



# Pro Chucker<sup>®</sup>

## PROGRESSIVE RELOADING PRESS

### PRODUCT INSTRUCTIONS





**Before using this product, read and follow these instructions carefully. Failure to do so could result in serious injury or death, or property damage.**

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If you have any questions while assembling or operating this product, call us at  
1-530-538-2699(US or Canada)

Or email us by filling out the "Contact Us" form on RCBS.com

This instruction manual contains important safety and operating information. Keep this as a permanent part of your reloading equipment. If lost, contact us for a replacement.

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## **RELOADING SAFETY**

**NOTICE - This manual is not intended to provide comprehensive instructions or safety information on how to reload, or handle or use reloading components. Always read and thoroughly understand a reloading manual before attempting to reload ammunition.**

Reloading is an enjoyable and rewarding hobby when conducted safely. But, as with many hobbies, carelessness or negligence can make reloading hazardous. When reloading, always follow these safety guidelines to minimize the risk of personal injury or death.

- Always wear safety glasses.
- Understand what you are doing and why. Read handbooks and manuals on reloading. Talk to experienced reloaders. Write or call suppliers of equipment or components if you have questions or are in doubt.
- Read and understand all warnings and instructions accompanying your equipment and components. If you do not have written instructions, request a copy from the manufacturer. Keep instructions for future reference.
- Don't rush or take short cuts. Establish a routine and follow it at a leisurely pace.
- Keep complete records of reloads. Label each box showing the date produced, and the type of primer, powder and bullet used.
- Do not smoke while reloading, or reload near sources of heat, sparks or flame.
- Observe good housekeeping in the reloading area. Keep tools and components neat, clean and orderly. Promptly and completely clean up any spills.
- Keep all reloading equipment and components out of reach of children.
- Stay alert. Reload only when you can give your undivided attention. Do not reload when tired, ill, rushed or under the influence of drugs or alcohol.



### **WARNING! Keep away from children.**

- This device is not intended for use by those with restricted physical, mental or sensory capabilities or those with a lack of experience and/or knowledge, including children.
- Store device out of reach of children.
- Keep device and packaging material away from children.

Because RCBS has no control over the choice, assembly or use of components or other reloading equipment, RCBS assumes no liability, express or implied, for the use of ammunition reloaded with this product.

## **LOADING DATA**

Use only laboratory tested reloading data. We highly recommend the current Hodgdon Reloading Manual.



### **CAUTION! OBSERVE ALL WARNINGS ABOUT THE USE OF MAXIMUM LISTED LOADS.**

## WORKING WITH CARTRIDGE CASES

- Examine empty cases to be sure they are in good condition before reloading. Thin, split, deformed, or badly corroded or pitted cases may be structurally weak, and result in a dangerous condition. Pay particular attention to splits in the mouth, separation between the case and the head, and dents in the shoulder.
- Do not store cartridge cases or ammunition near harsh chemicals such as gasoline, household cleaners, or cat urine. The fumes can weaken the metal and present a dangerous condition.
- Do not clean cases with chemicals other than those specifically designed for the purpose.
- Do not attempt to clean loaded ammunition or primed cases. Doing so can cause corrosion, and weaken the case, or cause a misfire/ hangfire condition.
- Ensure cases have proper primer pocket sizes; remove primer staking/crimp if necessary. Attempting to seat a primer into an undersized pocket or pocket with staking/crimping can result in detonation.
- Do not ream out or enlarge flash holes of cartridge cases. This may change the ignition rate and result in dangerous pressures.
- Resize and trim fired cases to ensure reliable chambering and obtain proper bullet tension and crimp.
- Never attempt to guess at the identity of your ammunition.



**WARNING! - Do not attempt to resize a primed case with decapping pin installed.**

## WORKING WITH PRIMER PICKUP TUBES

In rare circumstances, primers can become lodged in tubes that are obstructed, damaged or improperly maintained.



**WARNING!** Never force or pound/tap on live primers, tap or pound on loaded primer tubes, or otherwise attempt to clear obstructions on your own. Doing so can cause serious injury.

If you experience a feeding problem in a Primer Tube, follow these steps:

1. Ensure no primers are in the white plastic pickup tip.
2. Remove the white tip with pliers.
3. If possible, carefully pour the primers out of the tube and return primers to original packaging. Do not use the tube.
4. If a stuck primer(s) remains, handle with care and take to your local hazardous waste disposal facility.
5. Replacement tubes can be purchased online at RCBS.com or through an authorized dealer. Warranty claims can be made by calling RCBS at 1-530-538-2699 (US or Canada).


To avoid primer feeding problems, always follow these precautions:

- Before use, always inspect tube for damage or interior obstructions.
- Never use bent, damaged or obstructed tubes.
- Ensure tube is free from primer residue buildup. Periodically clean inside of Tube using soap and warm water. Allow Tube to dry completely before using.

## PRIMER WARNINGS

 **WARNING!** Primer detonation can occur if misused. To avoid serious injury, always follow these precautions:


- Always wear safety glasses when using this or any other reloading tool.
- Never attempt to seat or reseal a primer in a loaded cartridge. Prime empty cases only.
- Before priming, ensure the case's primer pocket is properly sized. Minimum diameter is 0.1730 inch for small primers and 0.2085 inch for large primers.
- Completely remove pocket crimp from brass/case with crimped/staked primer pockets (e.g., mil spec brass).
- Never force primer into a case primer pocket. Apply slow, steady, gentle pressure and STOP if you encounter resistance.
- Make sure all reloading tools are in good condition and used in accordance with the manufacturer's instructions.
- Before each use, ensure device is clear of primer dust and other foreign objects. Disassemble and clean periodically (at least every 500 rounds).
- Seat primers flush with or below the case head to avoid inadvertent detonation by shearing or crushing.

 **DANGER!** If misused, primers can explode and cause serious injury or death. Always follow these precautions:

- Handle primers with extreme care. Do not drop or subject to heat, flame, friction, electricity, percussion (e.g., hammering, pounding, dropping) or other impact. Never smoke around primers.
- Always wear safety glasses when working with or around primers.
- To avoid the risk of multiple primers detonating, handle and use primers individually unless with a reloading tool specifically designed to safely handle multiple primers.
- Do not use primers of unknown identity or that have signs of corrosion, damage, or deformation.
- Do not decap live primers.

 **DANGER!** To avoid death, serious injury or property damage, follow these storage precautions:


- Store primers in a cool, dry environment free from wide temperature variations and under 150°F. Do not store primers in a building without temperature control (e.g., garage, shed) or where they can be exposed to direct sunlight.
- Never store primers near heat sources, electricity sources, electrical equipment or other ignition sources.
- Never store primers near gunpowder, gasoline, chemicals or other flammable or explosive material.
- To reduce the chance of multiple primers detonating, never store primers in direct contact with one another. Store primers only in the original factory container, which is specifically designed to reduce the chance of multiple primers detonating. Return unused primers to the same factory packaging for safety and to preserve their identity.
- Storage cabinets containing only primers are recommended. These cabinets should be ruggedly constructed of lumber at least 1" nominal thickness to delay or minimize the transmission of heat in the event of fire. SAAMI recommends against storing primers in sealed or pressurized containers.
- Dispose of unused primers in accordance with applicable regulations for hazardous materials.

 **DANGER!** Primer dust accumulation can detonate and cause death or serious injury. Before each use, inspect all reloading equipment and clean regularly with a damp cloth or sponge; allow surface to dry before use; thoroughly clean and rinse cloth after use. Never clean primer dust with a vacuum cleaner.


Lead Warning: Use of Primers may result in exposure to lead and other substances known to cause birth defects, reproductive harm, and other serious physical injury. Wash hands thoroughly after exposure.

## PRIMER SEATING DEPTH

During priming, check cases occasionally to be sure the primers are seated to the bottom of the primer pocket. Optimum seating depth is .003 inches to .005 inches below the case head. The base of a correctly primed case will sit flat when placed on a level surface. If it rocks, the primer needs to be seated deeper. Primer residue can build up in the primer pocket of fired cases, leading to high primers. Use an RCBS® Primer Pocket Brush or Primer Pocket Uniformer of the appropriate size to clean the primer pocket of your cases before attempting to seat the primer.

 **WARNING!** An improperly seated primer can cause misfires, out-of-battery firings, delayed firings, or inadvertent detonations during storage, handling, or use and cause serious injury or property damage.

## CARE AND MAINTENANCE

 **DANGER!** Small particles of priming compound can collect on surfaces in the form of yellow or gray primer dust. This accumulation of residue is extremely dangerous. Clean products regularly with a damp cloth or sponge. Allow surfaces to dry thoroughly before use. Clean and rinse cloth thoroughly after use. Do not use a vacuum cleaner. Failure to do so could cause a detonation resulting in death, serious injury, or property damage.

Clean Primer Tubes, Primer Dispensers, Primer Transfer Bars, and surrounding areas on the Shell Plate Holder every 500 rounds to prevent the build-up of primer dust. If you need additional help or replacement parts, call RCBS.

