

RCBS

Trimmer

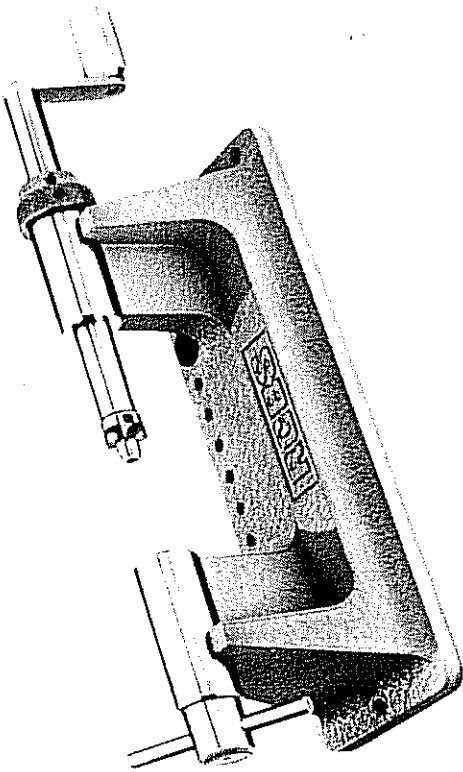
PRECISIONNEERED[®]

Case

Rotary Instructions



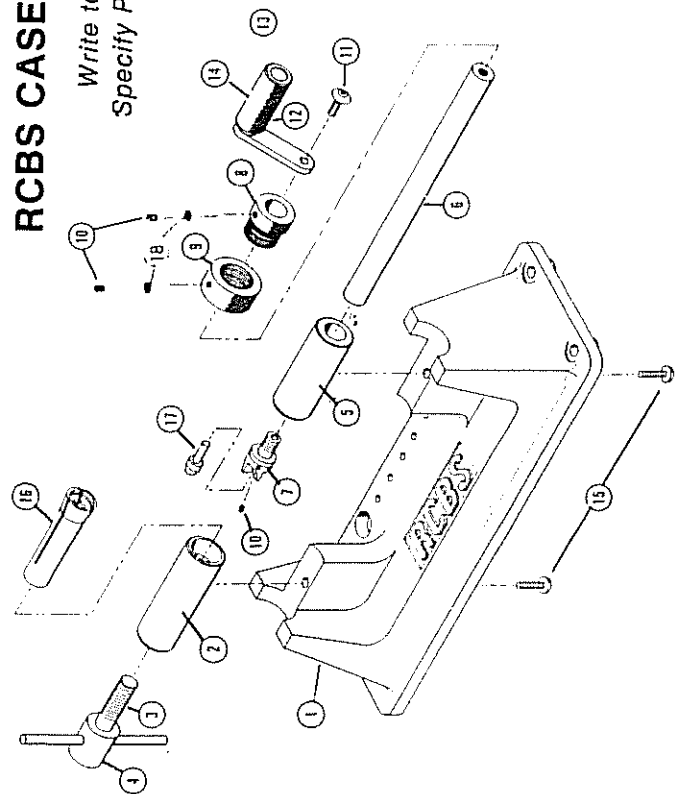
Sparring Equipment Division



RCBS CASE TRIMMER PARTS LIST

Write to RCBS for current prices.
Specify Part Number and Description.

IMPORTANT: If the Cutter becomes dull, unthread it from the Cutter Shaft and return it with your payment of \$1.50 to RCBS Customer Service, P.O. Box 1919, Oroville, California 95965. The Cutter will be re-sharpened and returned to you postage paid.



KEY	PART NO.	DESCRIPTION
1	09400	Base
2	09401	Collet Holder
3	09402	Collet Draw Screw
4	09403	Collet Draw Screw Pin
5	09404	Cutter Guide
6	09405	Cutter Shaft
7	09406	Cutter
8	09407	Adjustment Bushing
9	09408	Fine Adjustment Bushing
10	09409	Setscrew 8/32x1/8 (3)
11	09410	Brass Buffer 8/32 +
12	09019	Handle Screw
13	09412	Handle Link
14	09017	Handle Knob Pin
15	09018	Handle Knob
*	09414	Handle Assembly
16	09413	Base Screw 10/32x1/2 Rd. Hd. (2)
17	— — —	Collet
18	— — —	Pilot

*Not shown. +Used with Adjustment Bushings Setscrews only.

