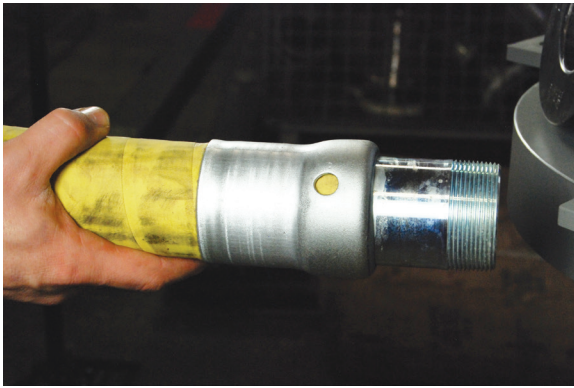


11a

To complete the swaging process, depress and hold the "on" switch of the remote control unit (or depress the foot pedal). Once the ferrule has entered the die and started to be reduced (approximately 1/3 of the way), it will no longer need the operator to keep it seated into the pusher. Continue the swage until the pusher meets the die, or until the gauge reads 10,000 PSI.



11b



Note: If the gauge reads 10,000 PSI before swaging is complete, stop. The ferrule or die used for that hose end may be incorrect. Contact Dixon® for further assistance.

Dixon® recommends that all hose assemblies be tested as recommended by the Association for Rubber Products Manufacturer's (ARPM) ARPMINC.com.

Typical Setup - 25 Ton Ram, External Swaging

