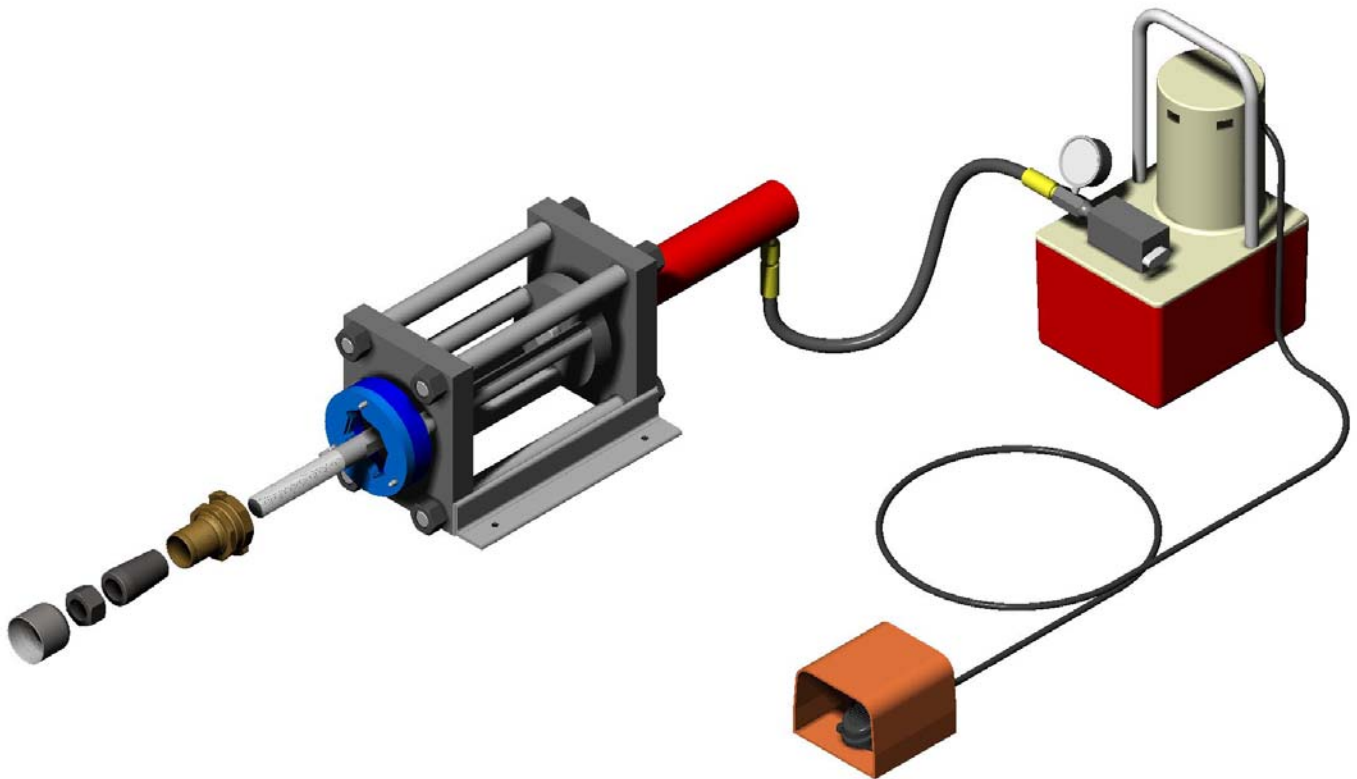


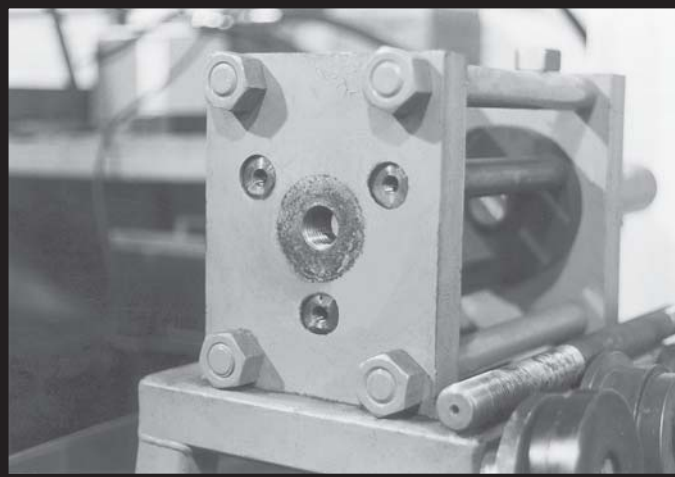


The Right Connection™

# 15 Ton Ram Internal Expansion Instructions for *Holedall Petroleum H520 Series Couplings*

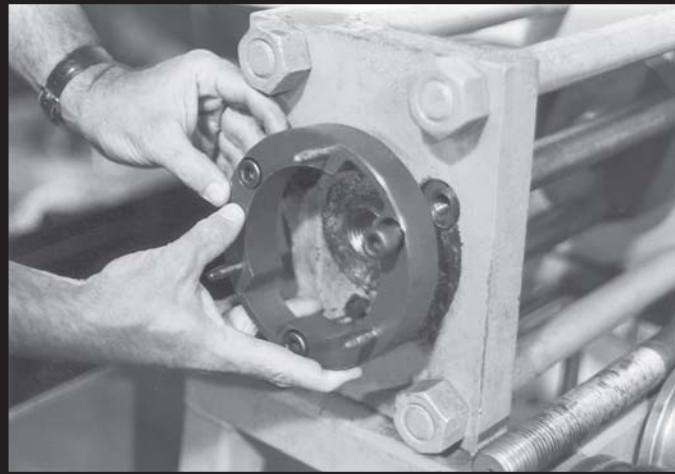


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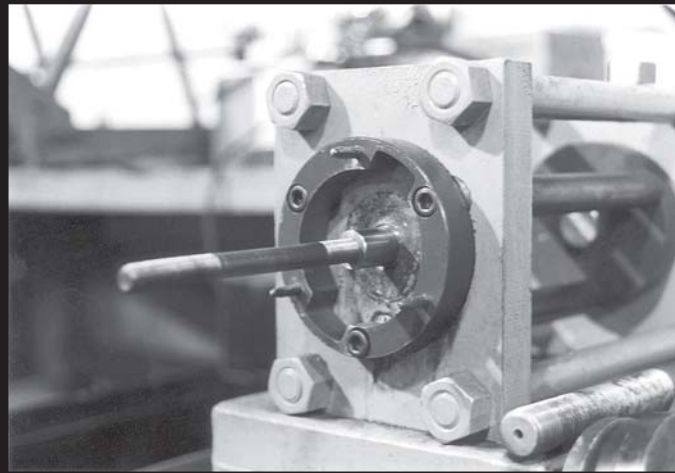
1a

