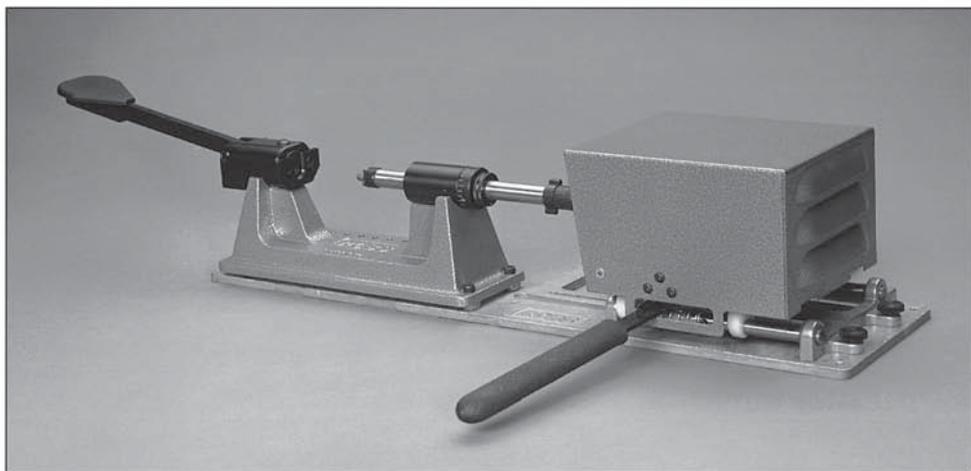
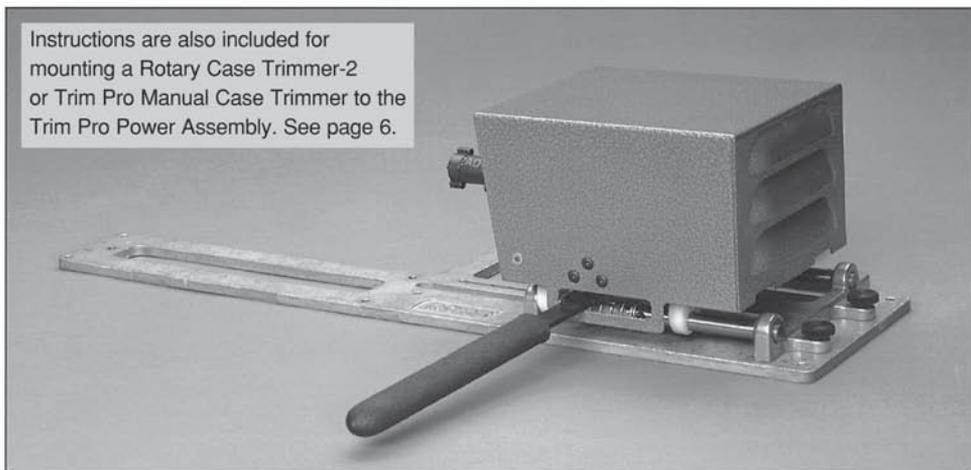


RCBS[®]

TRIM PRO[®] POWER CASE TRIMMER



Instructions are also included for mounting a Rotary Case Trimmer-2 or Trim Pro Manual Case Trimmer to the Trim Pro Power Assembly. See page 6.



PRODUCT INSTRUCTIONS

IMPORTANT

Before using the RCBS Trim Pro Case Trimmer, read this instruction manual carefully to learn how to safely operate the product.

Leave the power trimmer unplugged until you are ready to trim cases and have read these instructions. Failure to properly operate the trimmer may result in personal injury and/or equipment damage. If you have read these instructions and still do not understand some operation, call us at 800-533-5000 or 916-533-5191 and a technician will assist you. Our customer service hours are listed on the back of this instruction manual.

This instruction manual contains specific safety and operating information. It should be considered a permanent part of your reloading equipment and remain with the equipment at all times for easy reference.

