



Pro Chucker[®]

5 to 7 Conversion Kit



PRODUCT INSTRUCTIONS

UNPACKING

Refer to the list below to Identify parts as you unpack your new Pro Chucker 5 to 7 Conversion Kit.

- 1. Shell Plate Holder 7 Assembly
- 2. Pro Chucker 7 Powder Measure with CAPM* Linkage and Die

**CAPM: Case Activated Powder Measure*

- 3. Pro Chucker 7 Die Plate
- 4. Quick Change Powder Measure Cylinder
- 5. Parts Bags (7)



SHELL PLATE HOLDER 7 ASSEMBLY



PC7 POWDER MEASURE W/ CAPM LINKAGE AND DIE



PC7 DIE PLATE



QCPM CYLINDER

Loose parts bags include:

- QCPM Drain Tube Attachment
- QCPM Lock Pin Assembly
- QCPM Large Metering Screw Assembly
- QCPM Small Metering Screw Assembly



QCPM SM METERING SCREW ASSEM

QCPM LOCK PIN ASSEM

QCPM LG METERING SCREW ASSEM

QCPM DRAIN TUBE

Index Mount Assembly:

- Pro Chucker 7 Index Assembly
- 5-40 x 3/8" FHCS (2)



INDEX MOUNT ASSEMBLY 7

5-40 X 3/8" FHCS

Pro Chucker parts bag 7 Station:

- Primer Transfer Bar 7 Small (2)
- Primer Transfer Bar 7 Large (2)
- Primer Transfer Bar Actuator 7
- 8-32 x 3/8" Flat Head Cap Screw (4)



Pro2000 Parts Bag:

- CAPM* Spacer Bushing (2)
- CAPM* Powder Bushing Large Rifle
- CAPM* Powder Bushing Small Rifle
- CAPM* Powder Bushing Pistol
- Cylinder Link
- 10-32 x 3/8 BHCS (2)



PC 5 TO 7 CONVERSION ASSEMBLY

1. Remove the Pro Chucker 5 Die Plate, Primer Safety Shield and Primer Tube if not already removed from press.
2. Lower Press Handle and raise Ram to approximately mid stroke. Use the Lock Pin that came with your Pro Chucker 5 Press in a vertical orientation, to prop up the Shell Plate Holder Assembly. Insert a 3/16" hex key wrench into the

shoulder bolt and use a 5/8" wrench to remove the nyloc nut being used to secure shell plate, as shown in photo 1. Remove the Shell Plate, Index Ball Spring and Detent Ball



Photo 1

3. Remove the Discharge Chute using a 1/8" hex key wrench, as shown in photo 2. Using a 5/64" hex key wrench also remove the Spent Primer Tube from the Shell Plate Holder.

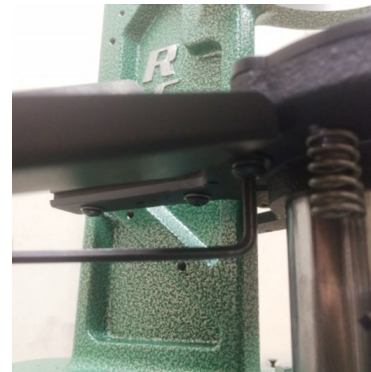


Photo 2

4. Lower Press Handle and Raise Ram to remove Lock Pin from beneath Shell Plate Holder, then raise Press Handle to lower Ram to bottom of stroke.
5. Remove the button head cap screws used to retain the Primer Transfer Bar Guide and Primer Dispenser using a 3/32" hex key wrench, as shown in photo 3. Retain these items as they will be needed later.

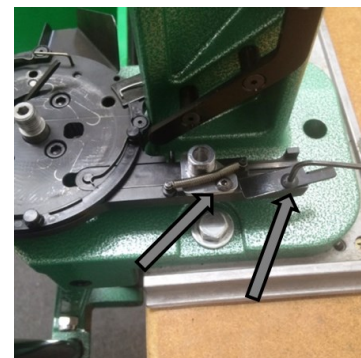


Photo 3

6. Remove the Primer Bar Actuator 5 by removing the four 8-32 flat head cap screws using a 3/32" hex key wrench, as shown in photo 4.

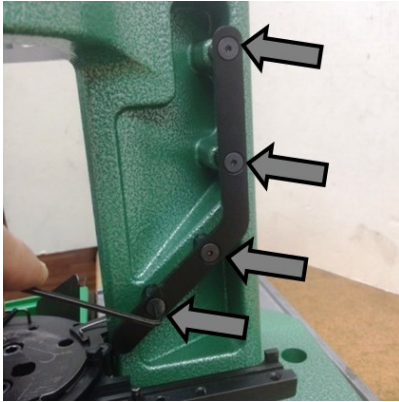


Photo 4

7. Using a 3/16" hex key wrench remove the two 1/4-28 cap screws securing the Shell Plate Holder to the Ram, as shown in photo 5.

