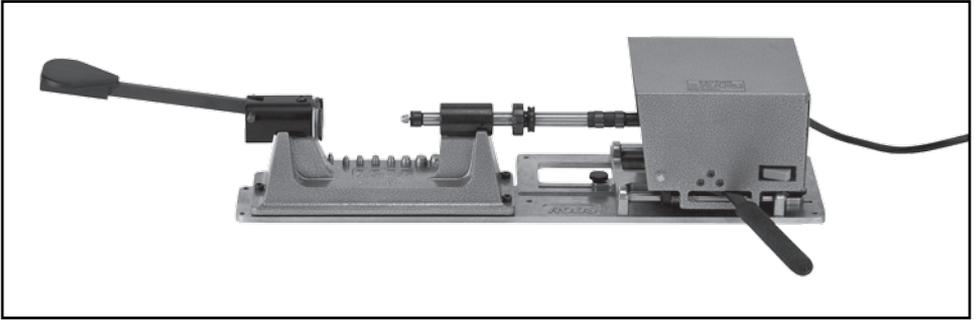


# ***RCBS***®

## **TRIM PRO—2 POWER CASE TRIMMER**



### **PRODUCT INSTRUCTIONS**

** WARNING!**

Before using the RCBS Trim Pro—2 Power Case Trimmer, read these instructions carefully to fully learn how to safely operate the related reloading equipment. Failure to properly operate the related reloading equipment can result in severe personal injury and/or equipment damage.

**If you have any questions while assembling or operating this tool,  
Call us at 1-800-533-5000 or 1-530-533-5191  
Monday – Thursday 6:30 a.m. – 4:00 p.m. Pacific Time  
(hours may vary)  
Or email us at [rcbs.tech@atk.com](mailto:rcbs.tech@atk.com)**

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.

**TWO YEAR LIMITED WARRANTY**

Your Power Unit is warranted to be free from defects in material or workmanship for two years from the date of purchase. This warranty is extended only to the original consumer purchaser. All RCBS products are intended for non-commercial use by hobbyists. Any other use of these products will void the warranty. Should you believe that your Power Unit is defective in material or workmanship, you must return it to Ammunition Accessories Inc. through its Oroville operation (hereinafter “Oroville Operations”) postage paid for evaluation. If defective, the product will be repaired or replaced at Oroville Operations’ option, at no charge. Send a dated proof of purchase to Oroville Operations for return shipping and handling, along with the Power Unit to:

Ammunition Accessories Inc.  
Oroville Operations  
605 Oro Dam Blvd East  
Oroville, California 95965

Warranty services cannot be provided without meeting the above requirements. THIS LIFETIME LIMITED WARRANTY DOES NOT COVER DEFECTS OR DAMAGE RESULTING FROM: CARELESSNESS, MISUSE, COMMERCIAL USE, ABUSE, IMPROPER INSTALLATION, MODIFICATION, OR NORMAL WEAR AND TEAR. THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE LIMITED TO THE DURATION OF THIS LIFETIME LIMITED WARRANTY. OROVILLE OPERATIONS IS NOT LIABLE FOR DAMAGES IN EXCESS OF THE PURCHASE PRICE OF THE PRODUCT AND UNDER NO CIRCUMSTANCES SHALL OROVILLE OPERATIONS BE LIABLE FOR CONSEQUENTIAL OR INCIDENTAL DAMAGES. HOWEVER, SOME STATES DO NOT ALLOW LIMITATIONS ON INCIDENTAL, OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

The above warranty provides the sole and exclusive warranty available to the customer in the event of a defect in material or workmanship in the reloading product. This warranty gives you specific legal rights, and you may also have other rights which vary from State to State.

## **LIFETIME LIMITED WARRANTY**

Your Trim Pro Trimmer is warranted to be free from defects in material or workmanship for lifetime of the original consumer purchaser. All RCBS products are intended for non-commercial use by hobbyists. Any other use of these products will void the warranty. Should you believe that your Trim Pro Trimmer is defective in material or workmanship, you must return it to Ammunition Accessories Inc. through its Oroville operation (hereinafter "Oroville Operations") postage paid for evaluation. If defective, the product will be repaired or replaced at Oroville Operations' option, at no charge. Send a dated proof of purchase to Oroville Operations for return shipping and handling, along with the Trim Pro Trimmer to:

Ammunition Accessories Inc.  
Oroville Operations  
605 Oro Dam Blvd East  
Oroville, California 95965

Warranty services cannot be provided without meeting the above requirements. THIS LIFETIME LIMITED WARRANTY DOES NOT COVER DEFECTS OR DAMAGE RESULTING FROM: CARELESSNESS, MISUSE, COMMERCIAL USE, ABUSE, IMPROPER INSTALLATION, MODIFICATION, OR NORMAL WEAR AND TEAR. THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE LIMITED TO THE DURATION OF THIS LIFETIME LIMITED WARRANTY. OROVILLE OPERATIONS IS NOT LIABLE FOR DAMAGES IN EXCESS OF THE PURCHASE PRICE OF THE PRODUCT AND UNDER NO CIRCUMSTANCES SHALL OROVILLE OPERATIONS BE LIABLE FOR CONSEQUENTIAL OR INCIDENTAL DAMAGES. HOWEVER, SOME STATES DO NOT ALLOW LIMITATIONS ON INCIDENTAL, OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

The above warranty provides the sole and exclusive warranty available to the customer in the event of a defect in material or workmanship in the reloading product. This warranty gives you specific legal rights, and you may also have other rights which vary from State to State.

