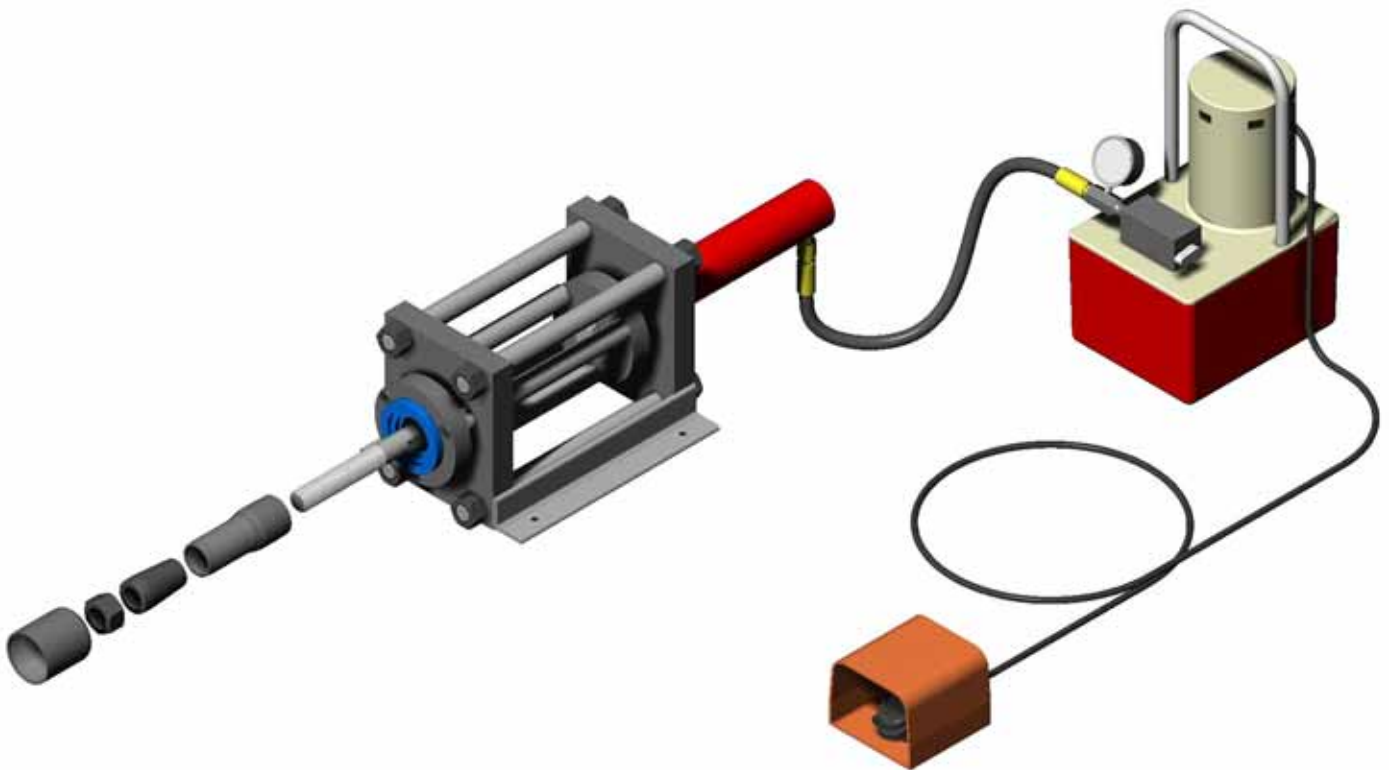


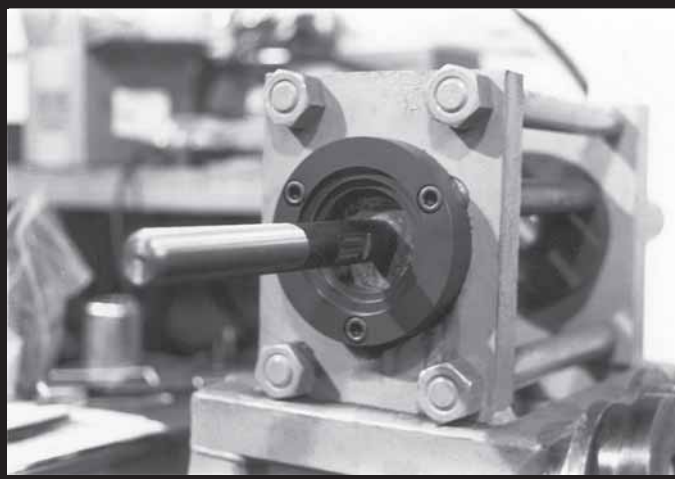


The Right Connection™

15 Ton Ram Internal Expansion Instructions *for* *Carbon Steel &* *Stainless Steel Couplings*



Dixon Valve & Coupling Company
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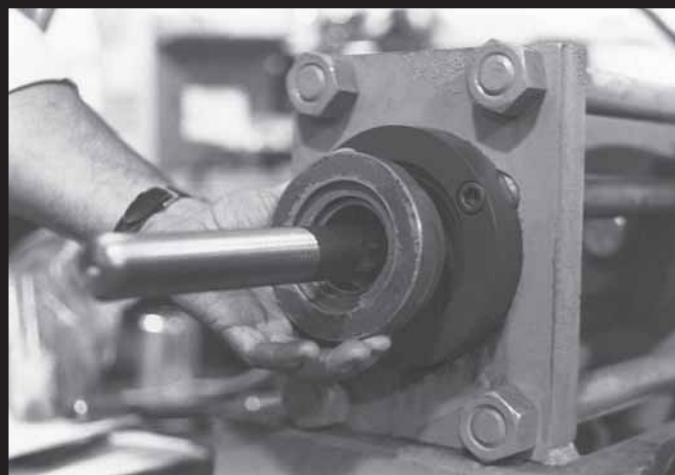
1a

Ensuring that the ram is fully retracted, select the proper pull rod. For 1" through 1 1/2" couplings use **15RODSMALL**. For 2" through 3" couplings use **15RODLARGE**.
Note: **15RODLARGE** is shown.



