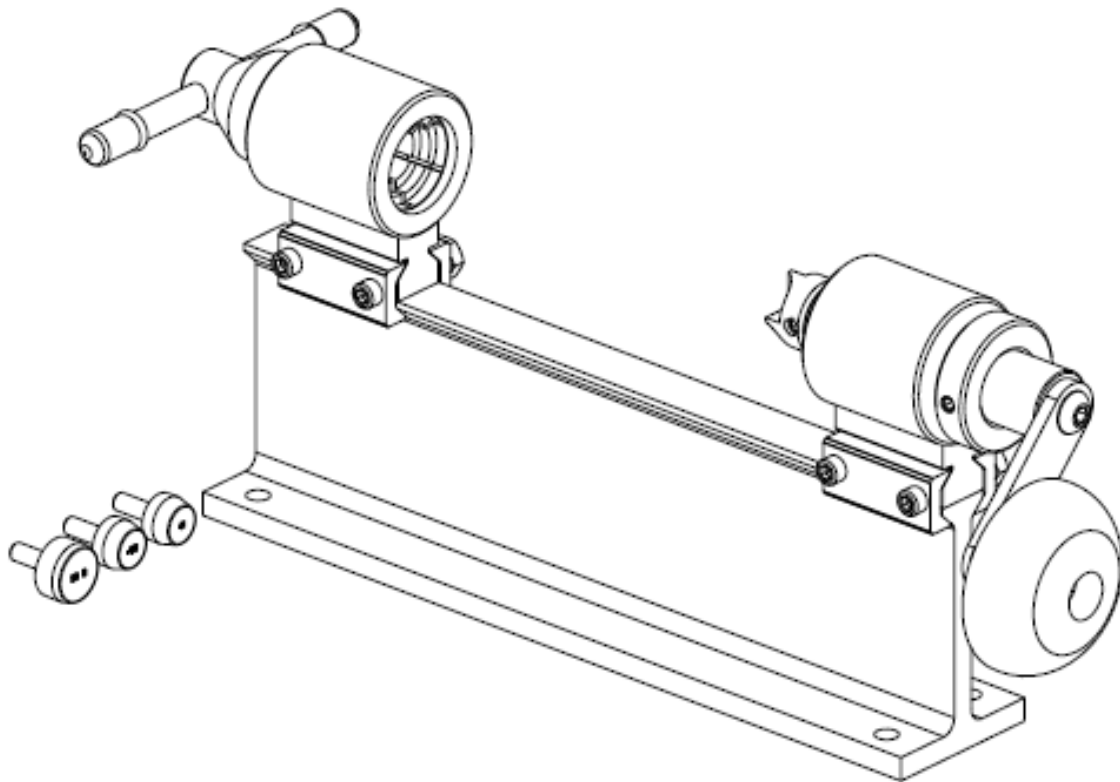


# ***RCBS***<sup>®</sup>

## **High Capacity Case Trimmer Kit**



PRODUCT INSTRUCTIONS

**⚠ WARNING**

Before using the RCBS High Capacity Case Trimmer kit, read these instructions carefully to fully learn how to safely operate the related reloading equipment. Failure to properly operate the related reloading equipment can result in severe personal injury and/or equipment damage.

**If you have any questions while assembling or operating this tool,**

**Call us at 1-800-533-5000 or 1-530-533-5191**

**Monday – Thursday 6:30 am – 3:00 pm Pacific Time**

(hours may vary)

Or email us at [rcbs.tech@atk.com](mailto:rcbs.tech@atk.com)

This instruction manual contains specific safety and operating information. It should be considered a permanent part of your reloading equipment and remain with the equipment at all times for easy reference.

**LIMITED LIFETIME WARRANTY**

Your High Capacity Case Trimmer Kit is warranted to be free from defects in material or workmanship for as long as the original owner owns it. This warranty is extended only to the original consumer purchaser. All RCBS products are intended for non-commercial use by hobbyists. Any other use of these products will void the warranty. Should you believe that your High Capacity Case Trimmer Kit is defective in material or workmanship, you must return it to Ammunition Accessories Inc. through its Oroville operation (hereinafter "Oroville Operations") postage paid for evaluation. If defective, the product will be repaired or replaced at Oroville Operations' option, at no charge.

