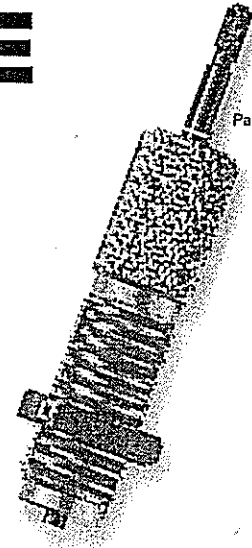




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# LOCK-OUT™ DIE



Patent # 4852451

I N S T R U C T I O N S

## **SAFETY**

Reloading is an enjoyable and rewarding hobby that is easily conducted with safety. But carelessness or negligence can make reloading hazardous. This product has been designed from the beginning with the user's safety in mind.

## **GENERAL**

- Use the reloading equipment as the manufacturer recommends. Study the instructions carefully and become thoroughly familiar with the operation of the product. Don't take short cuts.
- 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. Develop a reloading routine to avoid mistakes. Avoid haste - load at a leisurely pace.
- Always wear adequate eye protection. You assume unnecessary risk when reloading without wearing safety glasses.

## **LOADING DATA**

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

## **PRIMERS AND POWDER**

- **WARNING:** Primers are designed to explode and will do so when subjected to heat or percussion.
- Do not decap live primers.
- Never attempt to seat or reseat a primer in a loaded round.
- Store primers and powder beyond the reach of children and away from heat, dampness, open flames and electrical equipment.

- DO NOT use primers of unknown identity.
- Keep primers in original factory container until ready to use. Return unused primers to the same factory packaging for safety and to preserve their identity.
- DO NOT store primers in bulk. The blast of just a few hundred primers is sufficient to cause serious injury to anyone nearby.
- DO NOT force primers. Use care in handling primers.
- DO NOT use any powder unless its identity is positively known.
- If you use a powder measure, replace the lids on both the powder hopper and powder can after the powder hopper has been filled.
- Before charging cases, settle the powder hopper. Throw and check the weight of at least ten charges. This will assure you that the correct powder charge is being thrown.
- After a reloading session ends, pour the remaining powder back in its original factory container. This will preserve the identity and shelf life of the powder.
- DO NOT smoke while handling powder or primers.

## **RECORD KEEPING**

- Keep complete records of reloads. Apply a descriptive label to each box showing the date produced, and the primer, powder and bullet used. Labels for this purpose are packed with SPEER bullets.

Since RCBS has no control over the choice of components, the manner in which they are assembled, the use of this product, or the guns in which the resulting ammunition may be used, no responsibility, either expressed or implied, is assumed for the use of ammunition reloaded with this product.

## GENERAL INFORMATION

The Lock-Out™ die detects a "no powder" or a "double charge" condition in the reloading process and locks up or halts the upward travel of the press ram. This will alert the reloader to the problem so the cause can be corrected. The Lock-Out™ die is not an alternative to the need to periodically check powder charges on an accurate reloading scale but is designed to alert the reloader to an unsafe condition so it can be corrected. The RCBS Lock-Out™ die is for use with pistol calibers (9mm and larger) on progressive reloading presses.

## PREPARING THE LOCK-OUT™ DIE

Except for installing the adaptor, the Lock-Out™ die is shipped completely assembled. Because of "spring-loaded" internal parts, we do not recommend taking the die apart. Manufacturing oils have been removed from any part that may come in contact with powder.

Select one of the white nylon adaptors (key # 7 or 8 in the illustration). The large, flared adaptor (# 8) is for use when reloading .44 and .45 caliber cartridges. The smaller, straight-sided adaptor (# 7) is for 9mm to .44 calibers. Install the adaptor (large or small) by pressing it onto the plunger.

## TO USE

After the powder measure has been adjusted to dispense the correct powder charge, install the Lock-Out™ die in the die station that immediately follows the powder charging station. Thread the die into the press so the bottom of the die body is about 1/4" from the shell plate. Place a case with the correct powder charge in the shell plate so the case is located directly under the Lock-Out™ die. Then, lower the handle. The case will stop abruptly when the case mouth contacts the bottom of the case lock at the bottom of the die.

