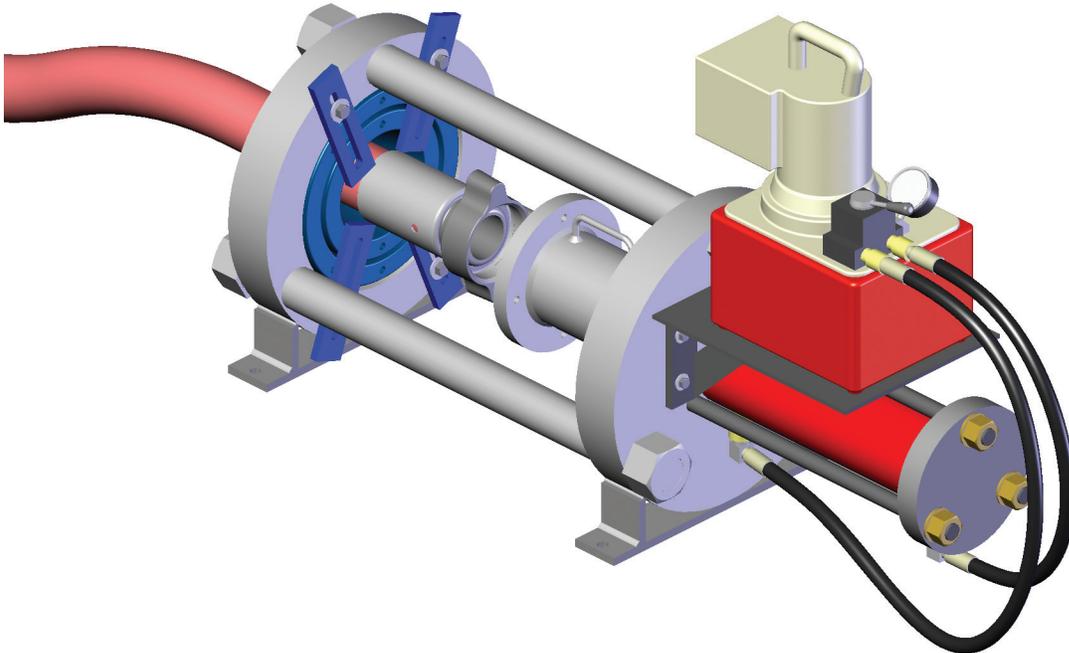




*The Right Connection®*

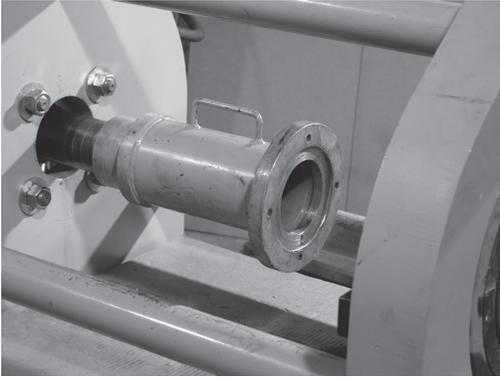
*Section 6*

**50 Ton Ram Operating Instructions  
for  
Boss Ground Joint  
Holedall™ Couplings**



Dixon  
800 High Street • Chestertown, MD 21620  
ph: 877.863.4966 fax: 800.283.4966  
dixonvalve.com

1



Install the 6" Main Pusher (**MPUSH600**) by sliding it onto the rod cap of the ram cylinder. Make sure that the pusher is all the way on the rod cap. Install the appropriate adapter pusher (by coupling size) into the main pusher.

2



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 chart.

3



Assuring that the hose end is cut square, chamfer the I.D. of the hose  $\frac{1}{8}$ " 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.

4a



Hold the ferrule against the stem collar (sizes 1½" - 3" only). Using a small ruler or other measuring device, insert it between the stem and ferrule until it contacts the stem collar. Measure the depth at the end of the ferrule. Place a mark on the hose (the hose end to be assembled) that corresponds with this measurement.

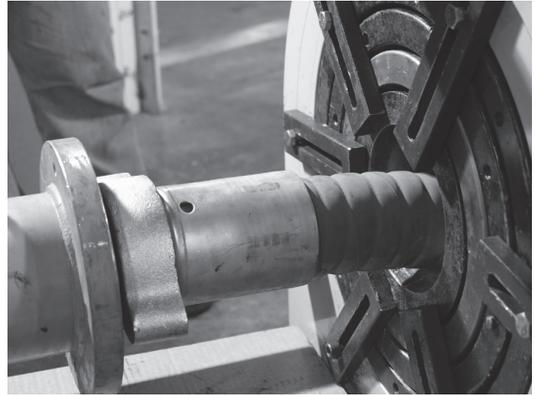
## 4b

Lubricate the I.D. of the hose and the O.D. of the stem (as well as possible) with Dixon Coupling Lubricant or equivalent. Insert the stem all the way until the mark on the hose (from Step 4a) is at the end of the ferrule.



