

RCBS

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 or visit our website at www.rcbs.com

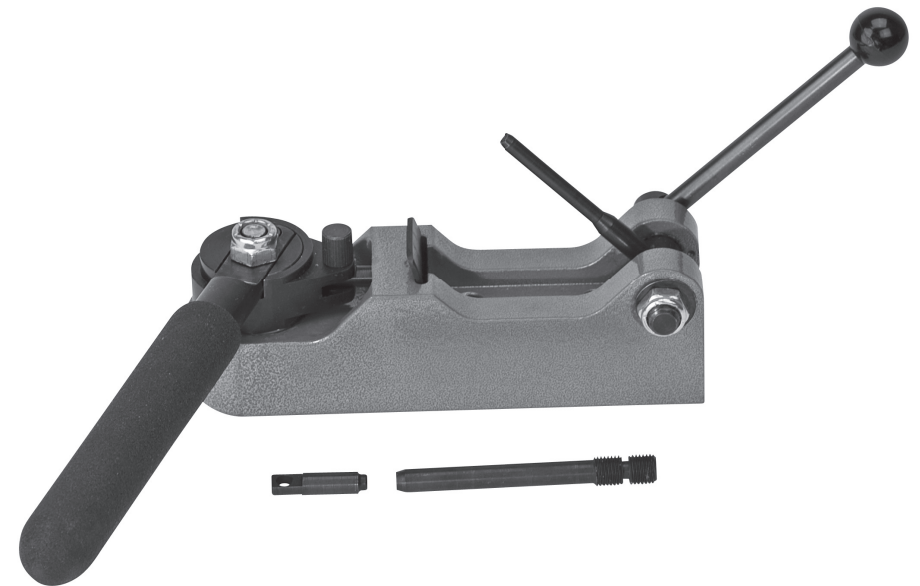
RCBS 605 Oro Dam Blvd. East Oroville, CA 95965

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

7200497/0112

RCBS

Primer Pocket Swager — Bench Tool



PRODUCT INSTRUCTIONS

⚠ WARNING!

Before using the RCBS Primer Pocket Swager—Bench Tool, 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 am – 4:00 pm Pacific Time
(hours may vary)
Or email us at 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.

LIFETIME LIMITED WARRANTY

Your Primer Pocket Swager—Bench Tool 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 Primer Pocket Swager—Bench Tool 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 Primer Pocket Swager—Bench Tool 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.

⚠ WARNING/ CAUTION

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 Primer Pocket Swager—Bench Tool is designed to deform the crimp ring around the primer pocket of cartridge cases that have staked or crimped primers. It is not intended to swage the entire primer pocket. Much of today's commercial ammunition (for certain cartridges) is sold this way, as well as all military ammunition. The crimping process leaves a thin lip of brass folded onto the edge of the primer to secure it in place. When reloading a crimped case, that brass lip around the primer pocket must be removed.

The RCBS Primer Pocket Swager—Bench Tool comes partially assembled with parts installed to swage small primer pockets. To swage large pockets, simply switch out the Small Swaging Rod and Head to Large set (both included). See **Adjustment** section of this manual for more information.

