



The Right Connection®

25 Ton Ram Operating Instructions

Section 9

Parts List

Dixon

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25 Ton Ram

25 TONRAM

Mulcoram includes 115V pump, 10,000 PSI hose, gauge

External Swage Attachments

Please note that on some sizes, more than two attachments may be necessary. Read carefully through all descriptions to determine which attachments are needed for your applications. Please consult Dixon® if you need more information.

25PUSH400	4" pusher for external swage (pusher hat) (Needed for all sizes)
25PUSH300	3" pusher for external swaging
25PUSH250	2½" pusher for external swaging
25PUSH200	2" pusher for external swaging
25PUSH150	1½" pusher for external swaging
25PUSH125	1¼" pusher for external swaging
DH9-004-1	Die holder needed for 4" only (must use with DH9-004)
DH9-004	Die holder needed for all sizes
DH6-003	Die holder needed for 1-1/4" to 3"
RST300SPACE	3" spacer ring for NOS ferrules (must use with 25PUSH300E)
RST200SPACE	2" spacer ring for NOS ferrules (must use with D011-018)
RST150SPACE	1½" spacer ring for NOS ferrules (must use with RE150PUSH)

Swage dies not included

25 Ton Ram

Equipment to Swage 1¼" to 4" ID Hose (cont.)

RN150NOPUSH	1½" pusher for notched turned back nipple
RN200NOPUSH	2" pusher for notched turned back nipple
RN300NOPUSH	3" pusher for notched turned back nipple
RN400NOPUSH	4" pusher for notched turned back nipple
M011-331	Pusher for female Holedall (TF16WF1-80)
M011-332	Pusher for female Holedall (TF16WF3-80)
M011-333	Pusher for female Holedall (TF16WF3-80)
25PUSH125-MOD	Pusher for 1¼" female Holedall
25PUSH200-MOD	Pusher for 2" female Holedall

Unirange External Swage

Equipment to Install ¼" to 1" Unirange Couplings

DH9-004	Die holder needed for all Sizes
DH6-003	Die holder for all Sizes 3" and below
DH3-001	Die holder needed for all Sizes 1" and below
25PUSH100	Pusher adapter (needed for all sizes below)
M011-327	Pusher for 16P1
M011-328	Pusher for 16P2, R16P1620
M011-329	Pusher for 16P3
M011-330	Pusher for 16P4, R16P1770
M011-320	Pusher for 12P1
M011-321	Pusher for 12P2
M011-322	Pusher for 12P3
M011-313	Pusher for 8P1
M011-314	Pusher for 8P2
M011-315	Pusher for 8P3
M011-310	Pusher for 6P1
M011-311	Pusher for 6P2
M011-312	Pusher for 6P3
M011-306	Pusher for 4P1
M011-307	Pusher for 4P2
M011-308	Pusher for 4P3
AKPUSH	Pusher for Air King® ½" - 1"

Swage dies not included

25 Ton Ram

Equipment to Swage 1" through 4" Cam & Groove

DH9-004-1	Die holder needed for 4" only (must be used with DH9-004)
DH9-004	Die holder needed for all sizes
DH6-003	Die holder needed for 3" and below
DH3-001	Die holder needed for 1" and below
25PUSH400C	Pusher for 4" C
25PUSH400E	Pusher for 4" E
25PUSH300E	Pusher for 3" E
D011-018	Pusher for 2" C, 2" E and 3" C
RC150PUSH	Pusher for 1½" C (two parts)
RE150PUSH	Pusher for 1½" E
RC100PUSH	Pusher for 1" C
RE100PUSH	Pusher for 1" E
150CGSPACE *	Spacer rings for 1½" C
100CGSPACE *	Spacer rings for 1" C

Swage dies not included

* Future designs may not require spacer rings. Contact Dixon® for more information.