Send a dated proof of purchase to Oroville Operations for return shipping and handling, along with the High Capacity Case Trimmer Kit to:

Ammunition Accessories Inc.,  
Oroville Operations  
605 Oro Dam Blvd  
Oroville, California 95965

Warranty services cannot be provided without meeting the above requirements.

THIS LIMITED LIFETIME WARRANTY DOES NOT COVER DEFECTS OR DAMAGE RESULTING FROM: CARELESSNESS, MISUSE, COMMERCIAL USE, ABUSE, IMPROPER INSTALLATION, MODIFICATION, OR NORMAL WEAR AND TEAR. THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE LIMITED TO THE DURATION OF THIS LIMITED LIFETIME WARRANTY. OROVILLE OPERATIONS IS NOT LIABLE FOR DAMAGES IN EXCESS OF THE PURCHASE PRICE OF THE PRODUCT AND UNDER NO CIRCUMSTANCES SHALL OROVILLE OPERATIONS BE LIABLE FOR CONSEQUENTIAL OR INCIDENTAL DAMAGES. HOWEVER, SOME STATES DO NOT ALLOW LIMITATIONS ON INCIDENTAL, OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

The above warranty provides the sole and exclusive warranty available to the customer in the event of a defect in material or workmanship in the product. This warranty gives you specific legal rights, and you may also have other rights which vary from State to State.

**SAFETY**

Reloading is an enjoyable and rewarding hobby that can be conducted safely. But, as with any hobby, carelessness or negligence can make reloading hazardous. This product has been designed from the beginning with the user's safety in mind. When reloading, safety rules must be followed. By observing these rules, the chance of a hazardous occurrence causing personal injury or property damage is minimized.

**GENERAL**

- Use all equipment as the manufacturer recommends. Study the instructions carefully and become thoroughly familiar with the operation of the product. If you do not have written instructions, request a copy from the equipment manufacturer.
- Do not take short cuts. Attempting to bypass established procedures is an invitation to an accident.
- Observe "good housekeeping" in the reloading area. Keep tools and components neat, clean and orderly. Promptly clean up primer and powder spills.
- Reload only when you can give your undivided attention. Do not reload when fatigued or ill, or under the influence of medications or alcohol.
- Develop a reloading routine to avoid mistakes which may prove hazardous. Do not rush - load at a leisurely pace.
- Always wear adequate eye protection to protect your eyes from flying particles. You assume unnecessary risk when reloading without wearing safety glasses.

**LOADING DATA**

- Use only laboratory tested reloading data. We highly recommend the current SPEER Reloading Manual.
- OBSERVE ALL WARNINGS ABOUT THE USE OF MAXIMUM LISTED LOADS

**PRIMERS AND POWDER**

- Store primers and powder beyond the reach of children and away from heat, dampness, open flames and electrical equipment. Avoid areas where static electricity is evident.
- Do not use primers of unknown identity.
- Dispose of unknown primers in accordance with applicable regulations.
- Keep primers in the original factory container until ready to use. Return unused primers to the same factory packaging for safety and to preserve their identity. Primer packaging is designed to provide safe storage.
- DO NOT store primers in bulk. The blast of just a few hundred primers is sufficient to cause serious injury to anyone nearby.
- DO NOT force primers. Use care in handling primers.
- DO NOT have more than one can of powder on the bench at one time. Powder cans should be stored away from the bench to avoid picking up the wrong one.
- DO NOT use any powder unless its identity is positively known. The only positive identification is the

- manufacturer's label on the original canister. Discard all mixed powders and those of uncertain identity.
- If you use a powder measure, replace the lids on both the powder hopper and powder can after the powder hopper has been filled.
- When using a powder measure, settle the powder in the powder hopper before charging any cases. Throw and check the weight of at least ten charges. This will assure you that the correct powder charge is being thrown.
- When you finish a reloading session, pour any remaining powder back into its original factory container. This will preserve the identity and shelf life of the powder.
- DO NOT smoke while reloading.

