



REPLACING LOWER ACTUATING ARM(S)

INSTALLATION INSTRUCTIONS

Part Number: SIZE290200

1. Empty all components from the reloader, drain shot and powder reservoirs, remove shot and powder hopper and reservoir plate assembly, remove Rack Gear. (Refer to your manual).
2. Remove ¼-28 x 1 button head cap screw (BHCS) "A" on the under side of the Crosshead. Loosen 3/8-16 x 1 BHCS "B" in the Toolhead 2/3 of the way out and tap down on the BHCS with a soft hammer (i.e.: plastic/brass) hammer or mallet to knock the Actuating Assembly down with the Final Shell Knockout out of the Toolhead and off the Guide Pins. Now, remove screw "B" and the assembly will drop out – catch it.
3. Remove 10-32 x 3/8 screw "C" and remove the Upper Actuating Arm and replace it with the new arm. Inspect all the components in this assembly, checking for undue wear on the hex-shaft, and tightness of the screw opposite to screw "C" (on the right side).

IMPORTANT: When replacing the Actuating Arm onto the hex-shaft, be sure it tilts backwards 60° (one notch) when the Lower Actuating Arms "D" are pointed straight down. See drawing.

4. Replace and tighten screw "C", (I suggest using Blue Loctite) reinstall assembly into Toolhead. Be sure to align holes in top of assembly with the guide pins in Toolhead.
5. Install screw "B" and tighten (pulling the assembly up and into place in the Toolhead).
6. Replace the Rack Gear with the timing marks lined up with the marks on the shot and powder gears. HINT: The standard position of the shot and powder gears when installed in the aluminum housing are such that their timing marks are setting at 12:00 as you look at the housing. Check by carefully sliding Rack Gear back and forth.

WARNING: Do NOT cycle the reloader with the Rack Gear in place AND the absence of the top shot and powder reservoir plate in place. The Rack Gear will have a tendency to jump out of its operational slot and could damage the aluminum housing. If you need to operate the Rack Gear with the reservoir OFF the machine safely hold down the FRONT of the Rack Gear when cycling the machine.

7. Replace shot and powder reservoir plate. Put a small amount of aLube or grease on the Rack Gear pin in the Upper Actuating Arm's slot.

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Give me a call or an e-mail if you have any questions

WHILE YOU ARE REPLACING THE LINK ...

This link breaks, as it is designed to do, rather than many other parts. It will break under several conditions, these being:

1. The horizontal Hex Shaft P/W (800 Plus Schematic # 52) is worn badly allowing the upper link and the two lower actuating arms "D" to become loose.
☛ **SOLUTION:** *Replace hex shaft and lube with aLube™ or a light grease.*
2. The 10-32x3/8" button head cap screws have worked loose permitting the links to loosen.
☛ **SOLUTION:** *Coat the BHCS with BLUE Loctite and reinstall along with their star lock washers.*
3. The Rack Gear in the upper reservoir aluminum housing is either binding due to powder residue or canting in its operating slot.
☛ **SOLUTION:** *Thoroughly clean the Rack Gear and its slot, coat base of aluminum slot with powdered Graphite (any automotive store has these for key lock).*
4. Residue in, around, and under the black shot and powder gears and shut-off plates. This is THE MOST overlooked area and should always be clean thoroughly on an annual basis by the following procedure.
 - A. Remove the two black gears and clean with hot soapy water, brush the teeth and thoroughly dry,
 - B. Carefully remove both shot and powder shot-off plates IN THIS MANNER: 1). Remove the shut-off handles
 - C. Insert each one VERTICALLY into the center threaded hole (pick out any shot that may be lodged in this hole.
 - D. Gently WIGGLE UP on the plate using the handle as leverage – CAREFUL because you are about to launch or lose a ball-bearing. The ball-bearing sits and 3:00 on the right side of the hole and is the detent ball for the shut-off plate.
 - E. Remove the ball-bearing and its small coils spring (inspect the coil for condition. OEM coils are prone to losing their tension. I sell a cheaper replacement of top quality.
 - F. THOROUGHLY clean the entire area using whatever you can to get it immaculately clean.
 - G. Reinstall coil spring and ball-bearing. The bearing tends to NOT want to stay in place.
 1. I use an X-Acto knife with a sharp blade to hold it in place as I slide DOWN the shut-off plate.
 2. You can also use a small diameter tube like a brass ball-point pen refill UNDER the shut-off plate to hold the ball-bearing in place just enough to slide down the off plate in position where you can remove the brass tube and the ball remains in position.
 3. Or, you can remove the large 3/16 set-screws on the OUTSIDE of the housing used to set the tension of the ball-bearings and simply insert the shut-off plate, then drop the ball-bearing into the hole followed by the coils, and reinserting the set screw. (The set-screw is not accessible for the shot plate because the final crimp assembly shaft is in the way. You can drop this shaft (don't unscrew it) by loosening the 1/8" set-screw in the rear of the top toolhead, and pounding down the top of the threaded shaft – DON'T FORCE IT. IF IT IS STUCK, you've not loosened the 1/8" set-screw enough.