## GUNPOWDER WARNINGS


 **WARNING!** Keep out of reach of children

 **WARNING!** DO NOT smoke while reloading.

- Store powders in their original package in a cool, dry environment free from wide temperature variations.
- Keep containers tightly sealed and labels intact.
- Mark date of purchase on container, for future reference. Use older stock first.
- Never use glass as a storage container. This may cause a “greenhouse effect” raising the temperature in the container and degrade the powder.
- Check canister and powder for signs of degradation. Many powders will exhibit a fine red-brown dust on the granules and/ or inside the container when this happens. If it does, do not use propellant; dispose of it properly in compliance with local regulations.

- DO NOT have more than one canister of powder on the bench at one time. Powder containers 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. Properly discard all mixed powders and those of uncertain identity in compliance with local regulations.
- If you use a powder measure, after the Powder Hopper has been filled, replace the lids on both the Powder Hopper and Powder container .
- 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 (10) 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.

## MACHINERY

 **WARNING** Avoid wearing loose clothing and jewelry which can be drawn into moving/rotating components

 **CAUTION!** Avoid pinch points on tool; keep fingers clear of moving parts.

- Keep children and others away from machinery.
- Be sure that all moving parts are shielded and all guards are in place before operating any equipment.

## UNPACKING

Refer to the list below to Identify parts as you unpack your new Pro Chucker Auto Index Progressive Reloading Press.

1. Press Assembly
2. Powder Measure with CAPM\* Linkage and Die

*\*CAPM: Case Activated Powder Measure*

3. Spent Primer Tube
4. Safety Shield and Cap
5. Primer Tubes (4)
6. Die Plate
7. Ammo Bin/Shrunk Wrap
8. Handle Assembly
9. Parts Bags (5)

PRESS ASSEMBLY



PC7 POWDER MEASURE W/  
CAPM LINKAGE AND DIE



SPENT PRIMER TUBE



SAFETY SHIELD & CAP



PRIMER TUBES



PRO CHUCKER 7 DIE PLATE



AMMO BIN/SHRUNK WRAP



HANDLE ASSEMBLY



Loose parts bags include:

- UPM 3 Quick Change Drain Tube
- UPM 3 Competition Lock Screw
- UPM 3 Competition Micrometer Adjustment Screw

Micrometer Adj Screw  
Assembly



Lock Screw

QC Drain Tube

Pro2000 Parts Bag:

- CAPM\* Spacer Bushing (2)
- CAPM\* Powder Bushing Large Rifle
- CAPM\* Powder Bushing Small Rifle
- CAPM\* Powder Bushing Pistol
- Cylinder Link
- 10-32 x 3/8 BHCS (2)

10-32 X 3/8 BHCS



SPACER BUSHINGS



PISTOL BUSHING



CYLINDER LINK

SM. RIFLE

LG. RIFLE





Ammo Bin (Contains the following parts)

**Pro Chucker parts bag #1 (Diagram A)**

Primer Plug Assembly Small  
 Primer Plug Assembly Large  
 Primer Dispenser  
 Primer Transfer Bar Return Spring

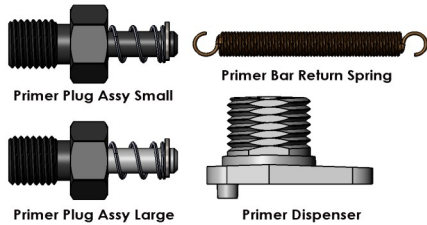


Diagram A

**Pro Chucker parts bag #2 (Diagram B)**

8-32 x 1/4" Socket Head Set Screw  
 8-32 x 3/8" Button Head Cap Screw  
 10-32 x 3/8" Button Head Cap Screw  
 Nyloc Nut 7/16-20  
 Shell Plate Washer  
 Detent Ball 3/8"  
 Index Ball Spring  
 #8 Wood Screw (2)  
 #10 Lock Washer

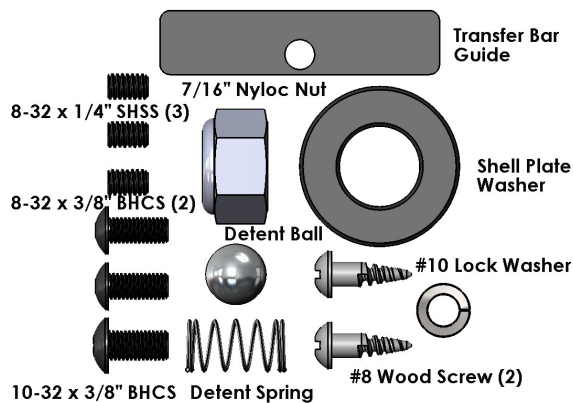


Diagram B

**Pro Chucker parts bag 7 Station (Diagram C)**

Primer Transfer Bar 7 Small (2)  
 Primer Transfer Bar 7 Large (2)  
 Primer Transfer Bar Actuator 7  
 8-32 x 3/8" Flat Head Cap Screw (4)

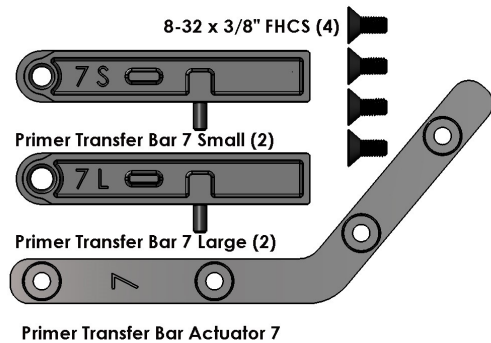


Diagram C

**And the following (Diagram D)**

UPM 3 Competition Cylinder Quick Change  
 Cartridge Discharge Chute  
 Box Bracket

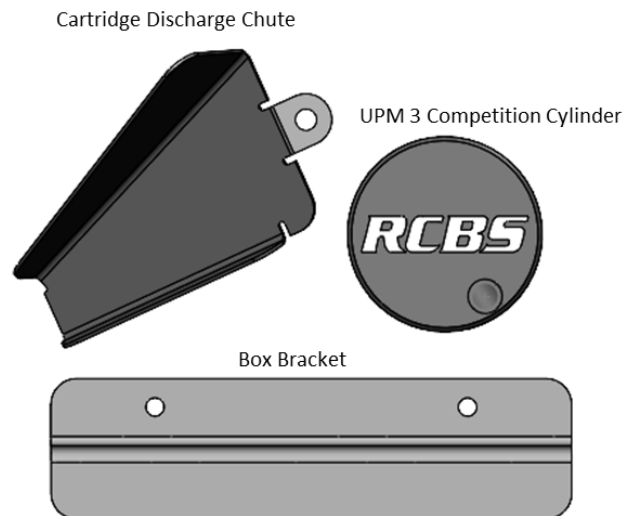


Diagram D



## PRESS ASSEMBLY

1. Select a solid bench on which to mount the Pro Chucker Auto Index Press. You must use the three holes for mounting holes (use casting as a template). For benches with limited space, or to increase the rigidity of your bench, try our Accessory Base Plate 3, (#09282), available through your local dealer. See photo below.



*RCBS Accessory Base Plate 3*

2. Select an area with approximately one foot of clearance on each side of the Pro Chucker Press. Install with three 3/8" bolts, *see photo 1*, length to be determined by the thickness of your reloading bench (mounting hardware not included).



**Photo 1**

3. Install the Pro Chucker Handle by threading into Toggle Block. Tighten with a 9/16" wrench. **Be sure the handle is installed before proceeding. The following steps require raising of the ram.** *See photo 2.*



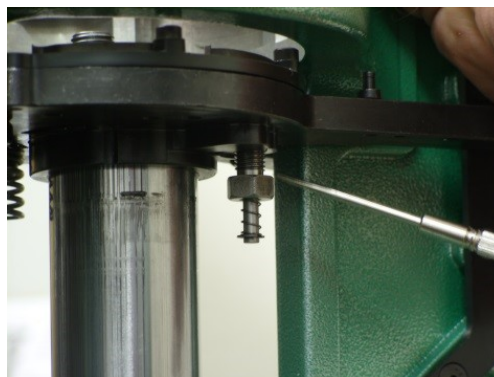
**Photo 2**

4. After the press is securely mounted to a bench or Accessory Base Plate 3, remove the plastic tie securing the Lock Out Pin to the Ram and remove the Lock Out Pin. The Lock Out Pin can be used with a small lock (not included), to secure the press when not in use. *See photo 2A.*



**Photo 2A**

5. Pull Handle down to bring Ram up to top of stroke. Install appropriate Primer Plug (for small or large primers) and tighten with 7/16" wrench. *See photo 3.*



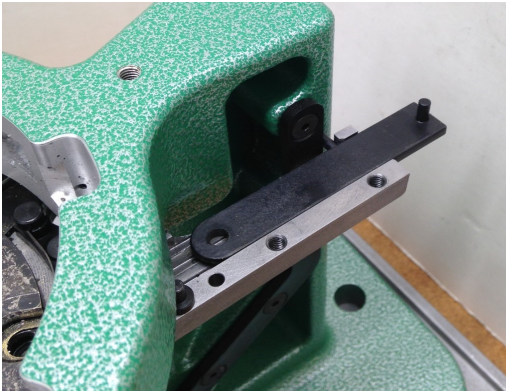
6. Bring Handle back up to lower Ram to bottom of stroke. Install Primer Transfer Bar Actuator 7 on right side of Press with four 8-32 x 3/8 Flat Head Cap Screw using 3/32" hex key wrench. Bias Actuator Arm toward rear of press as you secure FHCS *See photo 4.*



7.

