

RCBS[®]

CARBIDE REPLACEMENT CUTTER FOR TRIM PRO 3-WAY CUTTER

LIMITED LIFETIME WARRANTY

Your Carbide replacement cutter for Trim Pro 3-Way Cutter is warranted to be free from defects in material or workmanship for as long as the original owner owns it. This warranty is extended only to the original consumer purchaser. This warranty excludes any electrical components or products. All RCBS products are intended for non-commercial use by hobbyists. Any other use of these products will void the warranty. Should you believe that your Carbide replacement cutter for Trim Pro 3-Way Cutter is defective in material or workmanship, you must return the Carbide replacement cutter for Trim Pro 3-Way Cutter to Ammunition Accessories Inc. through its Oroville operation (hereinafter "Oroville Operations") postage paid for evaluation. If defective, the product will be repaired or replaced at Oroville Operations' option, at no charge.

Send a dated proof of purchase to Oroville Operations for return shipping and handling, along with the Carbide replacement cutter for Trim Pro 3-Way Cutter to:

Ammunition Accessories Inc.,
Oroville Operations
605 Oro Dam Blvd East
Oroville, California 95965

Warranty services cannot be provided without meeting the above requirements.

THIS LIMITED LIFETIME WARRANTY DOES NOT COVER DEFECTS OR DAMAGE RESULTING FROM: CARELESSNESS, MISUSE, COMMERCIAL USE, ABUSE, IMPROPER INSTALLATION, MODIFICATION, OR NORMAL WEAR AND TEAR. THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE LIMITED TO THE DURATION OF THIS LIMITED LIFETIME WARRANTY. OROVILLE OPERATIONS IS NOT LIABLE FOR DAMAGES IN EXCESS OF THE PURCHASE PRICE OF THE PRODUCT AND UNDER NO CIRCUMSTANCES SHALL OROVILLE OPERATIONS BE LIABLE FOR CONSEQUENTIAL OR INCIDENTAL DAMAGES. HOWEVER, SOME STATES DO NOT ALLOW LIMITATIONS ON INCIDENTAL, OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

The above warranty provides the sole and exclusive warranty available to the customer in the event of a defect in material or workmanship in the Carbide replacement cutter for Trim Pro 3-Way Cutter. This warranty gives you specific legal rights, and you may also have other rights which vary from State to State.

SAFETY

Reloading is an enjoyable and rewarding hobby that can be conducted safely. But, as with any hobby, carelessness or negligence can make reloading hazardous. This product has been designed from the beginning with the user's safety in mind. When reloading, safety rules must be followed. By observing these rules, the chance of a hazardous occurrence causing personal injury or property damage is minimized.

GENERAL

- Use all equipment as the manufacturer recommends. Study the instructions carefully and become thoroughly familiar with the operation of the product. If you do not have written instructions, request a copy from the equipment manufacturer.
- Do not take short cuts. Attempting to bypass established procedures is an invitation to an accident.

- Observe "good housekeeping" in the reloading area. Keep tools and components neat, clean and orderly. Promptly and completely clean up primer and powder spills.
- Reload only when you can give your undivided attention. Do not reload when fatigued or ill, or under the influence of medications or alcohol.
- Develop a reloading routine to avoid mistakes which may prove hazardous. Do not rush - load at a leisurely pace.
- Always wear adequate eye protection to protect your eyes from flying particles. You assume unnecessary risk when reloading without wearing safety glasses.

LOADING DATA

- Use only laboratory tested reloading data. We highly recommend the current SPEER Reloading Manual.
- OBSERVE ALL WARNINGS ABOUT THE USE OF MAXIMUM LISTED LOADS

INTRODUCTION

The Carbide replacement cutter for Trim Pro 3-Way Cutter was designed to provide a lifetime of use and to produce clean and consistent cutting.

DISASSEMBLY

Disassemble your existing 3-Way Cutter to remove the Standard Cutter Head.

