

# ***RCBS***®

## **Tube Pistol Bullet Feeder**



**PRODUCT INSTRUCTIONS**

**⚠ WARNING!**

Before using the RCBS® Tube Pistol Bullet Feeder, 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 – 4:00 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.

**LIFETIME LIMITED WARRANTY**

Your RCBS Tube Pistol Bullet Feeder 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. This warranty excludes any electrical components or products. 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 Tube Pistol Bullet Feeder 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 Tube Pistol Bullet Feeder to:

Ammunition Accessories Inc.,  
Oroville Operations  
605 Oro Dam Blvd East  
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 TWO YEAR LIMITED 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 Tube Pistol Bullet Feeder. 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 and completely 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

 **WARNING/ CAUTION**

## 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.*

## USE

The RCBS Tube Pistol Bullet Feeder has been designed to increase your progressive pistol load rate by ~50% by reducing the manual operation of placing a bullet onto the case mouth. All parts and adapters are included for you to be able to feed .380, 9mm, .38 Spl, .357 Mag, .40 S&W or .45 ACP pistol bullets.

The Bullet Feeder is designed to work with FMJ/TMJ, JACKETED or SEMI JACKETED Hollow Point, Soft Point, Round Nose, Truncated/Flat Nose and Semi Wadcutter designed bullets ONLY. Cast or swaged LEAD bullets can also be used. Wadcutter (HB, BB, DE) bullets are NOT to be used. The lube from lead bullets deposits on the moving parts and collects dust and dirt, slowing down the function of the Bullet Feeder. Periodic cleaning of parts is necessary when using lubed bullets.

The Bullet Feeder is designed to be used on RCBS 5-station progressive presses such as the Pro 2000, Pro 2000 Auto and PiggyBack. The Bullet Feeder has also been designed to function on progressive presses manufactured by other companies. RCBS has successfully tested the Bullet Feeder on the following presses:

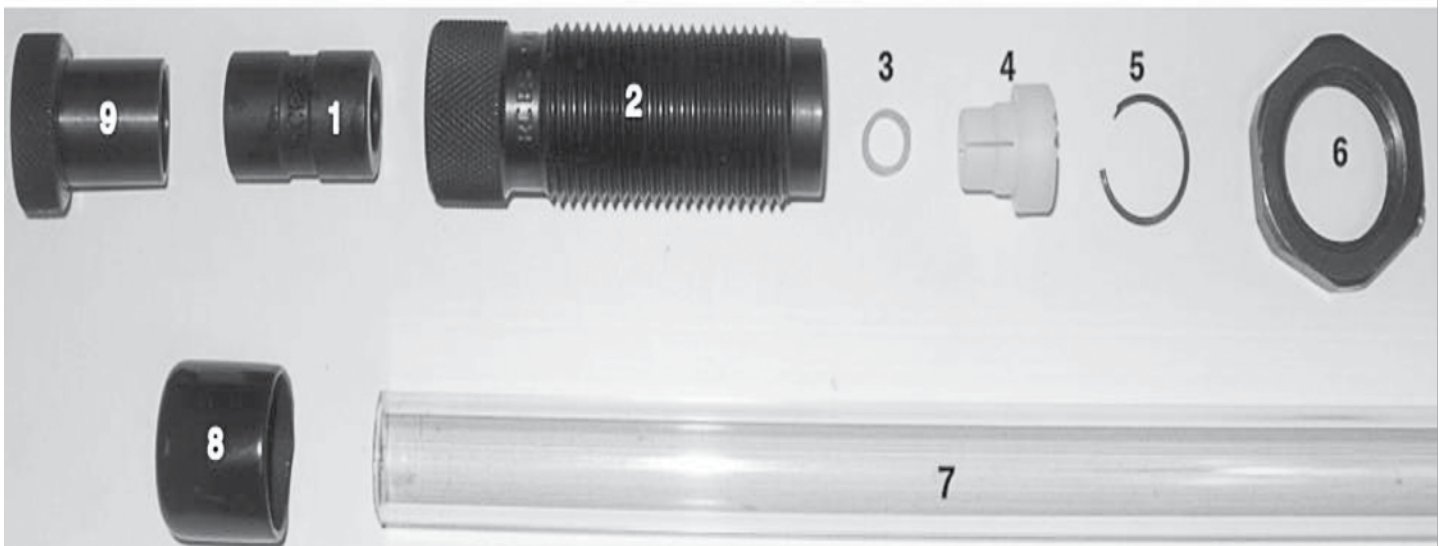
Dillon® RL550B, XL650 and Hornady® Projector™, L-N-L™AP™. For presses that require you to Seat and Crimp bullets in separate operations, you may need to combine bullet Seating and Crimping to accommodate the Bullet Feeder. This may require the purchase of a combination bullet Seat and Crimp die (not included).

