

PRIMER POCKET BRUSH COMBO



Residue buildup in primer pockets can be a real problem for those who reload ammunition. This buildup can cause misfires, which can be both frustrating and dangerous. Fortunately, the RCBS Primer Pocket Brush is designed to make cleaning out that residue a breeze. The Primer Pocket Brush works by easily scrubbing residue from inside primer pockets with a couple of twists. It features stiff bristles that are tough on residue but gentle on the brass. This tool is perfect for those who want to clean primer pockets quickly and efficiently.

- Removes residue in primer pockets with a couple of twists
- Stainless bristles and interchangeable mounts for large and small primer pockets
- Includes no-roll accessory handle

PRIMER POCKET BRUSH PARTS LIST

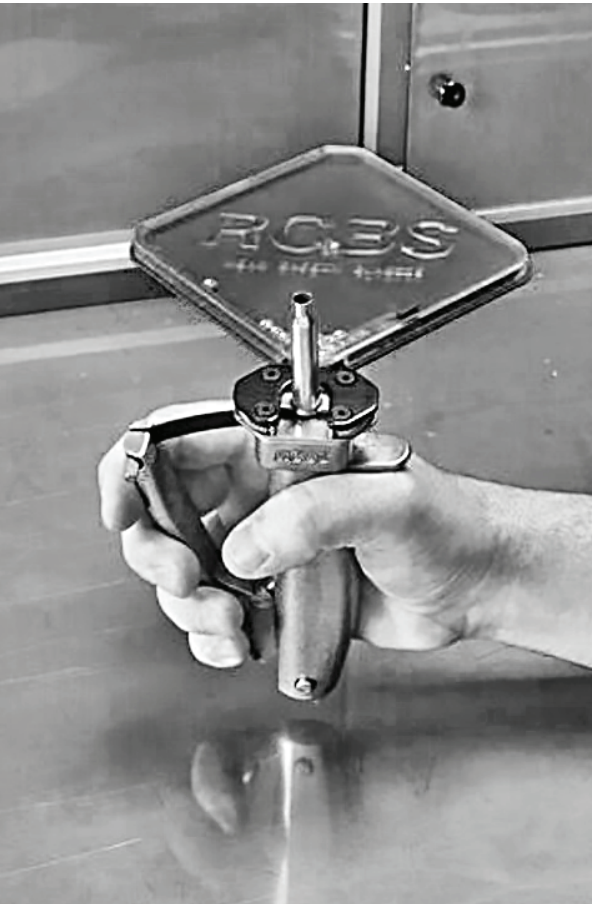
PART NO.	DESCRIPTION
9575	Primer Pocket Brush Combo
9577	Primer Pocket Brush only, Large
9578	Primer Pocket Brush only, Small
9327	Case Neck Brush – Small
9328	Case Neck Brush – Medium
9329	Case Neck Brush – Large
9332	Accessory Handle-2
90378	Primer Pocket Uniformer – Carbide – Large Rifle
90379	Primer Pocket Uniformer – Carbide – Small
90383	Primer Pocket Uniformer – Carbide – Large Pistol

UNIVERSAL HAND PRIMING TOOL



The Universal Hand Priming Tool features a universal case holder and large primer tray. The case holder can accept cases from .32 ACP to .45-70 Government. A safety gate isolates the primer seating operation from the primer supply. The removable primer tray orients the primers for use and will fit all primer manufacturer's packaging. The Universal Hand Priming Tool includes accessories to seat both large and small primers.

- Features a Universal Case Holder
- Primer isolating safety gate
- Large Primer Tray to fit all manufacturer's packaging
- Accessories for both large and small primers. (Rifle and Pistol)
- RCBS Limited Lifetime Warranty



IMPACT-RESISTANT AMMO BOXES



RCBS's improved ammo boxes are proudly **Made in the USA** and ready for your next reloading project. Ammo boxes hold 50 rounds, are easily stackable and available in 7 sizes.

Keep your ammo safe and organized with the RCBS tough, impact-resistant ammo boxes. With a translucent lid, it's easy to see what's inside without having to open the box. Opening with a durable mechanical hinge, the boxes are also stackable, allowing you to save space on your shelf or in your range bag. Available in multiple sizes, there's an RCBS ammo box to fit your needs, whether you're loading for any size rifle or pistol rounds. Don't risk damage to your ammunition – choose the RCBS ammo boxes for reliable protection every time.