SAFETY

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

When reloading, safety rules must be followed. By observing these rules, the chance of a hazardous occurrence causing personal injury or property damage is minimized.

GENERAL

- Use all equipment as the manufacturer recommends. Study the instructions carefully and become thoroughly familiar with the operation of the product. If you do not have written instructions, request a copy from the equipment manufacturer.
- Don't take short cuts. Attempting to bypass established procedures is an invitation to an accident.
- 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. Don't rush - load at a leisurely pace.

- Always wear adequate eye protection to protect your eyes from flying particles. You assume unnecessary risk when reloading without wearing safety glasses.

ELECTRICAL

- This product is equipped with a 3-wire, "U" ground cord; plug only into a proper outlet.
- Do not work on wet floors.
- Do not plug into electrical outlet until the proper voltage is supplied.
- Locate all electric cords away from moisture, rain and moving parts.
- Periodically check all cords for worn/frayed spots and replace or repair to code if needed.

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.

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. Never attempt to guess at the identity of your ammunition.
- This product is intended for use by persons familiar with proper handloading practices and their own loading equipment. If you are uncertain as to the operation of any of your equipment, contact the equipment manufacturer for additional assistance.

Because 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 ABOUT CASE TRIMMING

Repeated firing, resizing and reloading results in the brass of a case "flowing" toward the case mouth and the case therefore growing in length. A case which becomes too long may enter the throat of the firearm. If this happens, the case cannot release the bullet correctly on firing and pressures increase as a result.

Whenever a case grows longer than the maximum specified case length, it must be trimmed back to a length near the minimum for the caliber. It is important for safety and chambering that cases not exceed the maximum specified length. There are case length specifications for every cartridge and a current copy of the SPEER Reloading Manual is an excellent source for this information.

Certain characteristics that reloaders look for in a case trimmer are:

- Consistent repeatable trim lengths . . . the trimmer should trim cases to the same length.
- The trimmer should cut the case mouth “squarely” which means the cut is perpendicular to the longitudinal axis of the case. We have retained the case pilot system to align cases for “square” cuts.
- The trimmer should be easy to set-up and adjust.
- It should be quick and easy to change from one caliber to another.
- The trimmer should be easy to use and not cause pain or discomfort.

TRIM PRO POWER CASE TRIMMER INSTRUCTIONS

IMPORTANT: Leave the power case trimmer unplugged until you are ready to trim cases and have read these instructions.

CAUTION: When the unit is plugged in and the motor handle is moved from the motor stop position, the motor will switch on and the cutter shaft will turn. Make sure you are ready to trim a case before moving the motor handle. Unplug the trimmer when you are through trimming cases and when you are making trim length adjustments.

Carefully unpack the power case trimmer and look for the following items:

- Trim Pro Power Case Trimmer
- Case Holder Accessory Handle
- Handle Pin
- Motor handle
- Four Trim Pro shell holders and nine case trimmer pilots
- Parts bag

Securely fasten the power case trimmer to a sturdy bench using the six wood screws provided in the parts bag. See photo #1.

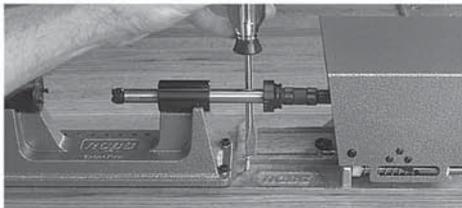


Photo #1

After mounting the case trimmer to a solid surface, attach the case holder handle by slipping the end into the slot of the handle support and inserting the knurled pin. See photo #2.



Photo #2

Next, select the proper shell holder. Refer to the Reference Table beginning on page 11. Trim Pro shell holders use the same numbering system as the shell holders used with RCBS loading dies. So, if you are reloading 30-06 cases (which takes a #3 shell holder) you would use a #3 Trim Pro shell holder in the trimmer. **Hold the shell holder with the “RCBS” letters and number stamp facing the cutter and the slot facing up.** Press down on the case holder handle and slide the “keyholes” in the shell holder over the two matching posts on the case holder, making sure the shell holder slips down firmly into position. See photo #3. Check to be certain the shell holder is properly aligned on the posts before you start to trim cases.