## **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.
- Do not 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, or under the influence of medications or alcohol.
- Develop a reloading routine to avoid mistakes which may prove hazardous. Do not 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.

## **LOADING DATA**

- Use only laboratory tested reloading data. We highly recommend the current SPEER Reloading Manual.



**OBSERVE ALL WARNINGS ABOUT THE USE OF MAXIMUM LISTED LOADS.**

<b>WARNING/ CAUTION</b>
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## **PRIMERS AND POWDER**

- Store primers and powder beyond the reach of children and away from heat, dampness, open flames and electrical equipment. Avoid areas where static electricity is evident.
- DO NOT use primers of unknown identity.
- Dispose of unknown primers in accordance with applicable regulations.
- Keep primers in the original factory container until ready to use. Return unused primers to the same factory packaging for safety and to preserve their identity. Primer packaging is designed to provide safe storage.
- 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 have more than one can of powder on the bench at one time. Powder cans should be stored away from the bench to avoid picking up the wrong one.

- DO NOT use any powder unless its identity is positively known. The only positive identification is the manufacturer's label on the original canister. Discard all mixed powders and those of uncertain identity.
- If you use a powder measure, replace the lids on both the powder hopper and powder can after the powder hopper has been filled.
- When using a powder measure, settle the powder in the powder hopper before charging any cases. Throw and check the weight of at least ten charges. This will assure you that the correct powder charge is being thrown.
- When you finish a reloading session, pour any remaining powder back into its original factory container. This will preserve the identity and shelf life of the powder.
- DO NOT smoke while reloading.

## 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.

*Because RCBS has no control over the choice of components, the manner in which they are assembled, the use of this product, or the firearms in which the resulting ammunition may be used, we assume no responsibility, expressed or implied, for the use of ammunition reloaded with this product.*

## USE

The RCBS Trim Pro—2 Power Case Trimmer is designed to cut cartridge case length to manufacturer recommendations. Repeated firing, resizing, and reloading of cases cause them to grow in length. Whenever a case grows longer than the manufacturer's maximum specified case length, it must be trimmed back to an acceptable length for that cartridge.

There are case length specifications for every cartridge. A current copy of the Speer Reloading Manual is an excellent source for this information. To order one, contact RCBS or see our website ([www.rcbs.com](http://www.rcbs.com)).

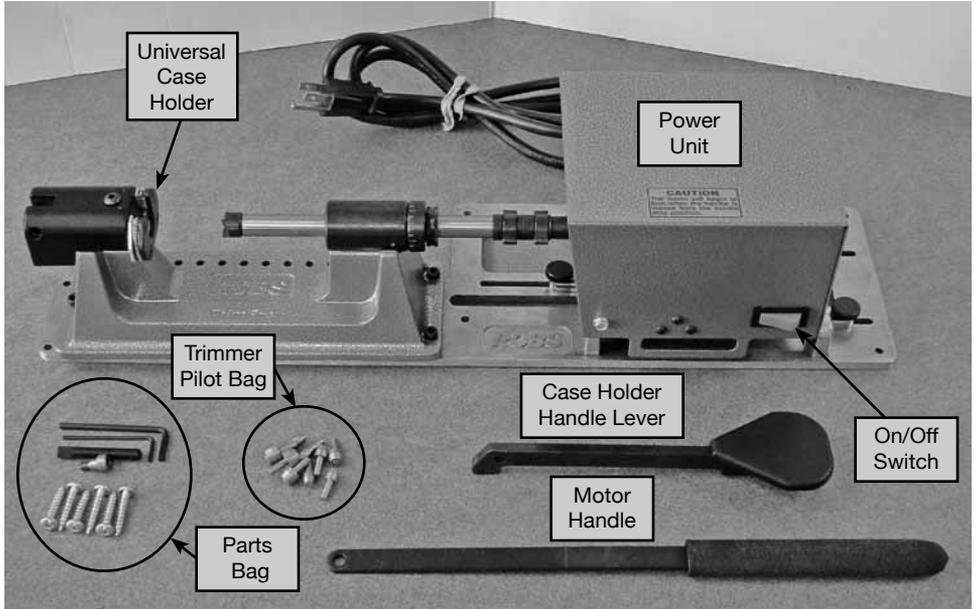
**⚠ CAUTION** *It is critical for safety that cases not exceed the maximum specified case length. A case that is too long can enter the throat of the firearm when chambered. If this happens, the case cannot release the bullet properly upon firing, resulting in excessive pressure increase.*

The Trim Pro—2 will give you a consistent repeatable trim. The case mouth will be cut square/perpendicular to the longitudinal axis of the case. It is quick to setup, easy to use, easy to change from one caliber to another, and provide years of trouble-free service.

After trimming a case, chamfer/ debur the case mouth inside and out with an RCBS Debur Tool (sold separately). An optional Three-Way Cutter Tool (sold separately) can be used on the Trim Pro—2 unit to combine trimming and chamfering the inside and outside into one easy operation. To order either or find out more information, contact RCBS or visit our website ([www.rcbs.com](http://www.rcbs.com)).