IMPORTANT FEATURES OF YOUR RCBS PRECISIONEERED[®] ROTARY CASE TRIMMER

The RCBS Rotary Case Trimmer is constructed of 100% metal — no wood or plastic. Cutter Blades are machined from hardened tool steel for extended service life, and can be removed for sharpening.

The Cutter Assembly has double lock rings to permit a quantity of cases to be trimmed with a single adjustment.

Your RCBS Rotary Case Trimmer works just like a lathe. A brass case is locked securely into place in the Collet, and the Cutter is adjusted to trim case to desired length. A few turns of the handle and the case is trimmed quickly, easily, and accurately.

Interchangeable, quick-release Collets are available for all popular calibers — .17 to .45. Collets are machined with multiple steps to hold cases of different head diameters. (Figure 1). This eliminates the need of buying

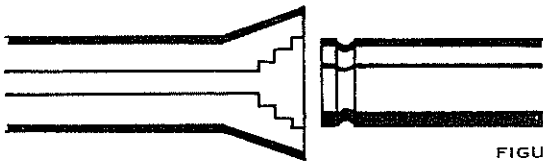


FIGURE 1

a Collet for each diameter of case head. Collets #1, 2, and 3 each have three steps. Collet #4 has only two steps. To learn which number Collet fits which calibers of cases, consult the Reference Table.

Trimmer Pilots are interchangeable and available in twenty sizes, to fit from .17 to .45 caliber cases. Each size of Pilot is machined to the caliber of the resized case mouth. This snug fit eliminates wobbling and en-

ures perfect alignment of case during trimming. The Pilot is secured to the Cutter Blade with an Allen set-screw. (Figure 2).

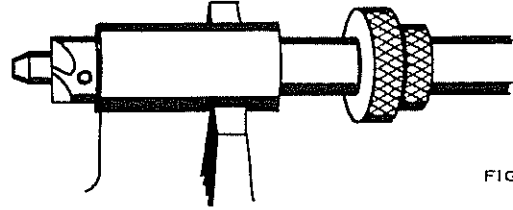


FIGURE 2

The RCBS Case Trimmer comes equipped with a Collet and Pilot that will trim most .30 caliber cases. Other calibers of cases will require a different Pilot and possibly a Collet. See Reference Table for Pilot and Collet required for each caliber of case. Base of Trimmer has slots for storing extra Collets and Pilots.

MEASURING CASE LENGTHS

Whenever a brass case has stretched in resizing, or it has been formed into a different caliber, it must be trimmed down to the correct length. See Reference Table in this pamphlet for lengths.

To properly measure a case you should use a Case Length Gauge similar to the one shown on the back cover. Otherwise, use a new factory case as a guide. After trimming, use one of these methods to recheck case length.

IMPORTANT DO'S AND DON'T'S:

1. All cases must be full-length sized, and expanded **before** trimming.
2. Trimmed case mouths should be beveled inside and out with an RCBS Burring Tool — available from your dealer.
3. When not using Trimmer, tension on Collet should be released to retain its spring tension.
4. If you trim cases of several different calibers, keep one case of each caliber to use as a master when adjusting Trimmer. Mark each case with paint or tape to identify.
5. Occasionally lubricate Cutter Shaft with a light machine oil.

TO MOUNT CASE TRIMMER:

Mount Case Trimmer on a bench or table, using three #10 screws of sufficient length to hold it securely in place. **DO NOT** use a "C" clamp on the Trimmer base. If portability is desired, mount Trimmer on a board slightly larger than the base. Then "C" clamp the **board** to bench or table. After Trimmer is mounted lubricate Cutter Shaft with a light machine oil.

TO ADJUST FOR TRIMMING:

- 1 Grasp handle and slide Cutter Assembly to the right until it stops. (Figure 3)

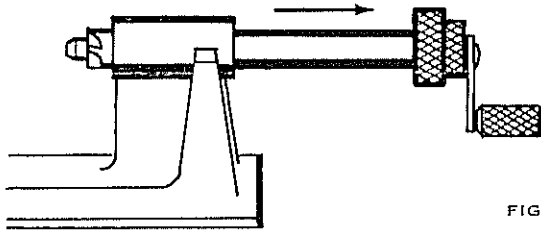


FIGURE 3

- 2 With your left hand insert the base of the case into the Collet as far as it will go and hold it there. (Figure 4)

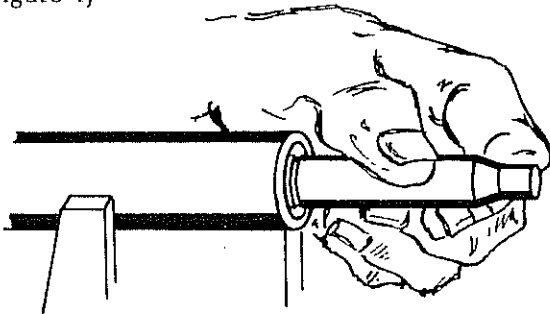


FIGURE 4

- 3 With your right hand slide Cutter Assembly to the left, until Pilot enters the case mouth up to the Cutter Blade. (Figure 5). This will hold case centered.

