

RCBS®

AMMOMASTER SINGLE-TO-AUTO CONVERSION INSTRUCTIONS

GENERAL INFORMATION

AmmoMaster is an easy-to-use single-stage press. It is also the only press that can be both single-stage and progressive. By switching and adding a few parts, the single-stage AmmoMaster becomes a fully progressive AmmoMaster-Auto. This supplement is designed to take you through the necessary steps to assemble the press. After converting from single-to-auto, use the regular AmmoMaster-Auto Instruction Manual for important safety information and easy how-to-use instructions. Refer to page 24 of the AmmoMaster-Auto Instruction Manual for a drawing and description of all the parts used to convert from single-to-auto.

Before starting, make sure the press is securely bolted to a sturdy bench using the three mounting holes in the base of the press. The bolts must reach through the bench and be secured with washers and hex nuts. Failure to do so can result in equipment damage or serious personal injury.

ASSEMBLY INSTRUCTIONS

Using a 7/32 hex key wrench, remove the three flat head screws from the top plate. See Photo #1. Lift off the top plate and set it aside. You will not use this top plate again unless you switch back to single-stage reloading. Next, raise the ram by lowering the press handle. Use a 3/16 hex key wrench to remove the cap screws and shell holder adaptor. See Photo #2.

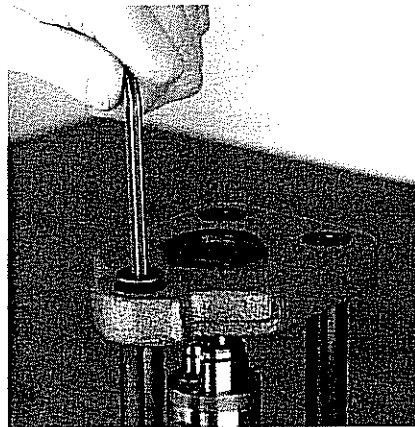


Photo #1



Photo #2

Although it is not necessary, the following steps may be easier to perform if the three support rods are removed. See Photo #3. Install the index locating pin as shown in photo #4.

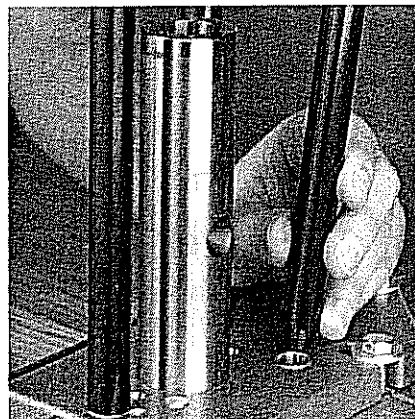


Photo #3

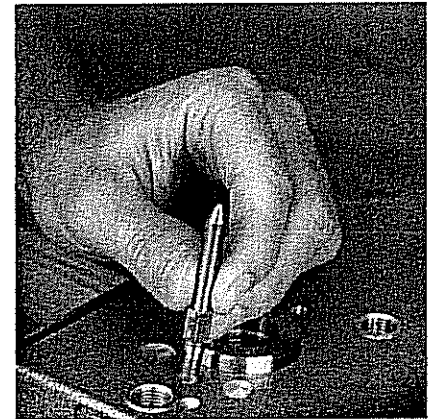


Photo #4

Install the primer seating depth screw and hex nut as shown in photo #5. The final adjustment will be made in another step. Again, raise the ram if it was lowered and install the ram shell holder adaptor. See Photo #6.



Photo #5



Photo #6

Place the shell plate holder on the adaptor. See Photo #7. Attach it to the adaptor with the two screws. See Photo #8.



Photo #7

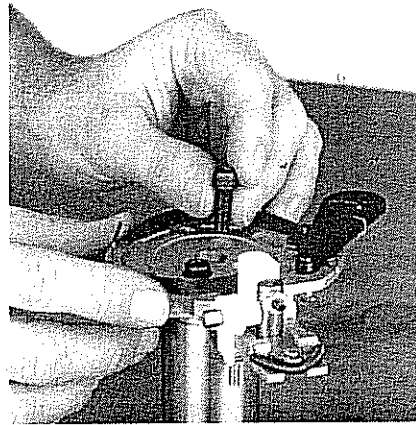


Photo #8

Install the plugs into the case retaining springs as shown in photo #9.



Photo #9

The small priming system was installed at the factory. If the caliber you will be loading requires large primers, remove the small priming parts and replace them with the large priming system following these steps:

Drop the large primer plug into the shell plate holder. See Photo #10. Raise the ram approximately half way through the stroke. Slide the spring over the bottom of the primer plug and compress the spring with your finger. Using a pair of long-nose pliers, install the hair pin clip in the groove of the plug. See Photo #11.

