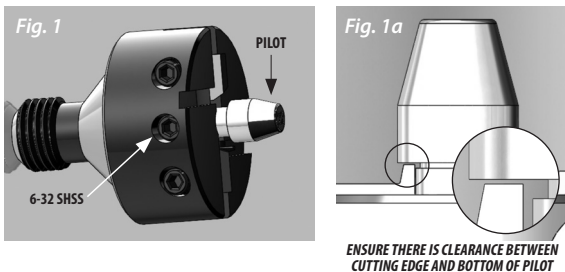
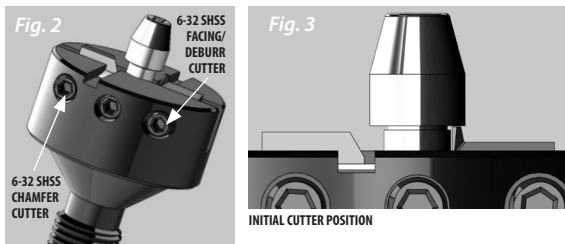


- Using a 1/16" hex wrench, loosen the center 6-32 SHSS so an appropriately sized trimmer Pilot can be inserted into the Cutter Head. Insert trimmer pilot and ensure bottom of pilot does not make contact with the highest point on the Facing/Deburr cutter, Fig. 1-1a. The clearance will allow for adjustment of the Facing/Deburr cutter. Tighten the 6-32 SHSS.



- Using a 1/16" hex wrench, loosen both 6-32 SHSS used to secure both the Facing/Deburr and Chamfer Cutters. Fig. 2 Just break loose enough to allow the inserts to slide in and out. Ensure the Inside Deburr insert is adjusted inward all the way, so it is either in contact with pilot shaft or the inside deburr cutter is completely beneath bearing surface of pilot and Outside Chamfer Insert is moved outward far enough to not contact cartridge case, Fig. 3



LIMITED LIFETIME WARRANTY

Your VLD 3-Way Cutter is warranted to be free from defects in material or workmanship for the reasonable, useable lifetime of the product. This warranty is extended only to the original consumer purchaser with dated proof of purchase. Exclusions and limitations apply.

For full warranty details including exclusions, limitations and how to inquire about a warranty claim, visit RCBS.com.

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VLD 3-Way Carbide Cutter Instructions:

Introduction:

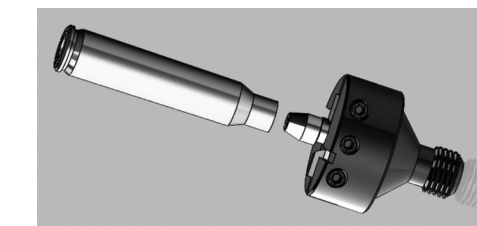
Your VLD 3-Way Carbide Cutter sets the standard in case trimming as it offers everything you need and want in a cutter. This unique, one-of-a-kind cutter offers two adjustable carbide cutter inserts:

- The Facing and Deburr carbide insert trims the cartridge case to length as well as deburrs the inside of the case mouth to a 11° angle accommodating VLD style bullets.
- The Chamfer carbide insert removes the burr on the outside of the case mouth by cutting a 30° angle chamfer.

The VLD 3-Way Carbide Cutter requires the use of standard RCBS pilots and can be adjusted to accommodate the trimming of cartridge cases ranging from .22 to .50 Cal.

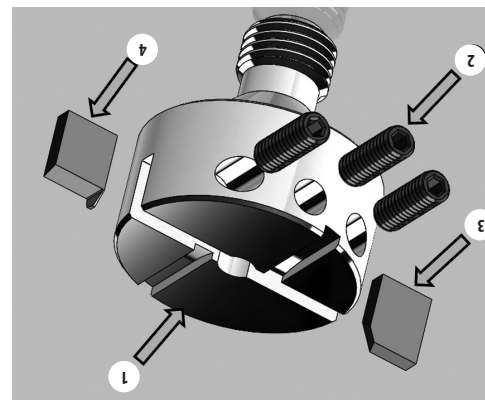
The VLD 3-Way Carbide Cutter attaches easily and works with the Trim Pro Manual, Trim Pro Power, RCBS Universal Case Prep Center, and Rotary Case Trimmers.

Refer to your case trimmer instructions for important safety and operating information.

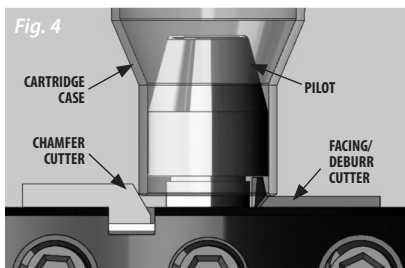


ITEM #	PART #	DESCRIPTION	QTY.
1	20034248	3 WAY VLD CUTTER HEAD	1
2	7187156	6-32 X 3/8" SHSS	3
3	20034254	CARBIDE CHAMFER INSERT	1
4	20034245	FACING & DEBUR CARBIDE INSERT	1

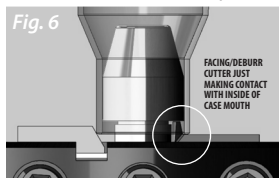
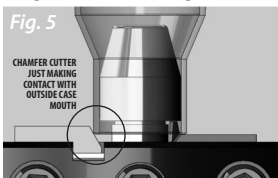
Replacement Parts List:



- Using a **chamfered/deburred case**; place over the pilot and onto the Facing/Deburr Cutter as shown in Fig. 4. This case will be used to adjust cutters.