PART NO.	DESCRIPTION
86910	.223 Rem. / 5.56 NATO
86911	243 Win. / 6.5CM / 308 Win.
86911	243 Win. / 6.5CM / 308 Win.
86912	.270 Win. / 30-06 Springfield
86914	.380 ACP / 9MM Parabellum
86915	.38 Special / .357 Magnum
86916	.44 Special / Magnum
86917	.40 S&W / 45 ACP

See your local dealer or contact RCBS for further information.

PRIMER POCKET SWAGER - BENCH TOOL



The dedicated bench-mounted RCBS Primer Pocket Swager Tool is a highquality tool that makes the removal of primer pocket staking/crimp simple and easy. This is particularly important for reloaders who work with ARplatform rifles, as much commercial ammunition has staked primer pockets. The rugged die-cast aluminum base, hardened steel cam, and foam-padded grip handle make this tool durable and easy to use. The tool requires 35% less force than other similar tools, making it a more efficient and comfortable choice for reloaders. Using the Primer Pocket Swager Tool is easy: simply mount it on a bench, insert a case into the tool, and squeeze the handle. The tool will remove the primer pocket crimp and allow you to easily reload the case. This tool is an essential addition to any reloader's bench, particularly for those who work with AR-platform rifles or other firearms that have staked primer pockets. Its efficiency, durability, and ease of use make it an outstanding choice for reloaders of all skill levels.

- Dedicated bench-mounted tool simplifies the removal of primer pocket staking/crimp
- Requires 35 percent less force than other tools
- Hardened steel rod offers support from the inside the case ensuring perfect alignment
- Includes two hardened steel swaging heads and rods to accommodate cases 22-caliber and larger
- Great for AR-platform rifles or other firearms that have staked primer pockets

PRODUCT INSTRUCTIONS



PRIMING TOOL AND ACCESSORIES



**Got a question?**  
Customer Service (530) 538-2699 (US or Canada)  
or visit our website at [www.RCBS.com](http://www.RCBS.com)

SAFETY

Reloading is an enjoyable and rewarding hobby that is easily conducted with safety. But carelessness or negligence can make reloading hazardous. This product has been designed from the beginning with the user's safety in mind. As with any reloading operation, some safety rules must be followed. By observing these few rules, the chance of hazardous occurence causing damage or injury becomes extremely remote.

GENERAL

- Use the reloading equipment as the manufacturer recommends. Study the instructions carefully and become thoroughly familiar with the operation of the product. Don't take short cuts.
- 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. Develop a reloading routine to avoid mistakes. Avoid haste – load at a leisurely pace.
- Always wear adequate eye protection. You assume unnecessary risk when reloading without wearing safety glasses.

LOADING DATA

- Use only laboratory tested reloading data. We highly recommend the use of the HODGDON Reloading Manual.

• **OBSERVE ALL WARNINGS ABOUT THE USE OF MAXIMUM LISTED LOADS.**

PRIMERS AND POWDER

- WARNING: Primers are designed to explode and will do so when subjected to heat or percussion.
- Do not decap live primers.
- Never attempt to seat or reseal a primer in a loaded round.
- Store primers and powder beyond the reach of children and away from heat, dampness, open flames and electrical equipment.
- DO NOT use primers of unknown identity.
- Dispose of unknown primers in accordance with applicable regulations.
- Keep primers in original factory container until ready to use. Return unused primers to the same factory packaging for safety and to preserve their identity.
- 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 use any powder unless its identity is positively known. Discard all mixed powders and those of uncertain or unknown identity.
- If you use a powder measure, replace the lids on both the powder hopper and the powder can after the powder hopper has been filled.
- Before charging cases, settle the powder in the powder hopper. Throw and check the weight of at least ten charges. This will assure you that the correct powder charge is being thrown.
- After a reloading session ends, pour the remaining powder back in its original factory container. This will preserve the identity and shelf life of the powder.
- DO NOT smoke while handling powder or primers.

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 RCBS reloading dies.

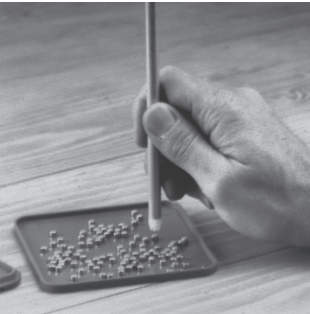
Since RCBS has no control over the choice of components, the manner in which they are assembled, the use of this product, or the guns in which the resulting ammunition may be used, no responsibility, either expressed or implied, is assumed for the use of ammunition reloaded with this product.