25 Ton Ram

Equipment to Internally Expand Steel IX

25IXATTACH	Internal expanding attachment for 25 Ton Ram includes 4" internal expanding adapter (needed for all sizes)
DH9-004	Die holder/ adapter for 25IXATTACH (needed for all sizes)
25RODLARGE	IX rod for 2" - 4" hose
25RDLG-A	Large rod for only 25TONRAM
25RDLG-B	Nut only for 15 & 25 TON RAMS
25RODSMALL	IX rod for 1" to 1½" hose
25RDSML-A	Small pull rod
25RDSML-B	Small pull rod adapter
25RDSML-C	Nut for small rod
M011-385	4" IX adapter (IXM64 only)
25ADAPT300	3" IX adapter
25ADAPT250	2½" IX adapter
M011-384	2½" IXM40 adapter (must be used with 25ADAPT250)
25ADAPT200	2" IX adapter
25ADAPT150	1½" IX adapter
25ADAPT125	1¼" IX adapter
25ADAPT100	1" IX adapter
IXPLUG400	4" IX plug for steel & Holedall Petroleum fittings
IXPLUG300	3" IX plug for steel & Holedall Petroleum fittings
IXPLUG250	2½" IX plug for steel & Holedall Petroleum fittings
IXPLUG200	2" IX plug for steel & Holedall Petroleum fittings
IXPLUG150	1½" plug for steel & Holedall Petroleum fittings
IXPLUG125	1¼" IX plug for steel & Holedall Petroleum fittings
IXPLUG100	1" IX plug for steel & Holedall Petroleum fittings

25 Ton Ram

Equipment to Internally Expand Flow Chief Food Grade Fittings

25IXATTACH	Internal expanding attachment for 25 Ton Ram includes 4" internal expanding adapter for male NPT (needed for all sizes)
DH9-004	Die holder (needed for all sizes)
25RODLARGE	IX rod for 2" - 4" hose
25RDLG-A	Large rod for only 25TONRAM
25RDLG-B	Nut only for 15 & 25 TON RAMS
25RODSMALL	IX rod for 1" to 1½" hose
25RDSML-A	Small pull rod
25RDSML-B	Small pull rod adapter
25RDSML-C	Nut for small rod
25ADAPT300	3" IX adapter for male NPT
25ADAPT250	2 ½" IX adapter for male NPT
25ADAPT200	2" IX adapter for male NPT
25ADAPT150	1½" IX adapter for male NPT
PFADAPT400	4" sanitary end adapter (Tri Clover style)
PFADAPT300	3" sanitary end adapter (Tri Clover style)
PFADAPT250	2½" sanitary end adapter (Tri Clover style)
PFADAPT200	2" sanitary end adapter (Tri Clover style)
PFADAPT150	1½" sanitary end adapter (Tri Clover style)
PFADAPT150-3A	1½" sanitary end adapter for 3A (Tri Clover style)

25 Ton Ram

Equipment to Internally Expand Flow Chief Food Grade Fittings (cont.)

PFACNTA400	4" bevel seat Acme nut adapter (must buy PFADAPT400 to use this part)
PFACNTA300	3" bevel seat Acme nut adapter (must buy PFADAPT300 to use this part)
PFACNTA250	2½" bevel seat Acme nut adapter (must buy PFADAPT250 to use this part)
PFACNTA200	2" bevel seat Acme nut adapter (must buy PFADAPT200 to use this part)
PFACNTA150	1½" bevel seat Acme nut adapter (must buy PFADAPT150 to use this part)
IXFDPLG400	4" food plug (for stainless steel fittings only)
IXFDPLG300	3" food plug (for stainless steel fittings only)
IXFDPLG250	2½" food plug (for stainless steel fittings only)
IXFDPLG200	2" food plug (for stainless steel fittings only)
IXFDPLG150	1½" food plug (for stainless steel fittings only)
IXFDPLG287	3" 3A food plug (for stainless steel fittings only)
IXFDPLG187	2" 3A food plug (for stainless steel fittings only)
IXFDPLG137	1½" 3A food plug (for stainless steel fittings only)