Photo #3

To insert a case, press down on the case holder handle and place the rim of the case between the shell holder and the face of the case holder. See photo #4. Release the pressure on the handle and the case will be securely held in position for trimming.



Photo #4

Now, attach the appropriate case trimmer pilot. See photo #5. Pilots are interchangeable and available in a variety of sizes to fit most everything from a .17 caliber to a .45 caliber case. Each size of pilot is machined to the caliber of the resized case mouth. This snug fit helps eliminate case wobble and insures alignment of the case while it is being trimmed. If the case mouth fails to line up with the pilot, press down on the case holder handle and slide the pilot into the case mouth. Secure the pilot to the case trimmer cutter with the setscrew located on the side of the cutter.

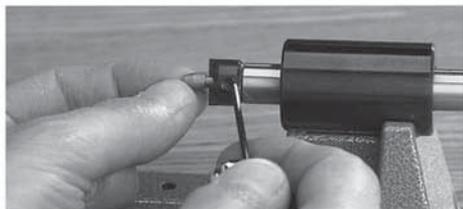


Photo #5

Install the motor handle by inserting the handle through the slot in the motor housing. See photo #6. Attach the handle to the back of the motor base plate with the shoulder bolt from the parts bag. See photo #7. Make sure the motor handle is placed in front of and to the

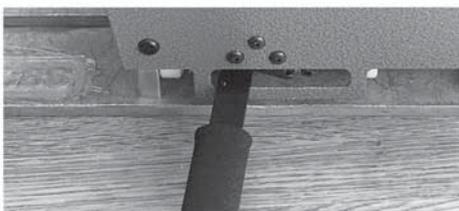


Photo #6



Photo #7

left of the pin on the bottom of the motor. See photo #8. **If you find it necessary to remove the handle or make any adjustments to the trimmer, be sure the unit is unplugged. Then move the handle out of the handle stop bracket and then remove the shoulder bolt.**



Photo #8

To adjust the motor assembly for proper trimming, lock the motor handle in the handle stop position. See photo #9. Loosen the three

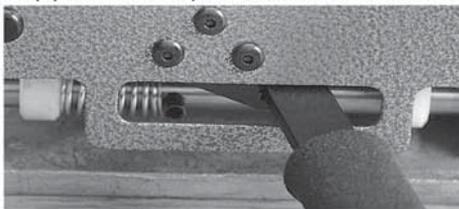


Photo #9

thumb screws that lock down the motor assembly. See photo #10. Insert a "reference" case in the shell holder and slide the motor assembly toward the case. Leave about 1/4" – 3/8" between the end of the pilot and the mouth of the case. See photo #11. Tighten the



Photo #10

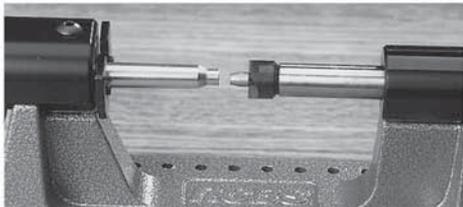


Photo #11

three thumb screws. Adjust the trimmer to the correct trim length as described in the section called "Case Trimmer Adjustment." The maximum case length and trim-to length for popular calibers are shown in the Reference Table beginning on page 11. The trimmer is now ready to trim cases.