PRIMER TRAY

This Primer Tray is designed to position primers anvil side up, for fast, easy handling. To use: scatter primers onto the specially grooved surface of the Primer Tray. Shake tray horizontally until all primers are postioned anvil side up. Primers can now be picked up manually and inserted directly into the Primer Arm Sleeve. For Automatic Primer Feed Tube loading, simply replace cover on Primer Tray. Then, turn the tray upside down. All primers will now be positioned anvil side down, and can be easily picked up with the top end of your Automatic Primer Feed Tube. Sturdy plastic case permits safe, easy storage of primers. Tray capacity: 100 primers.



Primer Tray



Filling a primer tube is easy with the RCBS Primer Tray.

RCBS  
605 ORO DAM BLVD EAST  
OROVILLE, CA 95965

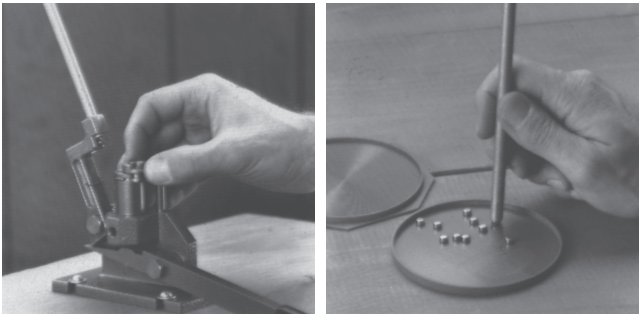
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AUTOMATIC PRIMING TOOL

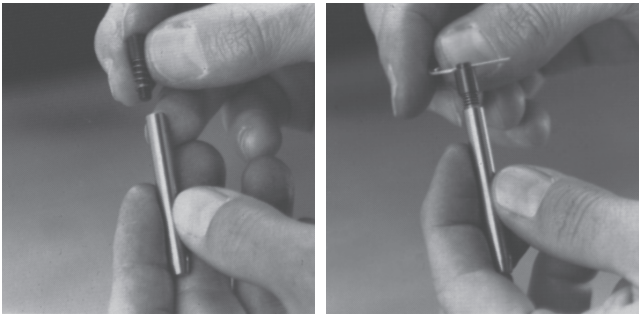
**WARNING:** Care must be taken when loading the Auto Primer Feed Tube. **DO NOT** force primers. Because of the stacked condition of the primers, if one should ignite, all the primers in the tube can explode causing serious personal injury. No more than five pounds pressure should be applied when picking up primers with the Auto Primer Feed Tube (this can be checked using a bathroom scale). If difficulties occur in primer pick-up, investigate the cause and clear the condition or return the Auto Primer Feed Tube to RCBS for correction.

**TO INSTALL:** Bolt Priming Tool to the reloading bench or table, using the slots provided in the Main Body Casting. Mount tool toward the front edge of the bench so that the handle will operate through its full stroke. Insert a Shell Holder into the Main Ram and rotate it to a convenient working angle. Then, using the proper Primer Rod Assembly (for large or small primers), insert the rod into the Shell Holder and Main Ram until it contacts the handle.



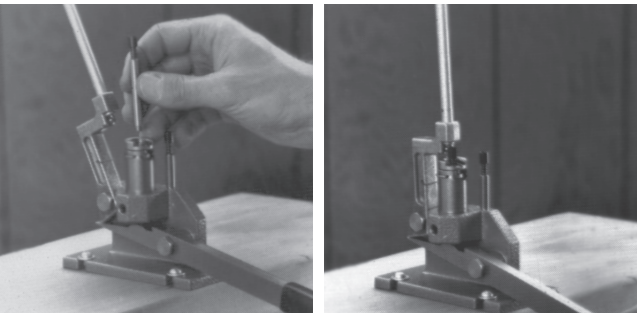
Snap the shell holder into the ram. Fill a primer tube.

**NOTE:** The Primer Rod Assemblies have been designed to allow for replacement of the individual components. To assemble the Primer Rod Assemblies: 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. Before changing Shell Holders, you must first lift out the Primer Rod Assembly.