**Photo 4**

7. Raise ram to top of stroke, install the Primer Transfer Bar (7S or 7L), depending on which press and what size primer is used. Ensure the rear post is pointing upward. Side tab needs to be placed to the rear side of the actuator. *See photo 5.*
10. Install the black steel Primer Safety Shield by threading onto Primer Dispenser. *See photo 8.*



**Photo 5**

8. Install the Primer Dispenser ensuring the post on the bottom side is inserted into hole on the Shell Plate Holder. Push on side of Primer Dispenser to bias it's location toward the Primer Transfer Bar. Secure the Dispenser with a 8-32x3/8" BHCS using a 3/32 hex key wrench. *See photo 6.*

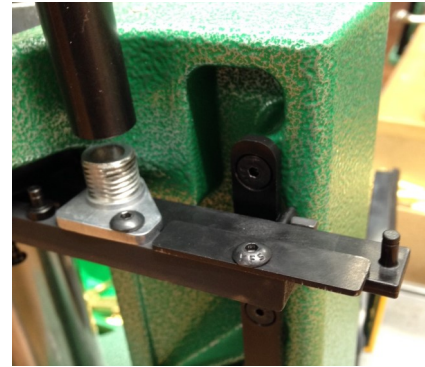


**Photo 6**

9. Install Transfer Bar Guide using another 8-32x3/8" BHCS in the hole at the end of the Primer Transfer Slot. *See photo 7.* Before operating the press, it's position may need to be adjusted. (see section on Transfer Bar Alignment.)



**Photo 7**



**Photo 8**

11. Install appropriate sized aluminum Primer Tube (for small or large primers) by inserting down through Safety Shield and into Dispenser. Aluminum Tube should extend approximately 1/4" above Safety Shield. Install threaded Safety Shield Cap to secure Primer Tube. Thread onto Safety Shield gently. Ensure all parts are aligned by visually inspecting through top of Cap. *See photo 9.*



**Photo 9**

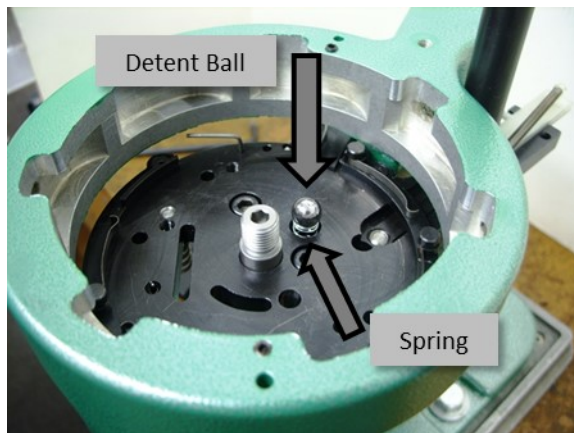
13. Lower Ram and push Primer Transfer Bar forward. Install Transfer Bar Spring by slipping the ends of the spring over the two posts. *See photo 10.* A small screwdriver or hex key wrench is helpful.



**Photo 10**

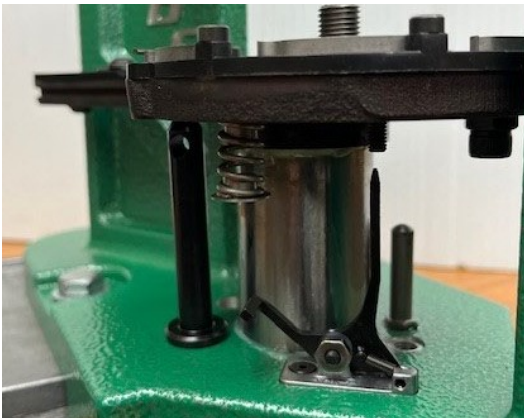


14. Raise ram to top of stroke. Insert Detent Spring into the hole on the Shell Plate Holder, then place Ball Bearing on top of spring, as shown in *photo 11*.



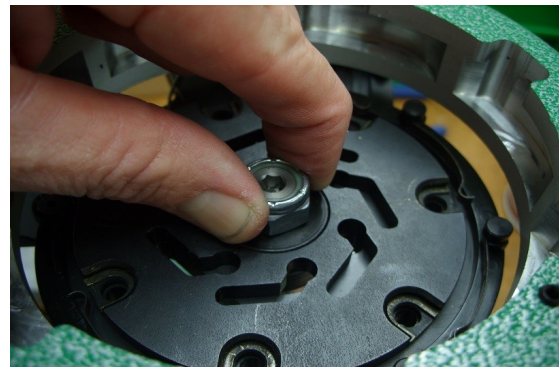
**Photo 11**

15. Place the Lock Out Pin underneath the Shell Plate Holder and lower ram until Shell Plate holder is resting on Lock Out Pin. Doing this will prevent damage to the Index Arm during assembly of Shell Plate. See *photo 12*

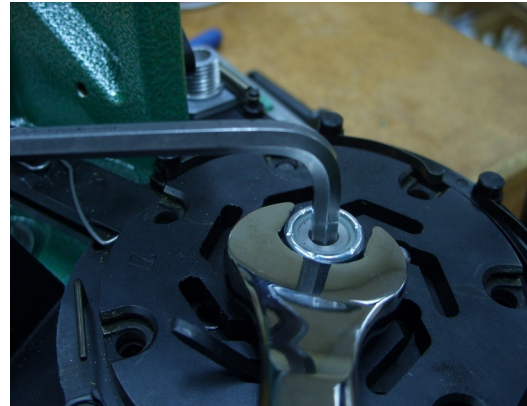


**Photo 12**

16. Place appropriate Shell Plate for your particular cartridge) on top of the Shell Plate Holder. Install washer and nyloc nut on Shoulder Bolt. Thread the nut down until snug. Insert a 3/16" hex key wrench into the Shoulder Bolt and back the nut off 1/4 turn. Be sure the Shoulder Bolt remains tight. See *photo 13, 14*

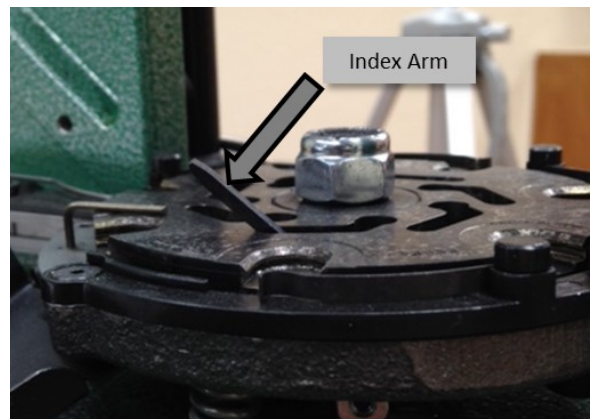


**Photo 13**



**Photo 14**

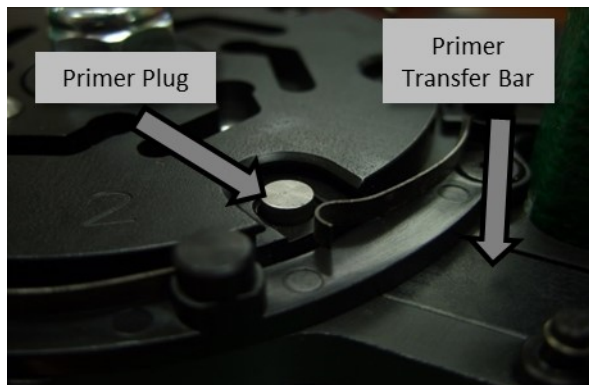
17. Manually index the Shell Plate to successive stations. Be sure the Shell Plate indexes fully and smoothly. If further tightening or loosening of the nyloc nut is necessary, be sure to use a 3/16" hex key wrench in the Shoulder Bolt. This is to keep the Shoulder Bolt from 'backing out' and becoming loose. Do not over tighten or the Shell Plate will not advance and damage to the Index Arm may occur.
18. Raise the ram slightly and remove the Lock out Pin, then slowly lower the ram to ensure that the Index Arm passes up thru the Shell Plate Holder and Shell Plate. See *photo 15*.