To operate the trimmer, make sure the motor handle is in the handle stop position. See photo #12. Plug the power cord into a convenient



Photo #12

outlet. Place an untrimmed case in the shell holder, unlock the motor handle from the handle stop position by moving the handle to the right and down, then to the left (see photo #13) and allow the springs under the motor housing to feed the cutter to the case. Maintain

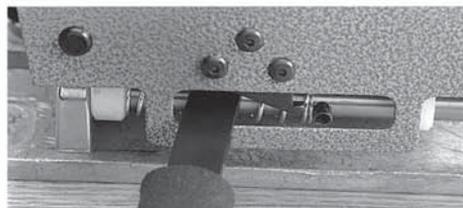


Photo #13

control of the handle until the cutter engages the mouth of the case. Let the springs do the work. It is not necessary to apply additional pressure with the motor handle to get a good, clean trim.

When the power trimmer is finished trimming the case, you will hear a slight change in the sound of the motor and you will see that the cutter blade is not removing any more brass. Now move the cutter away from the case by moving the motor handle to the handle stop position. Lock the motor handle in the handle stop bracket by moving the handle to the right and "up." Remove the case from the shell holder by pressing down on the case holder handle and lifting the case free.

CASE TRIMMER ADJUSTMENT

The first step in case trimming is determining whether the cases need to be trimmed. The RCBS dial caliper is an excellent companion for the case trimmer and will provide accurate case length measurements. Use the calipers to measure your cases. See photo #14. If any



Photo #14

cases exceed the maximum length it is a good idea to trim all the cases in the lot so they are all a uniform length.

For example: Let's say you have measured your case and found it is over the maximum recommended length by 0.003". The suggested trim length is 0.010" less than the maximum length. You will need to remove 0.013" from the length of the case to bring the case back into specification. That is the 3 thousandths the case is over maximum case length and the ten thousandths under maximum that is the recommended trim length.

The trim length is controlled by the rough and fine adjustment bushings which are mounted on the cuttershaft. The fine adjustment bushing (the larger of the two) is threaded onto the rough adjustment bushing. See photo #15. Both bushings have setscrews to hold them

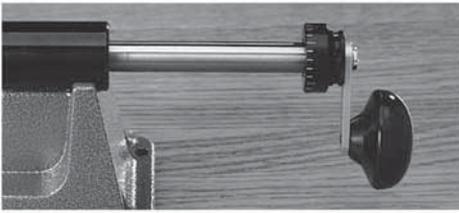


Photo #15

securely in place. The location of the bushings on the cutter shaft will determine the length of a trimmed case.

Start by placing the case in the shell holder on the trimmer. See photo #16. Make sure there is



Photo #16

a pilot installed on the cutter. Loosen the setscrews on both the rough and fine adjustment bushings. This should let the bushings move freely on the cutter shaft. The handle will need to be off the handle-stop position. As stated earlier, the fine adjustment bushing is threaded on the rough adjustment bushing. While looking at the right-hand end of the tool, hold the fine bushing (see photo #17) and turn the rough bushing two



Photo #17

or three turns counter-clockwise. With the cutter firmly against the case mouth, push the bushings all the way against the cutter guide. It is this contact that will stop the cutting process. Secure the setscrew on the rough bushing. You probably noticed small white lines on the fine bushing and a "witness" mark or dimple on the cutter guide in front and near the casting. Each of the white lines represent approximately 0.001" and the witness mark is used as a point-of-reference. One complete turn of the fine bushing equals 0.025" of cutter blade movement.

When you turn the fine bushing towards you, you will notice a small gap appears between the fine bushing and the cutter guide. This gap represents the amount the case will be trimmed. Remember in our example we wanted to remove 0.013." Turn the fine bushing towards you until 13 marks have passed and secure the setscrew. Your trimmer should now be very close to the correct setting.

Trim the first case by applying power to the trimmer. When the case is finished being trimmed, remove the case from the shell holder and chamfer and deburr with your deburring tool. Use your dial caliper to check the case length. If a final adjustment is necessary, remember to turn the fine bushing. Turning it counter-clockwise will result in a shorter case and turning it clockwise will result in a longer case.

Now secure both setscrews and you are ready to trim a quantity of cases.