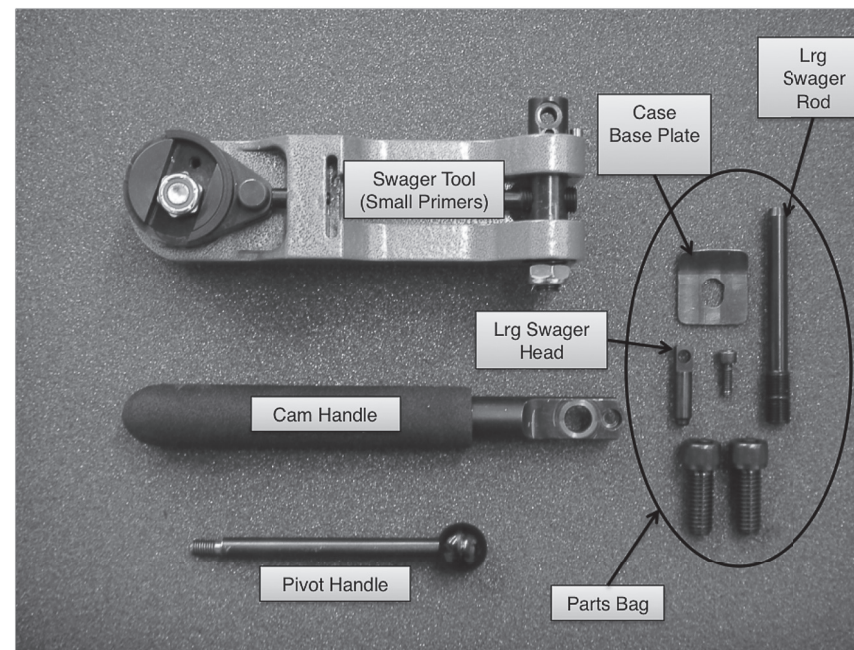
TERMINOLOGY REFERENCE

The following abbreviations are used throughout this instruction manual:

- BHCS – Button Head Cap Screw
- SHCS – Socket Head Cap Screw
- CW – Clockwise
- CCW – Counter Clockwise

UNPACKING

Refer to the list below to identify parts as you unpack your new Primer Pocket Swager—Bench Tool:



Parts Bag #1

- Large Swager Rod (1)
- Large Swager Head (1)
- Case Base Plate (1)
- 8-32 x 1/2" long SHCS (1)
- 3/8-16 x 1" long SHCS (2)

Note: The 3/8-16 SHCS are optional for mounting to an RCBS Accessory Base Plate-2 (#9280, sold separately). To order one or find out more information, contact RCBS or visit our website (www.rcbs.com).

ASSEMBLY

Reference the part schematic on page 14 for more information.

You will need the following tools in order to assemble and install this Kit:

- 3/16" hex key/ Allen wrench
- 9/64" hex key/ Allen wrench
- 9/16" wrench or small adjustable wrench

Cam Handle

Remove the Nyloc Nut from Swager Tool's Cam using a 9/16" wrench (Photo 1).

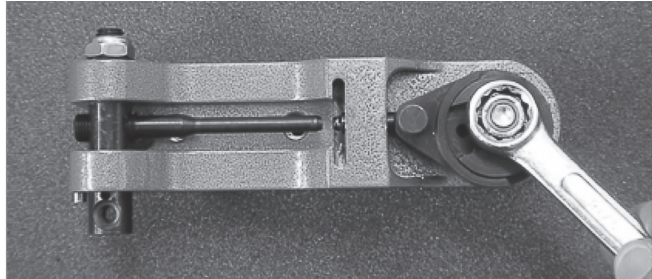


Photo 1. Cam Nyloc Nut

Place the Cam Handle over the Cam Bolt aligning the small holes in the Handle and Cam. Install the 8-32 x 1/2" long SHCS and tighten securely with a 9/64" hex key/ Allen wrench. (Photo 2).

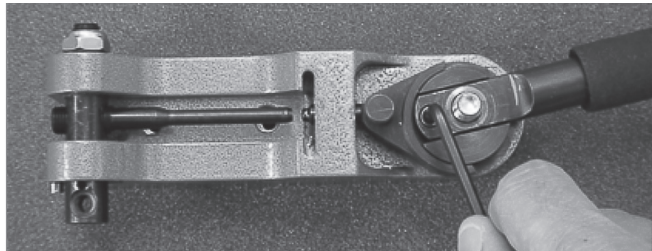


Photo 2. Cam Handle Assembly

Verify the head of the Cam Bolt is inside the hex-shaped pocket on the bottom side of the Swager. Reinstall and tighten the Nyloc Nut ensuring that the Cam is still free to rotate.

⚠ CAUTION Do not over-tighten!

Case Holder Pivot Handle

Thread the Pivot Handle into the Swager Tool's Pivot (Photo 3).

