

# RCBS®

## Hand Priming Tool



## PRODUCT INSTRUCTIONS

We think 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

1-800-379-1732 (US or Canada)

Hours: Monday - Friday, 5:00am - 5:00pm Pacific Time  
(hours may vary)

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**RCBS®**  
PRECISIONEERED RELOADING EQUIPMENT

### **⚠ WARNING!**

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

**If you have any questions while  
assembling or operating this product,  
call us at 1-800-379-1732 (US or Canada)  
Monday – Friday, 5:00 a.m. - 5:00 p.m. Pacific Time.  
Or email us at [rcbs.tech@atk.com](mailto:rcbs.tech@atk.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.

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

- Never attempt to seat or reseat a primer in a loaded cartridge. Prime empty cases only.
- Before priming, ensure the case's primer pocket is properly sized. Minimum diameter is 0.173 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 case pocket. Apply slow, steady, gentle pressure and STOP if you encounter resistance.
- Hold primer tool upright with the tray near horizontal when seating primers. Tilting the unit or holding the tray vertically can cause multiple primers to feed and possibly detonate.
- Never operate without the Safety Gate installed. It is designed to reduce the chance of multiple primers detonating in the tray if one primer detonates.
- Do not attempt to modify the Hand Priming Tool in any way.
- Before each use, ensure device is clear of primer dust and other foreign objects. Disassemble and clean periodically (at least every 500 rounds).
- Always wear safety glasses when using this or any other reloading tool.
- Seat primers flush with or below the case head to avoid inadvertent detonation by shearing or crushing.

**⚠ 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.

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

### 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 your hands and fingers away from "danger" spots and pinch-points where they might be injured.
- 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.

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

## PRIMER WARNINGS

**⚠ 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.
- Never force a primer into a case primer pocket. Apply slow, steady, gentle pressure and STOP if you encounter resistance.
- 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.
- Make sure all reloading tools are in good condition and used in accordance with the manufacturer's instructions.
- 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 inch 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.

## 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.

## 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 the identity of your ammunition.

## GENERAL INFORMATION

When used properly, the RCBS® Hand Priming Tool is a safe and efficient priming tool. Its most important feature is the exclusive Safety Gate Mechanism, which isolates the primer seating operation from the primer supply. This Safety Gate is designed to minimize the possibility of an inadvertently-detonated primer propagating (or “flashing back”) into the primer tray and causing multiple primers to detonate. The gate will cause a small amount of inconvenience when changing shell holders, but it is an essential part of the tool.

**⚠ WARNING!** DO NOT UNDER ANY CIRCUMSTANCE attempt to operate the tool without the Safety Gate in position or attempt to modify the tool in any way.

Other features include:

- Easily-interchangeable primer rods and feeds for large and small primers.
- A Primer Feeding System that requires no hand contact with primers.
- A detachable 100-count Primer Tray that is grooved to position primers anvil-side-up.
- A die cast body designed to fit comfortably in the palm of your hand.
- Uses standard RCBS® Shell Holders manufactured after 1980; the same ones used on RCBS presses. This eliminates the cost and hassle of buying extra equipment.
- Covered by our limited lifetime guarantee (see details at end of these instructions).

## UNPACKING YOUR HAND PRIMING TOOL

Unpack the Hand Priming Tool carefully. Look for and identify the following items:

- Hand Priming Tool with Large Primer Feed and Large Primer Rod Link installed.
- Green plastic Primer Tray with clear plastic lid.
- Plastic bag with the following parts: Small Primer Feed (Right-Half and Left-Half, both white colored) and Small Primer Rod Link.

Refer to the parts list at the end of these instructions for part numbers, descriptions and definition of capitalized terms.

## PREPARE YOUR HAND PRIMING TOOL (Large Primers)

This Hand Priming Tool comes assembled for use with large primers, with the large (black) Primer Feeds and Large Primer Rod Link already installed.

Note: For use with small primers, see the next section of this instruction manual.

Before use, you must install the appropriate Shell Holder (not included). To do this, follow these simple steps:

1. Grip the Priming Tool in your hand and squeeze the handle until partially or fully compressed.
2. Loosen the Safety Gate Screw on the handle and pull the Safety Gate completely out of the tool.
3. Release the handle slowly and allow it to fully open. See Photo 1.
  - a. Once you release the tension without the Safety Gate in position, the tool will open completely and the internal parts will need to be realigned. This is a safety feature to discourage using the tool without the Safety Gate in place. You will need to realign the internal linkage later in this procedure.



Photo 1: Handle Fully Open

4. Slide the installed Primer Feed to the side and out of the tool.
5. Place the appropriate Shell Holder on top of the Large Primer Feed.
6. Slide the Primer Feed and Shell Holder back into the Priming Tool body. See Photo 2.



Photo 2

7. Realign internal linkage by following the procedure in “Aligning Internal Linkage” section later in this instruction manual. Then return to the next step in this sequence.
8. Replace the Safety Gate. See Photo 3.