Ensuring that the ram is fully retracted, remove the standard base plate.



1b

Replace the standard base plate with the Holedall Petroleum thrust plate holder (*15ROSTPA*).



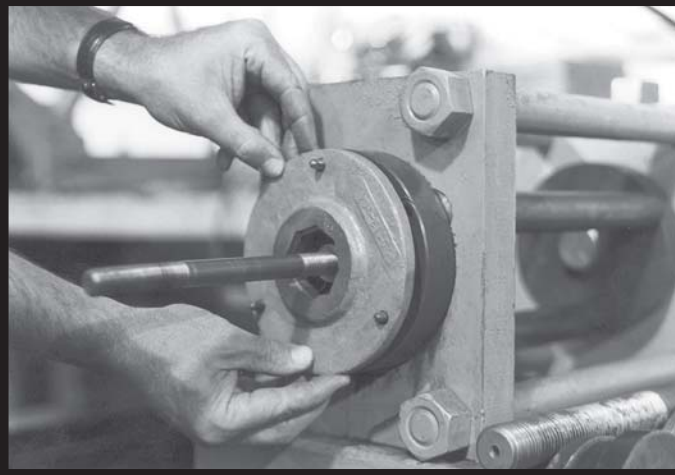
2

Select the proper pull rod. For 5/8" and 3/4" couplings use *15ROSTROD*. For 1" through 1 1/2" couplings use *15RODSMALL*.