An alternative method for setting the trimmer to the proper length is to save one of your trimmed cases to use as a "reference." Put this "reference" case in the shell holder and loosen the setscrew on both the rough and fine bushing. With the cutter all the way to the left, push the bushings so they are flush against the cutter guide and secure both setscrews. The reference case is acting as a guide and will make for easy set-up in the future.

TRIM PRO POWER ASSEMBLY INSTRUCTIONS

Carefully unpack the power assembly and look for the following items:

- Power Assembly unit and base
- Motor handle
- Parts bag

This unit converts an RCBS Rotary Case Trimmer-2 or manual Trim Pro into a high production power case trimmer. There are slightly different installation instructions depending on which manual trimmer you have. Choose Option #1, Option #2, or Option #3 from the following section.

OPTION #1

Use these instructions if you are installing an RCBS Rotary Case Trimmer-2 on the power

assembly AND if you plan to continue using the collet-type case holding system.

CAUTION: Make sure the power unit is not plugged in.

Step 1: Remove the palm handle from the cutter shaft by removing the screw from the palm handle bracket. See photo #18.



Photo #18

Step 2: Attach the case trimmer to the power assembly bracket with the three cap screws and three spacer washers. The spacer washers are necessary to elevate the base of the trimmer for proper alignment with the shaft that extends from the motor housing. See photos #19 and #20.

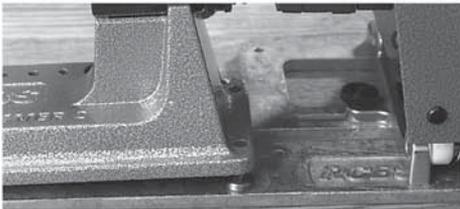


Photo #19

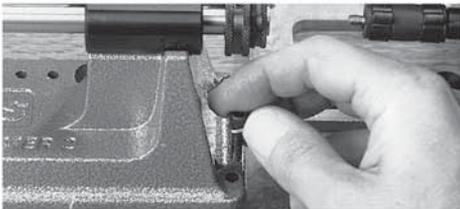


Photo #20

Step 3: Attach the trimmer shaft to the coupling on the power assembly unit. See photo #21.

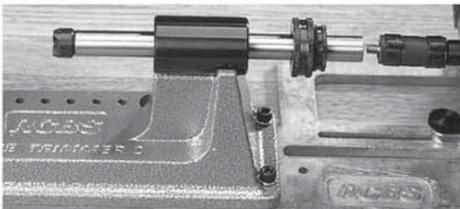


Photo #21

Step 4: Attach the motor handle to the unit as described on page 4.

Step 5: Secure the power assembly bracket to a sturdy bench using the six wood screws provided in the parts bag. The power trimmer is now ready to use.

OPTION #2

Use these instructions if you are installing a Rotary Case Trimmer-2 on the power assembly AND you have the new lever-type Case Holder Accessory.

Step 1: Remove the palm handle from the cutter shaft.

Step 2: Turn the Rotary Case Trimmer-2 upside down so you are looking at the bottom of the casting.

Step 3: With a 5/32" hex wrench (or a slotted screw driver if they are standard screws) remove the two screws from the casting. See photo #22. One screw holds the case holder to the casting and the other holds the cutter guide.



Photo #22

Step 4: Turn the casting right-side up.

Step 5: Using one of the new cap screws and a lock washer in the hole in the casting, place the left saddle in position (see photo #23) and install the case holder accessory. Tighten the cap screw. **Do not over tighten.**



Photo #23

Step 6: Using the other new cap screw and lock washer in the hole in the casting, place the right-hand saddle in position (see photo #24) and re-install the cutter guide. The saddles are necessary for proper alignment and are only required for the Rotary Case Trimmer-2 with the lever-type case holder.