**Photo 15**

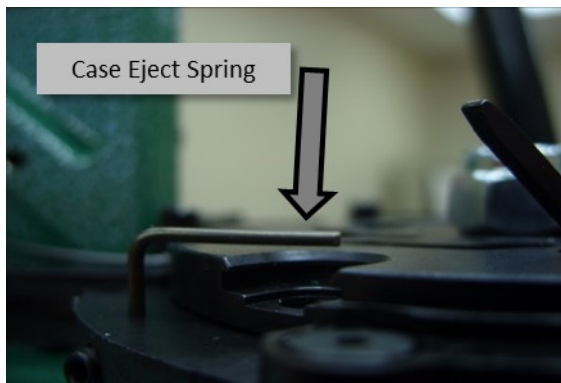
- a. Although the Index Arm is set at the factory, it can be biased slightly if necessary by removing the nut and screw and installing the flat washer on opposite side of Indexer Arm.

19. Cycle press stroke to ensure the Shell Plate indexes smoothly around at all stations. Ensure that the Primer Transfer Bar is actuating properly and that the Primer Plug is coming up thru the Transfer Bar and Shell Plate. *See photo 16.*

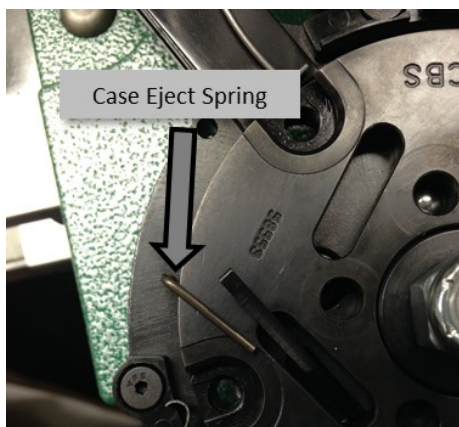


**Photo 16**

20. Adjust the Case Eject Spring approximately as shown. Case eject Spring should be set to approximately .030" above the Shell Plate. Check for ease of ejection. Some adjustment may be necessary. *See photos 17 and 18.*

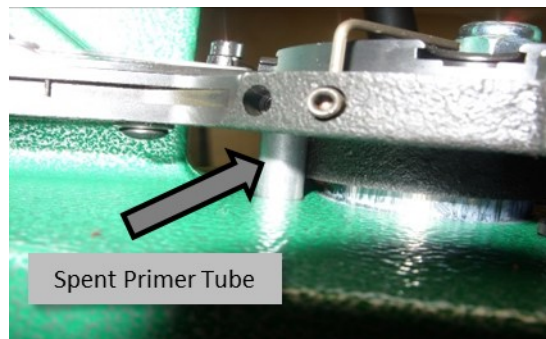


**Photo 17**



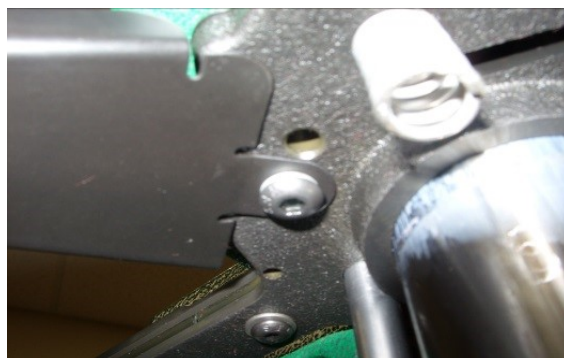
**Photo 18 Top View of Case Eject**

21. With the ram in the lowered position, insert the Spent Primer Tube in the hole on the underside of the press. The Spent Primer Tube will pass through on the left underside of the Press Frame and into the Shell Plate Holder. Ensure the Spent Primer Tube is fully inserted into the Shell Plate Holder and secure with the 8-32 x 1/4" SHSS in the side of the Shell Plate Holder using a 5/64" hex key wrench. *See photo 19.* Place a trash receptacle under Spent Primer Tube to collect old primers.



**Photo 19**

22. Raise the ram to the top of the press stroke. Attach the Discharge Chute to the underside of the Shell Plate Holder with a 10-32 x 3/8" BHCS and #10 Lock Washer using a 1/8" hex key wrench. *See photo 20.* Vary its orientation as needed to function effectively.



**Photo 20**

23. Insert the Die Plate into the top of the press. Insert the Die Plate lugs into the opening and turn clockwise. Secure with the three 8-32 x 1/4" SHSS. Be sure that the setscrews are in the countersinks on the Die Plate. This is to ensure alignment between the dies and cases. *See photo 21.*



**Photo 21**



**Photo 23**

23. The Pro Chucker Press comes with an Ammo Bin to catch the finished cartridges. A Box Bracket holds the bin. Mount the Box Bracket at bench top level using two #8 x 1/2" screws, with the right edge approximately 3/4" from the Press Frame. *See photo 22.*



**Photo 22**

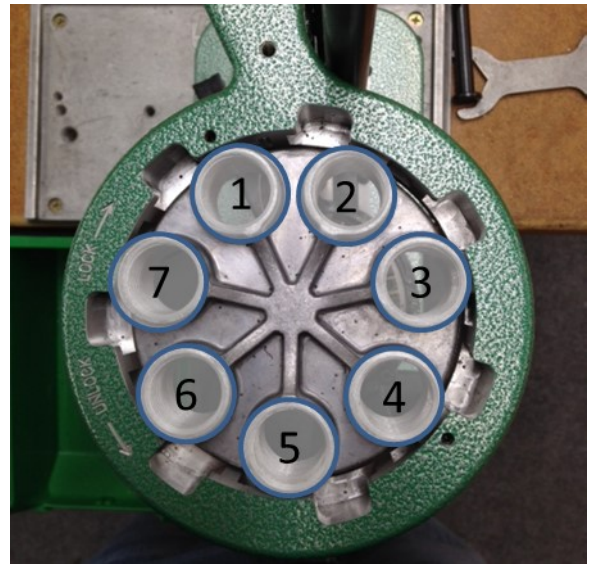
This will place the Ammo Bin as shown in *Photo 23*, to catch your loaded cartridges.



## RELOADING DIES SET-UP

Refer to reloading Die instructions for individual adjustment and set-up. See diagram for position and rotation.

Automatic Indexing is in a clockwise direction.



## STATION SET-UP OPTIONS

### **Station 1:**

1. Sizing Die

### **Station 2:**

1. Expander Die for straight wall cases.
2. No die for bottleneck cartridges.

### **Station 3:**

1. Powder charging. Refer to Powder Measure instructions on **page 14**.

### **Station 4:**

1. Lock Out Die (optional for pistol calibers 9mm and larger).
2. Powder Checker Die (optional, for most rifle and pistol calibers).

### **Station 5:**

1. Bullet Feeder (Tube or Power, pistol only)
2. Seat die or seat/crimp die

### **Station 6:**

1. Seat die or seat/crimp die

### **Station 7:**

1. Crimp die (optional, if you choose to seat and crimp separately).

## DIE ADJUSTMENT

Refer to the Reloading Die Instructions that came with your Dies. Contact the Die manufacturer for a copy if you are unable to find them or have any questions about setup or operation.

## POWDER MEASURE

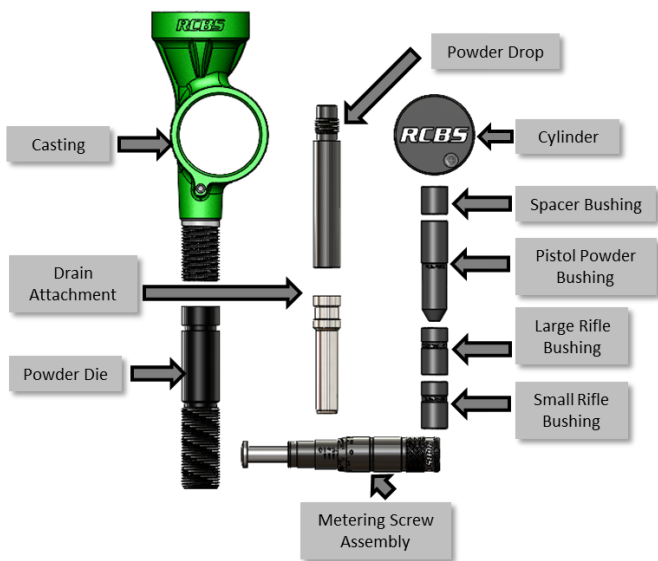
A Powder Measure is a device which measures powder by volume, not weight. However, before you start dispensing smokeless powder with a Powder Measure, the first several charges must always be weighed on a scale to verify the desired charge.

Accurate powder measure charges will also depend upon the size and uniformity of the powder kernels used.

**⚠ DANGER:** DO NOT use the Uniflow or Quick Change Powder Measure with black powder! Doing so can cause serious injury or death.

**Helpful Tip:** The consistency of the powder and static electricity are causes of erratic powder charges. Slowly roll the powder container several times to homogenize it before pouring it into the Powder Hopper. Static electricity can be reduced by wiping down the Powder Hopper with an anti-static cloth.