Note: *15RODSMALL* is shown. For 2" through 4" couplings use *15RODLARGE*.

Note: To use 1 1/4" through 4" keyed plugs (from HMA machine) use *15ROSTROD* with keyed shaft part number *25000HSP10*.

Install the pull rod into the base plate of the 15 Ton Ram.



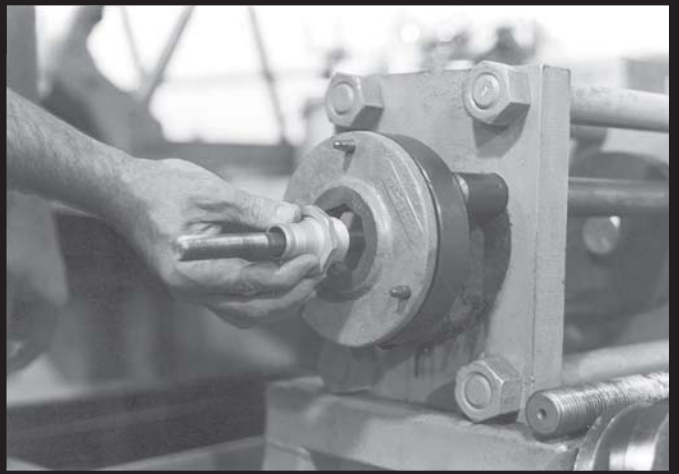
3

Select the proper thrust plate. Making sure that the recess is facing outward towards the operator, slide the thrust plate over the pull rod until it reaches the thrust plate holder. Align the holes in the thrust plate with the dowel pins on the *15ROSTPA* and slide the thrust plate over the dowel pins until it contacts the face of the *15ROSTPA*.

4a

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. For male stems, insert the hex into the recess of the thrust plate. For female stems, insert the first hex into the thrust plate so that it goes all the way through then insert the second hex into the recess of the thrust plate.

Note: *Do not lubricate!* No additional lubricant is needed. Stems are pre-lubricated from the factory.



4b

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

Note: 1" stem is shown.

Screw the retaining nut (if needed) on until it contacts the plug. With one hand move the stem about slightly while tightening the nut or plug until it is snug.



5

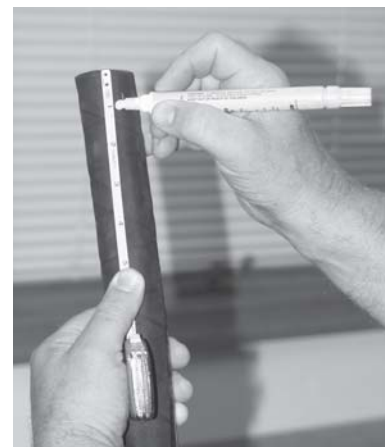
Accurately measure the hose O.D. with a diameter tape. Select the correct Holedall Petroleum ferrule from the DPL based upon the hose O.D. just measured.

**IMPORTANT!** If the incorrect ferrule is selected, failures will occur. Each hose end must be accurately measured and a ferrule selected based upon that measurement.



6

Make sure the hose end is cut square. Measure and mark the hose in accordance with the provided Insertion Dimension chart (see page 5). 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 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 the proper pocket is maintained.

**IMPORTANT!** If there is incorrect “pocket” for the rubber to displace into, damage may occur to the stem, ferrule or both, which could result in coupling failure.



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. Visually inspect the coupling.

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.

*Note: For internal expansion of Holedall Carbon Steel and Stainless Steel couplings, please refer to the Internal Expansion instructions for the 15-Ton Ram using Carbon Steel and Stainless Steel 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.

## Insertion Dimensions for Rostra Fittings

<u>Ferrule Sizes</u>	<u>Insertion Length</u>
1" .....	25/32"
1¼" .....	25/32"
1-3/8" .....	25/32"
1½" .....	1-1/32"
2" .....	1-19/32"
2½" .....	2-1/4"
3" .....	2-3/4"
4" .....	3-7/32"