The individual tubes will hold 20-25 bullets depending on caliber. Less for .45, more for 9mm.

## UNPACKING

Refer to the list below to Identify parts as you unpack your new RCBS Tube Pistol Bullet Feeder.

1. Bullet Guide
2. Bullet Feed Die Body
3. Tension Band (2)
4. Bullet Fingers (2)
5. Retaining Ring
6. Die Body lock Ring
7. Clear Feed Tube (2)
8. Tube Caps (4)
9. Small Tube Bushing (38/9mm only)



## INSTALLATION

Install the Tension Band down to the first “step” on the plastic Bullet Fingers, as shown below, and insert into the bottom of the Bullet Die. Secure with the Retaining Ring.



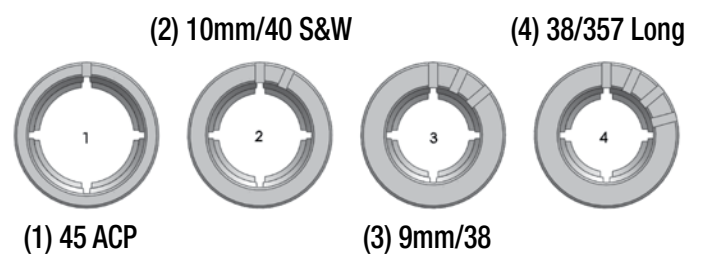
Bullet Fingers are coded on the bottom with a series of marks (lines):

One = 45 ACP

Two = 10mm/40 S&W

Three = 380/9mm/38

Four = 38/357 Long, 170 gr and heavier



Install the Bullet Die assembly into your press (See ADJUSTMENT section for proper setup). Where you choose to install the Bullet Die depends on the press that you are using. For RCBS five station presses, station four (4) is the most common position. See Photo 1.

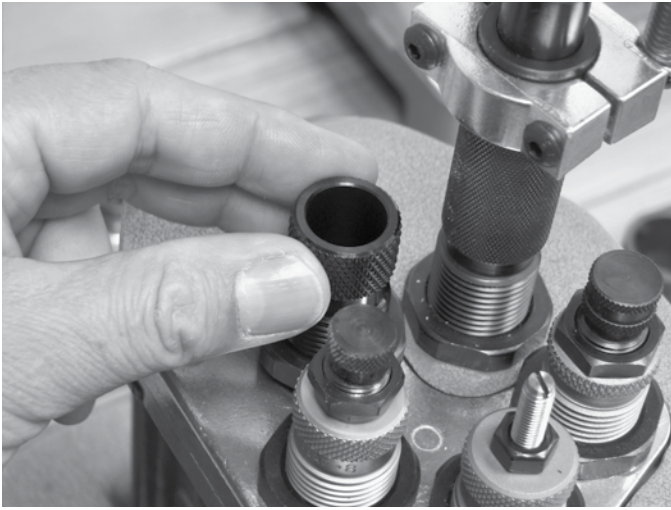


Photo 1

Install the Bullet Guide into the die body, the tapered inner portion is the “top” of the guide with the stamp ID up and readable. Bullet guides are stamped on the side for identification. See Photo 2.