25 Ton Ram

Equipment to Internally Expand Holedall Petroleum Fittings

25IXATTACH	Internal expanding attachment for 25 Ton Ram includes 4" internal expanding adapter for male NPT (needed for all sizes)
DH9-004	Die holder/adapter for 25IXATTACH (needed for all sizes)
25ROSTPA	Adapter plate to hold thrust plates
25ROSTROD	Pull rod for 5/8", 3/4" and 1" - consists of the following:
25ROSTROD-A	Small Holedall Petroleum pull rod
25DSML-B	Small pull rod adapter
25RDSML-C	Nut for small rod
25RODLARGE	Pull rod for 2" through 4" - Consists of the following:
25RDLG-A	Large rod for only 25TONRAM
25RDLG-B	Nut only for 15 & 25 TON RAMS
25RODSMALL	Pull rod for 1" to 1½" - consists of the following:
25RDSML-A	Small pull rod
25RDSML-B	Small pull rod adapter
25RDSML-C	Nut for small rod
IXPLUG400	4" IX plug for steel & Holedall Petroleum fittings
IXPLUG300	3" IX plug for steel & Holedall Petroleum fittings
IXPLUG250	2½" IX plug for steel & Holedall Petroleum fittings
IXPLUG200	2" IX plug for steel & Holedall Petroleum fittings
IXPLUG150	1½" IX plug for steel & Holedall Petroleum fittings
IXPLUG138	1⅜" IX plug for steel & Holedall Petroleum fittings
IXPLUG125	1¼" IX plug for steel & Holedall Petroleum fittings
IXPLUG100	1" IX plug for steel & Holedall Petroleum fittings

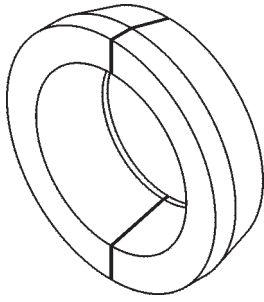
25 Ton Ram

Equipment to Internally Expand Holedall Petroleum Fittings (cont.)

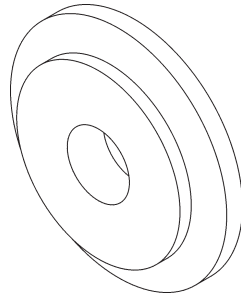
25000HTL03	1" IX plug (must use 25ROSTROD)
25000HTL02	¾" IX plug (must use 25ROSTROD)
25000HTL01	⅝" IX plug (must use 25ROSTROD)
25000HTL26	Thrust plate for 3" aluminum H-520 style fittings
25000HTL25	Thrust plate for 2½" aluminum H-520 style fittings
25000HTL24	Thrust plate for 2" aluminum H-520 style fittings
25000HTL23	Thrust plate for 4" H-520 style fittings
25000HTL22	Thrust plate for 3" H-520 style fittings
25000HTL21	Thrust plate for 2½" H-520 style fittings
25000HTL20	Thrust plate for 2" H-520 style fittings
25000HTL19	Thrust plate for 1⅜" & 1½" H-520 style fittings
H5211NSTADT	Adapter for NST female 1" H-520 style fittings
H5231NSTADT	Adapter for NST female 1½" H-520 series couplings
25000HTL18	Thrust plate for 1¼" H-520 style fittings
25000HTL17	Thrust plate for 1" H-520 style fittings
25000HTL16	Thrust plate for 1" x 1½" H570 style fittings Thrust plate for 1" x 1 9/16" H-570 style fittings
25000HTL15	Thrust plate for 1" x 1-25/64" H-570 style fittings Thrust plate for 1" x 1-29/64" H-570 style fittings
25000HTL14	Thrust plate for ¾" H-520 style fittings
25000HTL13	Thrust plate for ¾" x 1-7/32" H-570/H580 fittings
25000HTL12	Thrust plate for ¾" x 1-9/64" H-570/H580 fittings Thrust plate for ¾" x 1-11/64" H-570/H580 fittings Thrust plate for ¾" x 1-13/64" H-570/H580 fittings
25000HTL11	Thrust plate for ⅝" H-570 fittings

* Consult Dixon® for the necessary attachments to use the Scovill style plugs (1¼" - 4")

