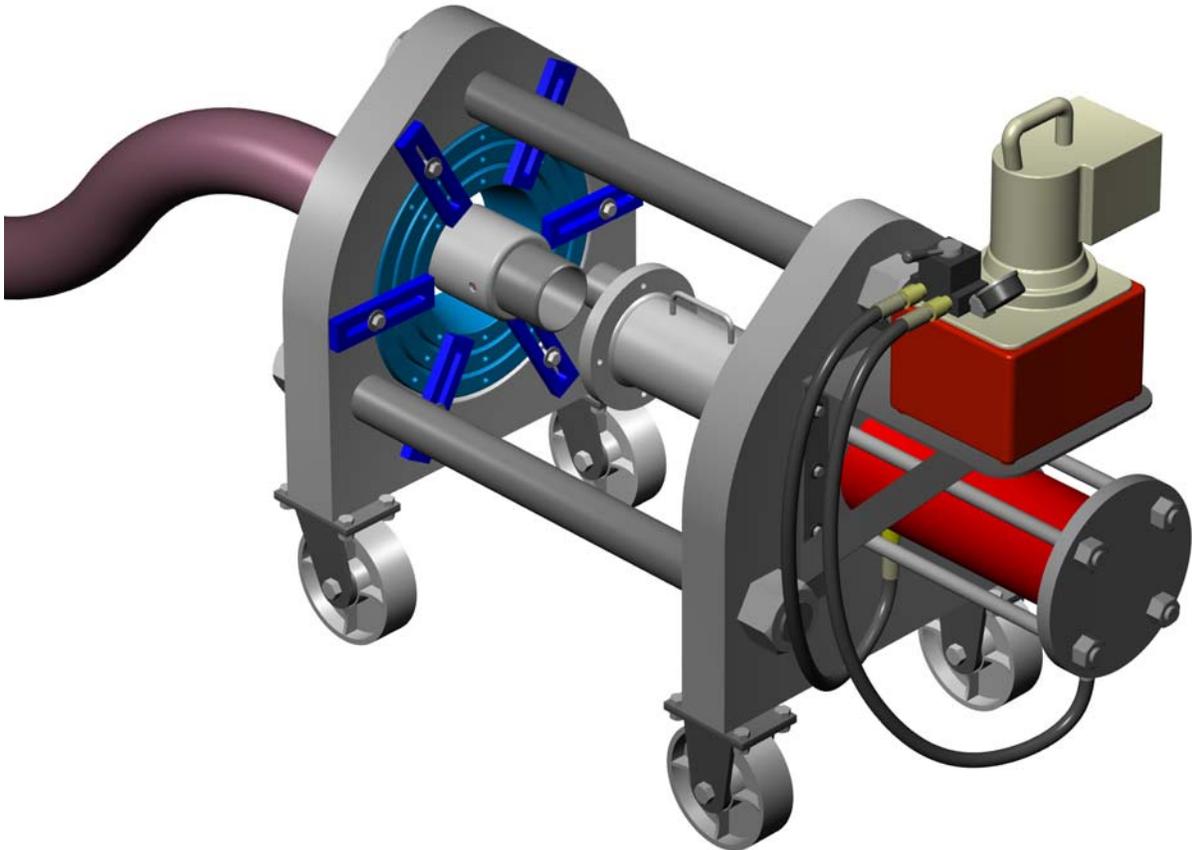




The Right Connection™

Section 2
100 Ton Ram Operating Instructions
for
**1-1/4" through 4" Standard & Long
Holedall Swaged Couplings**

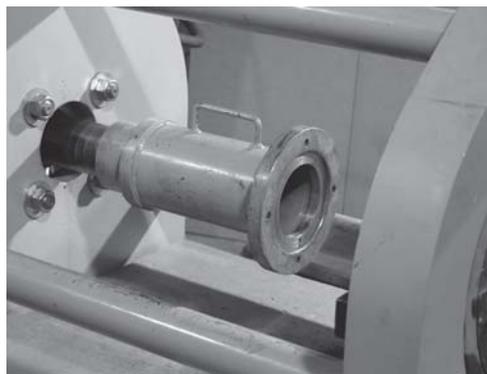


Dixon Valve & Coupling Company
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1a

Install the 4" main pusher (**M011-065**) by sliding it onto the rod cap of the ram cylinder. Make sure that the pusher is all the way on the rod cap.

For 1-1/4" - 3" couplings proceed to *Step 1b*.
For 4" couplings, proceed to *Step 2*.



1b

For 1-1/4" - 3" couplings insert the appropriate size adapter pusher into the 4" main pusher (**M011-065**).

Shown here is the 2" adapter pusher (**M011-115**) being inserted.



2

Install the required die holders ensuring that the seams between the die holder halves do not line up. The die holders are designed to fit one inside the other.

