



The Right Connection®

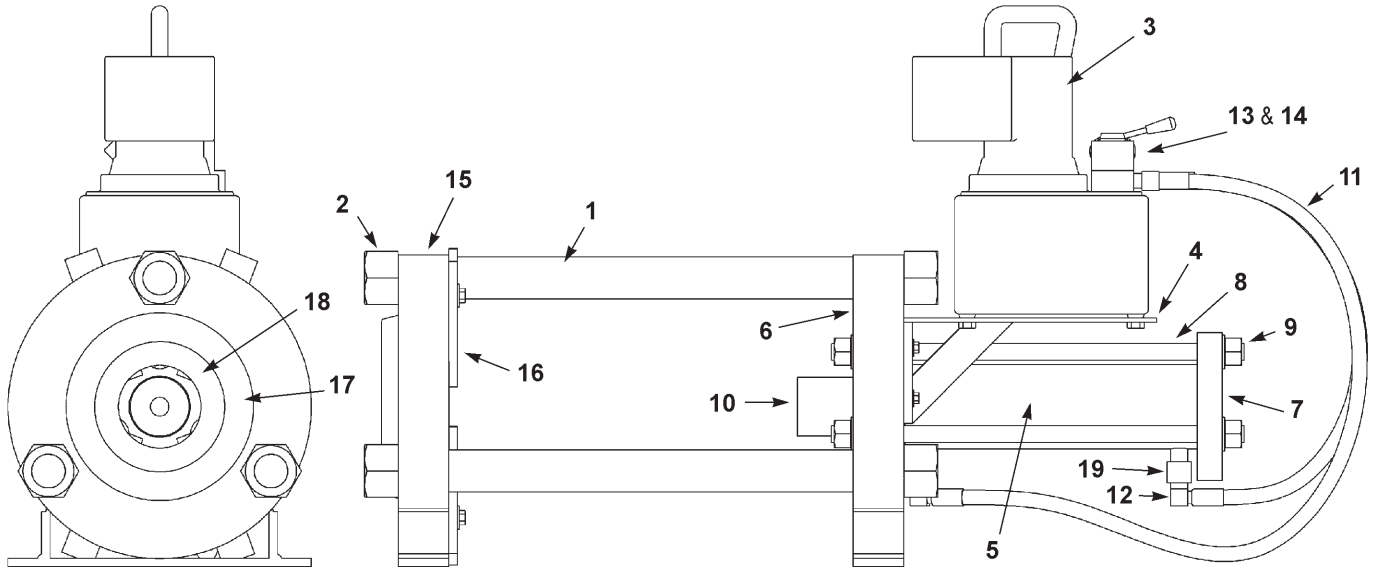
Section 1

50 Ton Ram

Specifications

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50 Ton Ram Instruction Manual



Item	Part #	Description	Qty
1	50T003	Tie rod	3
2	50T024	Tie rod hex nut	6
3	001-0008	Hydraulic pump	1
4	50T012	Hydraulic pump support	1
5	50T019	Hydraulic cylinder	1
6	50T002	Cylinder end plate	1
7	50T011	Cylinder backing plate	1
8	50T010	Cylinder tie rod	4
9	50T025	Cylinder tie rod nut	8
10	50T008	Rod cap	1
11	001-0019	Hydraulic hose with hydraulic couplings	2
12	31-300	Hydraulic quick connect NPT plug	2
13	GLSS10000	0-10,000 PSI liquid filled gauge	1
14	001-0024	Gauge adapter 45°	1
15	50T001	Die bed plate	1
16	50T007	Die retainer strap	6
17	50TDH9004	9" Die carrier	1
18	50TDH6003	6" Die carrier	1
19	30-300	Hydraulic couplings	2