The primer plug, sleeve and spring thread into the primer rod. Tighten the primer rod assembly with a straightened paper clip.

**TO FILL PRIMER TUBE:** Select the proper Automatic Primer Feed Tube (large or small) and fill with primers as follows: Remove primers from box and place on loading bench – or RCBS Primer Tray – cup side up (anvil down). Holding Primer Feed Tube and Cotter Pin up, press other end of Tube down onto primers – one at a time. When the Primer Feed Tube is full, insert the Cotter Pin end into the Automatic Primer Feed Body, as before. Remove the Cotter Pin and the Primers will drop down to the Stop Pin. The Automatic Primer Feed is now ready to use. NOTE: After priming is completed, replace the Cotter Pin. Primer Tube Capacity: 100 primers.

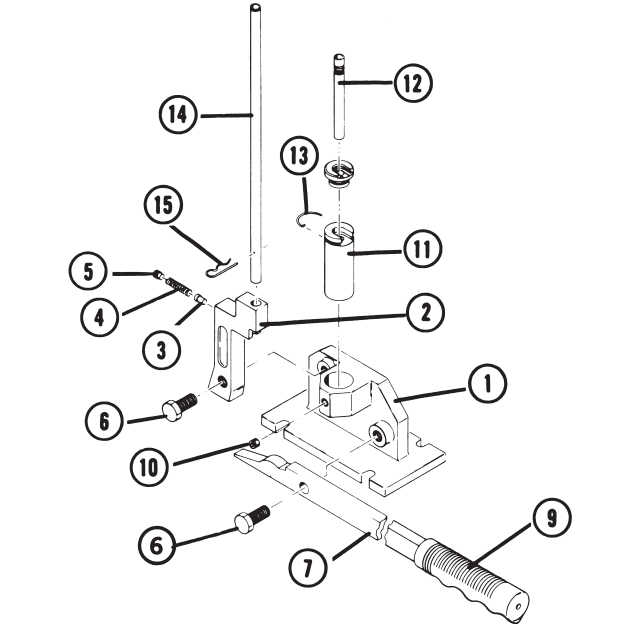


Insert the primer rod assembly. Pushing the handle down will move the primer feed arm into position.

**TO PRIME A CASE:** Push handle to the bottom of the stroke. The Primer Feed Arm will automatically drop a primer into the Primer Rod Assembly. Next, quickly raise handle to the top of the stroke and insert a case into the Shell Holder. Then lower the handle gently and seat the primer to the bottom of the primer pocket. Raise the handle and remove the primed case.

Repeat the above procedure for each primer to be seated. With a little practice you'll develop a rhythm that will speed up your case priming operation.

AUTOMATIC PRIMING TOOL PARTS LIST



KEY	PART NO.	DESCRIPTION
1	09462	Main Body Casting
2	09472	Automatic Primer Feed Arm
3	09595	Stop Pin
4	09596	Coil Spring
5	09591	Setscrew, 1/4-28 x 3/16 CP
6	09464	Shoulder Bolt 7/16"
7	09473	Handle
9	09264	Handle Grip
10	09467	Setscrew, 5/16-18 x 3/8" HD
11	09468	Main Ram
12	09471	Primer Rod Assembly, Lg & Sm
13	09111	Spring Clip
14	09592	Primer Tube Assembly, Large
14	09593	Primer Tube Assembly, Small
15	09599	Primer Tube Cotter Pin
**	09465	Return Spring

\*\*Not Shown

PRIMER POCKET SWAGER

**NOTE:** The Primer Pocket Swager is designed to remove the crimp and not to swage the entire primer pocket. If a primer will not seat properly after swaging the primer pocket, dispose of the case as the primer pocket is probably undersize.

The Primer Pocket Swager is designed for use in most "C" and "block-O" type presses with the standard 7/8"-14 thread and equipped with the removable type Shell Holder. The regular Swager Rod is used with the large or small Swager Head for all calibers except the .223 Remington. Use the .223 Remington (small) Swager Rod with the small Swager Head when swaging .223 Remington primer pockets.