**RECORD KEEPING**

- Keep complete records of reloads. Apply a descriptive label to each box showing the date produced, and the primer, powder and bullet used. Labels for this purpose are packed with SPEER bullets.
- Never attempt to guess at the identity of your ammunition.

*Because RCBS has no control over the choice of components, the manner in which they are assembled, the use of this product, or the firearms in which the resulting ammunition may be used, we assume no responsibility, expressed or implied, for the use of ammunition reloaded with this product*

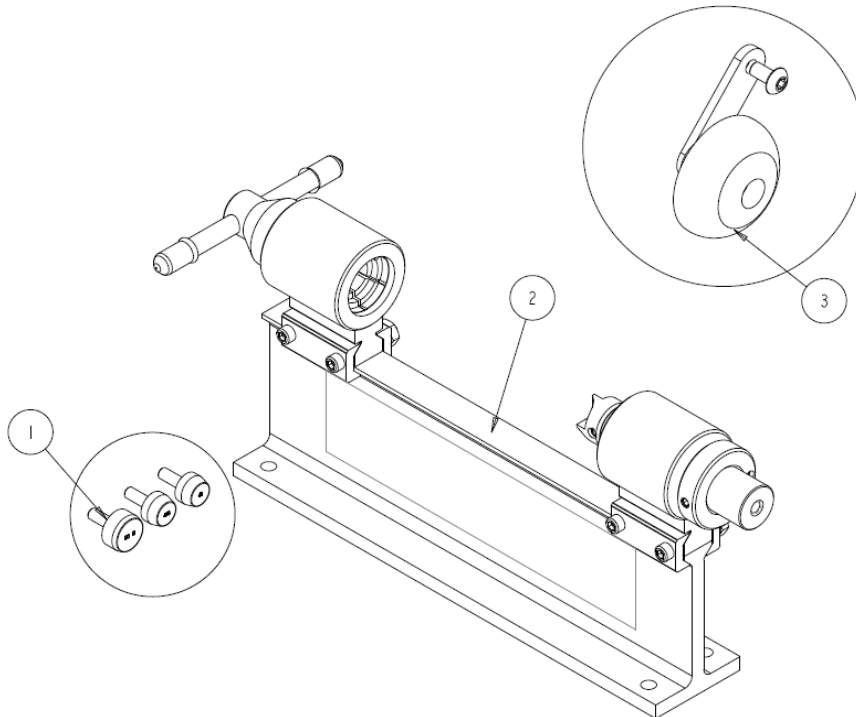
**UNPACKING**

Refer to the list below to Identify parts as you unpack your High Capacity Case Trimmer Kit.

- Parts bag #1 – Diagram 1
  - .408 cal Pilot
  - .416 cal Pilot
  - .500 cal Pilot

- Parts bag #2 – Diagram 3
  - Handle Assembly
  - 10-32 BHCS

- High Capacity Case Trimmer Assembly – Diagram 2



## TRIMMER ASSEMBLY

1. Select a solid bench on which to mount the High Capacity Trimmer Kit. You must use the four mounting holes (use casting as a template). Mounting hardware not included. Leave enough room to the left and right of the Trimmer Body to operate the Collet Handle and Trimmer Handle.
2. Place the Handle Assembly on the Cutter Shaft and secure the 10-32 Button Head Cap Screw with a 1/8" hex wrench (not included).



3. Select one of the three included Pilots for the cases you are about to trim. Install the desired Pilot into the Cutter Head and secure the 8-32 Socket Head Set Screw with a 5/64" hex wrench (not included).



4. There are two case holding diameters machined into the case holder Collet. The smaller diameter is for the .408 CheyTac® and the larger diameter will accommodate the .416 Barrett® and .50 BMG.