## UNPACKING

Refer to the list below to identify parts as you carefully unpack your new Trim Pro—2 Power Case Trimmer:



*Parts Bag*



- 1/8 Hex Key Wrench (1)
- 5/64 Hex Key Wrench (1)
- Case Holder Lever Pin (1)
- Motor Handle Shoulder Bolt (1)
- #10 x 1" L Wood Screws (6)

*Pilot Bag*



- |                  |                  |
|------------------|------------------|
| 22-cal Pilot (1) | 24-cal Pilot (1) |
| 25-cal Pilot (1) | 27-cal Pilot (1) |
| 28-cal Pilot (1) | 30-cal Pilot (1) |
| 35-cal Pilot (1) | 44-cal Pilot (1) |
|                  | 45-cal Pilot (1) |

**CAUTION** Leave the Power Case Trimmer unplugged until you have read all the instructions and are ready to trim cases.

## **ASSEMBLY**

Reference the part schematic on page 11 for more information.

### **Case Holder Handle Lever**

Attach the Case Holder Handle by inserting it into the slot on the Case Holder. Align the holes and insert the Lever Pin (Photo 1).



**Photo 1. Assemble Case Holder Handle**

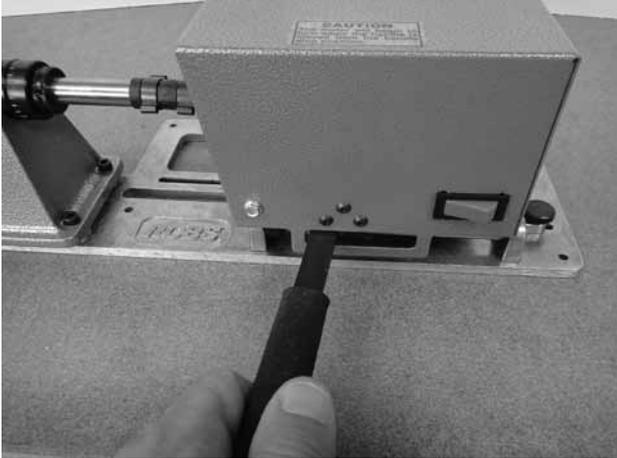
Ensure the Lever Pin is fully inserted and engaging both sides of the slot in the Case Holder (Photo 2).



**Photo 2.**

### **Motor Handle**

Insert the Motor Handle through the slot and ensure it is perpendicular to the Motor Housing (Photo 3). Make sure to insert along the left side of slot.



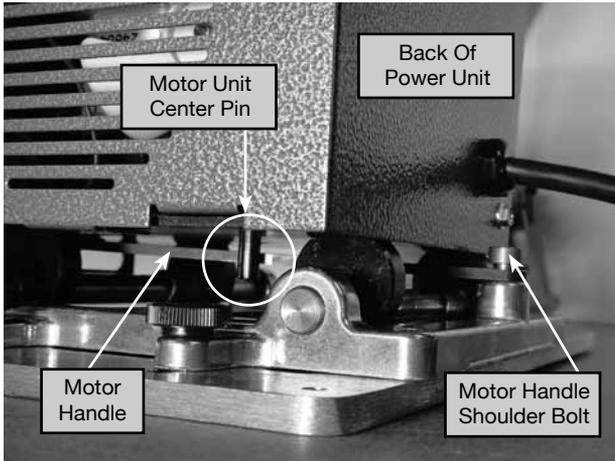
**Photo 3. Motor Handle in Left Side of Slot**

On backside of Motor Unit, align the Motor Handle with hole in Motor Base Plate. Install Motor Handle Shoulder Bolt and tighten using 5/64" Hex Key Wrench (Photo 4).



**Photo 4. Install Shoulder Bolt**

Check to verify the Motor Handle is to the left of the Center Pin on the bottom of the Motor Unit (Photo 5).



**Photo 5. Motor Handle Installation Location**

### **Caliber Pilot**

Fully insert the appropriate sized Case Trimmer Pilot into the end of the Cutter Head. Securely tighten the setscrew on the Cutter using a 1/8" hex key wrench (Photo 6).



**Photo 6. Installing Pilot**

Pilots are interchangeable and available in a variety of sizes. Each Pilot is machined to the caliber size of the resized case mouth. The snug fit helps eliminate case wobble and ensures alignment of the case while it is being trimmed.

## INSTALLATION

Note: Reference the part schematic on page 11 for more information.

**⚠ CAUTION** *Leave the Power Case Trimmer unplugged until you have read all the instructions and are ready to trim cases.*

### Mount the Trimmer

Securely mount your Trim Pro—2 Power Trimmer to your reloading bench at a location of your preference. Use the six wood screws provided, or other suitable method (Photo 7). Allow sufficient room around the Trimmer to operate it comfortably and safely.