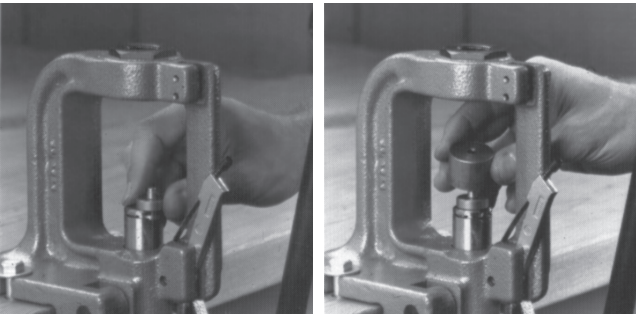
If using the RCBS Big Max Press, you will need the optional Case Stripper for Big Max Press. It replaces the regular Case Stripper and is used only with the Big Max Press.

The optional Case Stripper Washer is required for use with the RCBS Model "A-2" Press. The Primer Pocket Swager is not adaptable for use with progressive reloading tools.

**NOTE:** If the Swager Rod is set too low, it will bend during the swaging operation. Read the following instructions carefully, proceed slowly and be sure you understand each step before going on to the next one.

**TO INSTALL:** Remove the Shell Holder in the reloading press and install the large or small Swager Head in the Shell Holder Ram. Then place the Case Stripper, cup side down, over the Swager Head. The swaging spud on the Swager Head will pass through the hole in the Case Stripper.

**NOTE:** If using the RCBS Model "A-2" Press, insert the Case Stripper Washer under the regular Case Stripper.

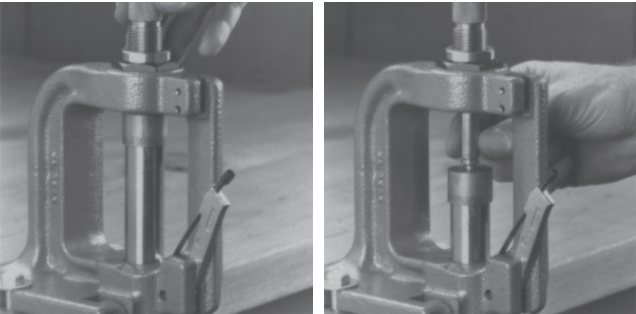


Install the swager head in the shell holder ram. Place the case stripper over the swager head.

Lower the press handle until the Swager Head and Case Stripper are at the top of the press stroke.

The Swager Rod must be backed up snugly and securely tightened against the top of the Swager Body at all times to avoid damage to the Swager Rod. Be sure the small Lock Ring is tightened securely. The amount of swaging is controlled by moving the Swager Body up and down.

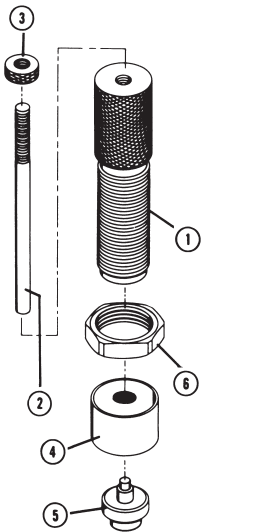
Screw the Swager Body into the press and allow about 1/2" between it and the Swager Head.



Lower the press handle and install the swager assembly. With the handle raised, place a case on the swager head and lower the handle.

**TO USE:** First, sort cases by brand before swaging. Different brands of cases have different web thicknesses. Next, raise the press handle. Place the mouth of the case to be swaged over the Swager Rod and slowly lower the press handle. Lower the Swager Body until it contacts the web of the case (bottom of case interior). You will feel resistance. Slightly lift the press handle and lower the Swager Body about 1/4 of a turn at a time until the proper depth is found. The swaged case will stick to the swaging spud on the Swager Head. To free it, lightly tap the handle backward when the handle is raised. When the primer pocket is properly swaged, tighten the Hex Lock Ring and you are ready to begin swaging. Inspect primer pockets to insure that the edge is radiused.

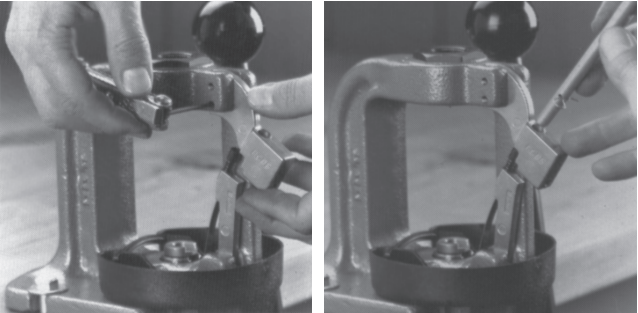
PRIMER POCKET SWAGER PARTS LIST



KEY	PART NO.	DESCRIPTION
1	09485	Swager Body
2	09486	Swager Rod
2	09498	Swager Rod .223 Remington
4	09487	Case Stripper
*	09489	Case Stripper for Big Max Press
*	09488	Case Stripper Washer for Model "A-2" Press
5	09483	Swager Head, Large
5	09484	Swager Head, Small
6	87505	Hex Lock Ring 7/8"-14
*Not Shown		