**⚠ CAUTION:** All internal components of the Powder Measure assembly must be thoroughly cleaned of rust preventatives applied at the factory. Failure to do this will cause powder charges to be inconsistent and provide erratic performance of your reloads. **See Diagram F for the following items that you must clean and dry before use:**



**Diagram F. POWDER MEASURE ASSEMBLY COMPONENTS**

A dependable powder scale should be used to set the first charges in the Powder Measure. It is not necessary to empty the Powder Hopper each time you change charges unless a different powder is required.

### POWDER MEASURE ASSEMBLY

**⚠ CAUTION:** DO NOT leave powder in the Powder Measure, as it will deteriorate and may clog and jam the Measuring Cylinder and etch the Powder Hopper.

1. Thread Powder Measure into Die Plate at desired station approximately five full turns.
2. Install the Quick Change Lock Screw 1/4-1/2 turn into the threaded hole on the side of the Measuring Cylinder. See photo A.



**Photo A**

3. Install the Cylinder into main Casting. Make sure the screw holes are oriented facing toward the Linkage Assembly before you slide it into the Main Casting. Carefully insert the Cylinder into the Main Casting. This is a precise fit, do not force the Cylinder into the Casting. See Photo B.



**Photo B**

4. Remove Thumb Screw and top end of Return Spring.
5. Slip the slotted portion of Cylinder Link over the Drive Pin. See photo C.





**Photo C**

6. Align holes in Link with nearest holes in Cylinder. Install two 10-32x3/8" button socket head cap screws using an 1/8" Hex Key wrench. *See Photo D.*



**Photo D**

7. Install Micrometer Adj. Metering Screw Assembly into Cylinder. Notice the hole on the side of the Metering Screw Assembly. This is the locking point for the Lock Screw. You may need to loosen Lock Screw while inserting Metering Screw body into the Cylinder bore. *See Photo E.* Try to rotate the Metering Screw body to insure it is locked in place. The Metering Screw Assembly has the following dispensing range:

Extruded Powder

Max = 95 grains

Min = 5 grains

Ball Powder

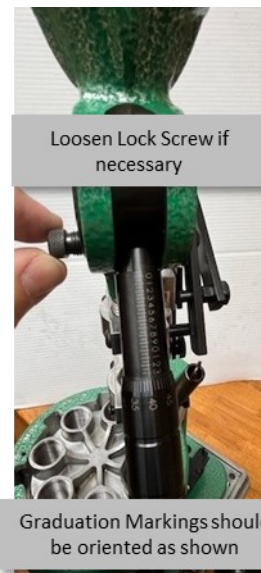
Max = 104 grains

Min = 1.3 grains

Flake Powder

Max=63 grains

Min= .4 grains



**Photo E**

8. Lift the Powder Measure Assembly up and out of the Powder Die. Select the correct Powder Bushing, Small Rifle 22-270, Large Rifle 7mm-45, or Pistol. Install Bushings with the funnel end up. *See photo F. See Powder Bushings in Diagram F on page 14 for correct orientation.*



**Photo F**

9. Install Powder Measure Assembly into Powder Die. *See photo G.*



**Photo G**

10. Connect the Powder Measure Linkage and tighten the Thumb Screw. See photo H. NOTE: Periodically check Thumb Screw for tightness during the loading session.

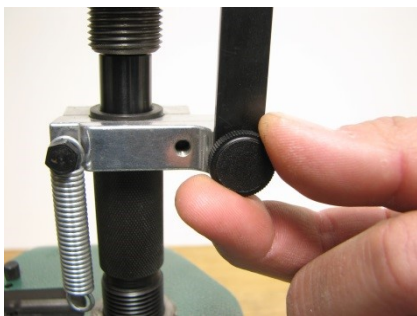


Photo H

Do not install the Return Spring yet.

11. Insert a sized and trimmed case in the station below the Powder Measure and raise Ram. Adjust powder dump in relation to case height by threading the Powder Measure assembly down on the case until a full stroke of the Powder Measure is achieved. NOTE: Full stroke is within 1/16" to barely touching the top of the slot in the Uniflow Powder Measure casting. See photo I. This allows the Powder Die to turn one full turn to orient the Powder Measure to a convenient position.



Photo I

Should the Powder Die hit the Shell Plate before the full powder measure stroke is achieved, back off the Powder die nine turns and install the spacer on top of the Powder Bushing. Thread the Powder Die down until full stroke on the Powder Measure is achieved.

12. Lower the Ram and attach the Return Spring. See photo J.

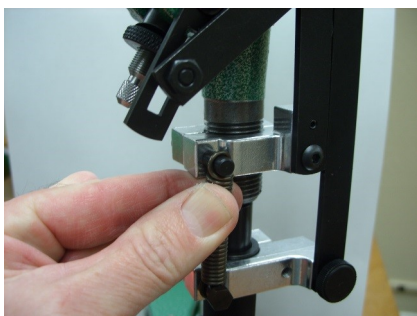


Photo J

13. Tighten the 7/8-14" lock ring on the Powder Die.

14. Install threaded Hopper w/Baffle. Powder Measure installation is now complete.

**CAUTION:** Before reloading cartridges, verify powder charge weight consistency by dispensing powder into appropriate cartridge cases several times, weighing the powder on a calibrated scale.

## TO REMOVE POWDER MEASURE FROM PRESS

To remove the Powder Measure from the Press, simply remove the Thumb Screw and Return Spring, then, lift off the Powder Measure Assembly.

## TO DRAIN POWDER HOPPER

It is not necessary to empty the powder hopper each time you change charges unless a different powder is to be used.

Powder should not be left in the measure as it will deteriorate and may clog and jam the Metering Cylinder and etch the Powder Hopper. The measure can be emptied without taking it off the press by using the provided Quick Change Drain Tube.

Dispense the remaining charge and hold the Metering Screw Assembly in the "up" position. Loosen the knurled Lock Screw, and remove the Metering Screw Assembly. Align the Lock Screw groove on the side of the Drain Tube and insert into the Metering Cylinder. While tightening the Lock Screw try to slide the Drain Tube in and out to insure that the Lock Screw is positioned on groove in Drain Tube. Tighten the knurled Lock Screw to secure. Place the correct powder container near the end of the Drain Tube and slowly rotate the Metering Cylinder to the "down" position. The powder will flow through the Metering Cylinder and Drain Tube and back into your powder container.

NOTICE: If the Metering Screw Assembly is in the "down" position when the Metering Screw Assembly is removed, the powder will flow through the Metering Cylinder and spill out of the powder measure!

## TO REMOVE A CYLINDER

To remove the Metering Cylinder for cleaning, first empty the powder hopper. Loosen the Lock Screw and remove the Drain Tube Attachment. Next remove the two Link screws and the Cylinder Link. Then carefully slide out the Metering Cylinder.

## POWDER BRIDGING

*Helpful Tip:* When using some extruded (long grain) or large flake powder, bridging can occur. This happens when the powder jams (bridges) together and stops the flow of powder. This is caused by the powder dumping too quickly from the Powder Measure Cylinder into the Drop Tube. It can also occur when lube/ oil is present on any surface contacting smokeless powder.

To eliminate this possible problem, slow down the Press Handle swing, which slows the Cylinder rotation and pours the powder from the Powder Measure Cylinder at a slower rate. Otherwise, a fast dump may cause the powder to bridge in the Powder Bushing. To prevent bridging, slow down the Press Handle swing halfway through its stroke.

## **FILLING PRIMER TUBES**

### **PRIMER TUBE WARNINGS**

In rare circumstances, primers can become lodged in tubes that are obstructed, damaged or improperly maintained.

**⚠ WARNING!** Never force or pound/tap on live primers, tap or pound on loaded primer tubes, or otherwise attempt to clear obstructions on your own. Doing so can cause serious injury.

If you experience a feeding problem in a primer tube, follow these steps:

1. Ensure no primers are in the white plastic pickup tip.
2. Remove the white tip with pliers.
3. If possible, carefully pour the primers out of the tube and return primers to original packaging. Do not use the tube.
4. If a stuck primer(s) remains, handle with care and take to your local hazardous waste disposal facility.
5. Replacement tubes can be purchased online at [RCBS.com](http://RCBS.com) or through an authorized dealer. Warranty claims can be made by calling RCBS at 1-530-538-2699.

To avoid primer feeding problems, always follow these precautions:

Before use, always inspect tube for damage or interior obstructions.

Never use bent, damaged or obstructed tubes.

Ensure tube is free from primer residue buildup. Periodically clean inside of tube using soap and warm water.

We recommend the RCBS Primer Tray-2 to be used in conjunction with the Primer Tube. This plastic primer tray and cover have been designed to orient primers for fast, easy handling and primer pick-up.

Step 1. Scatter the primers onto the grooved surface of the primer tray. Then, gently shake the tray horizontally until all the primers are positioned anvil side up. Place the cover on the tray, while holding the tray and cover together, turn the tray upside down. The primers will now be oriented anvil side down for easy pick-up with the appropriate size priming tube assembly. See *Photo K*.