Specifications

Net Weight	630 lbs., basic equipment only
Crated Weight	780 lbs.
Dimensions	53" long x 18" wide x 19" high
Crated Dimension	76" long x 40" wide x 48" high
Pump Motor	Power Team PE554 1-1/8 H.P. Universal Motor; 12,000 RPM; 115V single phase, 60/50 cycle AC (not dual voltage); 25 Amp, lightweight "handle-top" housing
Motor Control	"Run-Off-Remote" motor control switch; 25 Amp motor control relay cavity mounted in motor housing, hand held remote switch
Safety Valves	Relief valve set at 10,000 PSI
Control Valve	Built-in manually operated 4-way control valves with 3/8" NPT port
Gauge	Calibrated 0-10,000 PSI
Reservoir	Convenient mounting holes in base
Oil Delivery	650 cu. in/min. at 100 PSI 80 cu. in/min. at 1,000 PSI 70 cu. in/min. at 5,000 PSI 55 cu. in/min. at 10,000 PSI

Note: 2-stage pump provides fast, no load approach speed and then shifts into slow actuation as the load is applied.

- Ram double acting (Power Team RD5513-B)
- 13 1/8" stroke
- 55 tons of push at 10,000 PSI
- 28 tons of pull at 10,000 PSI

Preparations

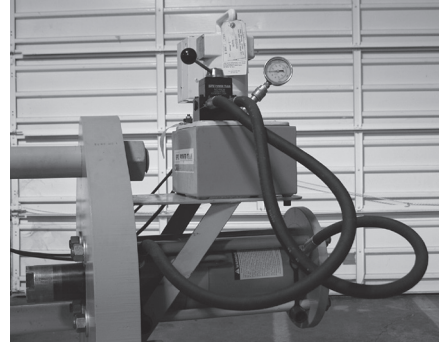
Filling the Reservoir	Before removing the filler plug, clean the area around the plug. The pump is a precision built unit, special care should be taken to preclude foreign particles from entering the reservoir. With cylinder fully retracted, fill the tank 1" to 1 1/2" from the top. Replace the filler plug.
Approved Hydraulic Oils	Power Team 9637 Mobile DTE25 or equivalent
Available Motor Variations	220-440, etc. Also 1 1/2 H.P. and 3 H.P.
Reservoir Variations	5 gallon or 10 gallon reservoir available

The standard 1 1/8 H.P., 12,000 RPM, 115 volt motor and the 2 1/2 gallon reservoir has proven highly successful. Dixon feels it is the best design, and variations are not desirable.

Operating Controls

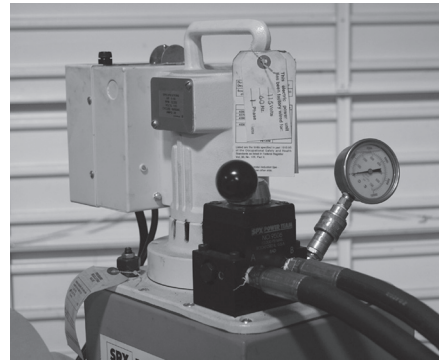
- F-N-R (Forward-Neutral-Reverse) directional control lever.

The F-N-R lever (shown in the neutral position) controls the direction of the ram cylinder. To extend the cylinder (forward) in the direction of the die bed, move the lever toward the pump motor then activate the pump. To retract the cylinder (reverse), move the lever away from the pump motor then activate the pump.



- On-Off-Remote switch, 0 - 10,000 PSI pressure gage and hand held remote.

When the toggle switch is placed in the "On" position, the pump motor will run until the toggle switch is placed in the "Off" position. When the toggle switch is placed in the "Remote" position, the hand held remote is activated. To run the pump motor, depress and hold the switch on the remote. To stop the motor, release the switch on the remote. For practical purposes, leave the toggle switch in the "Remote" position. All future references to activating the pump motor should be understood that the hand held remote is being used.



Caution! Never dead-end the cylinder (fully extended or fully retracted) and leave it with pressure showing on the gage. If the cylinder is dead-ended, always move the lever to the neutral position after stopping the pump. Failure to do so can shorten the life of the cylinder seals.

