

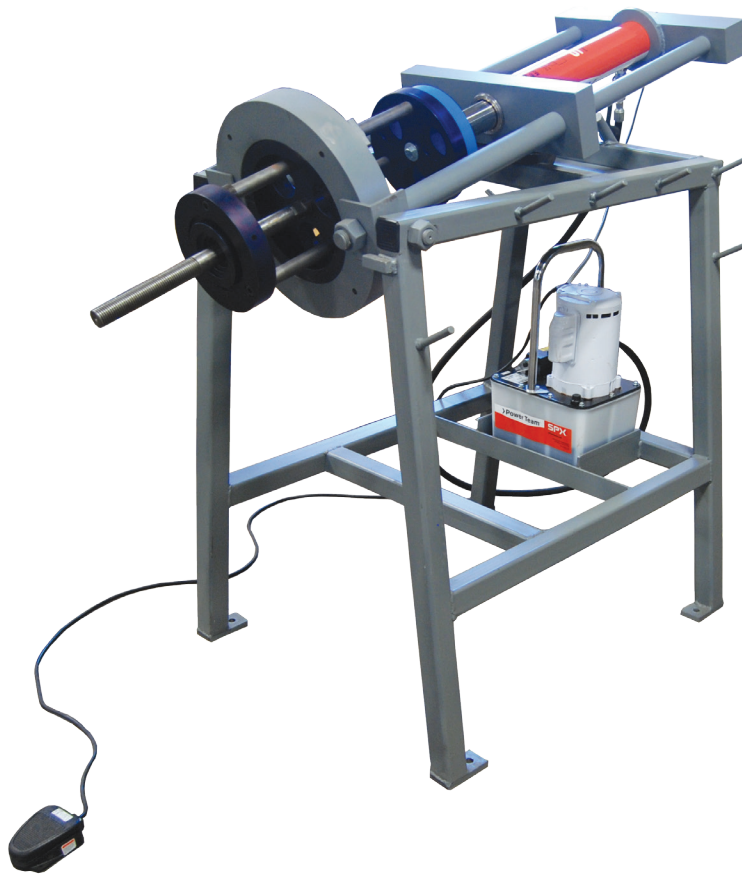


The Right Connection®

25 Ton Ram Operating Instructions

Section 4

Converting from Swaging to Expansion



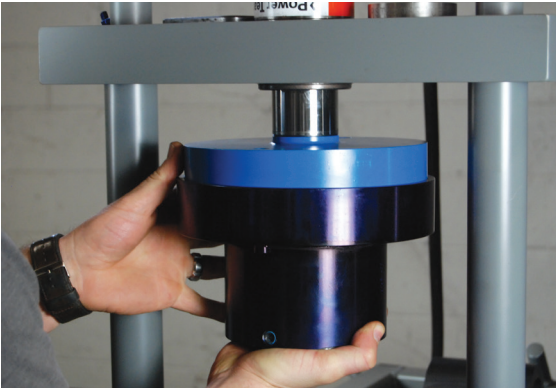
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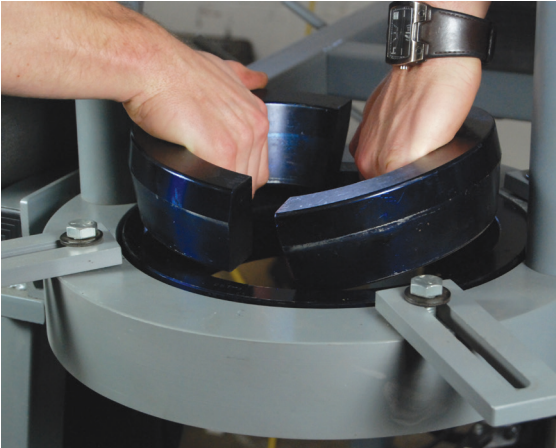
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1



Before you begin make sure the Ram is fully retracted. Remove the **25PUSH400** (also referred to as the pusher hat) from the main pusher plate, if installed on the Ram.

2



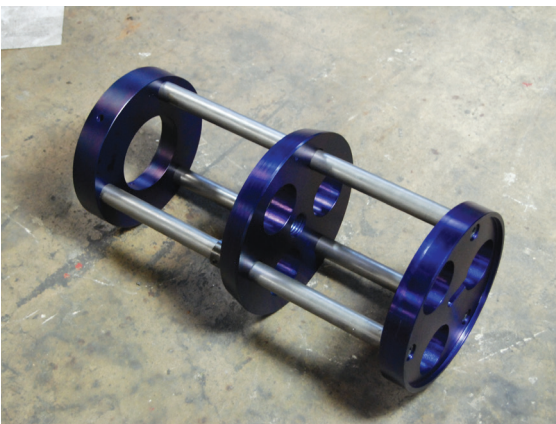
Loosen the keeper plate bolts, and remove all die holders.