Photo 3

9. Tighten the Safety Gate Screw. See Photo 4.



Photo 4

### **SWITCHING PRIMER SIZE (Large to Small)**

**Note:** This Hand Priming Tool comes assembled for use with large primers. To switch the configuration for use with small primers, follow these steps. The Small Primer parts are located in the Parts Bag that shipped with your product.

1. Grip the Priming Tool in your hand and squeeze the handle until partially or fully compressed.
2. Loosen the Safety Gate Screw on the handle and pull the Safety Gate completely out of the tool.
3. Release the handle slowly and allow it to fully open. See Photo 1.
  - a. Once you release the tension without the Safety Gate in position, the tool will open completely and the internal parts will need to be realigned. This is a safety feature to discourage using the tool without the Safety Gate in place. You will need to realign the internal linkage later in this procedure.
4. Slide the Large Primer Feed to the side and out of the tool.
5. Turn the Priming Tool over to remove the Primer Rod Link and Compression Spring inside the Priming Tool's body.
6. Select the proper size Primer Rod Link (small diameter rod for small primers (item 3) and large diameter rod for large primers (item 4)).
7. Slide Compression Spring (item 15) over small end of Primer Rod Link. See Photo 5.



Photo 5

8. Insert Rod/Spring unit into opening slot of HPT Body (item 1). See Photo 6.



Photo 6

9. Locate the appropriate Primer Feed (Large for large primers and Small for small primers). To avoid confusion, the large and small feeds have different colors and labels:
  - Small Primer Feed – white and identified with an “S”
  - Large Primer Feed – black and identified with an “L”

10. Place the appropriate Shell Holder on top of the proper Primer Feed.
11. Slide the Primer Feed with Shell Holder back into the Priming Tool body. See Photo 2.
12. Realign internal linkage by following the procedure in “Aligning Internal Linkage” section later in this instruction manual. Then return to the next step in this sequence.
13. Replace the Safety Gate. See Photo 3.
14. Tighten the Safety Gate Screw. See Photo 4.

### **ALIGNING INTERNAL LINKAGE**

To realign internal linkage, the ball-end of the Pivot Link must be centered inside the ball-socket on the bottom of the Primer Rod Link. To do this:

1. Invert the Hand Priming Tool, causing the Primer Rod Link and Compression Spring to fall toward the Primer Feed through a bore inside the body of the tool.
2. Use a screwdriver, or other long flat tool, to center the ball-end of Pivot Link (item 7) into the bottom ball-socket of Primer Rod Link (item 3 or 4). See Photo 7.



Photo 7: Centering Internal Linkage

3. While holding the Primer Rod Link in this position, squeeze the HPT Handle slightly so the Primer Rod Link begins to slide. Then remove the screwdriver and squeeze the handle until fully closed.
  4. Hold the handle in this position and continue to the next step.
- Note:** If excessive resistance or binding of mechanism is felt, stop immediately and try again.

### **FILLING THE PRIMER TRAY**

The next step is to install the Primer Tray. At some point, primers will need to be loaded into the tray. This can be done before or after the tray is attached to the priming tool. We recommend loading primers into the tray before attaching it to the Hand Priming Tool using this procedure:

1. With the Primer Tray detached from the Priming Tool, remove the clear plastic lid from the Primer Tray by lifting the lid straight off.
2. Scatter some primers onto the grooved surface of the green Primer Tray.
3. Gently shake the Primer Tray from side to side and the primers will flip over and be positioned anvil side up for proper feeding into the Hand Priming Tool.
4. Replace the clear plastic lid. Notice there is a notch cut into the lid that fits centered over the portion of the tray that funnels the primers into the Primer Feed. See Photo 8. There is also a wall inside the lid. By turning the lid you can either start or stop the flow of primers into the Primer Feed.
5. Turn the lid counter-clockwise to stop primers.

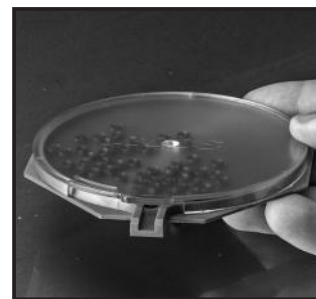


Photo 8: Primer Lid Notch and Tray Funnel

6. Insert the Primer Tray into the Primer Feed on the tool. See Photo 9. Photo 10 shows the Primer Tray installed with the lid in a closed position to stop the flow of primers.



Photo 9



Photo 10



- With the lid in this closed position, hold the tool in a vertical orientation and squeeze the handle fully through the entire stroke. Ensure the Primer Rod protrudes above the Shell Holder and travels smoothly. If any binding of the rod occurs, wiggle/move the Primer Feed gently to align the bore in the Primer Feed with the Primer Rod.

### USING YOUR HAND PRIMING TOOL

The tool is now ready to be used. To prime cases:

- Hold the Hand Priming Tool comfortably in your hand in a vertical orientation.
- Rotate the Tray Lid clockwise until the notch is in the open position and allows primers to flow out. See Photo 11.
- Slightly tilt the tool to cause a primer to enter the Primer Feed and onto the top (flat) surface of the Primer Rod. Visually inspect the primer to ensure it is in the correct orientation (anvil up).