1. Loosen the Outside Deburring Cutter Setscrew (D) and rotate Thumb Screw (B) counter clockwise to remove the Outside Deburring Cutter (C) from the 3-Way Cutter Holder (A).
2. Loosen the 8-32 x 1/8 Setscrew (I) and remove the Standard Cutter Head (E).
3. Remove the 8-32 x 1/8 Setscrew (G), 6-32 x 3/8 Setscrew (H) and the Outside Chamfering Pilot (F) from the Standard Cutter Head (E).

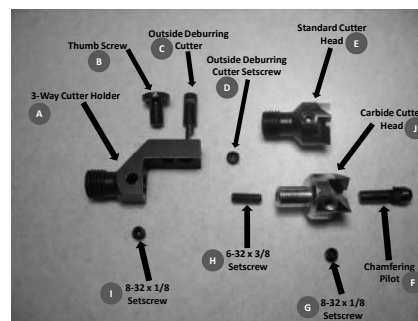


Photo 1

ASSEMBLY

Reassemble the 3-Way Cutter with the new Carbide Cutter Head.

1. Insert Chamfering Pilot (F), 6-32 x 1/8 Setscrew (H) and 8-32 x 1/8 Setscrew (G) into the Carbide Cutter Head (J). The 6-32 x 3/8 Setscrew (H) is used to adjust the amount of inside case mouth chamfer. The 8-32 x 1/8 Setscrew (G) is used to secure the Chamfering Pilot (F). Use a sized and de-primed case, ready to be trimmed, and place the case mouth over the Chamfering Pilot (F).
2. Make appropriate adjustments to the 6-32 x 3/8 Setscrew (H) to allow the case to rest on the cutting flutes of the Carbide Cutter Head (J). Once set, remove case and apply downward pressure to the nose of the Chamfering Pilot (F). Secure the Chamfering Pilot (F) in place with the 8-32 x 1/8 Setscrew (G). Ensure cutter orientation is similar to that in Figure 1. Final adjustments will be discussed later.
3. Insert the assembled Carbide Cutter Head (J) into the 3-Way Cutter Holder (A), ensure the back of the cutter bottoms out against the 3-Way Cutter Holder (A) and orientation of cutter is similar to what is shown in figure 1. Secure the assembled Carbide Cutter Head (J) in place with the 8-32 x 1/8 Setscrew (I) and make sure the 8-32 x 1/8 Setscrew (G) is accessible, for adjustment, as shown in Photo 2.
4. Insert the Outside Deburring Cutter (C) into the 3-Way Cutter Holder (A). Use case from step one, place over the Chamfering

Pilot (F) and bottom out case mouth on the cutting flutes of the Carbide Cutter Head (J).

5. Lower the Outside Deburring Cutter (C) until it just makes contact with the case, by rotating Thumb Screw (B) clockwise, and tighten the Outside Deburring Cutter Setscrew (D) to secure Cutter in place. NOTE: the Outside Deburring Cutter (C), should just make contact with the case. Do not drive cutter into the case as this can cause damage to the cutter. Remember when you deburr a case all you want to do is remove any burrs from the case mouth. Final adjustments will be discussed later.
6. Ensure Cutter Orientation is similar to that in Figure 1.

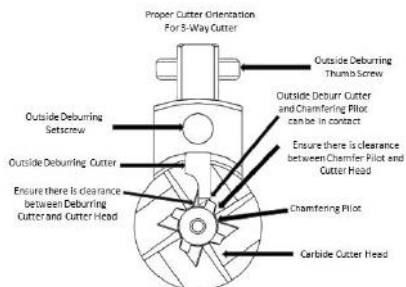


Figure 1

ADJUSTMENTS

Once assembly has been completed some adjustments will be required for the Chamfering Pilot and Outside Deburring Cutters.