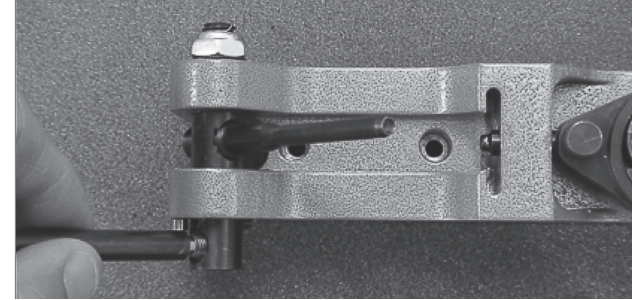


Photo 3. Install Pivot Handle

Rotate the Cam Handle CCW to retract the Swager Head. Slide the Case Base Plate into the Swager's slot (Photo 4). Make sure it is oriented with the bent tab up and toward the Cam.

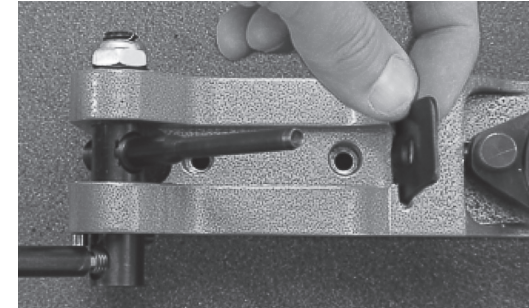


Photo 4. Install Case Base Plate

INSTALLATION

Reference the part schematic on page 14 for more information.

Mount the Swager Tool through the two holes along the center slot of the tool. Mount it to a flat stable surface as you see fit using appropriately sized hardware.

The Swager Tool can be installed onto an RCBS Accessory Base Plate-2 (#9280, sold separately) in holes labeled C & D using the provided 3/8-16 SHCS.

FUNCTION

First sort cases by brand before swaging. Different brands of cases have different web thickness which will affect the swaging repeatability.

Make sure the Swager Head is retracted by rotating the Cam Handle CCW. Rotate the Pivot Handle so the Swager Rod is pointing upward at an angle. Next, place the mouth of the case over the Swager Rod and slide it down until end of Rod is contacting the case web (Photo 5).

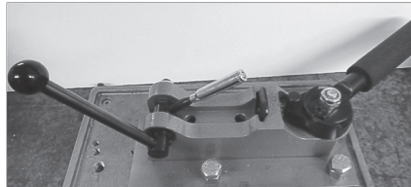


Photo 5. Placing case on Swager Rod

Then rotate the Pivot Handle to lower the case down into the Tool to align the Primer Pocket with the Swager Head (Photo 6). Adjust the Swager Rod's alignment per **Swaging Rod Alignment Adjustment** section of this manual (see **ADJUSTMENT** section for more information)

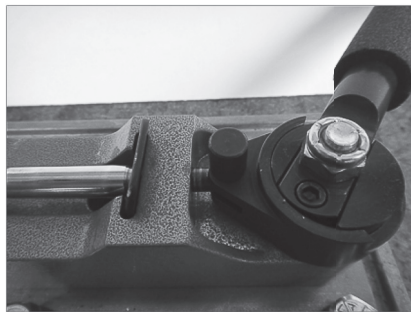


Photo 6. Align case with Swager Head

CAUTION If the Swager Rod is set too close to the Swager Head, it will bend the Rod during the swaging operation. Proceed slowly making minor modifications until the correct distance is established.

Adjust the Swager Rod's depth per **Swaging Depth Adjustment** section of this manual (see **ADJUSTMENT** section for more information)

Rotate the Cam Handle CW (clockwise) firmly until a hard stop is felt. This will force the Swager Head into the Primer Pocket (you will feel resistance). Rotate the Cam Handle CCW and unload case. Inspect the Primer Pocket to insure the Crimp Ring is removed and the edge is radiused.

ADJUSTMENT

Note: Reference the part schematics on page 14 of this booklet for more information.