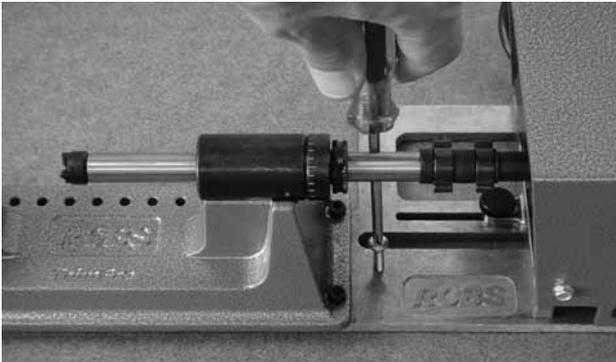


Photo 7. Mounting Trimmer

## FUNCTION

**⚠ CAUTION** *First flip the Main Power Switch to the “OFF” position (Photo 8).*

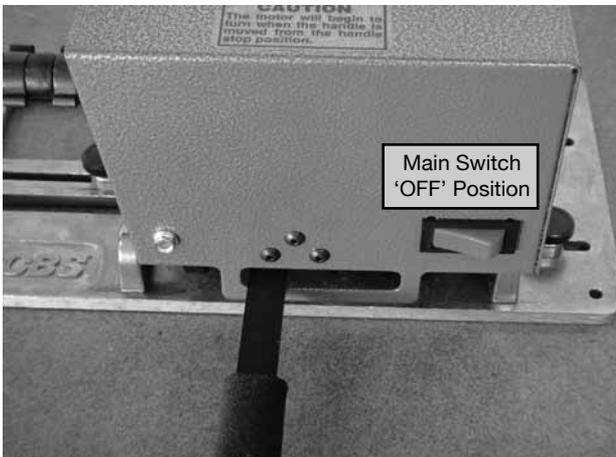
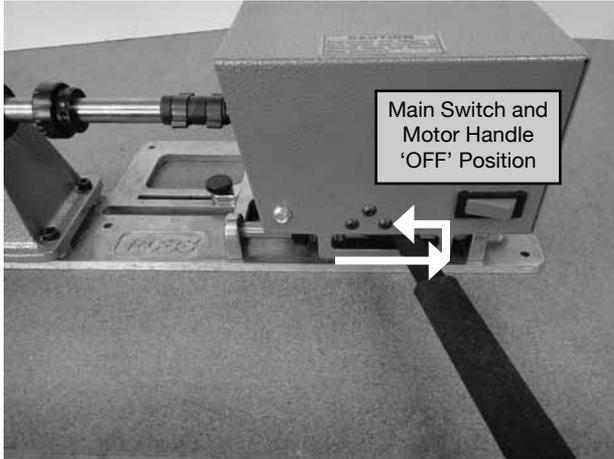


Photo 8. Main Power Switch OFF

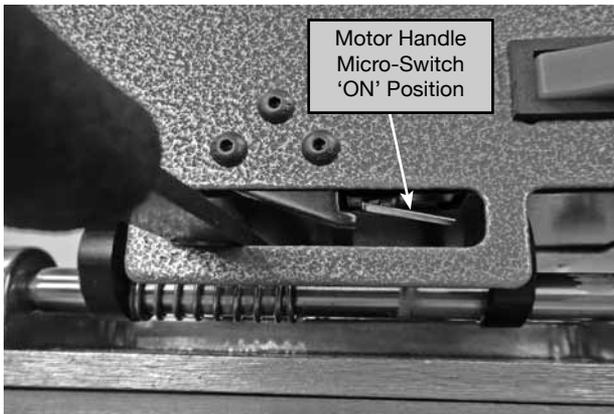
Plug the Power Cord into a grounded 120VAC outlet.

Slide the Motor Handle to the right, then up, then back to the left (Photo 9) to lock it in the 'Off' position. The Motor Handle will slide the entire Power Unit and Cutter Head with it. This entire assembly is spring-loaded to put positive pressure on the Cutter Head into the case mouth.



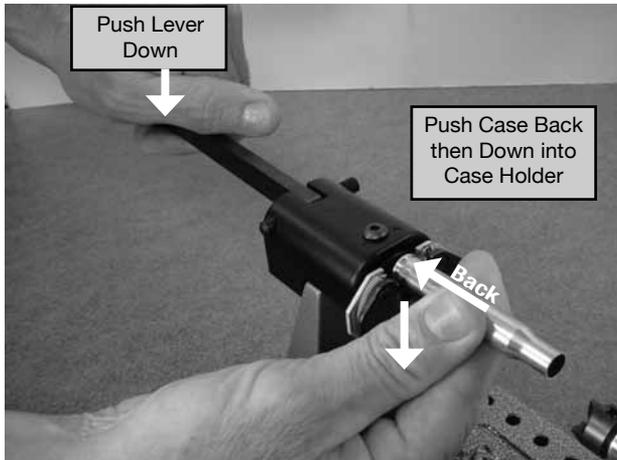
**Photo 9. Motor Handle Locked in OFF Position**

The Motor Handle has a Micro-Switch installed, which also controls electric power to the motor (Photo 10).



**Photo 10. Micro-Switch**

Next, load a resized case into the Universal Case Holder by pushing down and holding the Case Holder Lever with one hand, while inserting the case base with the other hand (Photo 11). Ensure the case base is flush with the Case Holder Knurl Face (Photo 12). The Case Holder has two spring-loaded 'fingers' that engage the Case's Extractor Groove/ Rim.



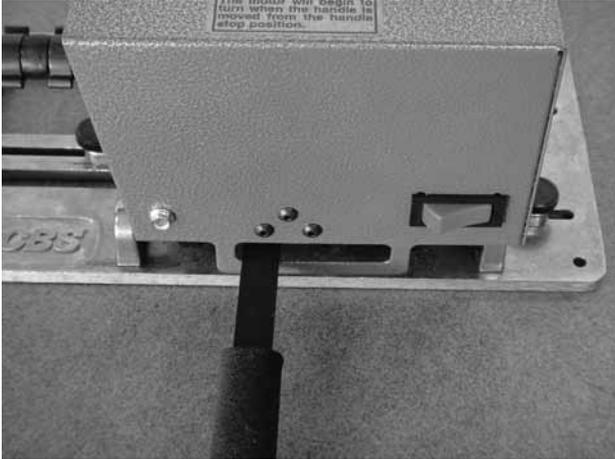
**Photo 11. Inserting Case into Universal Holder**



