



The Right Connection®

25 Ton Ram Operating Instructions

Section 2

External Swaging of RSTxxxNOS Stems



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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. Install the **MISCPUSH** into the **25PUSH400** and secure with set screw.



2

Insert Die Holders into the Die Bed Plate as follows:

- a) **DH9-004** - Die holder. This is necessary to hold all of the other die holders.
- b) **DH6-003** - Die holder for 1¼" - 3" I.D. hose dies.

Secure the die holders with the keeper plates supplied.



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.

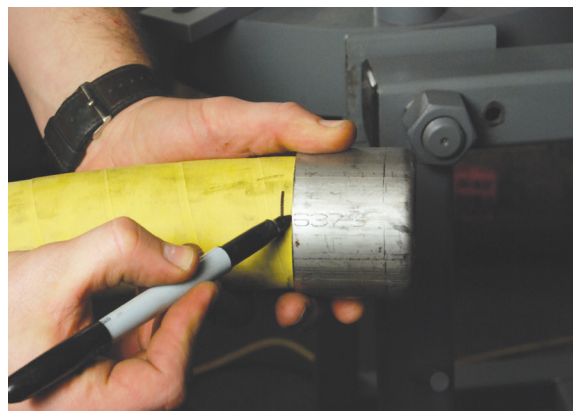
Select the correct ferrule and die based upon the hose free O.D. just measured, from the die chart.

Make sure the hose end is cut square. If the hose is to be static grounded, follow hose manufacturers procedure for proper static grounding.

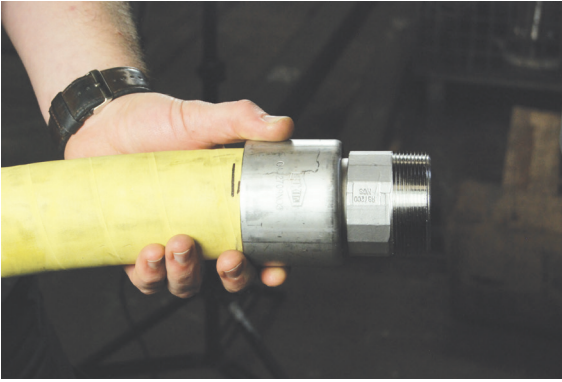


4

Slide the ferrule onto the hose. Place a mark on the hose at the end of the ferrule. Move the ferrule ⅛" from the mark just made towards the end of the hose. Place a second mark on the hose at the end of the ferrule.



5



Lubricate the O.D. of the stem and the I.D. of the hose with Dixon® lubricant or equivalent.

Insert the end of the fitting into hose. Assemble ferrule onto stem by sliding turned over portion of ferrule past notched section of the stem collar. Rotate the ferrule 90° (¼ turn). With ferrule and stem engaged, continue installing stem until ferrule reaches the second mark made on the hose.

6a



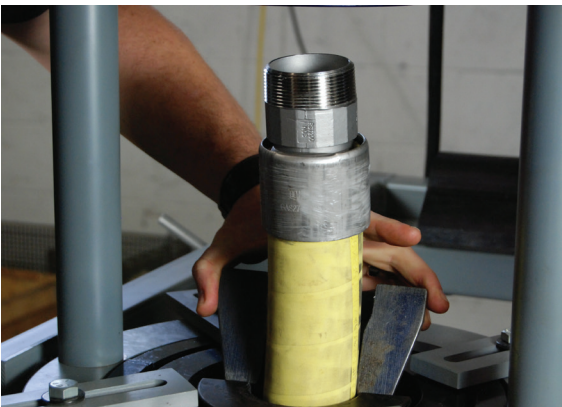
Lubricate the outside of the ferrule with Crisco® (recommended) or a high viscosity oil or heavy duty grease.

6b



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

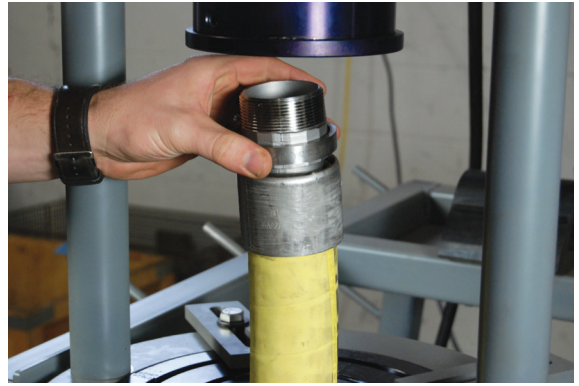
7



Insert the hose with fittings through the bottom of the ram (between the die holders) to allow enough room to install the die halves into the die holder.