1. Adjust the case trimmer for proper trim length. (Refer to your case trimmer instructions). Trim case.
2. Remove case from case trimmer and check overall case length, amount of chamfer on the inside of the case mouth and the amount of deburr on the outside of the case mouth.
3. To adjust the inside case mouth chamfer, remove the cutter from the trimmer, loosen the 8-32 x 1/8 Setscrew (G) while holding pressure on the end of the Chamfering Pilot (F) with your finger and adjust the 6-32 x 3/8 Setscrew (H), at the rear of the cutter, clockwise to increase the amount of chamfer and counter clockwise to decrease chamfer. NOTE: A 1/8th of a turn on the adjustment screw will change the chamfer depth by .004". Once set, retighten the 8-32 x 1/8 Setscrew (G).
4. To adjust amount of outside case mouth chamfer, the cutter can remain on the trimmer, loosen the Outside Deburring Cutter Setscrew (D) and rotate the Thumb Screw (B) clockwise to increase amount of chamfer and counter clockwise to reduce amount of deburr. NOTE: An 1/8th of a turn on the Thumbscrew will change the deburr depth by .002". Once cutter is set, retighten the Outside Deburring Cutter Setscrew (D).
5. Repeat steps 3 and 4 until you are satisfied with the amount of inside case mouth chamfer and outside case mouth deburr.
6. Ensuring the cutter orientation is the same as what is shown in figure 1, will reduce the amount of brass chips that can build up around the Outside Deburring Cutter and the Chamfering Pilot Cutter.
7. If the 3 Way Cutter binds on the case or does not chamfer correctly, condition A may exist, as shown in Figure 2. Loosen the 8-32 x 1/8 Setscrew (I) and position the Carbide Cutter Head (J) so the leading edge of the Cutter Head is lined up just past the tip of the Outside Deburring Cutter (C), as shown in condition B, and retighten the 8-32 x 1/8 Setscrew (I).

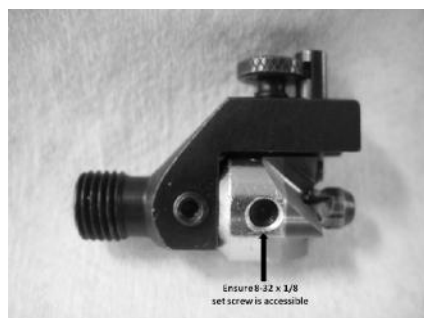


Photo 2

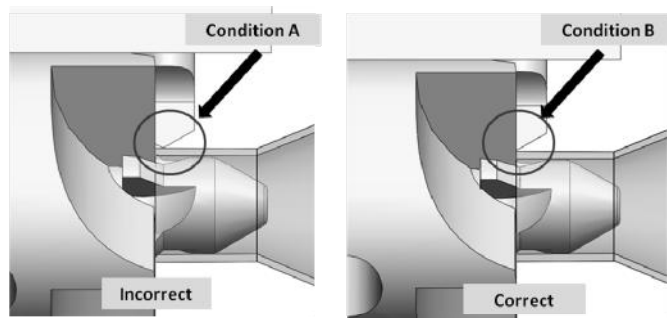


Figure 2

USE

You are now ready to trim your cases using the RCBS 3-Way Carbide Cutter. Refer to your case trimmer instructions for operation information. Thank you for your purchase and we are sure you will enjoy your 3-Way Carbide Replacement Cutter.

MAINTENANCE

Periodically clean Cutter components and apply a light coat of oil to help prevent oxidation of components. If the trim length of the cases begin to vary or the cutter stops trimming and deburring, remove the cutter assembly from the cutter shaft and clean the cutter by removing any brass shavings that may have built up on the cutter.

Photo 1 Bill of Material		
ITEM	DESCRIPTION	PART #
A	3-Way Cutter Holder	7786186
B	Thumb Screw	7786188
C	Outside Deburring Cutter	7786187
D	Outside Deburring Cutter Setscrew	7109409
E	Standard Cutter Head	7786185
F	Chamfering Pilot	-
G	8-32 x 1/8 Setscrew	7109409
H	6-32 x 3/8 Setscrew	7187156
I	8-32 x 1/8 Setscrew	7109409
J	Carbide Cutter Head	-

Customer Service

1-800-533-5000 (US or Canada) or 530-533-5191
 Hours: Monday - Thursday, 6:30am - 4:00pm Pacific Time
 (hours may vary)
 e-mail: rcbs.tech@atk.com or visit our website at www.rcbs.com
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