**Photo 12. Case Holder 'Fingers'**

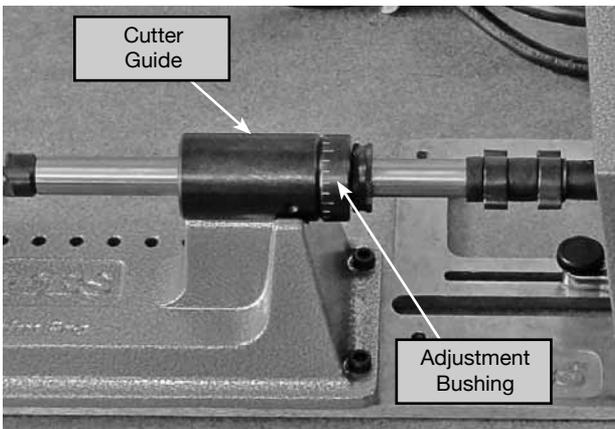
Proceed to the ADJUSTMENT section of this manual to fine-tune the Trim Length for your case.

To operate the Trimmer, turn the Main Power Switch 'ON' and unlock the Motor Handle by sliding it firmly to the right, then down, and then guiding it back to the left (Photo 13). Maintain control of the Motor Handle until the Pilot and Cutter engages the mouth of the case.



**Photo 13. Power Switch and Motor Unit 'ON'**

When the trimming operation is complete, you will hear a slight change in the sound of the motor when the Trimmer Adjustment Bushings contacts the Cutter Guide (Photo 14). Slide the Motor Handle to the right, then up, then back to the left (Photo 9) to lock it in the 'Off' position.



**Photo 14.**

Remove the trimmed case from the Universal Case Holder by pressing down on the Case Holder Lever and lifting the case out. Chamfer/ Debur the case mouth inside and out with an RCBS Debur Tool (sold separately). An optional Three-Way Cutter Tool (sold separately) can be used to combine trimming and chamfering the inside and outside into one easy operation. Contact RCBS for more information.

## ADJUSTMENT

Note: Reference the part schematics on page 11 of this booklet for more information.

**⚠ CAUTION** *It is critical for safety that cases not exceed the maximum specified length. A case that is too long can enter the throat of the firearm when chambered. If this happens, the case cannot release the bullet properly upon firing, resulting in excessive pressure increase.*

### Trimmer Length Coarse Adjustment

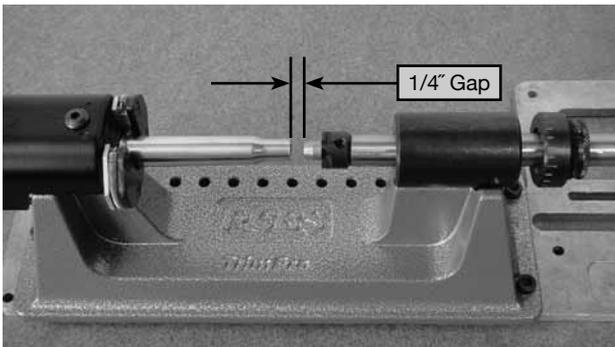
**⚠ CAUTION** *Turn the Main Power Unit Switch OFF before making adjustments (Photo 8).*

With Motor Handle locked in the 'OFF' position (Photo 9), loosen the three (3) thumbscrews that lock down the Power Unit (Photo 15).



**Photo 15. Motor Unit Thumbscrews**

Slide the entire Power Unit to the left, toward the Case Holder. Leave about a 1/4" gap between the end of the Pilot and the Case Mouth (Photo 16).



**Photo 16.**

Tighten the three (3) thumbscrews firmly to secure the Power Unit position.

## Trimmer Length Fine Adjustment

**⚠ CAUTION** Turn the Main Power Unit Switch OFF before making adjustments (Photo 8).

Final adjustments are controlled by the Trimmer's Adjustment Bushing mounted on the Cutter Shaft. The Fine Adjustment Bushing (larger of the two) is threaded into the Coarse Adjustment Bushing. The location of this Bushing Assembly creates a hard-stop for the Cutter Shaft and determines the final case length.

With the Main Power Switch 'OFF' and the Motor Handle locked in the 'OFF' position (Photo 9), install a sized case into the Universal Case Holder and the correct Pilot in the Cutter Head. Loosen the setscrew on the Coarse Adjustment Bushing (Photo 17) and the setscrew on the Fine Adjustment Bushing (Photo 18).



**Photo 17. Coarse Adjustment Bushing**



**Photo 18. Fine Adjustment Bushing**

Unscrew the Fine Adjustment Bushing 5-7 turns. With the Main Switch still 'OFF', unlock the Motor Handle by sliding it firmly to the right, then down, and then guide it back to the left. Maintain control of the Motor Handle until the Pilot enters the mouth of the case and the cutter blades come to a stop against the case mouth.

Next slide the Bushing Assembly to the left to contact the Cutter Guide (Photo 14) and tighten the setscrew on the Coarse Adjustment Bushing. Then slide the Motor Handle back into the locked 'OFF' position (Photo 9).

Remove the sized case and measure its length (Photo 19).



**Photo 19.**

Calculate the amount of brass you want to remove from the case, based on Manufacturer's 'Trim-to-Length' specifications. Screw the Fine Adjustment Bushing in by that amount. Note that each indication line on the Fine Adjustment Bushing represents approximately 0.001", and one full turn is approximately 0.025" of travel.