## 5

Bring the hose with the stem and ferrule through the die bed. Position the wing nut (or spud) as close to the pusher as possible. 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.



## 6a

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:

- DH3-001** ¼" - 1" I.D. hose
- 50TDH6003** 1¼" - 3" I.D. hose
- 50TDH9004** 4" I.D. hose

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

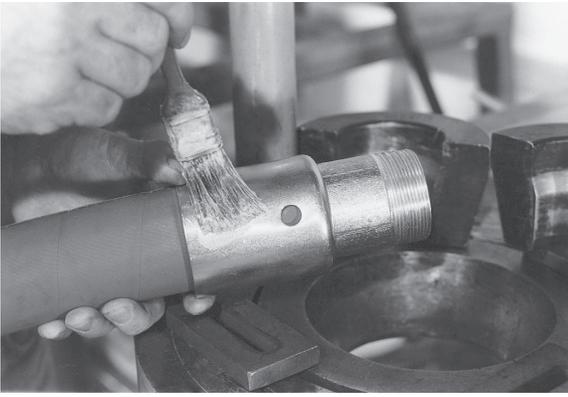


## 6b

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

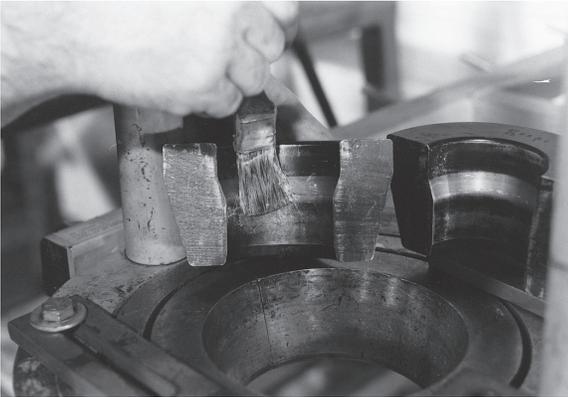


7a



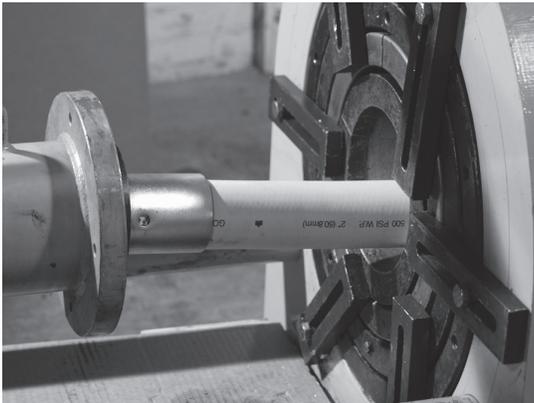
Lubricate the outside of the ferrule with Crisco® (recommended) or high viscosity oil or heavy duty grease.

7b



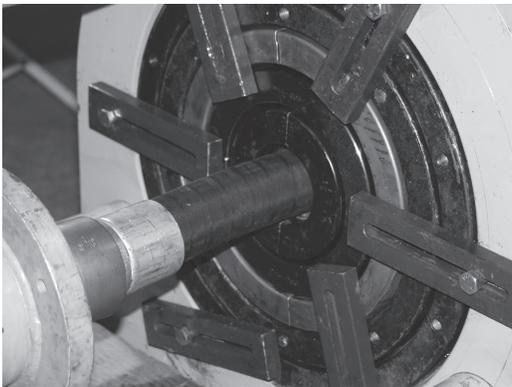
Lubricate the I.D. of both die halves with Crisco® (recommended) or high viscosity oil or heavy duty grease.

8a



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.

