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SPORTING EQUIPMENT DIVISION OF BLOUNT, INC.
RCBS Operation, 505 Oro Dam Blvd., Oroville, CA 95965

FORM #200503-1290
### RAM Priming Unit Parts List

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### Priming with the RAM Priming Unit

1. **WARNING:** Primers will explode.

2. Do not touch any primer head while priming.

3. Primers are not designed to explode and will do so when subjected to heat.

4. Always wear safety glasses when handling primers.

5. Do not handle primers in the near vicinity of an exploding primer.

6. Per federal regulations and safety, keep primers in their original packaging.

7. An accessible minimum of primers should be kept at the loading operation.

8. Do not exceed the primers.

9. Open only after proper safety precautions.
4. Insert appropriate Shell Holder (not supplied) into Ram Priming Body.

5. Assemble large or small Primer Rod Assembly as appropriate. To assemble the Primer Rod Assembly: Select the correct primer plug and sleeve (large or small). Drop the primer plug through the sleeve. Place the spring on top of the primer rod. Screw the primer plug into the top of the primer rod. Tighten the assembly with a small nail or straightened paper clip through the hole in the primer plug. Do not over-tighten.

6. Position the ram at the top of its stroke and drop the Primer Rod Assembly through the Shell Holder. It should come to rest extending approximately 1/2 inch above the Shell Holder (see fig. 1).

To prime simply place the primers into the extended Primer Rod Assembly (see fig. 2). Raise the operating handle of the press slightly, so that the Primer Rod Assembly has dropped below the level of the Shell Holder. Insert deprimed cartridge case (see fig. 3) and lower the operating handle until the primer is seated.

Proper primer seating requires that the primer be seated between .002 inch and .005 inch below the case head. Both insufficient and excessive primer seating depth greatly decrease primer sensitivity and can result in misfires. Due to the mechanical advantages of most presses, it is possible to overt-seat or crush primers during seating. Great care must be exercised until you learn the proper "feel."

The second and perhaps more precise method of primer seating, known as "seating primers to a positive stop," is as follows:

7. Repeat steps 1-6.

8. Loosen the Hex Lock Nut and unscrew the Ram Priming Body approximately 1/4 inch until proper primer seating is achieved exactly at the end of the ram stroke. Proper adjustment can be achieved only by trial and error.

Subsequent primer seating depth using this second method will vary only as much as the variation in the rim thickness of your cartridge cases.

Again, priming should be accomplished following either procedure precisely.
Priming with the Ram-ly Priming Unit

Described here are two methods for primer sealing using the Ram Priming Unit. Priming should be accomplished following either procedure precisely.

Method 1: "Sealing Primers by Feel"

1. Remove Conventional Shell Holder from ram.
2. Install Primer Red Holder in ram.
3. Thread the Ram Priming Body into the press, positioning it so the Hex-Lock Nut lines up with the top of the inside of the Body seat. Secure by tightening the Hex-Lock Nut.
4. Load the Ram Priming Assembly and the Case for which the primers are to be sealed into the ram, as follows:
   a. Large and small Primer Rods are seated into the shell holders.
   b. The Ram Priming Body is seated in the Ram Priming Body seat of the red holder and screws into the press ram and holds the Primer Rods.
5. To seal the primers, bring the press down on the shell, with the ram down to the point where the Hex-Lock Nut is seated into the body and the Ram Priming Body is snugly seated.
6. Remove the Ram Priming Body and Ram Priming Assembly as a unit. The primers are now sealed into the shell.
7. Remove the Shell Holder.

Method 2: "Sealing Primers by Pressure"

1. Remove Conventional Shell Holder from ram.
2. Install Primer Red Holder in ram.
3. Thread the Ram Priming Body into the press, positioning it so the Hex-Lock Nut lines up with the top of the inside of the Body seat. Secure by tightening the Hex-Lock Nut.
4. Load the Ram Priming Assembly and the Case for which the primers are to be sealed into the ram, as follows:
   a. Large and small Primer Rods are seated into the shell holders.
   b. The Ram Priming Body is seated in the Ram Priming Body seat of the red holder and screws into the press ram and holds the Primer Rods.
5. Remove the Ram Priming Body and Ram Priming Assembly as a unit. The primers are now sealed into the shell.
6. Remove the Shell Holder.

WARNING: PRIMERS WILL EXPLODE!

1. Keep primers away from children.
2. Do not smoke near primers.
3. Primers are designed to explode and will do so when subjected to heat or percussion.
4. Always wear safety glasses when handling primers.
5. Do not force primers. All primers in the vicinity of an exploding primer will usually also detonate violently. Do not store or handle primers in bulk.
6. For identification and safety, keep primers in their original protective packaging.
7. An absolute minimum of primers should be kept at the loading operation.
8. Do not keep primers dry or over primers.
9. Do not attempt to seal, or seal, a primer in a loaded round.