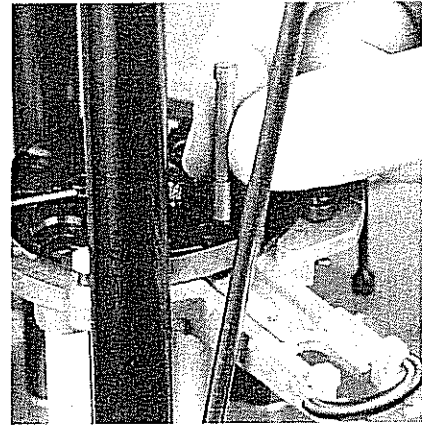


Photo #10

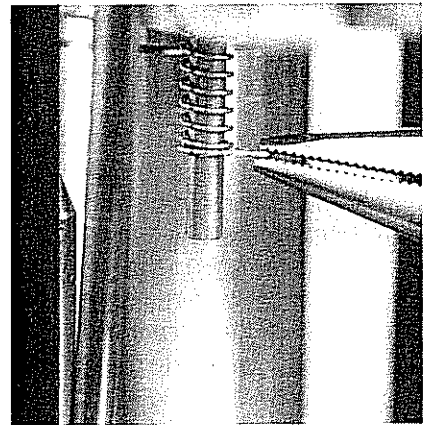


Photo #11

The AmmoMaster is supplied with two primer dispensers; one for small primers (stamped with an "S" on the front) and one for large primers (stamped with an "L" on the front). The small dispenser is installed at the factory. If the caliber you will be loading requires large primers, replace the small dispenser following these steps: Remove the small dispenser and snap the large primer dispenser onto the shell plate holder with the "L" facing out. Make sure it locks firmly in place. See Photo

#12. The primer dispenser must be firmly seated on the shell plate holder. If raised even slightly, primers will hang-up under the primer dispenser and fail to feed. Also, if the primer dispenser becomes loose, bend the legs inward to tighten the grip on the shell plate holder.



Photo #12

Select the proper primer transfer bar assembly. Again, the small transfer bar was installed at the factory. Slide the transfer bar into the primer slot in the shell plate holder. See Photo #13.

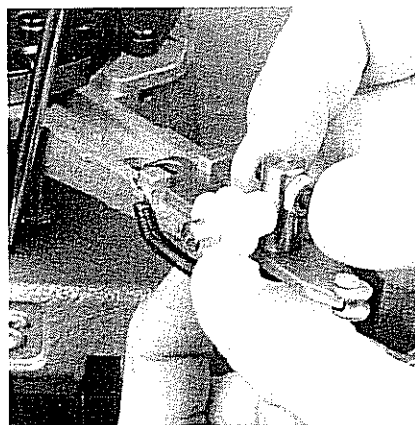


Photo #13

Slip the return spring over the two ears on either side of the primer slot on the shell plate holder and over the back of the primer transfer bar assembly. See Photo #14. Refer to the AmmoMaster-Auto instructions for important adjustments.

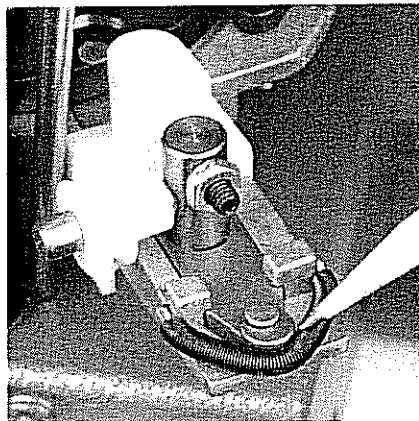


Photo #14

Insert the index ball spring into the hole in the shell plate holder. See Photo #15. Place the index ball on top of the spring. See Photo #16.

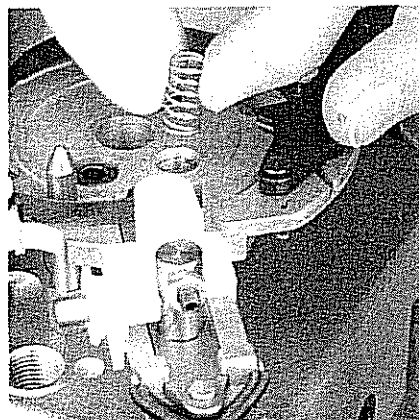


Photo #15

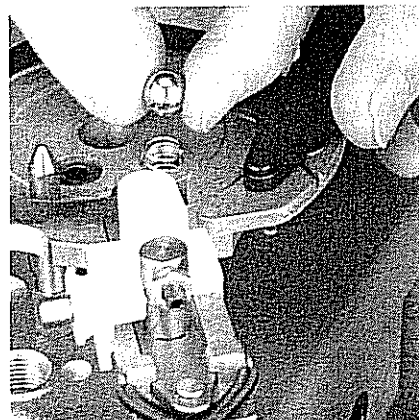


Photo #16

Make sure the ram is up and position the appropriate shell plate on the holder. See Photo #17. Install the ram shoulder bolt through the shell plate and tighten to the shell plate holder. See Photo #18.