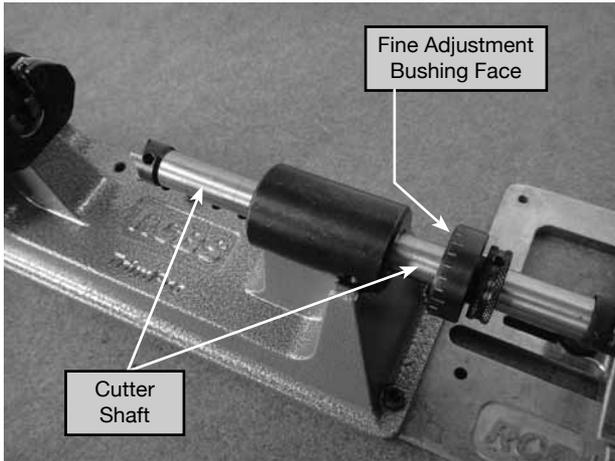
Tighten the setscrew on the Fine Adjustment Bushing. Turn the Main Power Switch 'ON', reinstall the sized case, and trim. Remove the trimmed case and measure to verify length is correct. Make any additional adjustments as needed to the Fine Adjustment Bushing via this process until desired results are achieved.

For future set-up to make trim length adjustments easy, save a trimmed case in a known location (Die Box, etc.). Install this 'reference' case to quickly set the Bushing Assembly position on the Cutter Shaft.

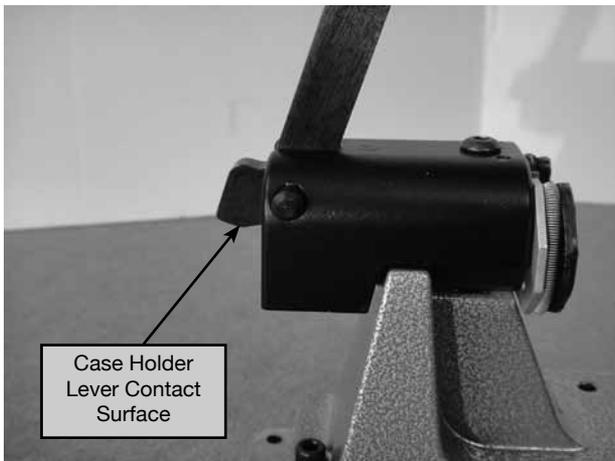
## MAINTENANCE

Occasionally clean your Trim Pro—2 Power Case Trimmer of brass shavings and debris to keep it operating smoothly.

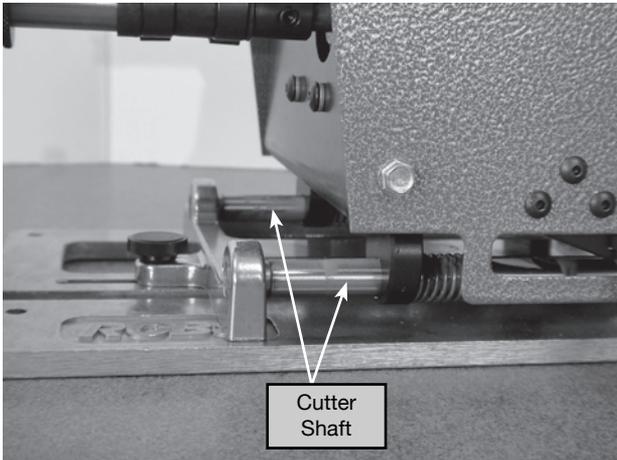
Lightly lubricate your trimmer after trimming approximately 300 cases or before long periods of storage. Use a light-weight multi-purpose grease at the following locations (Photos 20-23):



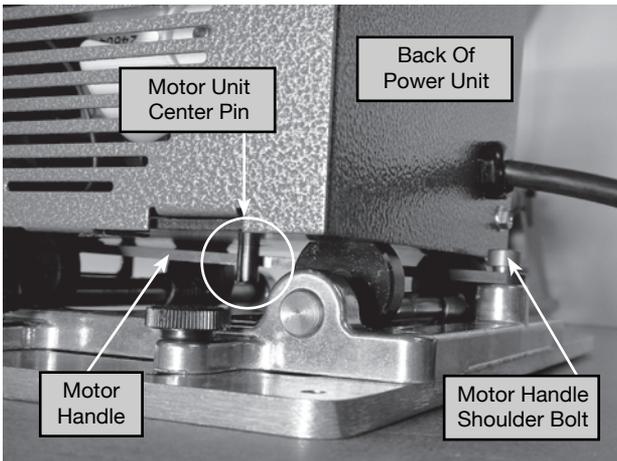
**Photo 20. Lubricate Cutter Shaft and Fine Adjustment Bushing Face**



**Photo 21. Lubricate Case Holder Lever**



**Photo 22. Lubricate Motor Guide Rods (4 places)**



**Photo 23. Lubricate Contact Surface of Motor Unit Center Pin (on Bottom of Motor) and Motor Handle**

## Trim Pro Accessories — sold separately

### CASE TRIMMER PILOTS



09377	.17 Cal.	09388	.34 Cal.
09376	.20 Cal.	09389	.35 Cal.
09378	.22 Cal.	09390	.36 Cal.
09379	.24 Cal.	09391	.37 Cal.
09380	.25 Cal.	09392	.40 Cal.
09381	.26 Cal.	09393	.41 Cal.
09382	.27 Cal.	09397	.416 Cal.
09383	.28 Cal.	09394	.44 Cal.
09384	.30 Cal.	09395	.45 Cal.
09385	.31 Cal.	09396	.45-R Cal.
09386	.32 Cal.	09398	.475 Cal.
09387	.33 Cal.	09399	.500 Cal.
		09400	.50-R Cal