**WARNING!** Hold the tool upright with the tray near horizontal when using. Tilting or holding with the tray vertical can cause multiple primers to feed and possibly detonate, causing death, serious injury, or property damage.

- Insert an unprimed and unloaded case into the Shell Holder. See Photo 12.



Photo 11



Photo 12

**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 undersized primer pocket. Decrimp military-specification cases and commercial cases with staked/ crimped primer pockets before use.

- With steady, gentle pressure, slowly squeeze the handle until you feel the primer seated to the bottom of the primer pocket. With a little practice you'll soon appreciate the sensitive "feel" of the Hand Priming Tool.

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

- Release the handle and remove the primed case from the Shell Holder. Check the seated depth of the primer.

### PRIMER SEATING DEPTH

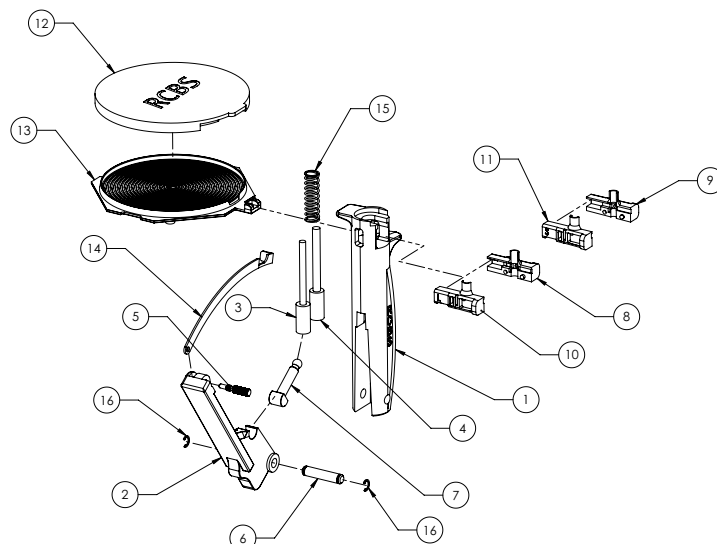
During priming, check cases occasionally to be sure the primers are seated to the bottom of the primer pocket. Optimum seating depth is .003 inches to .005 inches below the case head. The base of a correctly primed case will sit flat when placed on a level surface. If it rocks, the primer needs to be seated deeper. Primer residue can build up on 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

**WARNING!** 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 the primer tray and dispensers every 500 rounds to prevent the build-up of primer dust. Occasionally lubricate the Pivot Link on both ends with a drop of light oil. Remember, oil will contaminate primers and cause misfires. Avoid using too much lubricant on the tool. If you need additional help or replacement parts, call RCBS.



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	7790201	HPT Body	1
2	7790202	Handle	1
3	7790206	Primer Rod Link, Small	1
4	7790207	Primer Rod Link, Large	1
5	7790211	Safety Gate Screw	1
6	7790212	Handle Pin	1
7	7790220	Pivot Link	1
8	7190203	Primer Feed, Large Right Half	1
9	7190205	Primer Feed, Small Right Half	1
10	7190204	Primer Feed, Large Left Half	1
11	7190206	Primer Feed, Small Left Half	1
12	7190207	Primer Tray Lid	1
13	7190208	Primer Tray	1
14	7190216	Safety Gate	1
15	7190217	Compression Spring	1
16	7187549	External Ring 5103-25	2

### LIFETIME LIMITED WARRANTY

Your RCBS® Hand Priming Tool 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. If you believe that your product is covered by this warranty, you must return the product to RCBS at the address below, postage paid, with proof of purchase for evaluation. If covered, we will (at our sole option) repair, replace, or refund the purchase price of any part or product found to be defective. This remedy will be without charge except for reasonable shipping, handling and insurance charges.

TO ENSURE ACCURACY OF YOUR WARRANTY INFORMATION, SEND YOUR DATED PROOF OF PURCHASE TO THE ADDRESS BELOW. This limited warranty does not cover defects or damage resulting from carelessness, misuse, commercial use, abuse, neglect, improper installation or assembly, water submersion, unauthorized or improper repair, failure to follow operation instructions, modification or normal wear and tear.

ANY WARRANTIES IMPLIED BY LAW SHALL IN NO EVENT EXTEND BEYOND DURATION OF THIS EXPRESS WARRANTY. Some States do not allow limitations on how long an implied warranty lasts, so the above limitation may not apply to you. REPAIR OR REPLACEMENT AS PROVIDED HEREIN IS YOUR EXCLUSIVE REMEDY FOR ANY DEFECTIVE PRODUCT. IN NO EVENT SHALL WE BE LIABLE FOR ANY SPECIAL, INCIDENTAL, OR CONSEQUENTIAL DAMAGES OF ANY KIND ARISING OUT OF THE PURCHASE OR USE OF THIS PRODUCT, WHETHER BASED UPON CONTRACT, TORT, STATUTE OR OTHERWISE. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you. This warranty gives you specific legal rights, and you may also have other rights which vary from State to State.

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