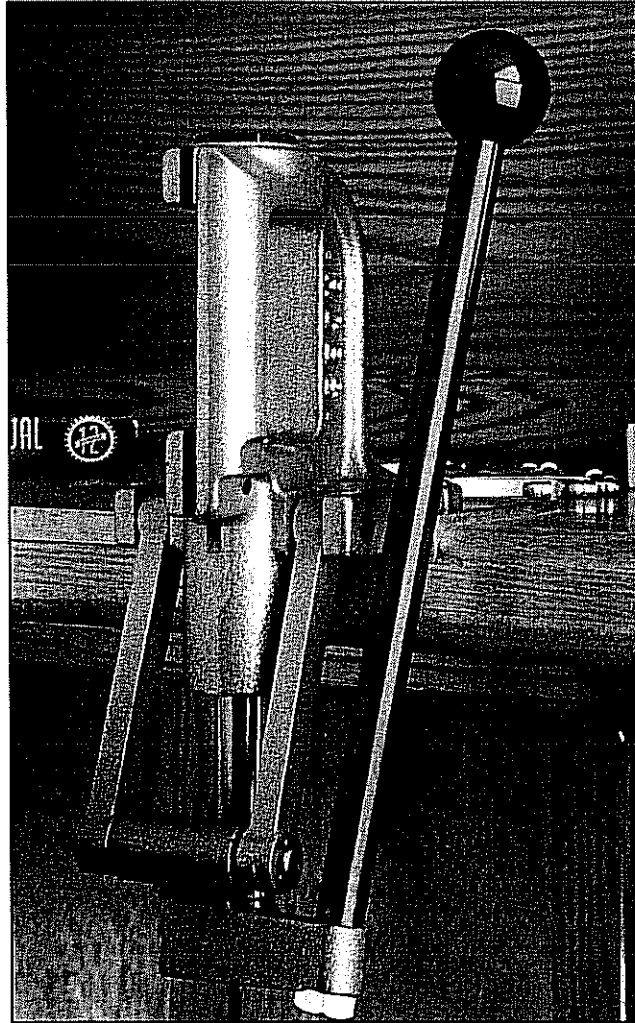


# ***RCBS***

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## **ROCK CHUCKER PRESS**



P R O D U C T   I N S T R U C T I O N S

# SAFETY

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

When reloading, some 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 tool. Don't take shortcuts.
- 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. Avoid haste—load at a leisurely pace.
- Always wear adequate eye protection.
- If any unusual resistance is encountered when moving the operating handle, STOP IMMEDIATELY and investigate the cause. To proceed against unusual resistance may damage equipment and/or cause serious personal injury!

## 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.

## PRIMERS AND POWDER

- Store primers and powder beyond the reach of children and away from heat, dampness, open flames, and electrical equipment.
- DO NOT use primers of unknown identity.
- Keep primers in original factory container until ready to use. Return unused primers to the same factory packaging for safety and to preserve their identity.
- 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 use any powder unless its identity is positively known. Discard all mixed powders and those of uncertain or unknown 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.
- Before charging cases, settle the powder in the powder hopper. Load and check the weight of at least ten charges. This will assure you that the correct powder charge is being loaded.
- After a reloading session ends, pour the remaining powder back in its original factory container. This will preserve the identity and shelf life of the powder.
- DO NOT smoke while handling powder or primers.

## 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.

Since RCBS has no control over the choice of components, the manner in which they are assembled, the use of this press, 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 press.

## INTRODUCTION

The Rock Chucker Press has been designed specifically for heavy-duty reloading, case forming, and bullet swaging. It is engineered to handle the largest and longest magnums down to .17 caliber. Because of the compound leverage system the Rock Chucker Press can full-length resize cases with less effort than other presses neck size. Using RCBS Case Forming Dies this press will form .30-06 cases into many other calibers.

By combining the famous RCBS block "O" frame with the compound leverage system, the Rock Chucker will develop work pressure that would spring other presses out of alignment. To insure alignment under these pressures, the Rock Chucker press frame provides a full four inches of ram-bearing surface to rigidly support the one inch diameter main ram. The compound leverage action is similar to that of a power punch press. As the handle pressure increases, the leverage is compounded, building up maximum work pressure in the main ram as it travels the full length of the stroke. The toggle block, links and pins are engineered to withstand the punishment of heavy-duty reloading. The handle is made of solid steel and features a comfortable ball-type handle grip. The Rock Chucker Press has standard  $\frac{7}{8}$ -14 thread for most popular reloading dies and accessories.

## ACCESSORIES

The Rock Chucker Press is designed to utilize the Universal Primer Arm. This priming system is equipped with interchangeable primer plugs and sleeves for seating large and small primers. A unique, flat return spring helps prevent the spent primers from jamming the primer arm action.

