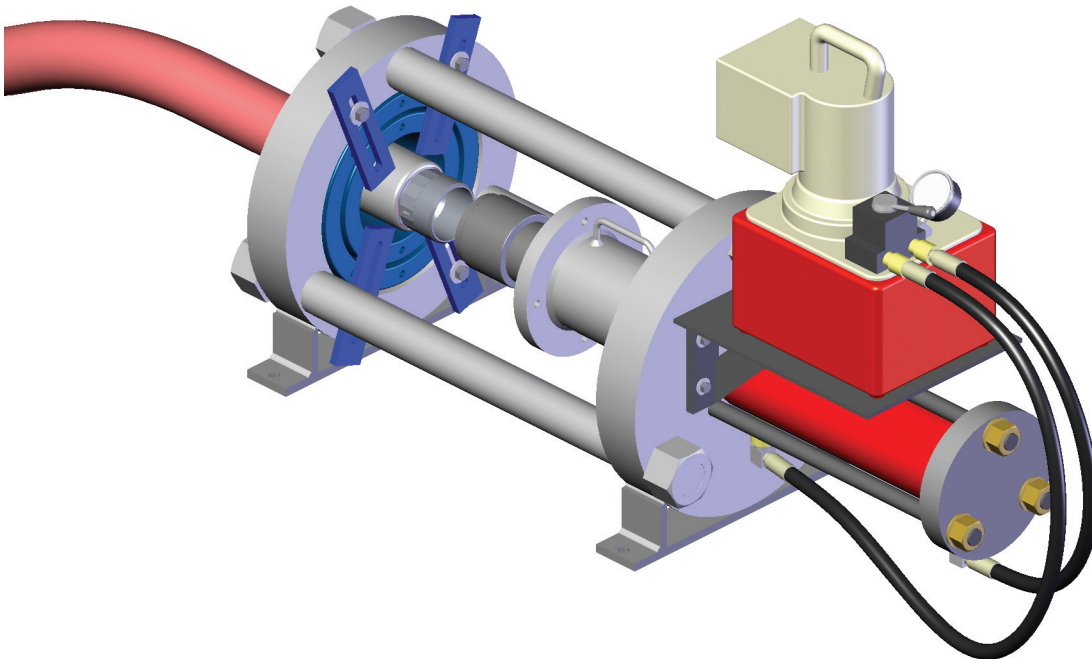




*The Right Connection®*

*Section 4*

**50 Ton Ram Operating Instructions  
for  
RSTxxxNOS Stems  
with  
GASxxxxNOS Ferrules**



Dixon  
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1



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:

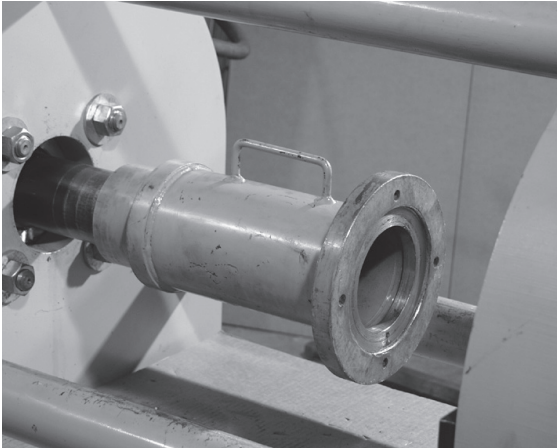
**50TDH6003** 1¼" - 3" I.D. hose

**50TDH9004** 4" - 6" I.D. hose

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

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

2



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

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.