2

Select the corresponding adapter plate. The 15 Ton Ram comes with a built-in 3" adapter made to accept adapters 1" through 2 1/2".



3

Making sure that the recess (es) are facing outward towards the operator, slide the adapter plate over the pull rod until it reaches the base.



4a

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

4b

Lubricate the O.D. of the small half (tapered end) of the IX plug with Crisco® (recommended) or a high viscosity oil or heavy duty grease.



4c

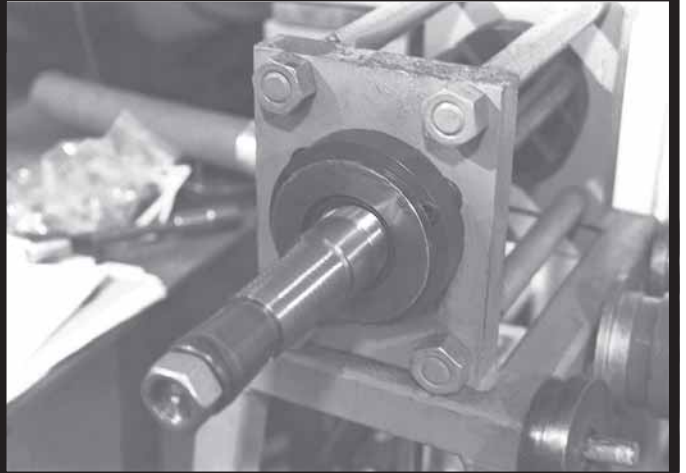
Slide the stem over the pull rod and into the recess of the adapter plate with the connection side of the stem facing the Ram.

Slide (or screw) the IX plug, small end first, onto the pull rod and into the shank of the stem.



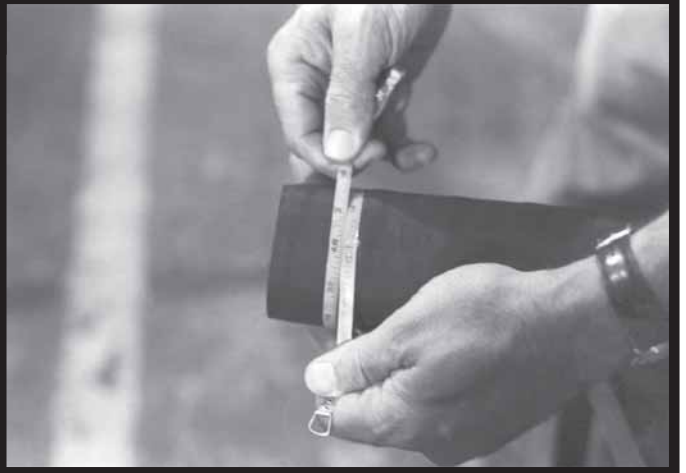
4d

Screw the retaining nut on (2" through 3") until it contacts the plug. Always assure that the nut is completely threaded onto the rod. With one hand move the stem about slightly while tightening the retaining nut or plug until it is snug. Lubricate the rest of the plug.



5

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





6

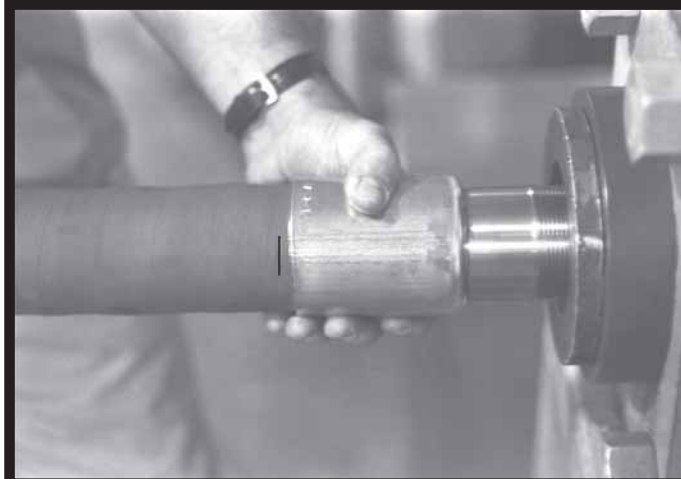
Make sure the hose end is cut square. Slide the ferrule over the hose until the hose end contacts the end of the ferrule. Place a mark on the hose at the junction of hose and ferrule. Move the ferrule away from the hose end 1/4". Place a second mark on the hose at the junction of the hose and ferrule. 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 second 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 proper pocket is maintained.

IMPORTANT! If there is insufficient "pocket" for the rubber to displace into, damage may occur to stem, ferrule or both.



8

Holding the hose and ferrule firmly against the stem shoulder and maintaining the proper "pocket", engage the Ram by stepping on the foot pedal. The internal expansion operation is complete when the hose and stem assembly is pushed completely over the internal expansion plug. Release the foot pedal. 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 stem I.D.

Note: For Holedall Petroleum H520 Series Couplings, please refer to the 15 Ton Ram Instructions for H520 Series Couplings.

Important! It is a prudent practice to test every length of hose after assembly and Dixon Valve & Coupling Company recommends this as a standard practice as recommended by the Rubber Manufacturers Association.