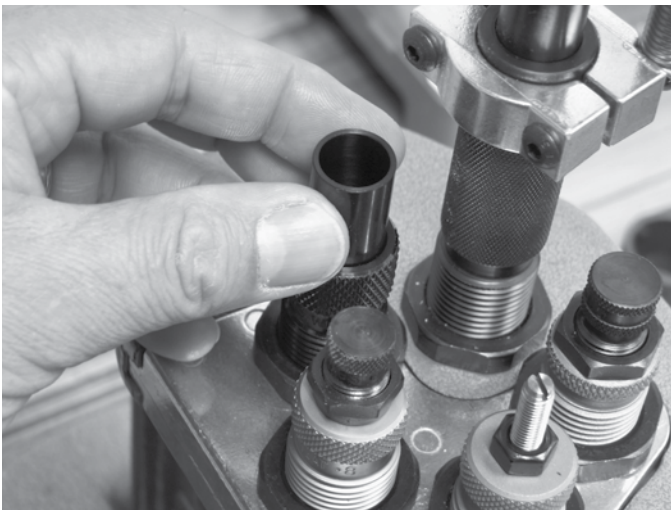


Photo 2

Place the plastic Clear Feed Tube into the top of the Bullet Die.

## OPERATION

Fill the Feed Tubes. The Bullet Guide in the top of the Bullet Die aligns the bullet for feeding through the Bullet Fingers. The case will expand the Bullet Fingers and allow one bullet to be placed on the case mouth. As the case is retracted, the Bullet Fingers close, preventing the next bullet from passing through the Bullet Die.

The weight of the bullet stack puts enough pressure on the placed bullet to prevent it from falling off the case as it moves to the next station to be seated and crimped. Add more bullets to the Feed Tube as needed. NOTE: The Small Tube Bushing is required for use with the small Clear Feed Tubes, (380/9mm/38). NOTE: Additional tubes are available.

## ADJUSTMENT

The position of the Bullet Die must be adjusted to properly place the bullet on the case mouth at the top of the press stroke. This is a trial and error adjustment.

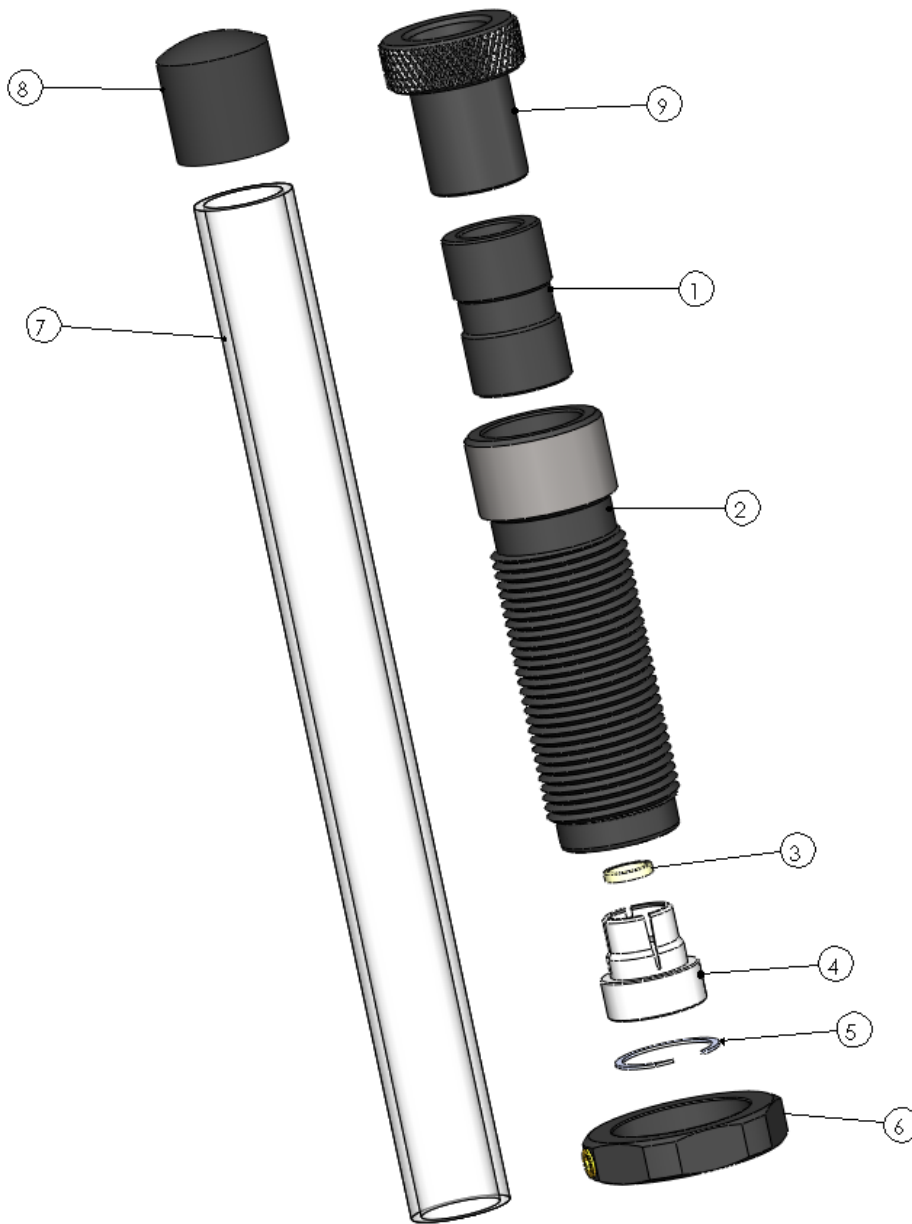
Case mouths must be belled/flared .030” over the bullet diameter. For example:

