



The Right Connection®

Section 10

**100 Ton Ram Operating Instructions
for
List of Parts and Attachments**

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

Equipment to Swage 1¼" to 10" I.D. Hose Sizes

Part Number	Description
100 TONRAM	"Mulcoram" including motor (115 volt) pump and bed plates 1¼" - 10"

External Swage Attachments

Please note that on some sizes, more than two attachments may be necessary. Read carefully through all descriptions to determine which attachments are needed for your applications. Please consult Dixon if you need more information.

Part Number	Description
M011-242	10" pusher for all standard length stems with and without flange
M011-249	10" pusher extension for all plain, threaded and grooved end stems (for both standard and long length)
M011-256	10" spacer for all flanged assemblies(for both standard and long length)
M011-254	10" pusher for all long length stems with and without flange
M011-253	10" pusher extension for all plain, threaded, grooved and flanged end long length stems
M011-101	8" pusher for all plain, threaded, grooved and flanged end standard and long length stems.
M011-117	8" pusher extension for all plain, threaded, grooved and flanged end long length stems.
M011-118	8" spacer for all flanged assemblies (for both standard and long length)
M011-070	6" pusher for all plain, threaded, grooved and flanged end standard and long length stems.
M011-073	6" pusher extension for all plain, threaded, grooved and flanged end long length stems.
M011-132	6" spacer for all flanged assemblies(for both standard and long length)
M011-079	5" adapter pusher (fits into 6" pusher). For all plain, threaded, grooved and flanged end standard and long length stems.
M011-076	5" adapter pusher extension for all plain, threaded, grooved and flanged end long length stems
M011-135	5" spacer for all flanged assemblies (for both standard and long length)
M011-065	4" pusher for all stems
M011-131	4" spacer for all flanged assemblies
DH6-003	Die holder needed for 1¼" to 3"
M011-115	3" adapter pusher (fits into 4" pusher). For all stems.
M011-158	3" spacer for all flanged assemblies
M011-114	2½" adapter pusher (fits into 4" pusher). For all stems
M011-274	2½" spacer for all flanged assemblies
M011-113	2" adapter pusher (fits into 4" pusher)
M011-275	2" spacer for all flanged assemblies.
M011-112	1½" adapter pusher (fits into 4" pusher)
M011-111	1¼" adapter pusher (fits into 4" pusher)

Equipment to Swage 1" through 4" Cam & Groove

Part Number	Description
M011-065	4" pusher (needed for all sizes)
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 - consists of the following: 100PUSHCG15A - 1½" pusher adapter RC150PUSHB - 1½" pusher
100PUSHCGRC	Pusher for 1" cam and groove couplers (fits inside the 100PUSHCG2)
RE100PUSH	Pusher for 1" E (use with 100PUSHCG2)
RST300SPACE	3" spacer ring for NOS ferrules (use with 100PUSHCG3)
RST200SPACE	2" spacer rings for NOS ferrules (use with 100PUSHCG2)
RST150SPACE	1½" spacer rings for NOS ferrules (use with 100PUSHCG15E)
150CGSPACE *	Spacer rings for 1½" C
100CGSPACE *	Spacer rings for 1" C

Swage dies not included

* Future designs may not require Spacer Rings. Contact Dixon for more information.

Holedall™ Dies

Minimum	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 1¼" - 6" I.D. Hose

For Use with Steel IX Fittings

Part Number	Description
001-0086	Master IX bar adapter (needed for all sizes)
001-0083	IX bar for 5" - 6"
001-0072	IX master plate (needed for all sizes)(this part is also 6" IX adapter)
25RADLARGE	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
25RADSMALL	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
001-0065	5" IX adapter
001-0067	4" IX adapter (needed for all sizes from 1¼" to 4")
M011-385	4" IX adapter (fits into 001-0067)
25ADAPT300	3" IX adapter
25ADAPT250	2½" IX adapter
M011-384	2½" IX adapter (IXM40 Only). Must be used with 25ADAPT250
25ADAPT200	2" IX adapter
25ADAPT150	1½" IX adapter
25ADAPT125	1¼" IX adapter
25ADAPT100	1" IX adapter

Equipment to Internally Expand 1" - 6" I.D. Hose

For Use with Steel IX and Holedall™ Petroleum Fittings

Part Number	Description
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
001-0086	Master IX bar adapter (needed for all sizes)
001-0072	IX master plate (needed for all sizes) (this part is also 6" IX adapter)
001-0067	4" IX Adapter (for male NPT) Needed For All Sizes from 1¼" to 4"
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
25ADAPT300	3" IX adapter (for male NPT)
25ADAPT250	2½" IX adapter (for male NPT)
25ADAPT200	2" IX adapter (for male NPT)
25ADAPT150	1½" IX adapter (for male NPT)
PFADAPT400	4" IX sanitary end adapter (Tri Clover style)
PFADAPT300	3" IX sanitary end adapter (Tri Clover style)
PFADAPT250	2½" IX sanitary end adapter (Tri Clover style)
PFADAPT200	2" IX sanitary end adapter (Tri Clover style)
PFADAPT150	1½" IX sanitary end adapter (Tri Clover style)
PFADAPT150-3A	1½" 3A IX 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 (for stainless steel fittings)
IXFDPLG300	3" food plugs (for stainless steel fittings)
IXFDPLG250	2½" food plugs (for stainless steel fittings)
IXFDPLG200	2" food plugs (for stainless steel fittings)
IXFDPLG150	1½" food plugs (for stainless steel fittings)
IXFDPLG287	3" food plug for 3A fittings
IXFDPLG187	2" food plug for 3A fittings
IXFDPLG137	1½" food plug for 3A fittings