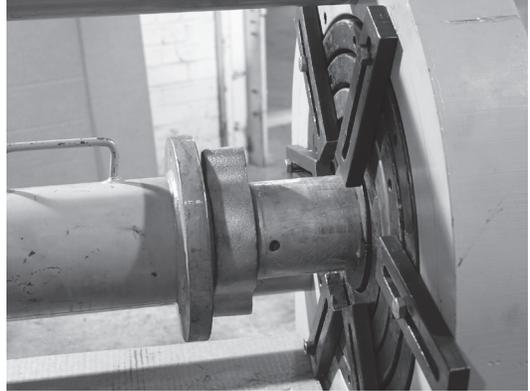
8b



While holding the die in place with one hand, place one of the tie down bars over the die so that it does not come out of the die holder unexpectedly. Secure the tie down bar by tightening the bolt.

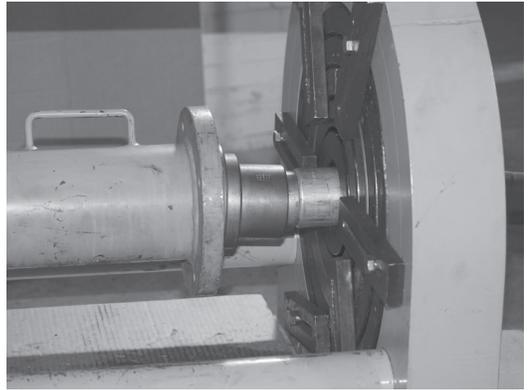
## 9a

Move the directional control lever to the "FORWARD" position and depress the button on the remote. Advance the cylinder forward until the end of the ferrule is near the die opening. Using a wooden board or metal pipe, lift the ferrule up. Jog the cylinder forward by depressing and releasing the button on the remote. This will allow the ferrule to enter the die slowly. After the ferrule has entered the die, stop advancing the cylinder.



## 9b

Align the wing nut (or spud) with the pusher ensuring they are flush with each other. Jog the cylinder forward until pressure begins to register on the gauge. Leave the directional control lever in the "FORWARD" position. Check the alignment between pusher and wing nut (or spud). If any adjustment is necessary, do it now.



## 9c

Reposition the tie down bars on the die face so that the wing nut (or spacer) will clear.

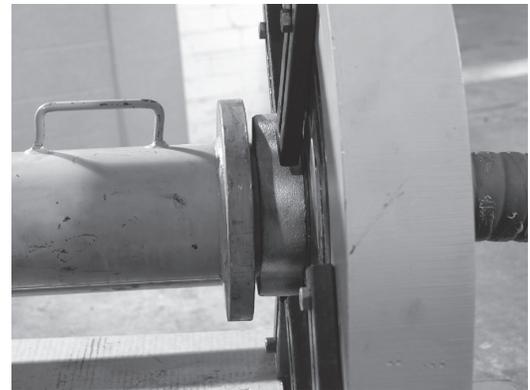


## 10a

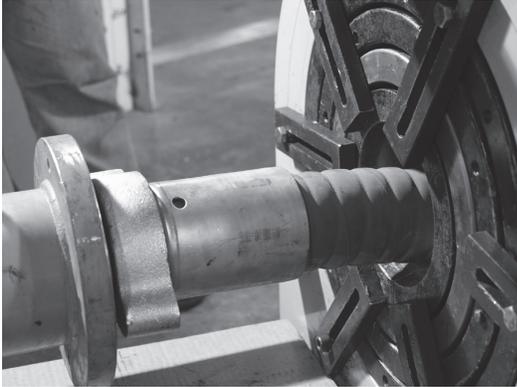
Depress and hold the button on the remote until the wing nut (or spacer) contacts the die face. Release the button. Return the directional control lever to the "NEUTRAL" position.

**Note:** For  $\frac{3}{4}$ " and 1" couplings having the ferrule crimped on, stop the swage when the crimped area of the ferrule begins to enter the die.

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

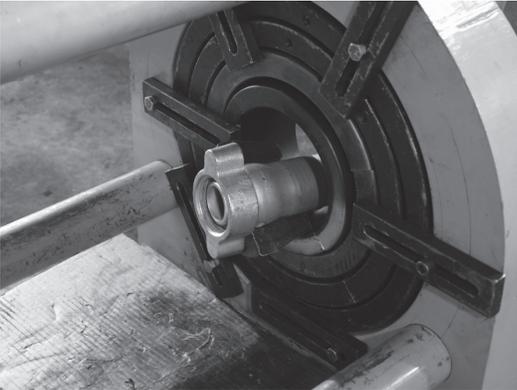


**10b**



Move the directional control lever to the "REVERSE" position and depress the button on the remote. Retract the cylinder until there is sufficient room for the stem and ferrule to clear the die bed.

**11a**



Position a rubber sheet or pad under the die bed. 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.

**11b**



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