A guideline for selecting die holders is:

M012-001 1-1/4" - 3" I.D. hose

M012-002 4" - 6" I.D. hose

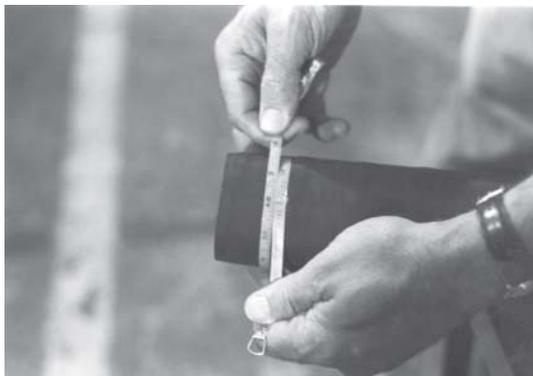
Caution! Never use a swaging die as a die holder!

Secure the die holders with tie down bars to prevent the die holders from slipping out of the die bed unexpectedly.



3

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.



4

Assuring that the hose end is cut square, chamfer the I.D. of the hose 1/8" at a 45° angle. This will aid in stem insertion. If the hose is to be static grounded, follow hose manufacturers procedure for proper static grounding.



5

Lubricate the I.D. of the hose and the O.D. of the stem with Dixon Coupling 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.



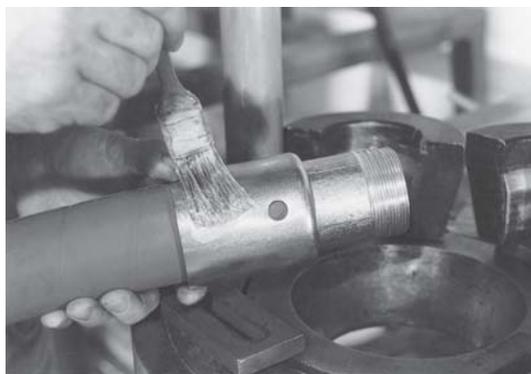
6

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.



7a

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



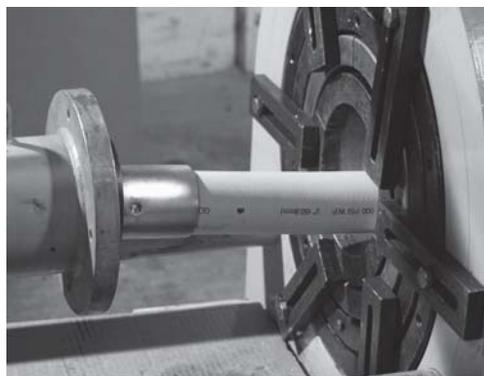
7b

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



8

Bring the hose with the stem and ferrule through the die bed. Insert the stem into the pusher so that the ferrule contacts the pusher. Make sure that there is sufficient room between the die holders and the end of the ferrule to comfortably insert the die halves into the die holders.



9

Lifting up the hose, insert one die half under the hose. Lower the hose so that it rests on the die. Insert the other die half. Make sure that the seams of the die do not line up with the seams on the die holders.



10

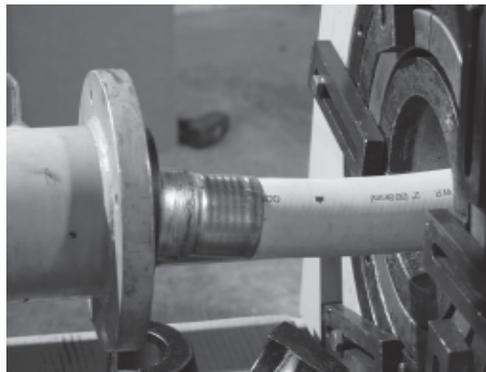
Continue to jog the cylinder until pressure begins to register on the gauge. Leave the directional control lever in the "FORWARD" position. Loosen the bolt on the tie down bar that is holding the die in place. Move the tie down bar so that the entire flange on the pusher will clear. Move any other tie down bars that may interfere with the pusher. When the pusher contacts the die release the pressure.

Important! Inspect the position of the stem and ferrule with the pusher. Make sure the collar (ring) on the stem is in contact with the ferrule before proceeding.



11

Move the directional control lever to the "REVERSE" position and depress the button on the remote. Retract the cylinder far enough (approximately 1") to allow a tie down bar be placed so that the die does not come out of the die holder. Secure the tie down bar by tightening the bolt. Continue retracting the cylinder until there is sufficient room for the stem and ferrule to clear the die bed.



12a

Position a rubber sheet or pad under the die bed. While holding the die in place with one hand, loosen the bolt on the tie down bar and move the tie down bar so that it clears the die. *Slowly* slide the hose towards the pusher. When the die clears the die holder, one or both halves may fall to the floor. If one half remains on the ferrule, tap it with a mallet until it releases. If both halves remain on the ferrule, it may require the halves be pried apart at the seam.



12b

Wipe excess lubricant from hose and ferrule. Bring hose with stem and ferrule back through die bed.

