

S&W SUPPLY, LLC

5308 TIMBERLINE TRAIL • RAPID CITY SD 57702 • ☎(605) 341-4412
WEBSITE: www.swsupply.com • ✉ whiz@swsupply.com

REPLACING INDEX PAD

© James L White, 2017

THIS IS NOT A SIMPLE “REMOVE AND REPLACE” PROCEDURE – READ & FOLLOW INSTRUCTIONS CAREFULLY

NOTE: Before replacing the Index Pad, you MUST disconnect and hydraulic system or Auto-Drive and put back in the Operating Handle to work machine manually. Remove the Primer Feed Assembly and Shell Seating Post and then replace Index Pad as instructed below.

1. On 800B/C/CVT and Plus machines, the operating handle must be in and stay in the down position.
2. Remove socket-head shoulder bolt (#118) that is screwed into the shaft of the broken Index Pad.
3. Grease the new Index Pad lightly with aLube™ or equivalent SOFT grease. Do not use stringy or heavy grease.
4. It would probably be a good idea to remove the coil spring located in the Index Pad housing (#115), and clean this entire area and lightly grease the coil spring. Return the coil into the Index Pad housing.
5. Line up the screw hole in the slot of the Index Pad housing and replace the socket-head shoulder bolt.
6. Check the angled groove in the Index Pad Housing for burrs, and wear and replace should it be in rough shape.
7. Your new Index Pad may look different from your original and you might need to adjust the complete unit once reassembled.

TO READJUST:

- A. First, replace the Index Pad as instructed above.
 - B. Maintain the Operating Handle in the down position.
 - C. Loosen the set-screw (#31) in the reloader base holding the Index Pad housing in place.
 - D. Rotate the housing until the Index Pad, the long square side, is facing the back of the machine.
 - E. As you lift the Operating Handle up, you will watch the Index Pin (#98) come down onto the Index Pad.
 - F. You will now rotate the Index Pad clock-wise until the Index Pin just sits ON the pad.
 - G. As you continue to pull the Operating Handle UP, you will notice the Index Pin slide off the top of the ID and fall beside the edge of the Index Pad.
 - H. Holding the Operating Handle all the way back, make sure there is about 3/32” (credit card thickness) between the edge of the Index Pad and the Index Pin. THEY MUST NOT TOUCH, BUT THIS CLEARANCE SPACE IS REQUIRED.
8. **NOTE:** You must check the Upper Actuating Arm position and may need to adjust the adjusting screw and nut located on the very bottom of the Index Pad housing.
 9. Try to move the Upper Actuating Arm. There should be very little front-to-back movement (you may have some side-to-side movement and this is OK).
 10. If there is too much movement (more than 1/8”), you will need to lower the ID housing. Each time you move the adjusting screw, YOU MUST check the Upper Actuating Arm. NEVER PERMIT THE Upper Actuating Arm to sit solidly against the rear opening in the tool head – future breakage may occur.
 11. Once you have achieved the correct position of the Upper Actuating Arm and Index Pad housing height, tighten the rear set-screw in the base holding the Index Pad in place (#31).
 12. Before replacing the Primer Seating Assembly and Shell Seating shaft, operate the machine to make sure the cylinder is indexing around properly.
 - A. If the cylinder does not rotate ALL THE WAY, the Index Pin (#95) will need to be adjusted DOWN. To do this, loosen set-screw in the crosshead behind the Index Pin (not the larger top set-screw on top of the Index Pin housing). Tap the entire Index Pad housing down about 1/16” and then retighten the set-screw (#31).
Pull handle again to make sure the cylinder is indexing clock-wise.
 - B. If the machine is rotating backwards when operating it, the pad was not installed correctly. Remove the Index Pad assembly out of the machine and repeat the installation instructions again (Steps 1-7) again.
 13. You can now install the Shell Seating Post. If you changed the Index Pad height adjusting screw (#116 & #117), you will need to either lower/raise the Shell Seating Post appropriately. Check proper height by inserting one

S&W SUPPLY, LLC

5308 TIMBERLINE TRAIL • RAPID CITY SD 57702 • ☎(605) 341-4412
WEBSITE: www.swsupply.com • ✉whiz@swsupply.com

newly inserted empty hull. Each newly inserted hull's base should be flush with the base of the die. You may want to go to my website (www.swsupply.com) and download the instructions for installing a new primer seating assembly and/or shell seating assembly.

- Next, you will check the primer depth at Station 2. Its adjustment will also be required if you the Index Pad height adjusting screw (#116 & #117). On the 800 Plus, simply raise/lower the Primer Seating Assembly up/down to permit correct primer seating depth. On 800B/C/CVT machine, you will be required to change the adjusting screw and nut appropriately.

