

4. Install the Bullet Tray with two 8-32x $\frac{1}{4}$ " socket head cap screws(A). Attach two Ammo Bins to the front of the Bullet Tray(B). See photo 3



Photo 3

5. Slide the Bottle Cap over end of Spent Primer Tube down to flared end and attach Bottle to Cap. Next, slide on the Return Spring Plate with the squared section pointed at the Bullet Tray as shown in photo 4, then slide on the Spring.



Photo 4

6. Raise the Ram to the top of the press stroke and install the Return Spring Plate, Spring, Spent Primer Tube and Bottle assembly by securing the setscrew at the bottom side of the Shell Plate Holder Assembly. **NOTE: The Return Spring Plate must rest on top of the Press Frame.** See photo 4 above.

CALIBER SET UP

The following steps should be completed for every caliber changeover.

1. Install the Detent Spring and Ball into Shell Plate Holder. See photo 5.



Photo 5

2. Attach Star Wheel to Shell Plate using two 8-32x $\frac{3}{8}$ " socket head button screws.
3. Install the Shell Plate onto the Shell Plate Holder assembly with the Shoulder Bolt and 5/16" hex wrench. See photo 6



Photo 6

4. Loosen the 5/64" SHSS in the shell plate holder assembly and adjust Case Eject Wire to point to the rear of the shell holder slot. Tighten SHSS using the included 5/64" hex key wrench. See photo 7.



Photo 7

5. The Small Primer Plug assembly is factory installed. Replace with the Large Primer Plug assembly if desired.

6. Tighten the primer plug assembly with a 7/16" open-end wrench (not included). See photo 8.

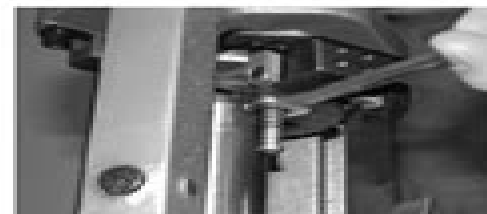


Photo 8

7. Insert a case into station 1. Loosen the 3/32" BHCS, adjust station 1 case holder spring to barely touch the rim of the case, hold spring in place and tighten BHCS. Use included 3/32" hex key wrench. Remove the case. See photo 9. **NOTE: This adjustment must be made each time you change shell plates.**



Photo 9

8. Thread in the Case Activated Powder Measure assembly into Station 3 of the Press Frame.
9. Install Die Plate and lock into place with the two Die Plate Pins. See photo 10. The two outside holes are for pin storage when Die Plate is removed.



Photo 10

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