Swaging Rod Alignment Adjustment

The Swager Rod's 'Stop' position (when it is horizontal) can be adjusted slightly to compensate for Primer Pocket alignment with the Swager Head. Start by inserting case over the Swager Rod then lower the Pivot Handle to the 'Stop' position. Next, loosen the SHCS on the side of the Pivot Assembly ~1/2 turn using a 3/32" hex key/ Allen wrench (Photo 7). Rotate the Case Holder Pivot to the desired position. Carefully check your adjustment to verify the Swager Head is aligned and operating correctly. Tighten the SHCS.



Photo 7. Adjusting horizontal "stop" position

Swaging Depth Adjustment

CAUTION If the Swager Rod is set too close to the Swager Head, it will bend the Rod during the swaging operation. Proceed slowly making minor modifications until the correct distance is established.

The amount of material you swage on the Primer Pocket lip/ edge is controlled by the depth the Swager Head is inserted into the Pocket. Start by setting the Swager Rod's position so there is at least a 0.125" gap between it and the Swager Head (Photo 8). Swage a case and inspect the Primer Pocket. Adjust the Swager Rod's position in small increments until the desired amount of swaging is achieved. One full revolution of the Swager Rod will move it ~ .04 inches.

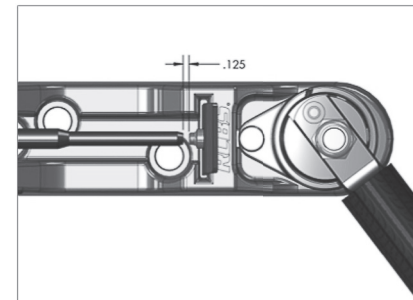


Photo 8.

Changing to Large Pocket Swaging

For swaging cases with large primer pockets, you must change the Swager Rod and Swager Head to large configurations.

With the Cam Handle in the CCW position, remove the Case Base Plate. Then raise the Pivot Handle to its vertical position (Swager Rod will be horizontal) and unscrew the Small Swager Rod using a 3/16" hex key wrench (Photo 9).

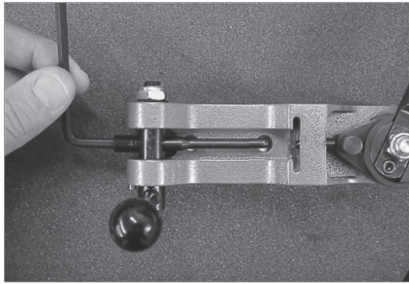


Photo 9. Loosen Swager Rod

Now pull the Swager Rod out of Pivot Shaft (Photo 10).

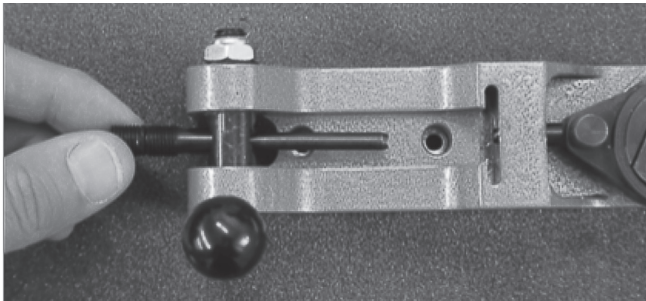


Photo 10. Remove Swager Rod

Next, remove the Swager Head Pin by pulling straight out of the Connecting Rod Clevis (Photo 11).

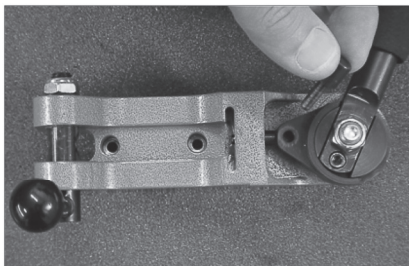


Photo 11. Pull Swager Head Pin

Now rotate the clevis and push the Small Swager Head out of the Swager Base (Photo 12).

