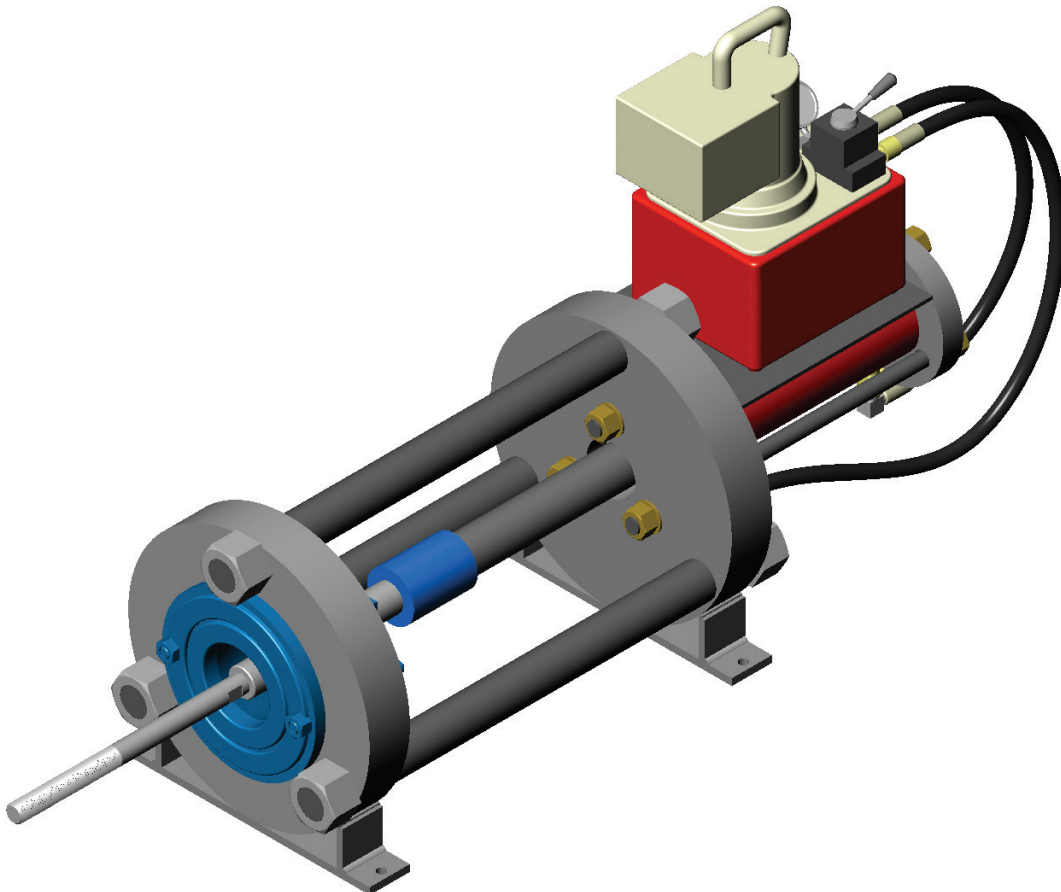




The Right Connection®

Section 7

**50 Ton Ram Operating Instructions
for
Converting from
Swaging to Internal Expansion**



Dixon

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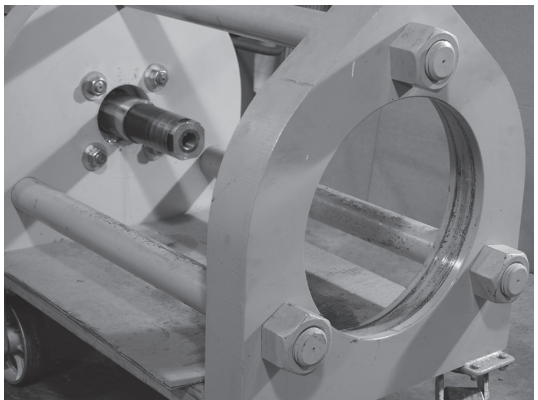
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1



Remove any swaging pusher from the ram cylinder rod cap.

2

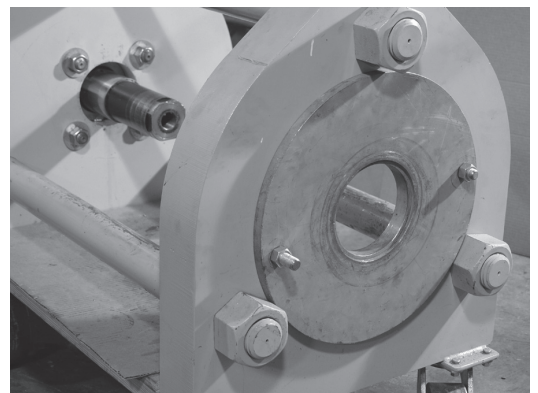


Position a rubber mat under the die bed. Position the tie down bars so that only one die bed spacer is clear. Remove the die bed spacer from die bed. Repeat this process until all die bed spacers have been removed from the die bed.

Caution! Die bed spacers are heavy. Remove the die bed spacers one half at a time.



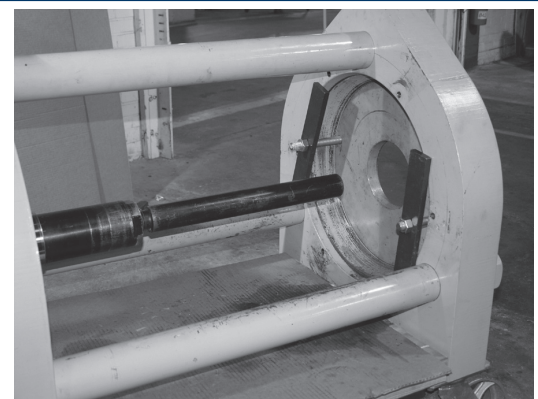
3



Install IX Master Plate onto outside of ram die bed. Position the bolt holes at the 3 o'clock and 9 o'clock positions. Secure with straps and bolts by positioning the straps on the inside of the die bed. Tighten the nuts on the bolts.

Note: It may be required to turn one or more of the large nuts on the outside of the die bed. If the IX Master Plate will not fit into the die bed opening, check the nuts to see if the flat on the nut is facing the die bed opening. If not, turn the nut until the flat is facing the opening.

4



Move the directional control lever to the "FORWARD" position. Depress the button on the remote and extend the ram cylinder fully. Release the button on the remote and move the directional control lever to the "NEUTRAL" position. Bring the IX Master Bar through the opening in the IX Master Plate, male thread end first. Thread the male thread on the IX Master Bar into the female thread of the rod cap. Continue to thread the bar in until the shoulder behind the thread on the bar contacts the face of the rod cap.