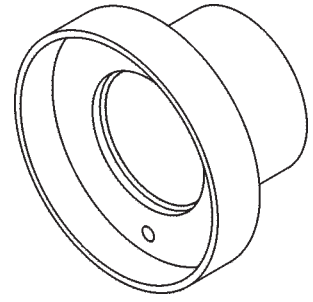
25 Ton Ram Parts - External Swaging



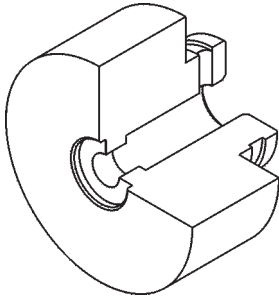
Die Holder



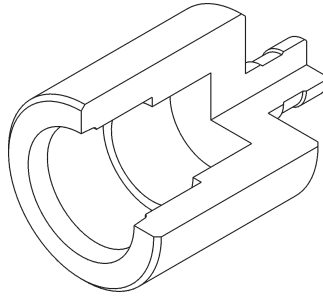
Pusher Plate



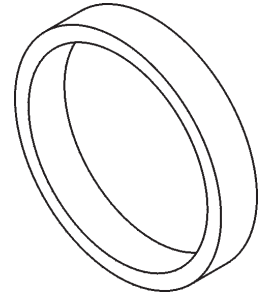
Pusher Hat (4")



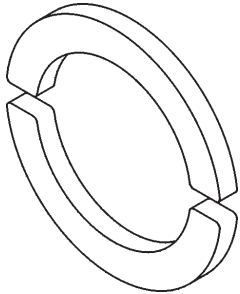
Pusher Adapter



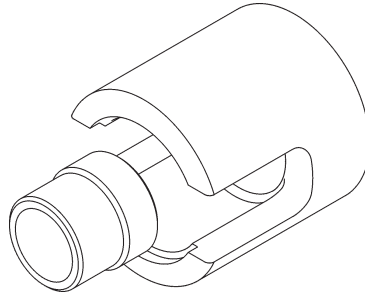
Unirange Pusher



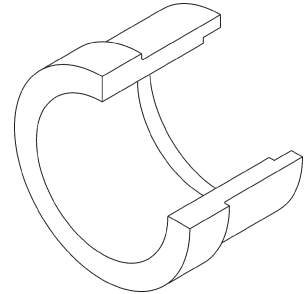
RSTXXX Spacer



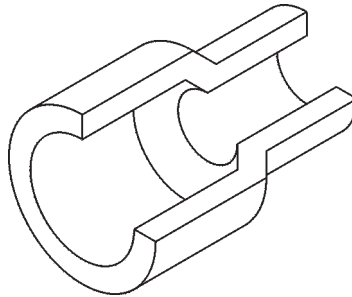
Cam & Groove Space
Ring



1 1/2" Cam & Groove
Pusher



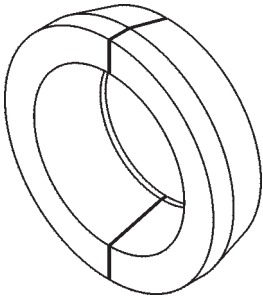
3" & 4" Cam & Groove
Pusher



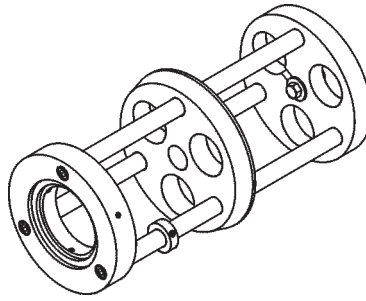
2" Type C & E Cam & Groove
Pusher;
3" Type C Cam & Groove Pusher

These drawings represent the overall shape of the parts only. Please consult the complete Ram Attachments listing for specific descriptions regarding size, usage, etc.