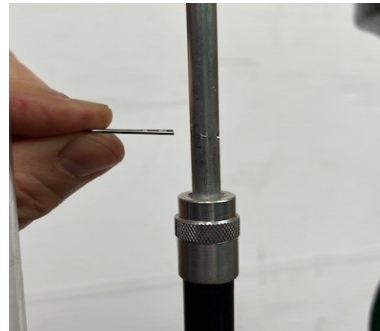


**Photo K.**

Step 2. Insert the primer feed tube cotter pin into the cross hole before picking up any primers.

**⚠ WARNING:** It is the responsibility of the operator to insure that all primers are properly oriented. Attempting to seat a primer upside down in a case may cause the primer to detonate, causing serious personal injury or damage to the equipment. Primer residue is dangerous when exposed to heat, impact and/or static electricity. Therefore, it is important to keep the primer tubes clean. We recommend periodic cleaning with soap and warm water.

Step 3. Use the plastic tipped end of the tube opposite the cotter pin for primer pick-up. After filling, place the tube, cotter pin end down, onto the top of the safety tube cap. While holding the tube, remove the cotter pin, dropping the primers into the top of the safety tube cap. Be sure all primers are transferred into the Priming Tube. See *Photo L*.



**Photo L.**



## PRESS OPERATION

We recommend that several cases be completely reloaded one at a time before proceeding with full operation. This will help you to become familiar with the loading process.

**⚠ WARNING! DO NOT UNDER ANY CIRCUMSTANCE attempt to reseal high primers, in loaded cartridges (a case with the primer, powder and bullet in place). Pull the bullet, dump the powder and then seat the primer to the correct depth.**

**⚠ WARNING! Never attempt to seat a primer in an under-sized primer pocket. Decrimp military-specification cases and commercial cases with staked/ crimped primer pockets before use.**

**⚠ WARNING! To prevent primer detonation, if you encounter any unexpected resistance during seating, STOP! Discontinue priming until the problem is found and corrected.**

### Step 1:

Insert clean, trimmed case into Station #1. This is the sizing station on the Pro Chucker Press. See photo M.



Photo M

The Case Feed Ramp, black plastic part holding the Case Retaining Spring #1, is reversible. The press is assembled with the Case Feed Ramp as shown in photo N. The case is inserted into Station 1 by placing the case down on the Case Retaining Spring #1 and inserting into the Shell Plate.



Photo N

Inserting the case into Station 1 with the Case Feed ramp reversed requires the Case Retaining Spring #1 to be pushed to the side to insert the case into the Shell Plate. Either method works, this is an operator option. See photo O.



Photo O

To reverse the Case Feed Ramp, remove the two 8-32 x 3/8" BHCS and flat washers from the underside of the Shell Plate Holder. See photo P. Also remove the 8-32 x 3/8" BHCS on the upper side that is holding the Case retaining Spring #1. Note: Take care in removing the Case Feed Ramp from the Shell Plate Holder. These parts fit snugly and the Case Feed Ramp can break if pried up on one end. A 3/16" hex key wrench pushed slowly thru the screw holes on the underside will move the Case Feed Ramp up enough for removal. Also take care in securing the Case Feed ramp to the Shell Plate Holder. Tighten the two 8-32 x 3/8" BHCS to just snug. Do not over tighten, as the threads in the Case Feed Ramp will strip and be destroyed.

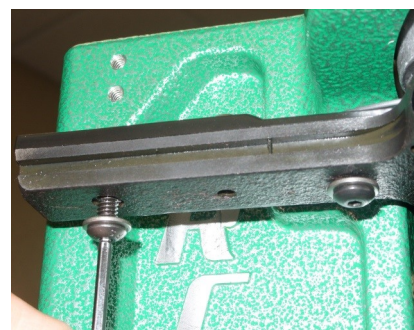


Photo P

Be sure that the Case Retaining Spring #1 is adjusted to keep the case in the Shell Plate but not to drag on the Shell Plate. See photo Q.

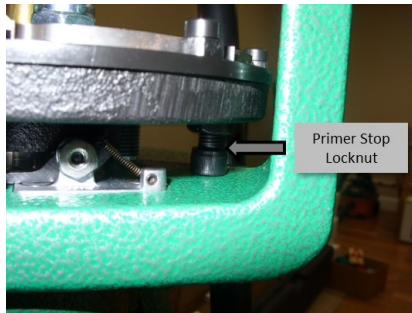


Photo Q

### Step 2:

With a properly lubricated case in Station 1, lower the handle to raise the case into the Sizing Die. The case will be sized and the spent primer will be ejected. Now raise the handle to lower the case and index the shell plate to Station 2. Firmly press the handle all the way to the rear to insert a new primer into the case. Allow the handle to return to the neutral position.

The primer is seated in the last 1/2" of the handle stroke below the shell plate neutral position. Remove the case and inspect primer depth. Adjust Primer Stop if necessary. See *photo R*.



**Photo R**

*NOTE: Primer depth can be set by the primer depth adjustment screw. Primers can also be seated by "feel" by simply adjusting the stop out of the way.*

#### **Step 3:**

Lower the handle to raise case into Station 2 to expand and flare/bell the mouth of the case.

*NOTE: Station 2 is for the expanding of straight wall rifle and pistol cases and is an empty station for bottleneck rifle and pistol cases.*

#### **Step 4:**

Cycle the handle to index case and raise it into Station 3 (Powder Measure) to charge the sized and primed case with powder. Remove the case and weigh powder on a scale to verify that the powder charge is correct. Refill case with powder and funnel. Reinsert the case back into the Shell Plate at station 4. Check every fifty rounds to ensure that the powder charge has not changed. *NOTE: Refer to Powder Measure instructions for adjustment.*

#### **Step 5:**

Cycle the handle to move the case through Station 4. *NOTE: This is an extra station that allows options such as a Powder Checker Die or Lock-Out Die or you may choose to have this as an empty station.*

#### **Step 6:**

When the case is at Station 5, Insert a bullet onto the case mouth, lower the handle to seat and crimp the bullet. *NOTE: This station can also be used for the Pistol Bullet Feeder, which would allow for seat and crimp the bullet in Station 6, or seat the bullet in Station 6 and Crimp the bullet in Station 7.*

#### **Step 7:**

Cycle the handle to move the loaded cartridge through station 6 and station 7 if not using the Pistol Bullet Feeder is Station 5 or using Station 6 for Bullet Seating and Station 7 for Bullet Crimping. As the Handle is lowered at Station 7 the loaded cartridge will be ejected onto the Discharge Chute and slide down into the Ammo Bin.

See *photo 5*



**Photo S**

### **Pro Chucker 7 Station Press**

Stations 4, 5, and 6 are extra stations for options such as Powder Checker Die, Lock Out Die, Pistol Bullet Feeder and to seat and crimp in separate operations.

# **Pro Chucker Progressive Reloading Press Operating Instructions**

Now that you have read the instructions and are familiar with your Pro Chucker Progressive Reloading Press, you are ready to reload!

Based on our experience, we will explain the most efficient way to use your new Pro Chucker Progressive Reloading Press. You may choose to change your technique as you become more accustomed to the function of this tool, but for now, we strongly suggest you use the following operating procedure.

Have your bullets and cases positioned on the left side of the press. The Ammo Bin will be used to catch the loaded ammunition as it is ejected from the press.

Fill the primer tube as instructed on page 18.

With your right hand on the Handle Ball, pick up an unsized case with your left hand and slide it fully into Station 1. Be sure the case holder spring is adjusted to barely touch the rim of the case.

Now smoothly pull the Handle down. This will size and deprime the case in Station 1. Raise the handle to the top of the stroke and smoothly push the handle fully to the rear, the Shell Plate will automatically index and you will be able to feel the primer being seated in the case. You now have a sized and reprimed case in Station 2. Insert another unsized case into Station 1 and lower the handle. Again, this will size and deprime the case in Station 1, while at the same time, expand the case in Station 2. Raise the handle and push fully to the rear to reprime the case in Station 2. Let the Handle return to the neutral position.

You now have a sized and reprimed case in Station 2 and an expanded case in Station 3. Insert another case into Station 1 and lower the handle. Station 1 and 2 will repeat the same operation while the powder charge is being dispensed in Station 3. Next, raise the handle and push fully to the rear and let it return to the neutral position.

You now have a sized and reprimed case in Station 2, an expanded case in Station 3, and a powder charged case in Station 4. Insert another case in Station 1 and lower the handle. Stations 1, 2 and 3 will repeat the same operations. Station 4 may perform a variety of operations, depending on your preferred reloading technique. In the case of rifle calibers, this may be an empty station or you may use a Powder Checker Die. In the case of pistol calibers, you may select to seat in Station 4 and crimp in Station 5. As another option, if loading pistol rounds, you may use an RCBS Lock-Out Die in Station 4, then, seat and crimp in one operation in Station 5.