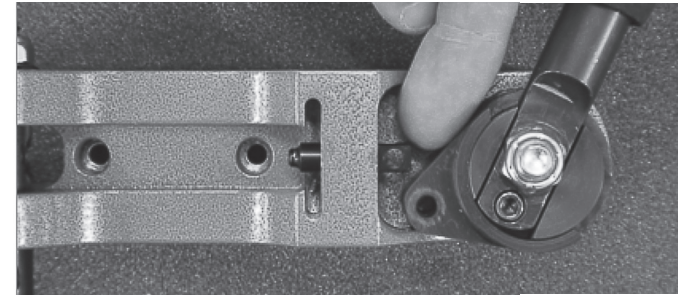


Photo 12. Remove Small Swager Head

Now reinstall the Large Swager Head into the Base (Photo 13).

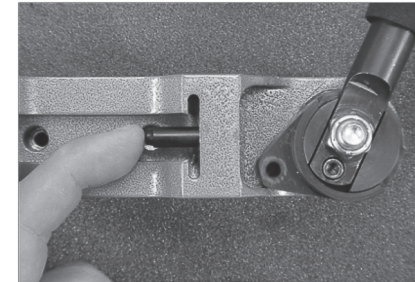


Photo 13. Install Large Swager Head

Align the hole in the Swager Head with the hole in the Connecting Rod Clevis and insert the Swager Head Pin (Photo 14).

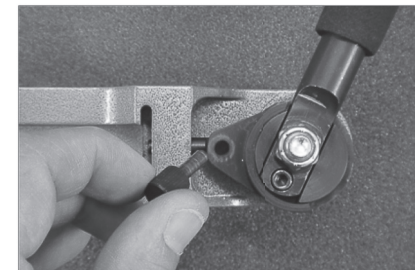


Photo 14. Install Swager Head Pin

Insert the Large Swager Rod through the Pivot Shaft (Photo 15) and tighten it using a 3/16" hex key wrench (Photo 16).

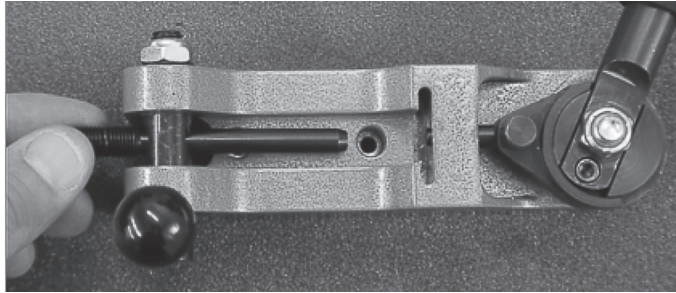


Photo 15. Install Large Swager Rod

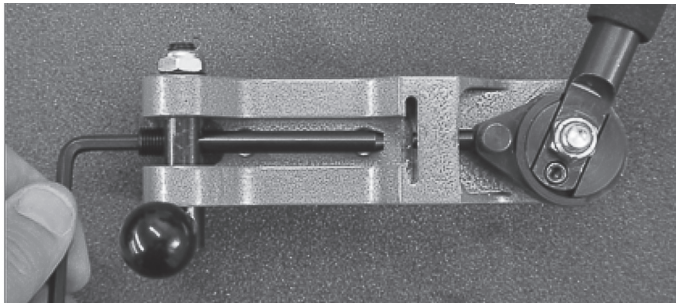


Photo 16. Tighten Large Swager Rod

Insure the Cam Handle is rotated CCW to retract the Swager Head. Slide the Case Base Plate into the Swager's slot (Photo 17). Make sure it is oriented with the bent tab up and toward the Cam.