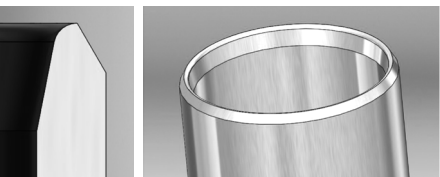
- Slide Outside Chamfer Insert until it just comes into contact with Chamfered Case, Fig.5 then re-tighten set screw to secure insert in place. Rotate the cutter head 180°, allowing gravity to slide the Trim & Inside Debur insert to slide outward until Inside Debur cutting edge comes into contact with deburred case mouth. Fig. 6. You may need pull case outward just enough to allow insert to move freely. Once Inside Debur cutting edge is against case, re-tighten set screw to secure insert in place.



- Test cutter on case to ensure all cutting edges are making contact and brass is being removed on the face and on the inside and outside of case mouth, to the desired amount. **DO THIS BY HAND TO ENSURE THE CUTTERS ARE SET PROPERLY AND TO PREVENT DAMAGING BRASS IF CUTTERS WERE SET INCORRECTLY.** Excessive chamfer and deburr will produce an undesirable sharp edge, if this happens readjustment of cutter is required. Fig. 7-7a.

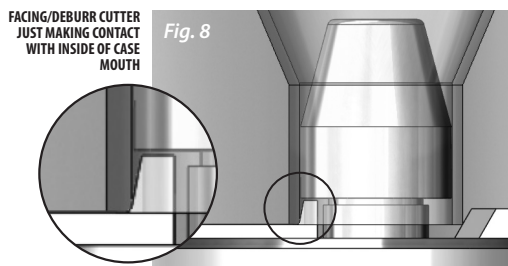


Fig. 7a
EXCESSIVE
CHAMFER
& DEBURR
CASE MOUTH
CREATING A
SHARP EDGE



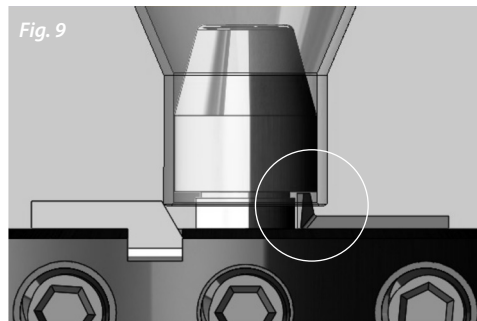
- Slight adjustments may be necessary to increase/decrease chamfer on outside of case mouth or increase/decrease deburr on inside of case mouth. To do this simply break loose the 6-32 SHSS securing cutter and slide the blade in or out using small increments to reposition cutter, using the 1/16" hex wrench.

Note If there is still a burr on the inside of the case mouth the cutter would need to be moved outward to remove more material from inside case mouth. After test cut has been completed and desired results are achieved, ensure both 6-32 SHSS are secured in place.

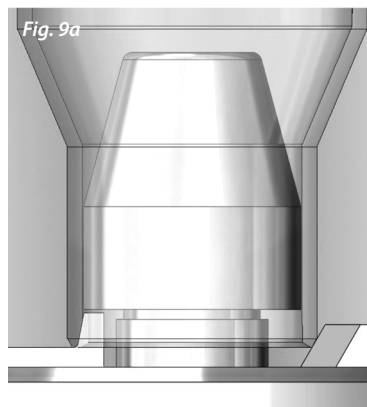


- It is important to note to not remove too much material, i.e., do not force the cutters into the cartridge case as this will generate an excessive amount of material being removed and will damage the cartridge case. Use small adjustments and when slight resistance is felt, i.e., cutter is in contact with case, secure cutter and conduct a test cut.

- If the desired results are not being achieved using this process, and more of deburr or chamfer is desired, this can be done by simply lifting the case off the cutting face slightly before advancing the cutters, then advance cutter until cutting edge is in contact with case, Fig. 9-9a. This will allow the cutter to be positioned to remove more material. If using this method perform a test cut by hand, if unable to rotate cutter and produce cut, then trying to remove too much material, so the cutters will need to be repositioned to take less material.



RAISE CASE OFF FACING CUTTER AND ADVANCE CUTTERS, TO GENERATE MORE AGGRESSIVE CUT. THIS IS DONE IF UNABLE TO ACHIEVE DESIRED REMOVAL OF MATERIAL WITH STANDARD PROCESS.



- Once desired results are achieved, loosen set screw and lower pilot until it comes into contact with post of Inside Cutter and re-tighten set screw to secure pilot.
- After cutter has been set correctly and desired results have been achieved it is time to place your VLD 3-Way Cutter on your Case Trimmer. Follow your case trimmer instructions for proper removal and installation of cutters.
- Once cutter has been installed on the trimmer, and before desired trim to length is set, insert the same case previously tested by hand and run a test cut on trimmer, at low RPM. Inspect case and ensure cutter is producing the desired cut, if not readjust cutter as needed, following instructions above.
- When all adjustments have been made and cutter is producing the desired results, adjust your trimmer to the appropriate cartridge case trim to length and begin trimming your cases.

- When cutter is in use, it is important to remove the brass chips from the cutting edge. If this is not done it can have an effect on the cartridge case length as the case is not in full contact with cutting edge. To prevent this from happening, monitor the cutter during use and when brass chips begin to build up on cutter, use a brush to remove to keep cutting edges free of chips, Fig. 10-10a



Fig. 10



Fig. 10a