## TRIM LENGTH ADJUSTMENT

1. Taking a case that has been resized, measure the over all length of the case and write this measurement down. Place the case into the case holder Collet, apply rearward pressure on the case and tighten the Case Holder Collet Draw Pin.



2. Adjust the 8-32 SHSS Adjustment Bushing Stop so that approximately 1/8" is exposed to the left of the Adjustment Bushing.



3. Slide the Adjustment Bushing towards the Cutter roughly 1/2" and temporarily lock it in place with the 8-32 SHSS.



4. Loosen the two 6/32" SHCS with a 7/64" hex wrench that secure the Case Holding Collet assembly to the Base. This allows the Collet Assy to be moved to the right.



5. Slide the Cutter Assy to the LEFT until the Adjustment Bushing Stop is up against the Cutter Sleeve. Holding the Stop in position, slide the Case Holder assembly to the RIGHT, until the case mouth contacts the Cutter. Secure the two 6/32" SHCS to lock the Case Holder Assembly into place.



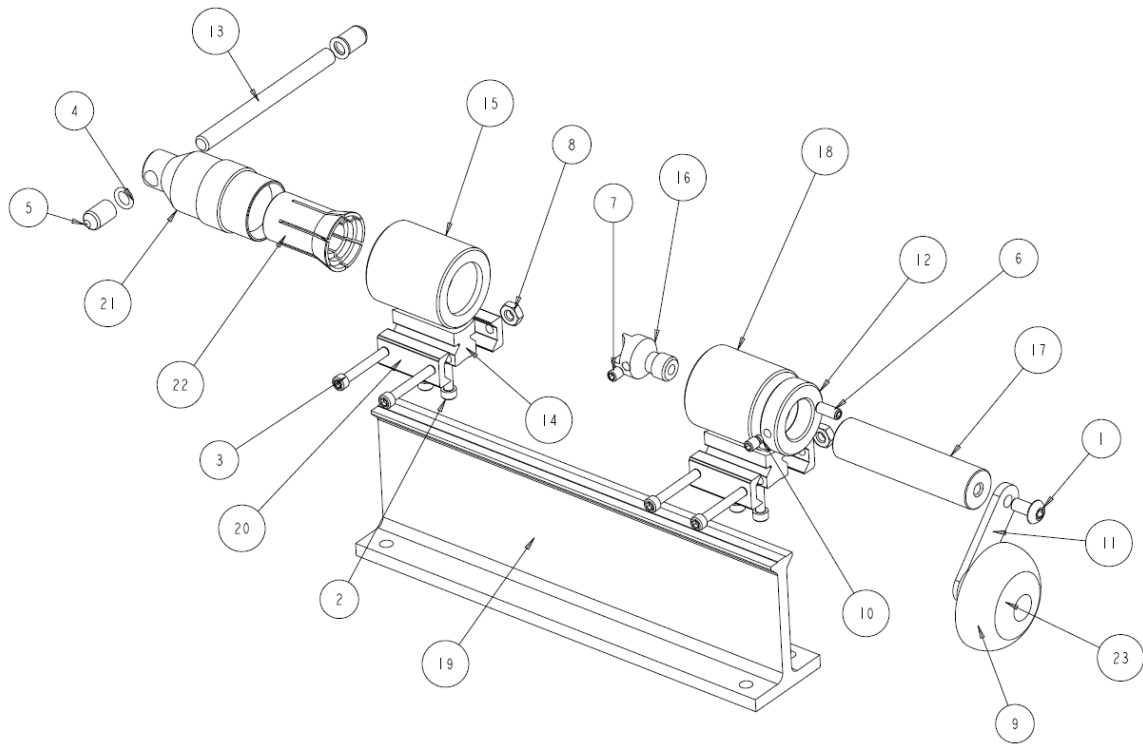
6. Refer back to your measurement of the overall length of the case. One complete revolution of the Adjustment Bushing stop Set Screw is equal to @.030". *NOTE: Do not make large adjustments of the set screw. You can always re-adjust to trim more off of the case but you cannot put back what has already been trimmed off!* If you need to remove .015" from the length of the case, unscrew the Adjustment Bushing Stop Set Screw, 1/2 turn counter-clockwise. *NOTE: This is a trial and error operation to adjust for overall length.*