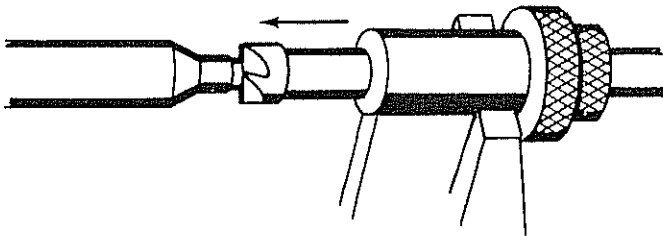


FIGURE 5

- 4 Firmly twist Collet Draw Screw handle to tighten Collet around case head. (Figure 6). This will prevent case from turning during trimming.

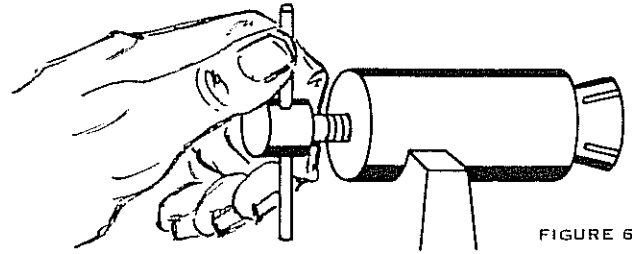


FIGURE 6

- 5 Holding Adjustment Bushing A firmly in place, unscrew Fine Adjustment Bushing B four or five full turns counter clockwise. (Figure 7). Now slide both Bushings left against Cutter Guide C, and tighten Allen setscrew in Bushing A only. Twist Bushing B clockwise 1/2 turn, and you're ready to trim the first case. NOTE: When turning Cutter handle, press lightly inward against case mouth—but do not force it!

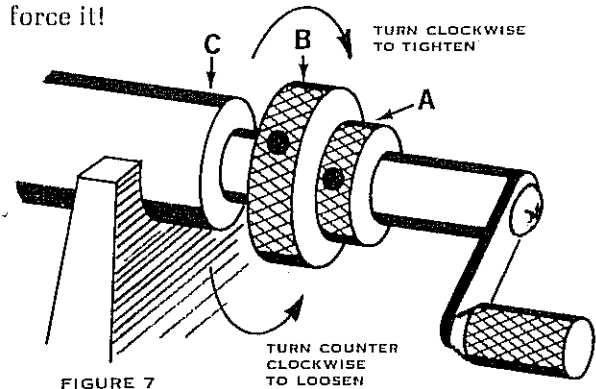


FIGURE 7

- 6 Remove trimmed case and check the overall length with a vernier caliper, a case gauge, or new factory case. If the trimming length must be changed, reset Fine Adjustment Bushing B. One complete turn equals .025" of Cutter Blade movement.

When the correct trim length is reached, tighten the Allen setscrew in Bushing B, and you're ready to trim a quantity of cases. On large runs, occasionally check the overall length of a trimmed case to be sure adjustment hasn't moved.

CAUTION: DO NOT trim a case shorter than the trim length shown in the Reference Table. Otherwise, dangerous problems can occur with straight-wall type cases that depend on case length for headspace.

Shows maximum and trim lengths for each caliber of case. Also Collet and Pilot needed to trim same.

IMPORTANT: Cases should never be longer than the Maximum Length or shorter than the Trim Length shown below.