Another option if loading for pistol, Station 4 could be configured with a Lock-Out or Powder Check Die, Station 5 a Pistol Bullet Feeder, Station 6 a Seat Die and Station 7 a Crimp Die.

Whichever method you choose is fine. Versatility is a big advantage of owning a seven station progressive press.

By now you should be getting the hang of the sequence of operating your Pro Chucker Progressive Reloading Press. Once the Shell Plate has a case in all seven stations, the basic operating procedure remains the same time after time. Always follow the procedure below :

## **Bullet, Case, Size, Index, Prime.**

It will help you to repeat these words to yourself each time you cycle the press:

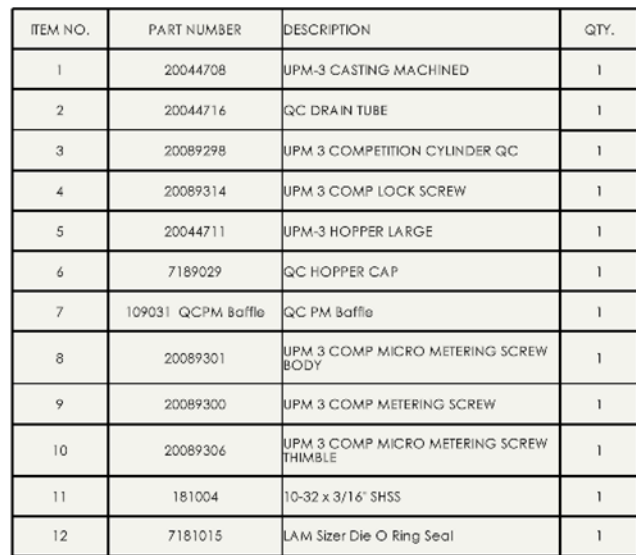
## **Bullet, Case, Size, Index, Prime:**

1. Bullet: Place bullet on case under seat die.
2. Case: Place unsized case in Station 1.
3. Size: Lower Handle and raise case into Dies.
4. Index: Raise Handle to lower cases and Index the Shell Plate.
5. Prime: Push Handle fully to rear to prime case in Station 2.

This is the sequence that will be repeated over and over as you operate your Pro Chucker Progressive Reloading Press. By now, everything should be working great. If not, re-read this portion of the instructions. If you are still experiencing problems, give us a call, we'd be glad to help.

**IMPORTANT:** Your Pro Chucker Progressive Reloading Press has been designed and manufactured to be an automatic indexing reloading press.

Any alteration or attempt to alter the function of this press will void any and all warranties offered by RCBS. We specifically warn against any attempt to convert this press to any motorized method of operation.



## Pro Chucker 7 Station

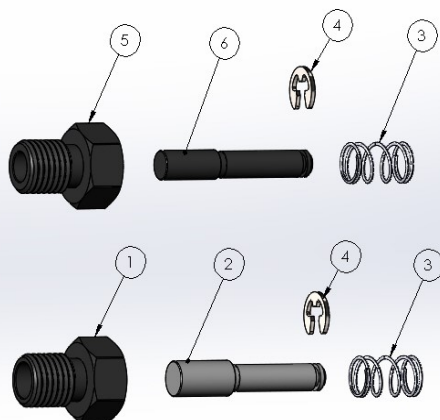


Case Actuated Powder  
Measure Linkage, Powder  
Die Assembly



ITEM #	QTY.	PART #	PART NAME
1	1	7788928	CAPM Powder Die
2	1	7788950	CAPM Lower Front Bracket
3	2	7788949	CAPM Back Bracket
4	2	7187210	10-32 x 1-1/4" BHCS
5	2	7187211	10-32 x 1" BHCS
6	1	7788941	CAPM Bottom Spring Anchor
7	1	7109187	Hex Lock Ring 7/8-14 No Hole
8	1	7187214	Century Spring #80584
9	1	7788951	CAPM Top Front Bracket
10	1	7788947	CAPM Pivot Link
11	5	7186144	10-32 x 3/8" BHCS
12	1	7187213	Roll Pin 1/8" x 3/8" Black
13	1	7788945	CAPM Drive Link
14	2	7788916	CAPM Linkage Nut
15	1	7788946	CAPM Long Link
16	1	7788944	CAPM UPM Drive Pin
17	1	7109603	Hex Nut 10-32
18	1	7186146	10-32 x 1/2" Thumb Screw
19	1	7788940	CAPM Top Spring Anchor
20	1	7788948	CAPM Cylinder Link
21	1	7788939	CAPM Powder Bushing Pistol
22	2	7788936	CAPM Spacer Bushing
23	1	7788934	CAPM Powder Bushing Small Rifle
24	1	7788938	CAPM Powder Bushing Large Rifle
25	1	7788935	CAPM Drop Tube

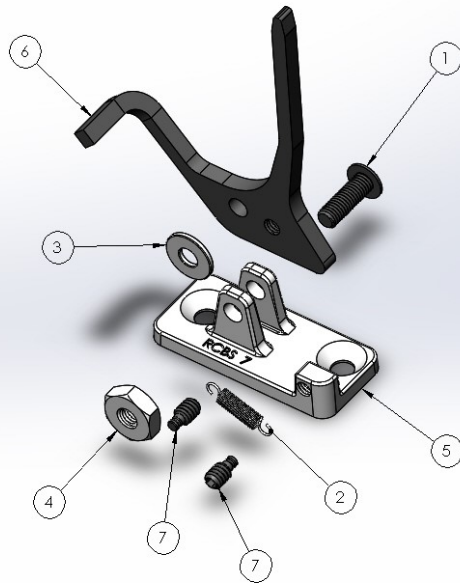
Primer Plug Assembly  
Large and Small



ITEM #	QTY.	PART #	PART NAME
1	1	7784219	Primer Plug Holder Large
2	1	7784221	Primer Plug Large
3	2	7181291	Primer Plug Spring #70464
4	2	7181294	Retaining Ring E Clip 5/32"
5	1	7784220	Primer Plug Holder Small
6	1	7784222	Primer Plug Small

## Index Mount Assembly

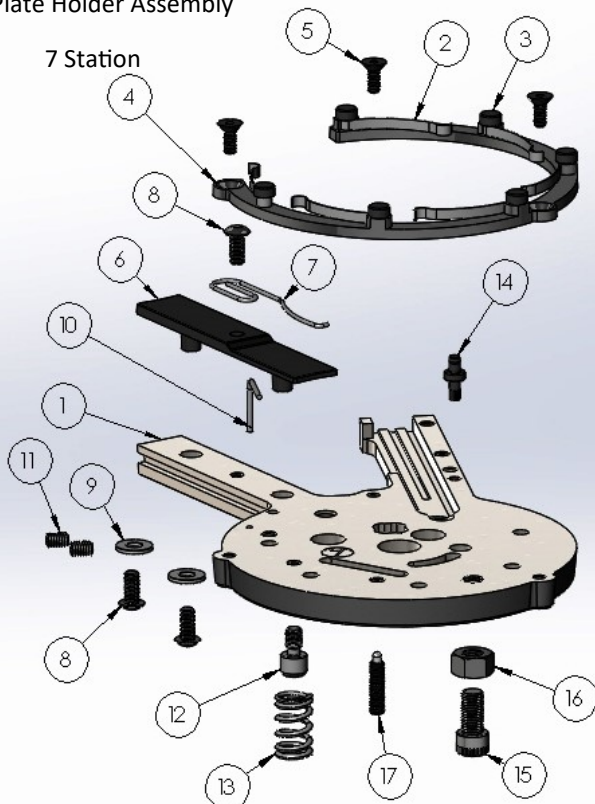
### 7 Station



ITEM #	QTY.	PART #	PART NAME
1	1	7181237	5-40 x 3/8 BHCS
2	1	7181290	Index Return Spring #80033
3	1	7187052	#4 Flat Washer
4	1	7189069	5-40 Machine Screw Nut Zinc
5	1	7784207	Index Mount 7
6	1	7784209	Indexer 7
7	2	7784215	Index Return Screw