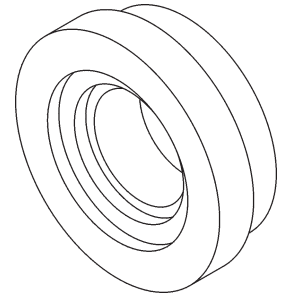
25 Ton Ram Parts - Internal Expansion



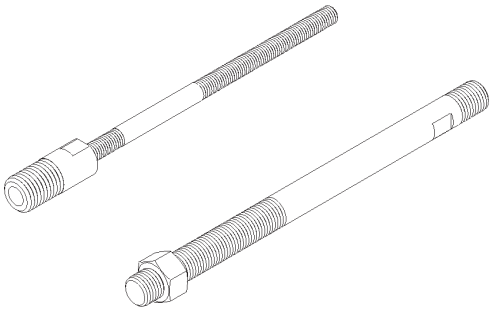
Die Holder



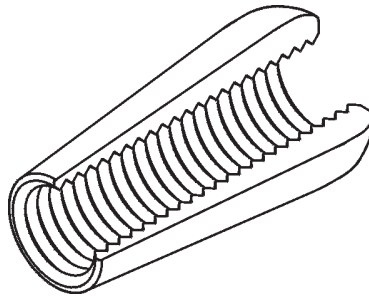
Internal Expanding Attachment



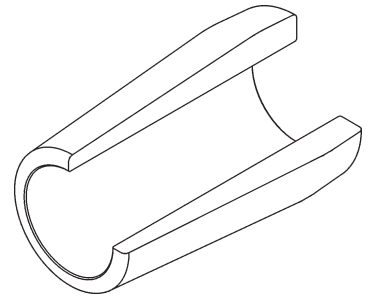
IX Adapter



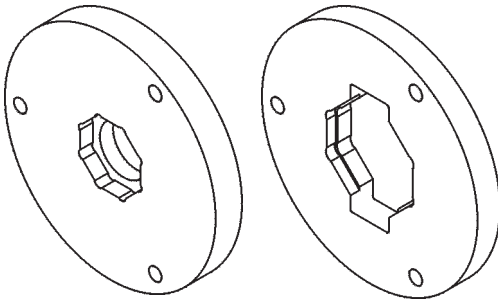
IX Pull Rods



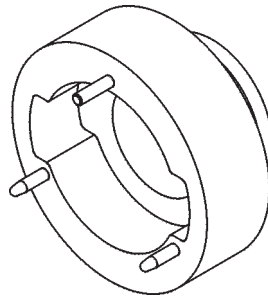
1 1/2" IX Plug



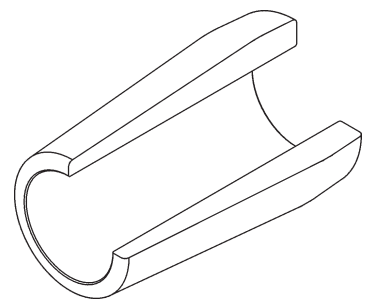
2" & larger IX Plug



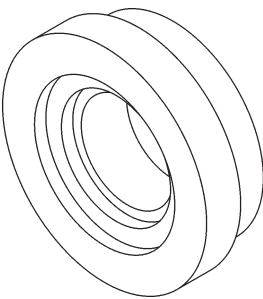
Thrust Plates



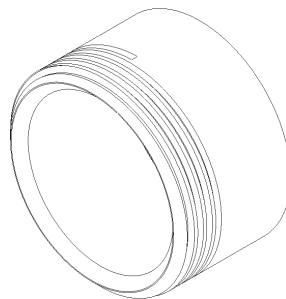
Adapter Plate for Thrust Plate



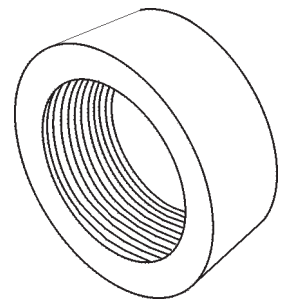
Food Plug



Sanitary End Adapter



Acme Nut Adapter



IX Male NPT Adapter

These drawings represent the overall shape of the parts only. Please consult the complete Ram Attachments listing for specific descriptions regarding size, usage, etc.

PUMP INSTALLATION

