



The Right Connection®

25 Ton Ram Operating Instructions

Section 6

Internal Expansion of Holedall H-520 Series Couplings



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1

Before you begin, make sure the Ram is fully retracted. Install the Holedall Petroleum Thrust Plate Adapter (**25ROSTPA**) to the end of the **25IXATTACH** with set screws. Select the proper Pull Rod.

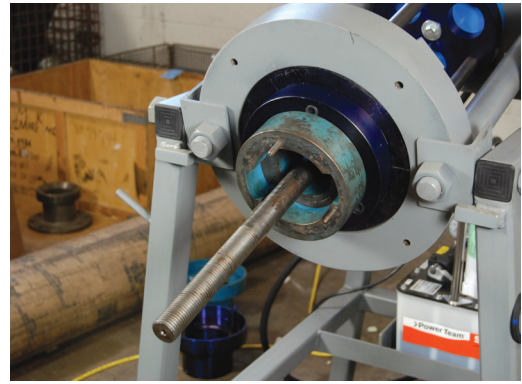
For $\frac{5}{8}$ " and $\frac{3}{4}$ " use **25ROSTROD** screwed together with **25ROSTADP**.

For 1" thru 1 $\frac{1}{2}$ " use **25RODSMALL**.

For 2" thru 4" use **25RODLARGE**.

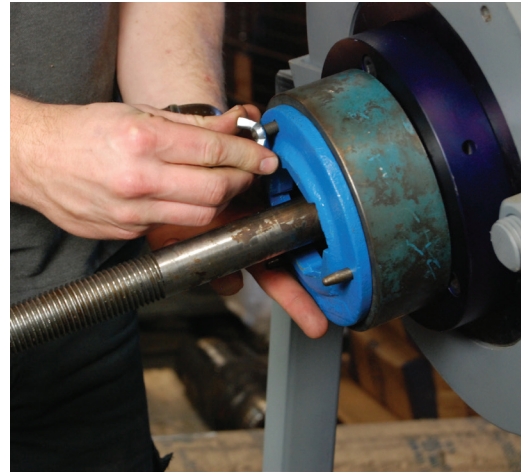
Screw the short threaded end of the rod into the face plate of the **25IXATTACH**.

Note: Picture shows **25RODLARGE**.



2

Select the corresponding thrust plate for the size fitting that you are installing. Ensuring that the recess is facing outward towards the operator, slide the thrust plate over the pull rod until it reaches the **25ROSTPA**. Align the holes in the thrust plate over the pins. Tighten the wing nut to lock it in place.



3

Slide the stem over the pull rod and into the recess of the thrust plate with the connection side of the stem facing the ram. For male stems, insert the hex into the recess of the thrust plate. For female stems, insert the first hex into the thrust plate so that it goes all the way through, so that the second hex will fit into the recess of the thrust plate.

Note: There is no need to lubricate the plug or stem. The stems are pre-lubricated at the factory .



4

Screw (or slide) the IX plug, small end first, onto the pull rod and into the shank of the stem. For 2" and above screw the retaining nut on until it contacts the plug. Move the stem slightly to allow for slack and hand tighten the plug or nut until it is snug.

Hint: When doing more than 1 hose assembly of the same ID size take the time to screw the pull rod further into the face plate of the **25IXATTACH**. This will allow for a shorter cycle time.



5



Accurately measure the hose O.D. with a diameter tape. Select the correct Holedall Petroleum ferrule from the DPL based upon the hose O.D. just measured.

Note: Always measure both ends of the hose for accurate ferrule selection.

6



Make sure the hose end is cut square. Measure and mark the hose in accordance with the provided Insertion Dimension chart (see page 3). This will ensure that the proper rubber displacement "pocket" is maintained when proceeding to Step 7.

7



Ensuring that the end of the ferrule is aligned with the mark from Step 6, slide the hose with ferrule over the shank until the ferrule contacts the shoulder of the stem. Check to see if the proper pocket is maintained.

Important! If there is an insufficient pocket for the rubber to displace into, damage may occur to the stem, ferrule and/or hose.

8



While holding the hose and the ferrule firmly against the stem shoulder, engage the Ram by stepping on the foot pedal, or depressing the "ON" button on the remote control. The internal expansion operation is complete when the hose and stem assembly is pushed completely over the internal expansion plug. Release the foot pedal or "ON" switch. Note: If the gauge reads 10,000 PSI before internal expansion is complete, stop. Contact Dixon® for further assistance.

During internal expansion never stand directly in front of the Ram. Visually inspect the coupling and clean excess lubricant from the stem ID. Dixon® recommends that all hose assemblies be tested as recommended by the Association for Rubber Products Manufacturer's.

Insertion Dimensions for Rostra Fittings

<u>Ferrule Sizes</u>	<u>Insertion Length</u>
1"	25/32"
1¼"	25/32"
1⅜"	25/32"
1½"	1-1/32"
2"	1-19/32"
2½"	2¼"
3"	2¾"
4"	3-7/32"