## Shell Plate Holder Assembly

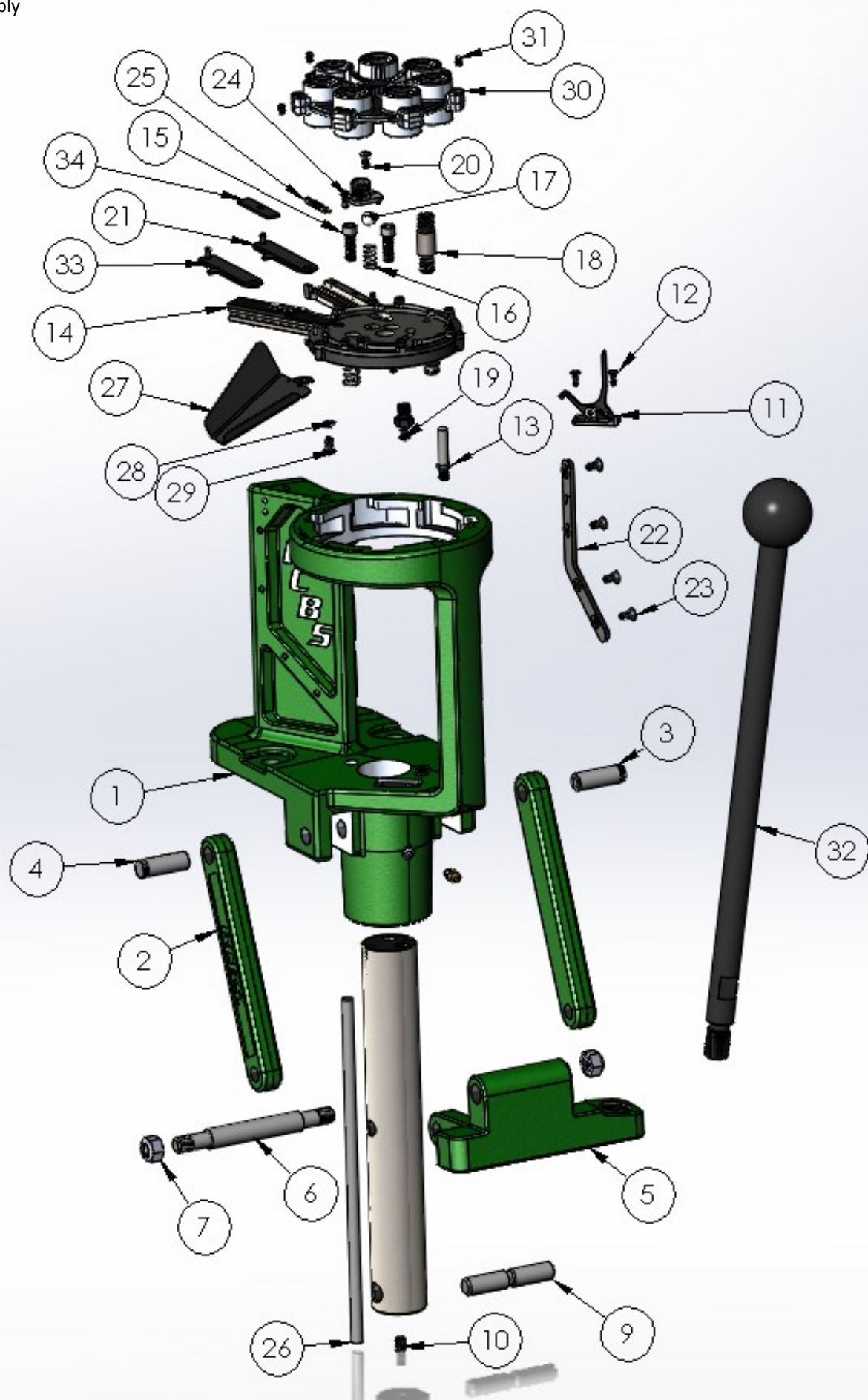
### 7 Station



ITEM #	QTY.	PART #	PART NAME
1	1	7784203	Shell Plate Holder 7
2	6	7187206	Case Retaining Spring
3	6	7788943	Case Retaining Spring Plug
4	1	7181281	Case Retaining Bracket 7
5	3	7187215	6-32 x 3/8" FHCS
6	1	7181288	Case Feed Ramp
7	1	7187208	Case Retaining Spring Station #1
8	3	7187217	8-32 x 3/8" BHCS
9	2	7187216	#8 Flat Washer
10	1	7784226	Case Eject Spring
11	2	7109509	8-32 x 1/4" SHSS
12	1	7784214	Index Spring Holder
13	1	7181293	PC Index Spring #S-404
14	1	7784223	Transfer Bar Return Pin
15	1	7187159	1/4-28 x 3/4" SHCS
16	1	7109604	1/4-28 Hex Nut
17	1	7181295	8-32 x 5/8" Spring Plunger

# Press Assembly

## 7 Station



Pro Chucker 7 Station BOM							
ITEM #	QTY.	PART #	PART NAME	ITEM #	QTY.	PART #	PART NAME
1	1	1002786	PC Frame w/Zerk		1	7784226	Case Eject Spring
	1	7784200	Frame		2	7109509	8-32 x 1/4" SHSS
	1	7109213	Zerk Fitting		1	7784214	Index Spring Holder
2	2	7788902	Link		1	7181293	PC Index Spring #S-404
3	1	7709128	Link Pin Right		1	7784223	Transfer Bar Return Pin
4	1	7709127	Link Pin Left		1	7187159	1/4-28 x 3/4" SHCS
5	1	7784201	Toggle Block		1	7109604	1/4-28 Hex Nut
6	1	7788912	Toggle Block Pin		1	7181295	8-32 x 5/8" Spring Plunger
7	2	7187212	Nyloc Nut 7/16-20	15	2	7187159	1/4-28 x 3/4" SHCS
8	1	7784211	Ram	16	1	7188037	Index Ball Spring BB-97
9	1	7788919	Ram Pin	17	1	7187152	Detent Ball 3/8
10	1	7187219	1/4-28 x 3/8" SHSS	18	1	7784217	Shell Plate Bolt
11	1		Index Mount Assembly 7	19	1		Primer Plug Assembly Small
	1	7784207	Index Mount 7		1	7784220	Primer Plug Holder Small
	1	7784209	Indexer 7		1	7784222	Primer Plug Small
	1	7181237	5-40 x 3/8 BHCS		1	7181291	Primer Plug Spring #70464
	1	7189069	5-40 Machine Screw Nut Zinc		1	7181294	Retaining ring E Clip 5/64"
	2	7784215	Index Return Screw	20	2	7187217	8-32 x 3/8" BHCS
	1	7181290	Index Return Spring #80033	21	1	7181284	Primer Transfer Bar Small 7
	1	7187052	#4 Flat Washer	22	1	7181287	Primer Bar Actuator 7
12	2	1002775	5-40 x 3/8" FHCS	23	4	7187218	8-32 x 3/8" FHCS
13	1	7784216	Locating Pin	24	1	7784210	Primer Dispenser
14	1		Shell Plate Holder 7 Assembly	25	1	7181292	Transfer Bar Return Spring
	1	7784203	Shell Plate Holder 7	26	1	7784224	Spent Primer Tube
	1		Case Retaining Bracket 7 Assembly	27	1	7784225	Discharge Chute
	6	7187206	Case Retaining Spring	28	1	7187051	Lock Washer #10
	6	7788943	Case Retaining Spring Plug	29	1	7186144	10-32 x 3/8" BHCS
	1	7181281	Case Retaining Bracket 7	30	1	7784205	Die Plate 7
	3	7187215	6-32 x 3/8" FHCS	31	3	7109509	8-32 x 1/4" SHSS
	1	7181288	Case Feed Ramp	32	1		PC Handle Assembly
	1	7187208	Case Retaining Spring Station #1		1	7784213	Handle
	3	7187217	8-32 x 3/8" BHCS		1	7109121	Handle Ball
	2	7187216	#8 Flat Washer	33	1	7181285	Primer Transfer Bar Large 7
				34	1	1003286	Transfer Bar Guide



**Optional Accessories for Your Pro Chucker Progressive Reloading Press. Find these and other RCBS products at your local dealer or on RCBS.com**



9634 Die Lock Ring Wrench



87590 Powder Check Die



87540 Lock Out Die



82355 Tube Pistol Bullet Feeder 9mm/.38-.357(90-158)

82356 Tube Pistol Bullet Feeder .38/.357 (158-180)

82357 Tube Pistol Bullet Feeder .40 S&W/10mm

82358 Tube Bullet Feeder .45 ACP

## LIFETIME LIMITED WARRANTY

Your RCBS® Pro Chucker Press 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 UPM-3 Competition is defective in material or workmanship, you must return it to RCBS, postage paid for evaluation. If defective, the product will be repaired or replaced at RCBS' option at no charge

Send a dated proof of purchase to RCBS for return shipping and handling, along with the Pro Chucker Press to:

RCBS  
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 LIMITED LIFETIME WARRANTY. RCBS IS NOT LIABLE FOR DAMAGES IN EXCESS OF THE PURCHASE PRICE OF THE PRODUCT AND UNDER NO CIRCUMSTANCES SHALL RCBS BE LIABLE FOR CONSEQUENTIAL OR INCIDENTAL DAMAGES. HOWEVER, SOME STATES DO NOT ALLOW LIMITATIONS OR 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 reloading product. This warranty gives you specific legal rights, and you may also have other rights which vary from State to State.

Please visit [RCBS.com](http://RCBS.com) for more information.



**PRECISIONEERED RELOADING EQUIPMENT**

Scan the QR to Download the RCBS APP for load information, reloading tips and more!



Customer Service

1-530-538-2699 (US or Canada)

To communicate via E-mail, fill out the

“Contact Us” form on RCBS.com

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