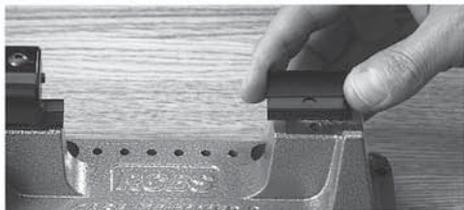


Photo #24

Step 7: Attach the case trimmer to the power assembly bracket with the three cap screws and lock washers. See photo #25. **You will not use the spacer washers from the parts bag.**

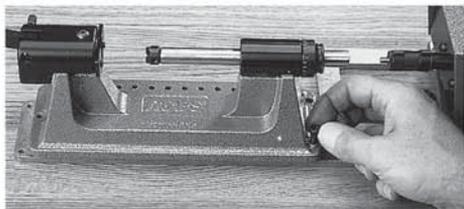


Photo #25

Step 8: Attach the trimmer shaft to the coupling on the power assembly unit.

Step 9: Attach the motor handle to the unit as described on page 4.

Step 10: Secure the power assembly bracket to a sturdy bench using the six wood screws provided in the parts bag.

OPTION #3

Use the following instructions if you are connecting an RCBS Manual Trim Pro to the power assembly:

- Remove the palm handle from the cutter shaft.
- Follow steps 7 through 10 as described in Option #2.

After installing one of the trimmers onto the power assembly, the unit is ready for operation. Refer to the section called "Trim Pro Power Case Trimmer Instructions" on page 3 for operating instructions.

CASE TRIMMING HINTS

- Typically trimming is done after the cases are full-length resized. However, the Trim Pro is designed so cases can be trimmed before resizing if you prefer.
- Trimmed case mouths should be chamfered inside and out with an RCBS deburring tool before loading. Trimming leaves burrs which, if not removed, can complicate the loading process.
- If you trim cases of several different calibers, keep one case of each caliber to use as a guide when adjusting the trimmer. This will become your "reference" case and should be stored in the die box with your reloading dies.

CARE AND MAINTENANCE

- Make sure the face of the compression pin is clean and free of dirt and foreign material.
- After trimming every 300 cases lubricate the following areas with a light oil. Also, if the trimmer has not been in use for 2 months or more, lubricate the same areas.



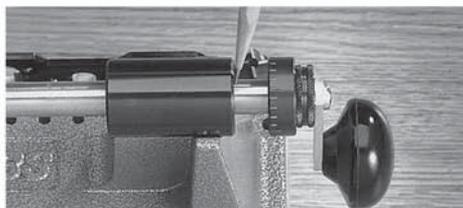
Lubricate the case holder handle.



Lubricate the case trimmer shaft.