RIFLE CALIBERS

CALIBER	CASE TRIMMER		MAXIMUM CASE LENGTH	TRIM LENGTH
	COLLET NUMBER	PILOT CALIBER		
.17 Remington	1	17	1.796"	1.786"
.17-222 Remington	1	17	1.700"	1.690"
.17-223 Remington	1	17	1.760"	1.750"
.218 Bee	2	22	1.345"	1.335"
.219 Zipper	2	22	1.938"	1.928"
.22 Savage High-Power	2	22	2.050"	2.040"
.22 Hornet	2	22	1.403"	1.393"
.22 K-Hornet	2	22	1.403"	1.393"
.22 Remington Jet	3	22	1.288"	1.278"
.22-250 (.22 Varminter)	1	22	1.912"	1.902"
.220 Swift	1	22	2.205"	2.195"
.221 Remington Fire Ball	1	22	1.400"	1.390"
.222 Remington	1	22	1.700"	1.690"
.222 Remington Magnum	1	22	1.850"	1.840"
.223 Remington (5.56mm)	1	22	1.760"	1.750"
.224 Weatherby Magnum	3	22	1.925"	1.915"
.225 Winchester	1	22	1.930"	1.920"
.240 Weatherby Magnum	1	24	2.480"	2.470"
.243 Winchester	1	24	2.045"	2.035"
6mm Remington (.244 Remington)	1	24	2.233"	2.223"
6mmx47 Remington (6mm-222 Rem. Mag.)	1	24	1.850"	1.840"
6mm-284 Winchester	1	24	2.170"	2.160"
.25 Remington	2	25	2.050"	2.040"
.25-20 Winchester	2	25	1.330"	1.320"
.25-35 Winchester	2	25	2.043"	2.033"
.25-06	1	25	2.494"	2.484"
.25-06 Improved (40")	1	25	2.494"	2.484"
.250 Savage (.250-3000 Savage)	1	25	1.912"	1.902"
.256 Winchester Magnum	3	25	1.281"	1.271"
.257 Roberts	1	25	2.233"	2.223"
.257 Improved (40")	1	25	2.233"	2.223"
.257 Weatherby Magnum	1	25	2.550"	2.540"
6.5mm-06	1	26	2.494"	2.484"
6.5mm Remington Magnum	1	26	2.170"	2.160"
6.5mmx54 Mannlicher-Schoenauer	1	26	2.112"	2.102"
6.5mmx50 Japanese Arisaka	1	26	1.988"	1.978"
.264 Winchester Magnum	1	26	2.500"	2.490"
6.5mmx55 Swedish Mauser	1	26	2.165"	2.155"
6.5mmx52 Carcano	3	26	2.050"	2.050"
.270 Weatherby Magnum	1	27	2.550"	2.540"
.270 Winchester	1	27	2.540"	2.530"
7mm Remington Magnum	1	27	2.500"	2.490"
7mm Weatherby Magnum	1	28	2.550"	2.540"
7x57 Mauser (7mm Mauser)	1	28	2.235"	2.225"
7mmx57 Improved (40")	1	28	2.235"	2.225"
7mmx64 Brenneke	1	28	2.519"	2.509"
.280 Remington	1	28	2.540"	2.530"
.284 Winchester	1	28	2.170"	2.160"
7.5mm Schmidt-Rubin	1	30	2.145"	2.135"
7.62mm Russian	*	*	2.114"	2.104"
7.65x53mm Mauser (Belgian)	1	31	2.095"	2.085"
7.7mmx58 Japanese Arisaka	1	31	2.270"	2.260"
.30-308 Winchester Magnum	1	30	2.500"	2.490"
.30 M1 Carbine	3	30	1.290"	1.280"
.30 Remington	2	30	2.050"	2.040"
.30-30 Winchester	2	30	2.039"	2.029"
.30-40 Krag	3	30	2.314"	2.304"
.30-06 Springfield	1	30	2.494"	2.484"
.30-06 Improved (40")	1	30	2.494"	2.484"
.300 Holland & Holland Magnum	1	30	2.850"	2.840"
.300 Savage	1	30	1.871"	1.861"
.300 Weatherby Magnum	1	30	2.825"	2.815"
.300 Winchester Magnum	1	30	2.620"	2.610"
.303 British	1	31	2.210"	2.200"
.303 Savage	2	30	2.015"	2.005"