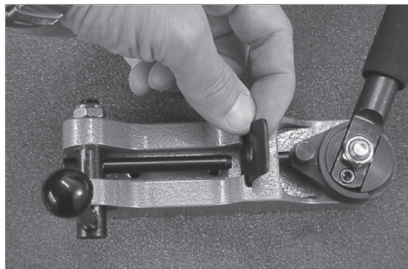


Photo 17. Install Case Base Plate

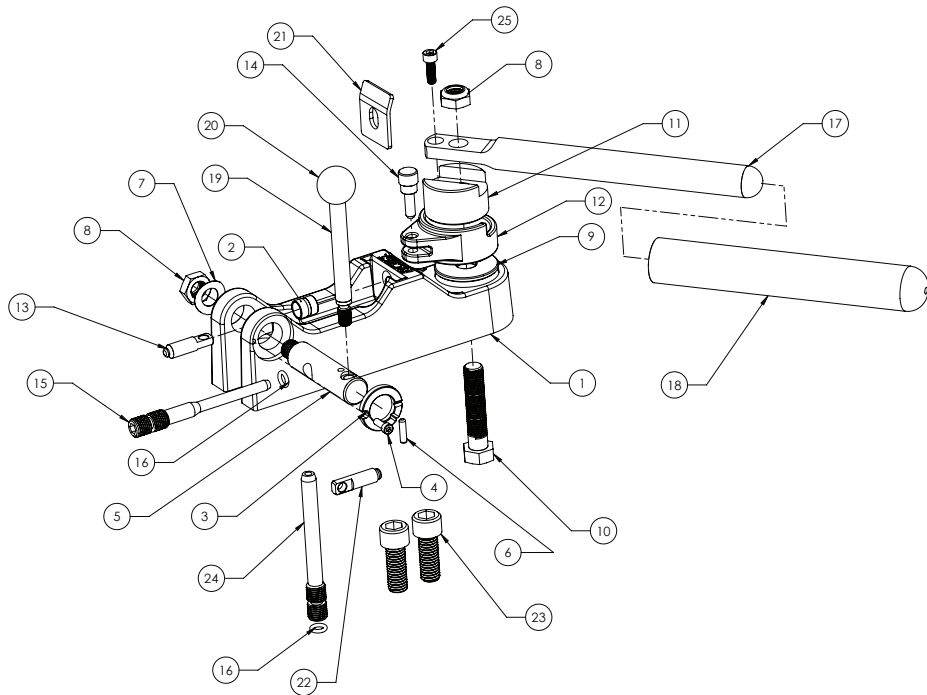
Adjust the Swager Rod's position per **ADJUSTMENT** section of this manual.

MAINTENANCE

Reference the part schematic on page 14 for more information.

Occasionally clean your Primer Pocket Swager—Bench Tool to keep the pivot points free of debris, brass shavings, etc. Dissassemble and clean under the Cam Assembly and the Swager Head. As needed, apply a small amount of lubricant/grease between the Cam and Cam Plate (item 9) to reduce wear and friction between the rotating parts of the Cam Assembly

Swager Head and Swager Rod should be clean, dry, and free of lubricants/ oils during operation to keep contaminants out of your Primer Pocket and cases.



ITEM #	PART #	DESCRIPTION	QTY.
1	709300	Base	1
2	709309	Head Bushing	1
3	709313	Adjustment Disc	1
4	188109	5-40 x 3/8L SHCS	1
5	709311	Pivot	1
6	109200	Dowel Pin 1/8 diam x 1/2 L	1
7	109260	Bow Washer 3/8 ID	1
8	186106	3/8-16 Nyloc Nut	2
9	709304	Cam Plate	1
10	109202	Cam Bolt	1
11	709302	Cam	1
12	709301	Connecting Rod	1
13	709307	Swager Head Small	1
14	709308	Swager Head Pin	1
15	709310	Case Rod Small	1
16	109204	Oring #009	2
17	709303	Cam Handle	1
18	109201	Foam Handle Grip	1
19	709312	Pivot Handle	1
20	180054	Handle Knob	1
21	709305	Case Base Plate	2
22	709306	Swager Head Large	1
23	109203	3/8-16 x 1L SHCS	2
24	709314	Case Rod Large	1
25	187227	8-32 x 1/2L SHCS	2