The amount of powder in the case will dictate where the plunger is set. Screw the plunger up or down until the "set line" appears when the case mouth contacts the case lock. The set line is the thin white line on the detection rod (#3) that sticks out of the top of the die. Half of the white line exposed at the top of the die is the center of the range. Hold the plunger (#5) and adaptor while adjusting the detection rod. There is approximately 1 1/2 turns each way in the adjustment. There are a total of three turns in the range. This three turn range depends on the case capacity and the powder type.

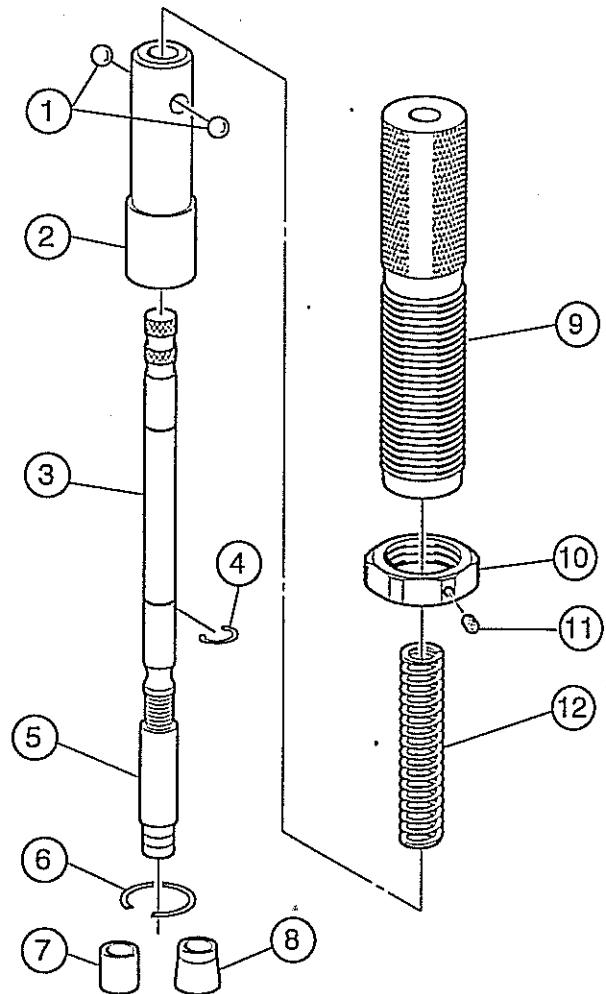
When the set line on the detection rod is slightly above the top of the die, the case will enter the die and allow normal ram travel for the reloading process. Fine tune the adjustment to allow free travel with the correct powder charge in the case.

### IMPORTANT

This product is covered by the RCBS Lifetime Warranty. Replacement parts are available from the factory. Contact RCBS Customer Service as shown on the back of this instruction booklet.

Your Lock-Out™ die is now correctly adjusted to prevent double charges or empty cases from going undetected. CAUTION: If excessive resistance is encountered, check to see the detection rod (# 3) still moves freely.

An alternative method of setting the adjustment is to charge a case with the correct powder charge. Set the case on a flat surface. Lower the die by hand onto the charged case noting where the "set line" is and adjust the rod by hand. When the final adjustment is correct, install the die so it is 1/4" or more over the shell plate.



Key	Part #	Description
1	1-87548	Steel Ball Bearings (2)
2	1-87543	Die Case Lock
3	1-87542	Die Detection Rod
4	1-87549	External Clip
5	1-87544	Plunger
6	1-87546	Spring Clip
7	1-87551	Die Adaptor #1, Small
8	1-87550	Die Adaptor #2, Large
9	1-87541	Die Body
10	87501	Die Lock Ring
11	87502	Brass Set Screw
12	1-87547	Compression Spring
*	1-87545	"O" Ring 02-002 Parker

\* Not Shown