



The Right Connection®

25 Ton Ram Operating Instructions

Section 7

Product Updates & Notes

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ENGINEERING BULLETIN

PRODUCT UPDATE

Date: October 28, 1997

Part Number: **IXM40**, 2½" Internal Expansion Male Stem

Update: Use **M011-384** Thread Adapter for assembly

Reason: Possible thread collapse during expansion process

In order to prevent possible thread collapse on **IXM40's** during installation, it is recommended that a female threaded adapter be installed prior to installation. The adapter part # is **M011-384**. Follow this procedure for installation:

1. Lubricate stem ID and small end of expansion plug.
2. Thread **M011-384** onto threads of **IXM40** hand tight ONLY!
3. Slide stem over pull rod thread adapter end first.
4. Seat **M011-384** onto OUTER recess of **25ADAPT250**.
5. Follow normal IX procedure.
6. When the assembly is removed from the pull rod, remove **M011-384** and clean the stem ID of excess lubricant.

ENGINEERING BULLETIN

PRODUCT UPDATE

Date: October 6, 1998

To: All 25 Ton Ram Customers

From: Dixon Engineering

Part Number: 4" Swaging and 4" IX Stems

In an effort to keep you up to date on installation procedures for the 25 Ton Ram, please review the following information regarding Swaging of 4" hose and the Internal Expansion of 4" Male Threads.

Swaging:

Dixon® recently received a report of a coupling retention situation using 4" Swaged Cam & Groove with Goodyear's Orange Flexwing Hose and 4" TM Holedall Stems on Boston Royalflex 1196 Hose. The fittings were installed using a 25 Ton Ram. Coupling movement occurred.

Both of the situations were corrected by using a die holder longer than the standard die holder (**DH9-004**). The new longer die holder is part number **DH9-004-1**.

It has been Dixon®'s policy that when applications arise where an improvement to a system is warranted, it notifies its customer base. Therefore, it is our recommendation that when doing 4" Swaged Cam & Groove or Standard Holedall Stems, you use the new 4" Die Holder. This is our first experience with any 4" Swage type fittings assembled with the 25 Ton Ram not performing as intended. It is important to note that it is only on the 25 Ton Ram that this new Die Holder is required.

The new Die Holder is to be used in conjunction with the **DH9-004** currently in use for 4" stems. The **DH9-004** is still needed to do smaller ID hoses, as well as with the **25IXATTACH**. The **DH9-004-1** is only for 4" ID hose.

Internal Expansion:

Dixon® recently received a report of a situation concerning the installation of 4" Internal Expansion Male Threaded Stems (**IXCM64**). The fittings were installed using a 25 Ton Ram with the **25IXATTACH**. At the base of the **25IXATTACH** is the 4" Adapter. Over time this adapter end can wear. This wear can cause the 4" **IXM64** stem to collapse at the threads during the installation process. This happens because even pressure is not applied on the threads as the stem is being expanded.

The situation can be corrected by using an adapter designed for the 4" fittings. This new part number is **M011-385**. Unlike the adapter designed for the **IXM40's**, this adapter is recommended only if the **25IXATTACH** has a worn plate. It is not a requirement that it be purchased to do 4" IX Stems.