AUTOMATIC PRIMER FEED

**WARNING:** Care must be taken when loading the Auto Primer Feed Tube. **DO NOT** force primers. Because of the stacked condition of the primers, if one should ignite, all the primers in the tube can explode causing serious personal injury. No more than five pounds pressure should be applied when picking up primers with the Auto Primer Feed Tube (this can be checked using a bathroom scale). If difficulties occur in primer pick-up, investigate the cause and clear the condition or return the Auto Primer Feed Tube to RCBS for correction.



Installing the APF Body in the milled slot of a Rock Chucker Press. Insert the primer tube into the APF Body.

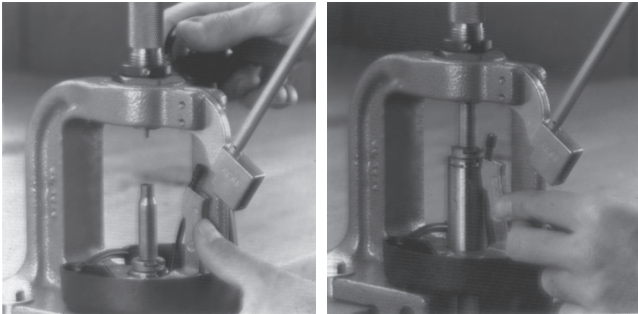
The RCBS Automatic Primer Feed is designed for the RCBS Reloader Special, Jr. and Rock Chucker Presses and most "C" type presses. The large and small Automatic Primer Feed tubes interchangeably fit the Automatic Primer Feed Body.

**TO INSTALL:** Insert the Cotter Pin end of an empty Tube into the Primer Feed Body. Then slide the Holding Bracket of the Body into the milled slot in the frame of the reloading press. Tighten Allen-type setscrew(s) in press frame. Now adjust the Body until the Primer Feed Tube lines up with the Primer Plug and is about 1/32" above the Primer Sleeve. Primer Tube Capacity: 100 primers.

**TO FILL TUBE:** Select the proper Automatic Primer Feed Tube (large or small) and fill with primers as follows: Remove primers from box and place on loading bench – or RCBS Primer Tray – cup side up (anvil down). Holding Primer Feed Tube with Cotter Pin up, press other end of Tube down onto Primers – one at a time. **SEE WARNING ABOVE BEFORE CONTINUING.** When the Primer Feed Tube is full, insert the Cotter Pin end into the Automatic Primer Feed Body, as before. Remove the Cotter Pin and the Primers will drop down to the Stop Pin.

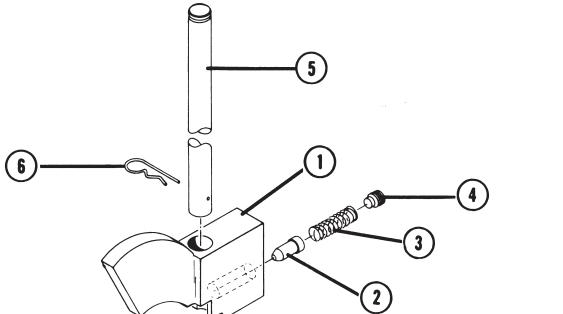
The Automatic Primer Feed is now ready to use. NOTE: After priming is completed, replace the Cotter Pin.

**TO USE:** Gently pull the Primer Arm back to activate the Primer Stop Pin. A primer will drop into the Primer Plug and Sleeve.



Gently pull the primer arm back to pick up a primer. Push the primer arm forward and lower the press handle.

AUTOMATIC PRIMER FEED PARTS LIST



KEY	PART NO.	DESCRIPTION
1	09594	Body Assembly
1	09598	Body
2	09595	Stop Pin
3	09596	Coil Spring
4	09591	Setscrew, 1/4-28 x 3/16 CP
5	09592	Primer Tube Assembly, Large
5	09593	Primer Tube Assembly, Small
6	09599	Primer Tube Cotter Pin