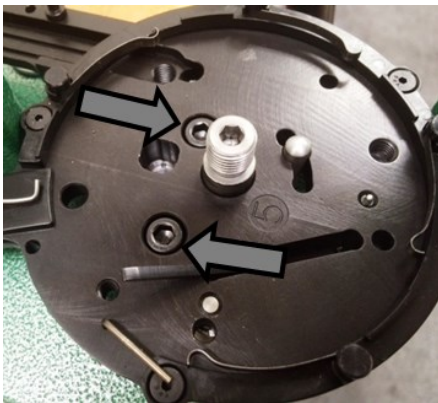


Photo 5

8. Lower Press Handle to raise Ram until the Shell Plate Holder is clear of the Indexer, as shown in photo 6. While keeping the Ram in this position, carefully remove the Shell Plate Holder Assembly from the Ram.

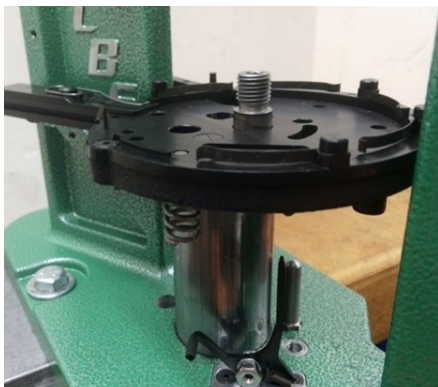


Photo 6

9. Using a 5/16" wrench remove the Locating Pin, as shown in photo 7.



Photo 7

10. Using a 5/64" ball end hex wrench remove the two 5-40x3/8" FHCS and remove the Index Mount Assembly 5 from the Press Frame, photo 8.



Photo 8

11. Place Index Mount Assembly 7 into the pocket on the press frame and carefully secure in place using the two 5-40x3/8" FHCS, photo 9

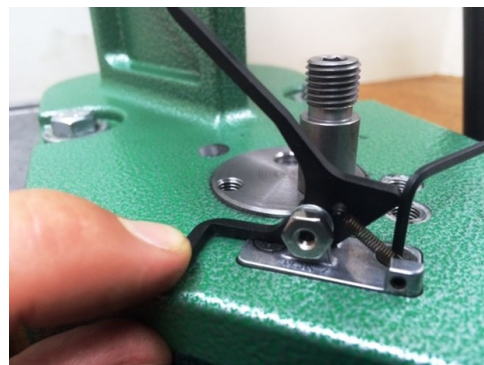


Photo 9

12. Using a 5/16" wrench, install the locating pin in the position shown in photo 10. NOTE: Ensure Locating Pin is installed in correct location.



Photo 10

13. Lower the Press Handle to raise the Ram and place Shell Plate Holder Assembly 7 onto Ram, ensure Ram is high enough so Indexer does not interfere with Shell Plate Holder, photo 11.

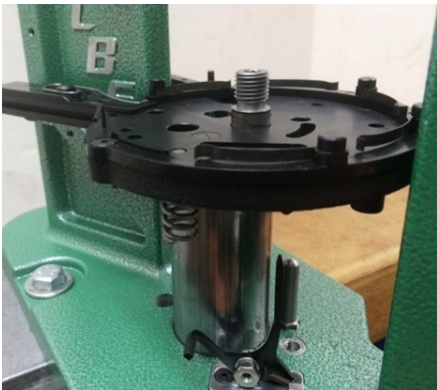


Photo 11

14. Raise Press Handle to lower Ram to bottom of stroke. Insert the two 1/4-28 cap screws. Using a 3/16" Hex Wrench lightly secure the Shell Plate Holder Assembly to the Ram, DO NOT TIGHTEN AT THIS POINT. Push forward on Press Handle compressing the Index Spring ensuring ram as at bottom of stroke and Locating Pin is engaging the Shell Plate Holder Assembly, this will correctly position Shell Plate holder Assembly. Using a 3/16" Hex Wrench tighten the 1/4-28 cap screws, securing the Shell Plate Holder Assembly to the Ram, photo 12.

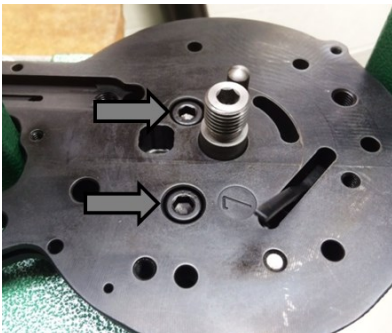


Photo 12

15. Install Primer Transfer Bar Actuator to Press Frame using the four 8-32x3/8" FHCS. Apply force in direction shown while securing Actuator to Press Frame, photo 13.



Photo 13

14. The Pro Chucker 5 Press has now been converted to a Pro Chucker 7. Refer to your original Pro Chucker Progressive Reloading Press Instructions for the remaining Press set up and operation.

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CONTACT US:

RCBS

605 Oro Dam Blvd East, Oroville, California, 95965

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

E-mail: rcbs.tech@vistaoutdoor.com

Website: rcbs.com



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RCBS, 605 Oro Dam Blvd. East, Oroville, CA 95965

01003290/0615