### THREE-WAY CUTTERS



Trim Pro Three-Way Cutters:  
(includes cutter & pilot)

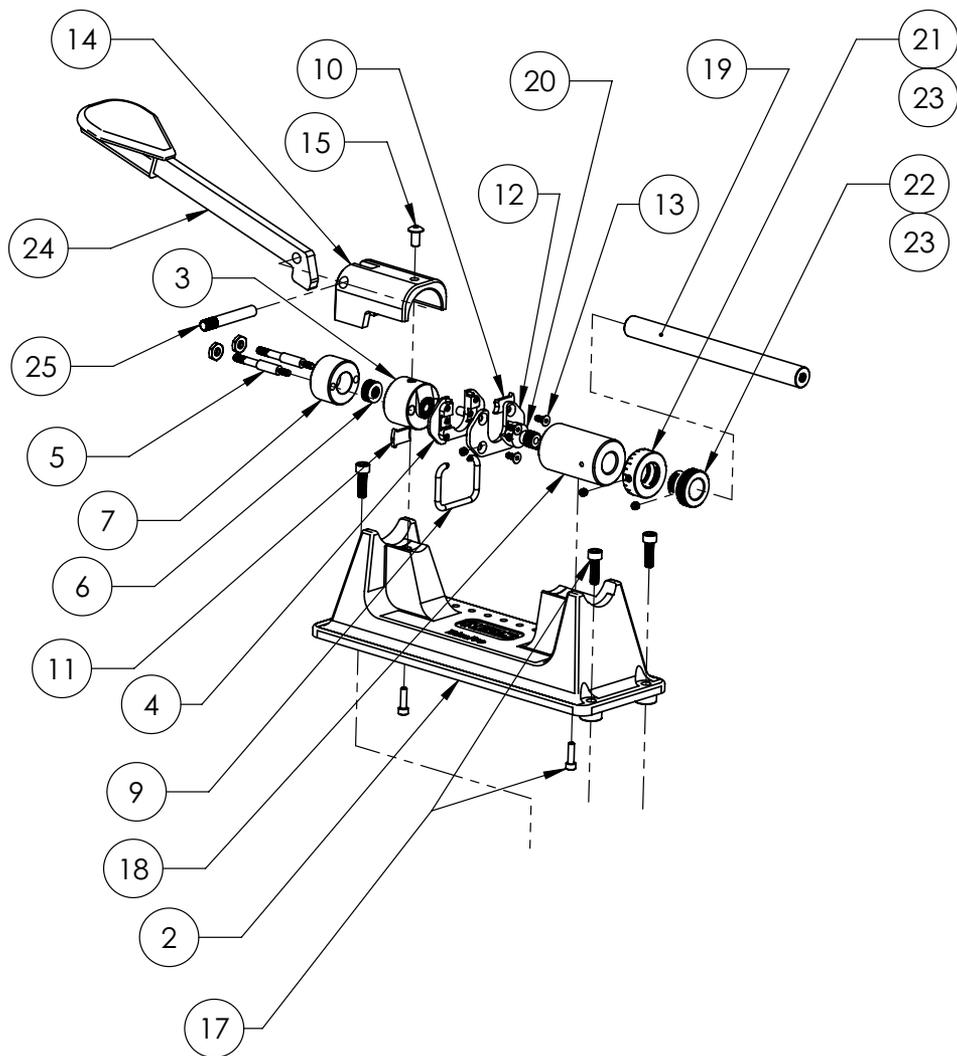
90276	.17 Cal.	90282	.270 Cal.
90277	.20 Cal.	90283	7mm Cal.
90278	.22 Cal.	90284	.30 Cal.
90279	6mm Cal.	90285	.32 Cal.
90280	.25 Cal.	90287	.338 Cal.
90281	6.5mm Cal.	90291	.375 Cal.

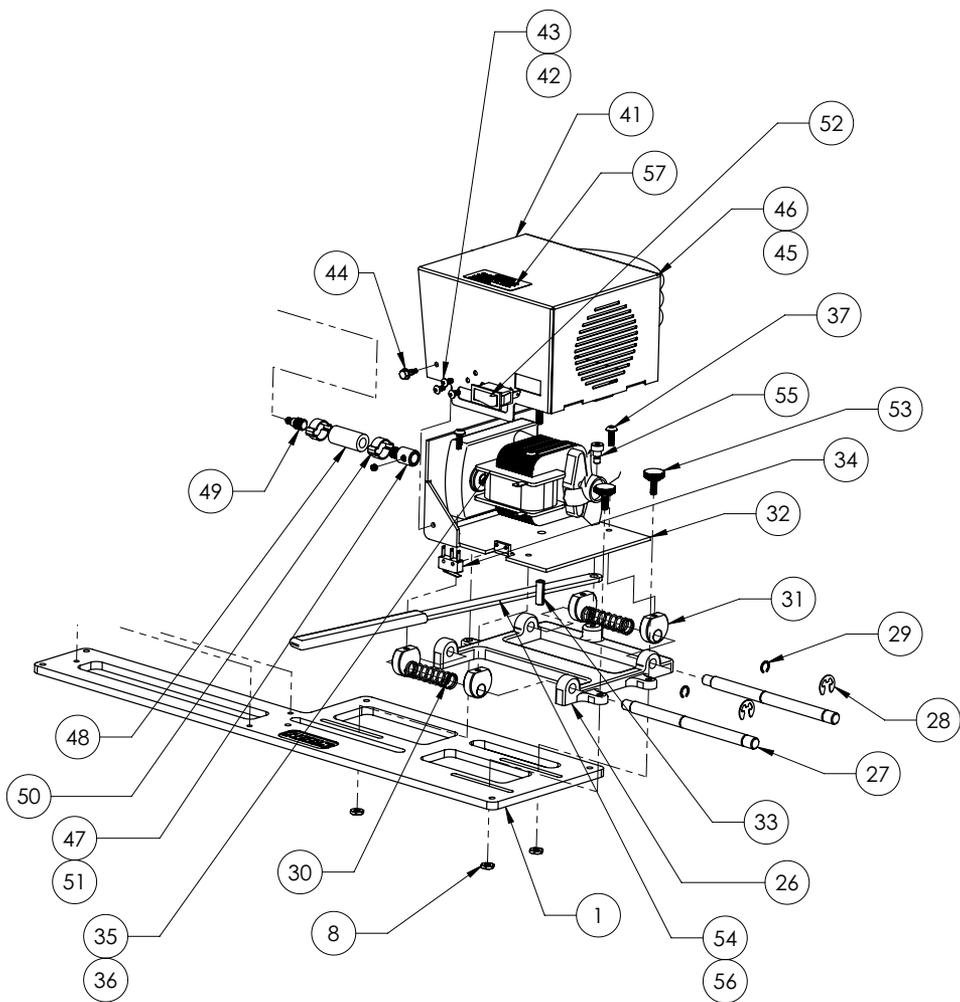
### 90250 - REPLACEMENT CARBIDE CUTTER HEAD