7. Trim the case and remove it from the Trimmer to check the over all length.

8. Re-adjust the Stop Bushing Set Screw as necessary to achieve the desired case over all length measurement.

## **CASE LENGTH ADJUSTMENT**

1. Shorter cases, such as the .416 Barrett, require the Collet Holder assembly to be moved closer in towards the cutter head.
2. Lock the case into the Collet Holder. The Adjustment Bushing should be positioned in the center of the Cutter Shaft.
3. Loosen the 6-32 Socket Head Set Screw with a 7/64 hex wrench and slide the Collet Holder assembly to the right. Slide the case mouth onto the Pilot while you are pushing the Cutter Shaft assembly to the left to center the case. Tighten the 6-32 SHSS.
4. Follow TRIM LENGTH ADJUSTMENT instructions above.



| HIGH CAPACITY CASE TRIMMER ASSY |        |          |                       |
|---------------------------------|--------|----------|-----------------------|
| Item #                          | Part # | Quantity | Description           |
| 1                               | 186144 | 1        | 10-32 X 3/8" BHCS     |
| 2                               | 186162 | 4        | 6-40 X 1/2 SHCS       |
| 3                               | 186163 | 4        | 6-32 X 1" SHCS        |
| 4                               | 186164 | 2        | O-Ring (009)          |
| 5                               | 186165 | 2        | VINYL CAP             |
| 6                               | 186166 | 1        | 8-32 X 3/8"           |
| 7                               | 186213 | 2        | 8-32 X 3/16" SS       |
| 8                               | 189071 | 4        | 6-32 HEX NUT          |
| 9                               | 198943 | 1        | PALM KNOB             |
| 10                              | 709410 | 1        | BRASS BUFFER          |
| 11                              | 709412 | 1        | HANDLE LINK           |
| 12                              | 790361 | 1        | ADJUSTMENT BUSHING    |
| 13                              | 790362 | 1        | COLLET DRAW PIN       |
| 14                              | 790364 | 2        | CARRIER               |
| 15                              | 790365 | 1        | COLLET SLEEVE         |
| 16                              | 790366 | 1        | HIGH CAP CUTTER HEAD  |
| 17                              | 790367 | 1        | HIGH CAP CUTTER SHAFT |
| 18                              | 790369 | 1        | CUTTER SLEEVE         |
| 19                              | 790370 | 1        | BASE                  |
| 20                              | 790371 | 4        | CLAMP                 |
| 21                              | 790372 | 1        | COLLET HOLDER         |
| 22                              | 790378 | 1        | COLLET                |
| 23                              | 798942 | 1        | KNOB HANDLE PIN       |



**PRECISIONEERED RELOADING EQUIPMENT**

We think that we make the very best reloading equipment in the world.  
If you agree, please tell your friends.  
If you disagree, tell us we want to do something about it!

Customer Service

1-800-533-5000 (US or Canada) or 530-533-5191

Hours: Monday - Thursday, 6:30am - 3:00pm Pacific Time  
(hours may vary)

e-mail: [rcbs.tech@atk.com](mailto:rcbs.tech@atk.com) or visit our website at [www.rcbs.com](http://www.rcbs.com)

RCBS 605 Oro Dam Blvd.E., Oroville, CA 95965

ALLIANT POWDER - CCI - CHAMPION TRAPS & TARGETS  
ESTATE CARTRIDGE - FEDERAL AMMUNITION - FUSION AMMUNITION  
GUNSLICK - INTENSITY - NITREX - ORBEX - OUTERS - RCBS - RAMLINE  
SHOOTERS RIDGE - SPEER - WEAVER

**7200218/0608**