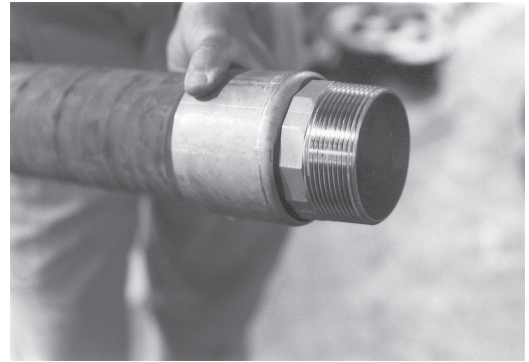
4



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



6

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



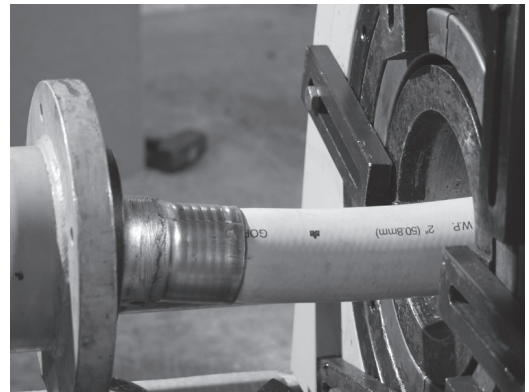
7

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



8

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.





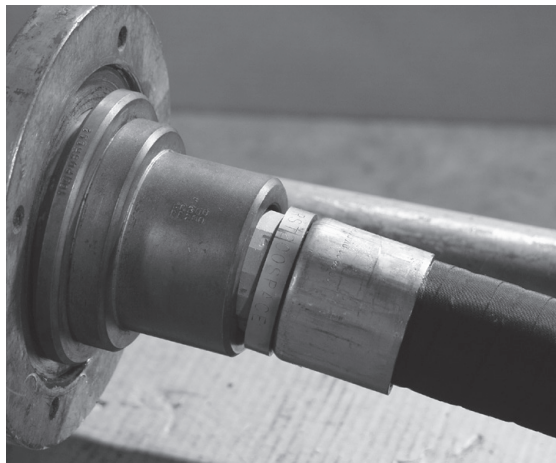
9



Install appropriate size spacer ring over the threads of the stem so that it contacts the ferrule. The spacer rings are listed as follows:

1½"	<b>RST150SPACE</b>
2"	<b>RST200SPACE</b>
3"	<b>RST300SPACE</b>

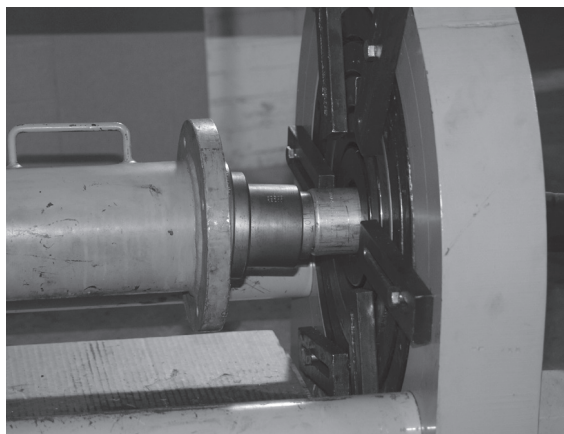
10



Insert the stem into the pusher so that the spacer ring just installed contacts the pusher.

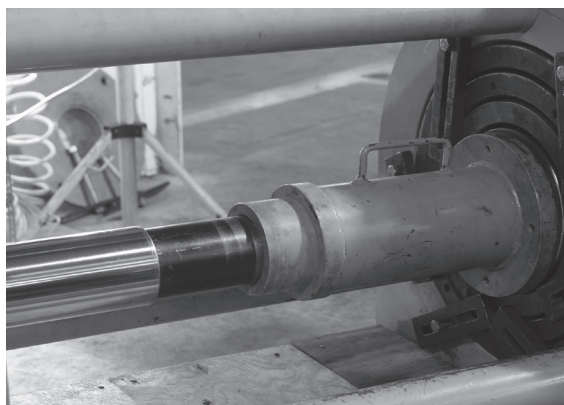
1½"	<b>50TPUSH150</b>
2"	<b>50TPUSH200</b>
3"	<b>50TPUSH300</b>

11



Put the directional control lever in the "FORWARD" position. 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 by depressing and releasing the button on the remote. This will allow the ferrule to enter the die slowly without contacting the die face.

12



Depress and hold the button on the remote until the pusher meets the die face. When the extension contacts the die, release the button. Move the directional control lever to the "NEUTRAL" position. **Note:** The spacer ring will 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.

13

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