### 90251 - REPLACEMENT THREE-WAY CARBIDE CUTTER HEAD







ITEM NO.	PART NO.	DESCRIPTION	QTY.
1	7186140	Mounting Plate	1
2	7786100	Base	1
3	7786124	Compression Pin	1
4	7786114	Case Holder Shelf	1
5	7786125	Actuating Rod	2
6	7186131	Belleville Washer	6
7	7786123	Spring Holder	1
8	7109603	10-32 Hex Nut	5
9	7186266	APS HPT Case Pawl Spring	1
10	7784138	APS HPT Case Holder Left	1
11	7784139	APS HPT Case Holder Right	1
12	7186263	APS HPT Case Holder Cap	1
13	7186157	5-40 x 5/16L FHCS	4
14	7786121	Handle Support	1
15	7186144	10-32 x 3/8L BHCS	1
16	7187051	#10 Lock Washer	2
17	7186624	10-32 x 5/8L SHCS	5
18	7798938	Cutter Guide	1
19	7709405	Cutter Shaft	1
20	7709406	Cutter Head	1
21	7709408	Fine Adjustment Bushing	1
22	7709407	Coarse Adjustment Bushing	1
23	7109409	8-32 x 1/8L Setscrew	3
24	7786122	Handle Lever Assembly	1
25	7786107	Handle Lever Pin	1
26	7186135	Motor Base Plate	1
27	7786115	Guide Rod	2
28	7109266	Retaining Ring RS II	2
29	7109143	Retaining Ring 318 Small	2

ITEM NO.	PART NO.	DESCRIPTION	QTY.
30	7186138	Compression Spring	2
31	7786113	Delrin Bearing	4
32	7786111	Motor Support	1
33	7186137	Roll Pin 1/4 x 3/4	1
34	7186141	Micro Control Switch	1
35	7186134	Trim Pro Motor, 120VAC	1
36		Trim Pro Motor Fan	1
37	7186149	#8-16 x 1/2L Plastite Screw	4
38	7186148	#8 Lock Washer	4
39	7186147	8-32 X 5/16" BHCS	4
40	7186153	Jumper Wire	1
41	7786175	Motor Cover	1
42	7786118	Motor Handle Stop	1
43	7186150	6-32 x 3/16 BHCS	3
44	7186152	8-18 x 3/8L Self Drilling Screw	2
45	7181133	Strain Relief	1
46	7186139	Trim Pro Power Cord	1
47	7786109	Motor Half Coupling	1
48	7786110	Power Shaft Flex Coupling	1
49	7786108	Trimmer Half Coupling	1
50	7102418	Oetiker Clamp	2
51	7187030	10-32 x 1/8L Setscrew	1
52	7186205	Rocker switch	1
53	7186146	10-32 x 1/2L Thumb Screw	3
54	7786116	Motor Handle	1
55	7786117	Shoulder Bolt, Handle	1
56	7186136	Handle Grip	1
57	7200607	TP Caution Label	1



## PRECISIONEERED RELOADING EQUIPMENT

We think that we make the very best reloading equipment in the world.

If you agree, please tell your friends.

If you disagree, tell us we want to do something about it!

### Customer Service

1-800-533-5000 (US or Canada) or 530-533-5191

Hours: Monday - Thursday, 6:30 a.m. - 4:00 p.m. Pacific Time  
(hours may vary)

e-mail: [rcbs.tech@atk.com](mailto:rcbs.tech@atk.com) or visit our website at [www.rcbs.com](http://www.rcbs.com)

RCBS 605 Oro Dam Blvd. East Oroville, CA 95965

Federal Premium Ammunition - RCBS - Alliant Powder - CCI - Speer Ammo - Speer Bullets  
Fusion Ammunition - Estate Cartridge - Blazer Ammunition - Force on Force  
Weaver - BLACKHAWK! - Champion - Gunslick Pro - Outers  
Buck Commander - Ramline - Redfield - Shooters Ridge

7200494/0112