ALTERNATE CLEANING PROCEDURE

If you find the cylindrical opening in the reservoir shows signs of wear in the base on the toolhead itself, you may want to remove the aluminum reservoir, clean all the areas completely, and the surface the top to the toolhead on which the reservoir sets. You would need access of a large, flat surface belt sander to accomplish this task. I do this during full rebuilds. You can also lightly surface BOTH sides of the reservoir to insure all surfaces are flat and not skew.

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To accomplish this, there are three bolts on the under side of the toolhead. Older machines used ¼-20x1½” slotted-head bolts. Newer machines use ¼-20x1½” hex head bolts. Whichever the case, upon reassembly, I suggest a small dab of BLUE Loctite.

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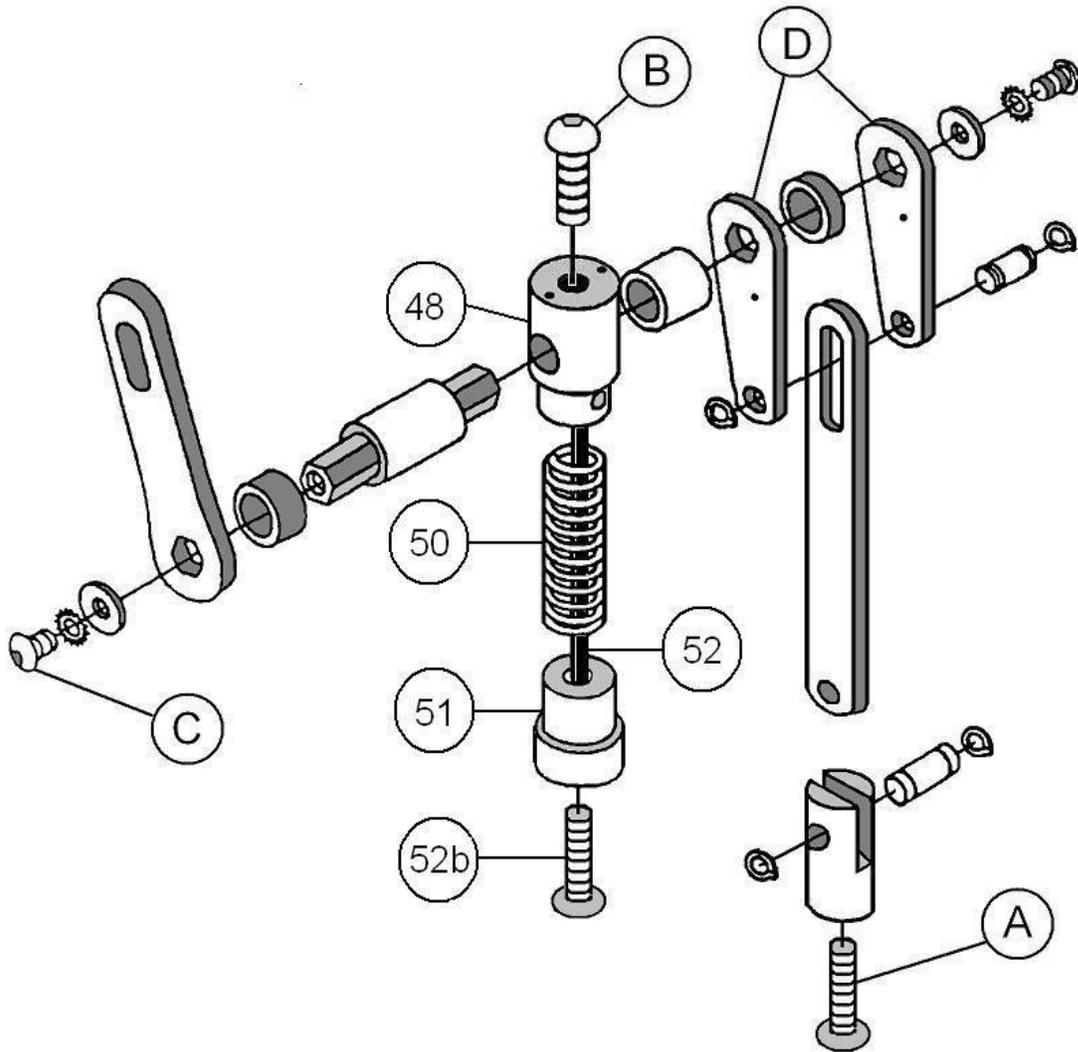
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