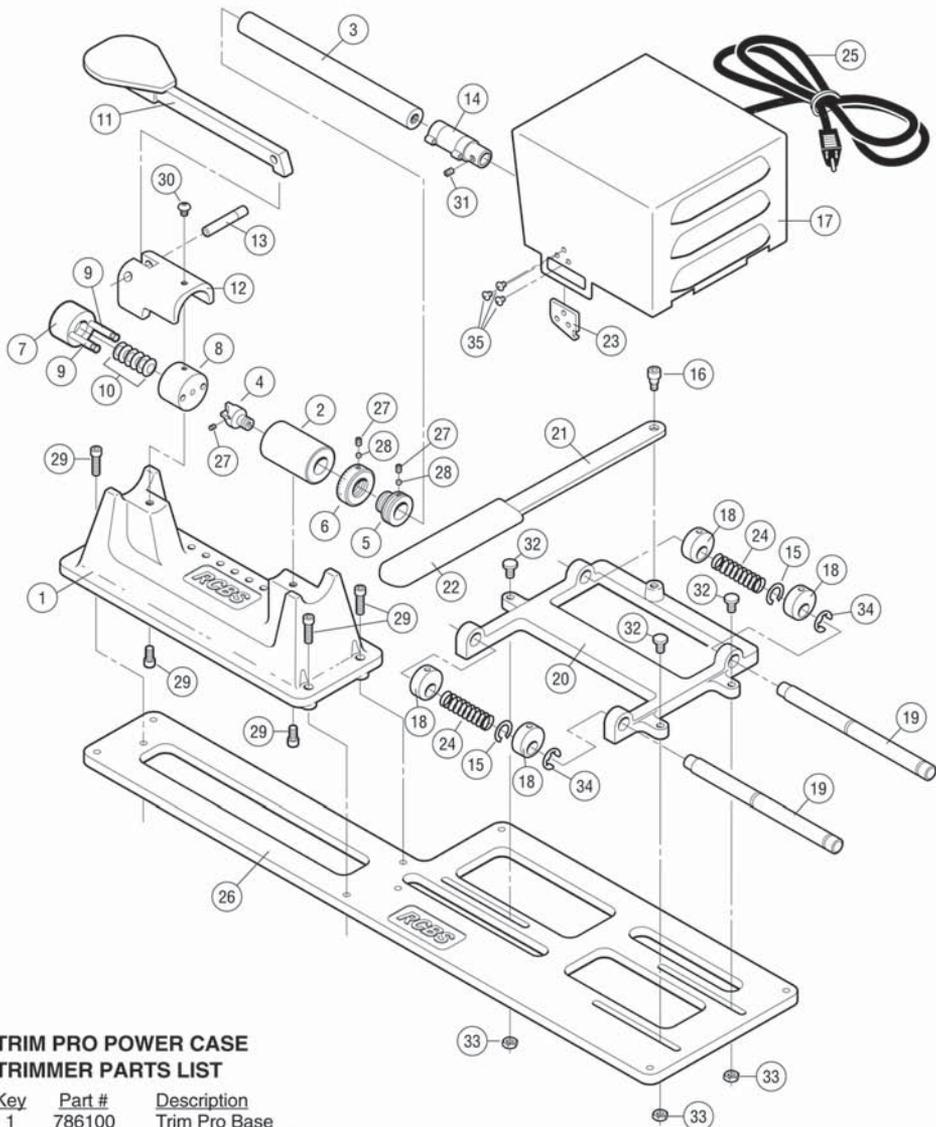
Lubricate the roll pin on the bottom of the motor housing.



Apply some light oil between the cutter guide and the fine adjustment bushing.



Lubricate the guide rods.



TRIM PRO POWER CASE TRIMMER PARTS LIST

Key	Part #	Description
1	786100	Trim Pro Base
2	98938	RCT Cutter Guide
3	9405	RCT Cutter Shaft
4	9406	RCT Cutter
5	9407	RCT Adjustment Bushing
6	9408	TP Fine Adjustment Bushing
7	786101	TP Spring Holder
8	786102	TP Compression Pin
9	786103	TP Actuating Rod (2)
10	186131	TP Disc Spring (6)
11	786122	TP Handle Lever Assembly
12	786121	TP Handle Support
13	786107	TP Handle Pin
14	786176	TP Coupling Assembly
15	9143	Retaining Ring 318 Small
16	786117	TP Handle Shoulder Bolt
17	786112	TP Motor Cover
18	786113	TP Bearing (4)
19	786115	TP Rod Guide (2)
20	786135	TP Motor Base Plate
21	786116	TP Motor Handle
22	186136	TP Handle Grip
23	786118	TP Handle Stop
24	186138	TP Drive Spring
25	186139	TP Power Cord
26	186140	TP Unit Mounting Plate
27	9409	Screw, 8-32x1/8 (3)
28	9410	Brass Buffer (2)
29	86624	Screw, 10-32x5/8 (5)
30	186114	Screw, 10-32x3/8
31	87030	Screw, 10-32x1/8
32	186146	Screw, 10-32x1/2 (3)
33	9603	Hex Nut, 10-32 (3)
34	9266	Retaining Ring (2)
35	186150	Screw, 6-32x1/8 (3)

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