RIFLE CALIBERS

CALIBER	CASE TRIMMER		MAXIMUM CASE LENGTH	TRIM LENGTH
	COLLET NUMBER	PILOT CALIBER		
.308 Winchester	1	30	2.015"	2.005"
.308 Norma Magnum	1	30	2.559"	2.549"
.32 Winchester Special	2	32	2.040"	2.030"
.32-20 Winchester	2	31	1.315"	1.305"
.32-40 Winchester	2	32	2.130"	2.120"
8x57 Mauser (8mm Mauser)	1	32	2.240"	2.230"
8mm-06	1	32	2.494"	2.484"
8x57 JR/.318"	1	32	2.244"	2.234"
8x57 R Mauser	1	32	2.240"	2.230"
8.15x46 Rim	2	32	1.801"	1.791"
.33 Winchester	4	33	2.105"	2.095"
.338 Winchester Magnum	1	33	2.500"	2.490"
.340 Weatherby Magnum	1	33	2.244"	2.234"
.348 Winchester	4	34	2.255"	2.245"
.35 Remington	1	35	1.920"	1.910"
.35 Whelen	1	35	2.434"	2.424"
.350 Remington Magnum	1	35	2.170"	2.160"
.358 Winchester	1	35	2.015"	2.005"
.358 Norma Magnum	1	35	2.520"	2.510"
.38-55 Winchester & Ballard	1	37	2.129"	2.119"
.375 Holland & Holland Magnum	1	37	2.850"	2.840"
.378 Weatherby Magnum	4	37	2.913"	2.903"
.40-82 Winchester	1	40	2.390"	2.380"
11mm Mauser (.43 Mauser)	*	*	2.350"	2.340"
.444 Marlin	1	44	2.225"	2.215"
.45-70 U.S. Government	4	45-R	2.105"	2.095"
.458 Winchester Magnum	1	45-R	2.500"	2.490"
.458x2" American	1	45-R	2.000"	1.990"
.50-70 U.S. Government	*	*	1.750"	1.740"

PISTOL CALIBERS

CALIBER	CASE TRIMMER		MAXIMUM CASE LENGTH	TRIM LENGTH
	COLLET NUMBER	PILOT CALIBER		
.22 Remington Jet	3	22	1.288"	1.278"
.221 Remington Fire Ball	1	22	1.400"	1.390"
.25 ACP (.25 Automatic)	*	*	.615"	.615"
.256 Winchester Magnum	3	25	1.281"	1.271"
.30 Luger (7.65mm Luger)	2	30	.850"	.840"
.30 Mauser (7.63mm Mauser)	2	30	.990"	.990"
.32 ACP (7.65mm Automatic)	1	31	.680"	.680"
.32 Smith & Wesson Long	1	31	.920"	.915"
.32 Smith & Wesson Short	1	31	.600"	.595"
.32-20 Winchester	2	31	1.305"	1.305"
8mm Nambu	2	32	.820"	.820"
.357 Magnum	3	35	1.290"	1.280"
.38 Colt Super Automatic	2	35	.900"	.900"
.38 Smith & Wesson	3	35	.775"	.770"
.38 Special	3	35	1.155"	1.150"
.380 Auto Pistol	1	35	.660"	.660"
.38-40 Winchester	*	*	1.295"	1.290"
9mm Luger	2	35	.754"	.754"
.41 Long Colt	*	*	1.120"	1.115"
.41 Magnum	2	41	1.290"	1.280"
.44 Magnum	1	44	1.285"	1.280"
.44 Auto Magnum	1	44	1.298"	1.298"
.44 Special	1	44	1.160"	1.155"
.44-40 Winchester	1	44	1.295"	1.290"
.45 Automatic (.45 ACP)	1	45	.898"	.898"
.45 Auto Rim	1	45	.888"	.883"
.45 Colt	1	45	1.275"	1.270"

* NOT AVAILABLE

COMPANION TOOLS FOR CASE TRIMMING.



RCBS Case Length Gauge

This vernier caliper accurately measures the overall lengths of cases. It is the ideal companion tool to the RCBS Rotary Case Trimmer. Includes instructions, and a wall chart which shows maximum lengths, and lengths cases should be trimmed to, for 120 of the most popular calibers of rifle and pistol cartridges. Gauge is made of tough, durable plastic.

WRITE FOR FREE CATALOG

Loaded with photos and drawings. Shows complete line of famous RCBS Precisioneered® reloading tools and prices; lists reloading dies for over 200 calibers, reference tables, and a heap of other interesting information. Most informative and most descriptive reloading catalog available anywhere.

RCBS BURRING TOOL

For beveling and removing burrs from case mouths of new factory cases, newly formed cases, and trimmed cases. Centering pin keeps case aligned during deburring. Precision-machined cutting flutes. Hardened to withstand years of usage. Knurled for use by hand or in a lathe. One size fits all cases from .17 to .45 calibers.



RCBS, P.O. BOX 1919, OROVILLE, CALIFORNIA 95965

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