The Right Connection®

Section 10

50 Ton Ram Operating Instructions
for
List of Parts and Attachments

Equipment to Swage 1¼" to 6" I.D. Hose Sizes

Part Number	Description
50TONRAM	Mulcoram including motor (115 volt) pump, 10,000 PSI hose and gauge

External Swage Attachments

Part Number	Description
MPUSH600	6" Pusher (needed for all sizes)
50TPUSH500	5" Pusher
50TPUSH400	4" Pusher
50TPUSH300	3" Pusher
50TPUSH250	2½" Pusher
50TPUSH200	2" Pusher
50TPUSH150	1½" Pusher
50TPUSH125	1¼" Pusher
50TDH9004	Die holder for 4" die (needed for all sizes)
50TDH6003	Die holder for 1¼" - 3" dies (needed for all sizes)

Equipment to Swage 1" through 4" Cam & Groove

Part Number	Description
MPUSH600	6" Pusher (needed for all sizes)
50TPUSH400	4" Pusher
50TDH9004	Die holders for 4" die (needed for all sizes)
50TDH6003	Die holders for 1¼" - 3" dies (fits into **50TDH9004**)
100PUSHCG4E	Pusher for 4" E
100PUSHCG4C	Pusher for 4" C
100PUSHCG3	Pusher for 3" E (fits on **100PUSHCG2**)
100PUSHCG2	Pusher for 2" C and E and 3" C (also use with **100PUSHCGRC** and **RE100PUSH**)
100PUSHCG15	Pusher for 1½" C and E (consists of **100PUSHCG15A** and **RC150PUSHB**)
100PUSHCG15A	1½" Pusher adapter
RC150PUSHB	1½" Pusher
100PUSHCGRC	Pusher for 1" C & G (fits inside the **100PUSHCG2**)
RE100PUSH	Pusher for 1" E (use with **100PUSHCG2**)
*150CGSPACE **	Spacer rings for 1½" C
*100CGSPACE **	Spacer rings for 1" C
RST150SPACE	1½" Spacer ring for NOS ferrules (use with **100PUSHCG15E**)
RST200SPACE	2" Spacer ring for NOS ferrules (use with **100PUSHCG2**)
RST300SPACE	3" Spacer ring for NOS ferrules (use with **100PUSHCG3**)

Swage dies not included
* Future designs may not require spacer rings. Contact Dixon for more information.

Holedall™ Dies

Mininum	Maximum
¾" x 9/16"	2" x 1⅞"
2⅛" x 1-11/16"	4½" x 4¼"
4-9/16" x 4-5/16"	6-15/16" x 6-7/16"
7" x 6½"	10" x 9½"
10" x 9½"	12-15/16" x 12⅜"
13" x 12⅜"	16" x 15½"

* Dies will be invoiced for full selling price when shipped, credit will be issued when returned for full selling price less rental charge. All freight charges are to be paid by Customer. All dies are to be returned within 30 days.

Equipment to Internally Expand 1" - 6" I.D. Hose
For Use with Steel IX Fittings

Part Number	Description
50T-0073	Master IX bar adapter (needed for all sizes)
50T-0072	IX master plate (needed for all sizes, this part is also 6" IX adapter)
25RODLARGE	IX Bar for 2" - 4" - consists of the following: *25RDLG-A -* large rod for only 25 ton ram *25RDLG-B -* nut only for 15 & 25 ton rams
25RODSMALL	IX bar for 1¼" and 1½" - consists of the following: *25RDSML-A -* small pull rod *25RDSML-B -* small pull rod adapter *25RDSML-C -* nut for small rod
001-0083	IX bar adapter for 5" - 6"
001-0065	5" IX adapter
001-0067	4" IX adapter (needed for all sizes from 1¼" to 4")
M011-385	4" IXM64 adapter (goes into 001-0067)
25ADAPT300	3" IX adapter
25ADAPT250	2½" IX adapter
M011-384	2½" IX adapter (**IXM40** only, use with **25ADAPT250**)
25ADAPT200	2" IX adapter
25ADAPT150	1½" IX adapter
25ADAPT125	1¼" IX adapter
25ADAPT100	1" IX adapter
IXPLUG600	6" IX plug
IXPLUG500	5" IX plug
IXPLUG400	4" IX plug
IXPLUG300	3" IX plug
IXPLUG250	2½" IX plug
IXPLUG200	2" IX plug
IXPLUG150	1½" IX plug
IXPLUG125	1¼" IX plug
IXPLUG100	1" IX plug

Equipment to Internally Expand "Flow Chief" Food Grade Fittings

Part Number	Description
001-0067	4" IX adapter (needed for all sizes from 1¼" to 4")
50T-0073	Master IX bar adapter (needed for all sizes)
50T-0072	IX master plate (needed for all sizes, this part is also 6" IX adapter)

25RODLARGE	IX bar for 2" - 4" - consists of the following:
	   25RDLG-A - large rod for only 25 ton ram
	   25RDLG-B - nut only for 15 & 25 ton rams

25RODSMALL	IX Bar for 1¼" and 1½" - consists of the following:
	   25RDSML-A - small pull rod
	   25RDSML-B - small pull rod adapter
	   25RDSML-C - nut for small rod

PFADAPT400	4" sanitary end adapter (tri clover style)
PFADAPT300	3" sanitary end adapter (tri clover style)
PFADAPT250	2½" sanitary end adapter (try clover style)
PFADAPT200	2" sanitary end adapter (tri clover style)
PFADAPT150	1½" IX sanitary end adapter (tri clover style)
PFADAPT150-3A	1½" 3A sanitary end adapter (tri clover style)
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 plugs
IXFDPLG300	3" food plugs
IXFDPLG287	3" food plug for 3A fittings (for stainless steel fitings)
IXFDPLG250	2½" food plugs
IXFDPLG200	2" food plugs
IXFDPLG187	2" food plug for 3A fittings (for stainless steel fittings)
IXFDPLG150	1½" food plugs
IXFDPLG137	1½" food plugs for 3A fittings
25ADAPT150-3A	1½" adapter (use with **IXFDPLG137**)