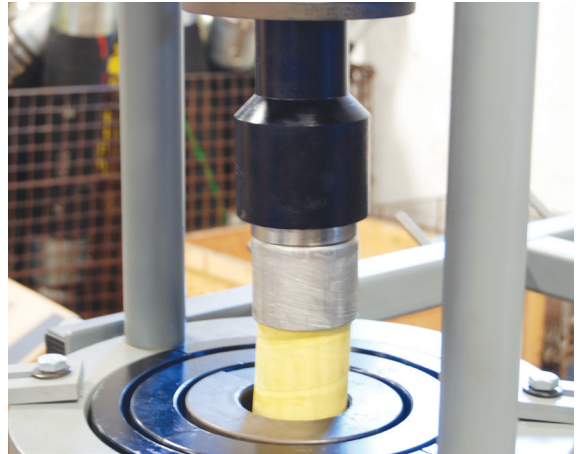
8

Install spacer ring over threads of stem and rest on top of ferrule.



9

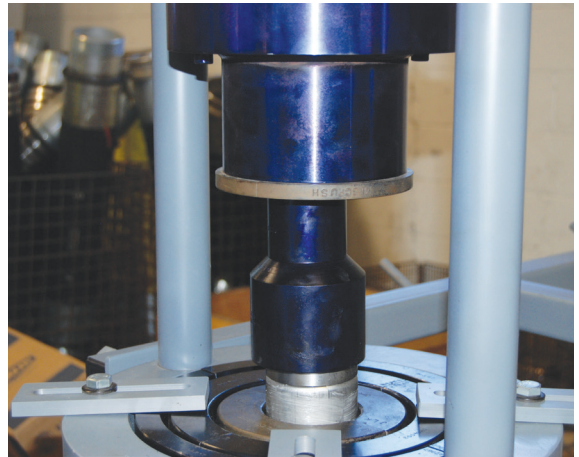
Install the proper pusher onto the stem. (Reference the chart for proper pusher selection)



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. Go slowly as the ferrule enters the die, making sure that the end of the ferrule does not contact the face of the die.

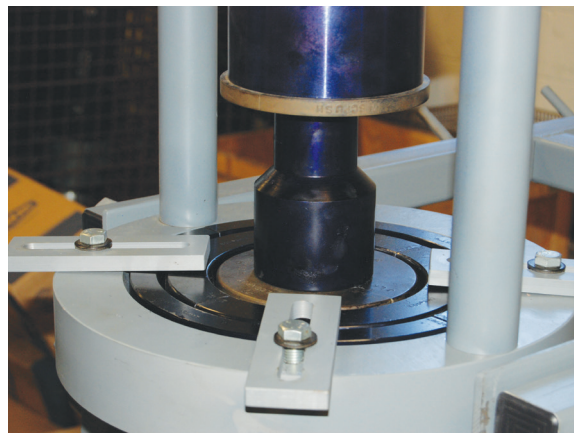
Make sure that the stem and ferrule are forced securely against the pusher until the swaging process has begun.



11

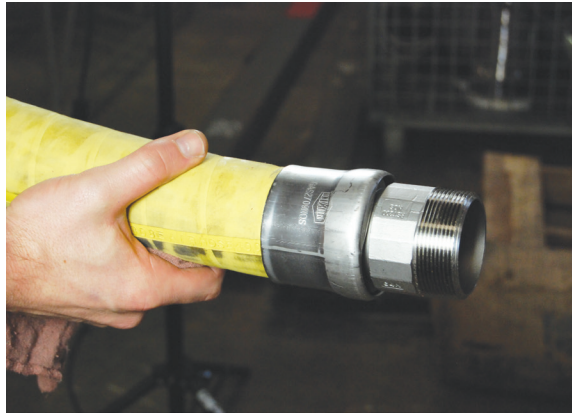
To complete the swaging process, depress and hold the "on" switch of the remote control unit (or depress the foot pedal). Once the ferrule has entered the die and starts to be reduced (approximately 1/3 of the way), it will no longer need the operator to keep it seated into the pusher. Continue the swage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

Note: The spacer ring will enter the die.



Lift the hose assembly up and remove the pusher, spacer ring and die halves from the die bed. Remove excess lubricant.

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



Pushers for RSTxxxNOS Stems

Size	Part Number
1½"	RE150PUSH
2"	D011-018
3"	RE300PUSH

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