3



Install the retaining bolt with washer into hole of the main Ram pusher plate (**25T5**).

4



Laying the **25IXATTACH** on it's side, move the guide plate to the center. Slide the retaining collar up until it contacts the guide plate. Tighten the set screw in the retaining collar. Stand the **25IXATTACH** up so that the end with the slot is on top.

5

Install the **25IXATTACH** by aligning the large hole with the slotted guide to the retaining bolt and washer. When installed the **25IXATTACH** will hang freely.



6

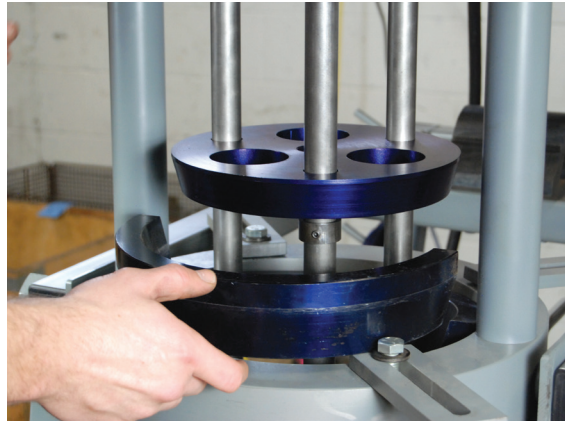
While lifting up on the **25IXATTACH**, tighten the bolt by hand in the main Ram pusher plate until it is snug.

Note: To make this step easier, stand in front of the ram and place one foot on the cross bar closest to you. Place your knee under the **25IXATTACH** and lift up. Tighten the bolt by hand until it is snug.



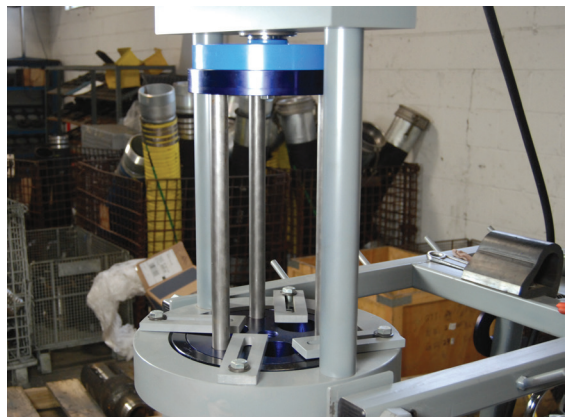
7

Install Die Holder **DH9-004**.



8

Loosen the retaining collar and allow the guide plate to slide down and fit into the die holder. Secure die holder and guide plate with keeper plates. Tighten evenly or else the Ram will jam.

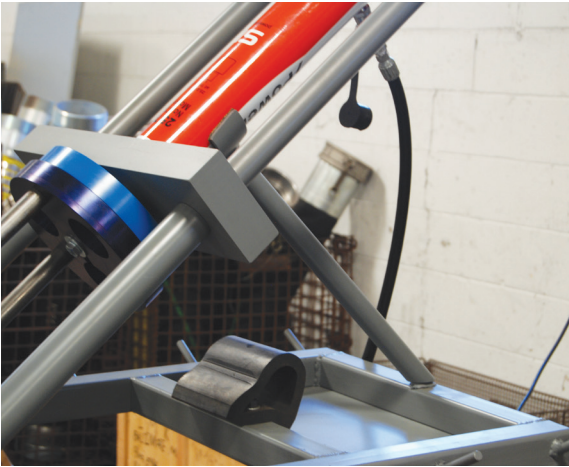


9



Remove the safety bolts behind the 1" nuts. Loosen the left 1" nut (when facing ram), then the right 1" nut (when facing ram). If this sequence is reversed (right, then left) the cylinder will rotate backwards on its own.

10a




There are two options for positioning the ram for internal expansion:

Install the 45° angle bracket.

10b



Lower the Ram carefully until it rests on the bracket. You are now ready to internally expand.

CAUTION! The ram is extremely heavy. It may be necessary to have 2 people (1 on each side) to lower the ram. 

11



Option #2 - Do not install the 45° bracket.

Lower the Ram completely until it rests on the safety bumper. You are now ready to internally expand.

CAUTION! The ram is extremely heavy. It may be necessary to have 2 people (1 on each side) to lower the ram. 