.380/9mm	.385”
.38/.357	.387”
.40 S&W	.430”
.45 ACP	.481”

Failure to flare cases .030” over bullet will not allow a bullet to drop from the Bullet Fingers. With the Bullet Die partially threaded into the press and the plastic Clear Feed Tube filled with bullets, run a properly flared case up into the Bullet Die. Thread the Bullet Die into the press until you hear a bullet drop or see the bullet stack move down. Thread the Bullet Die down a further ½ turn and temporarily lock the Bullet Die lock ring. Run another properly expanded and flared case up into the Bullet Die to check the setting. If a bullet is placed on the case and no other bullets fall through the die, the setting is correct. Lock the Bullet Die lock ring. If a bullet is not fed, loosen the Bullet Die lock ring and thread the die down in ½ turn increments until the proper setting is achieved. NOTE: If you are loading 170-grain or heavier .38/.357 bullets, the Bullet Finger with four marks and the .38 Bullet Guide marked “38L” with the stepped inner base must be used together.

## MAINTENANCE

Disassemble the Bullet Die body and clean the Bullet Guide and Bullet Fingers to ensure smooth function.



ITEM #	PART #	DESCRIPTION	QTY.
1	781216, 17, 18, 20	Bullet Guide — 38/9mm, 40, 45, 38L	1
2	781219	Bullet Feed Die	1
3	181226	Tension Band	2
4	181210, 11, 12, 13	Bullet Fingers — 38/9mm, 40, 45, 38L	2
5	187546	Retaining Ring	1
6	787500	Die Lock Ring	1
7	181271, 72	Clear Feed Tube — Large, Small	2
8	181273, 74	Tube Caps — Large, Small	4
9	781229*	Small Tube Bushing *	1

\*Small Tube Bushing only used with 38/357/9mm.

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**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, 6:30 a.m. - 4:00 p.m. 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)

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Federal Premium Ammunition - RCBS - Alliant Powder - CCI - Speer Ammo - Speer Bullets  
Fusion Ammunition - Estate Cartridge - Blazer Ammunition - Force on Force  
Weaver - BLACKHAWK! - Champion - Gunslick Pro - Outers  
Buck Commander - Ramline - Redfield - Shooters Ridge

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