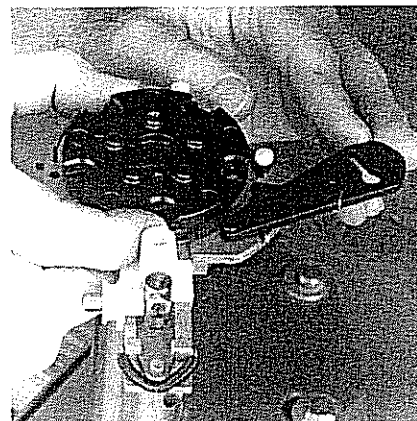


Photo #17

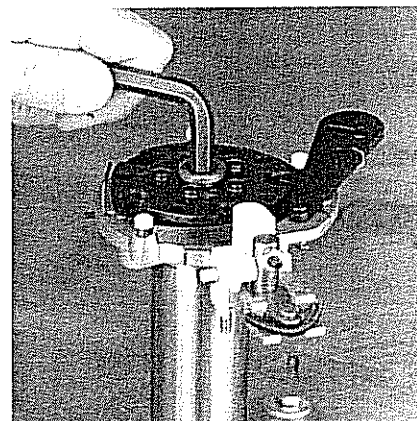


Photo #18

Clean the index rod with a dry cloth to remove any grit or debris. Match the notches in the connecting plate with the raised threaded hole on the shell plate. See Photo #19.

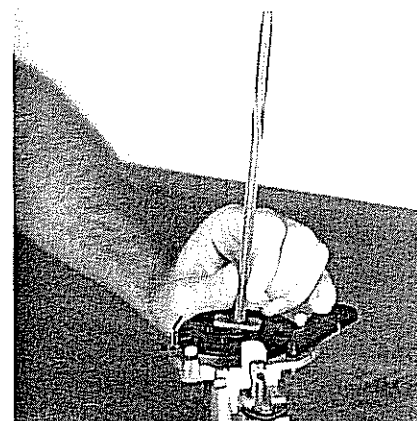


Photo #19

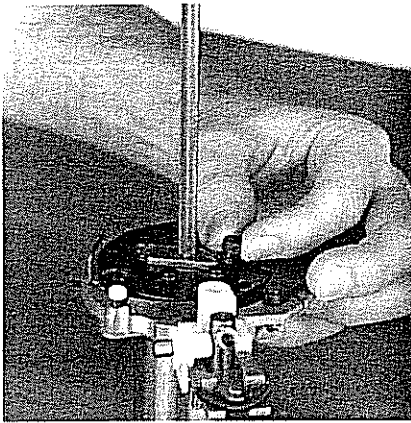


Photo #20

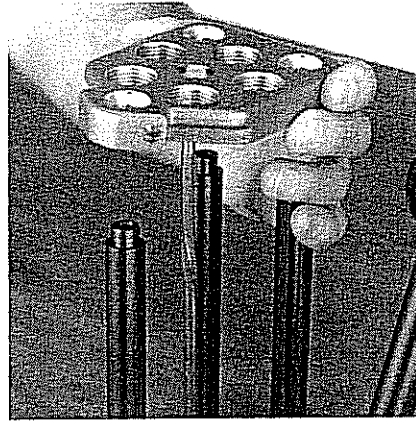


Photo #21



Photo #22

Insert the knurled connecting plate screws into the threaded holes in the shell plate and tighten. See Photo #20.

Now, reinstall the three support rods that were removed earlier. Attach the 5-station top plate to the index rod and three support rods. See Photo #21. Make sure to place the bottom of the cam wire in the counterbored hole in the base of the press. The counterbored hole is for cam wire location only and is not meant to "hold" or retain the cam wire. Reinstall the flat head screws. See Photo #22.

With the conversion from single-to-auto partially complete, you can now turn to page 14 of the AmmoMaster-Auto Instruction Manual for the final assembly operations. Remember, give us a call if you have any questions during the assembly or operation of the AmmoMaster.



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