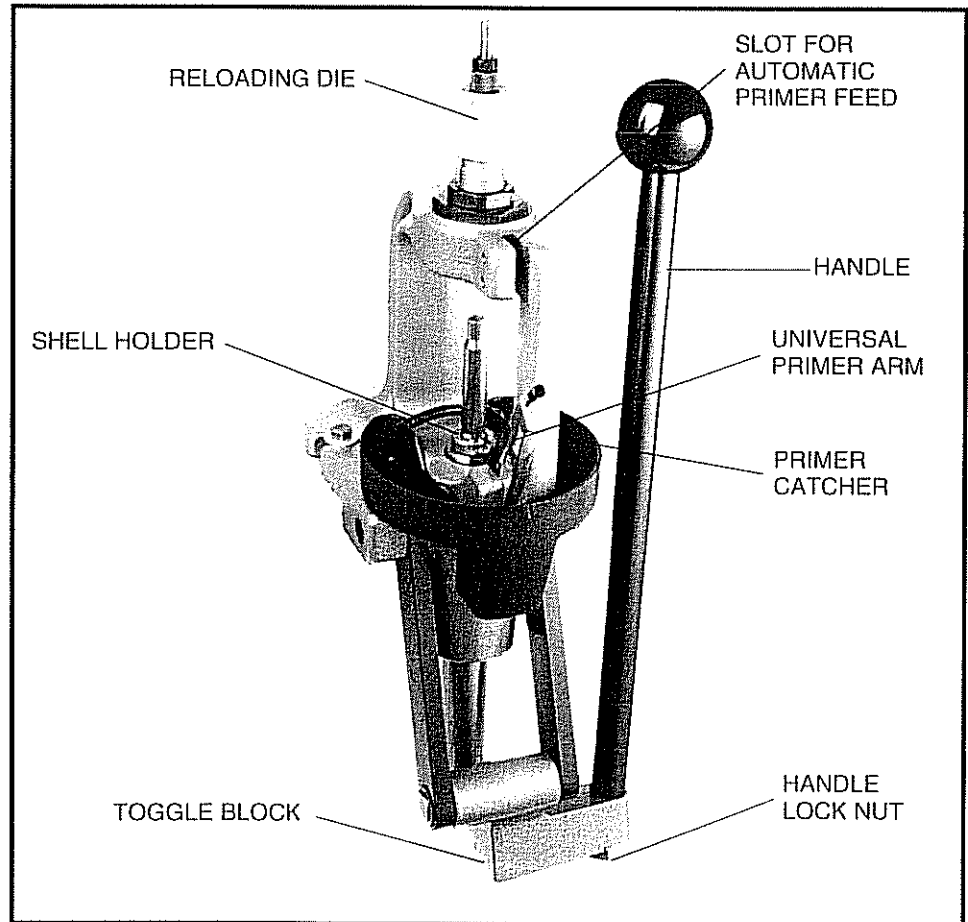
The Primer Catcher keeps spent primers from dropping to the floor and is easily removed for emptying.

## UNPACKING

Unpack the press carefully and look for the items listed below. Refer to the parts list for identification.

- Press
- Handle
- Primer Catcher
- Accessory Pack: Contains handle nut, Universal Primer Arm, large and small primer plugs and sleeves, coil spring, setscrews for Automatic Primer Feed and case resizing lubricant

Report any shortage to your dealer.



## INSTALLATION

Mount the Rock Chucker Press to a sturdy workbench or table with two  $\frac{3}{8}$ " bolts of sufficient length to penetrate the press base and bench.

Install the threaded portion of the handle through the toggle block. Attach the handle nut and tighten firmly. The handle nut must remain tight at all times to avoid damage to the handle and toggle.

Install the Universal Primer Arm as shown in photos #1 and #2. Make sure the flat return spring stays in the milled slot on the press.

Carefully remove the locking clip from the front of the primer catcher. Slip the primer catcher into place around the press frame and secure with the locking clip in the slots provided. See photo #3.

The Rock Chucker press ram accepts removable type shell holders. To install, insert the shell holder into the ram and twist slightly to the left. To remove, twist slightly to the right. See photo #4.

## WARNING

**TO AVOID INJURY, READ AND FOLLOW THESE SAFE PRIMING PRACTICES.**

**DO NOT ATTEMPT TO PRIME MILITARY CARTRIDGE CASES WITH CRIMPED PRIMER POCKETS UNTIL THE CRIMP HAS BEEN REMOVED WITH A COUNTER SINK, A SPECIAL REAMER OR BY SWAGING. PRIMERS SEATED INTO CRIMPED POCKETS ARE SUBJECT TO DEFORMATION WHICH CAN CAUSE MISFIRES AND EVEN DETONATION DURING SEATING WHICH CAN CAUSE SERIOUS PERSONAL INJURY.**

**DO NOT ATTEMPT TO SEAT PRIMERS AGAINST EXCESSIVE RESISTANCE WHICH MIGHT CAUSE DETONATION AND POSSIBLE SERIOUS PERSONAL INJURY. CHECK TO BE CERTAIN THAT THE CASE WAS NOT PREVIOUSLY PRIMED, THAT THE FIRED PRIMER WAS REMOVED, THAT A PORTION OF THE PRIMER CUP WALL MIGHT STILL BE IN THE PRIMER POCKET AND THAT YOU ARE USING THE CORRECT SIZE PRIMER.**

**DO NOT MODIFY THE PRIMING SYSTEM IN ANY MANNER OR ATTEMPT TO USE SIMILAR PARTS OR PRIMING SYSTEMS FROM OTHER MANUFACTURERS. TO DO SO COULD RESULT IN PRIMER DETONATIONS RESULTING IN SERIOUS PERSONAL INJURY.**

**NEVER SEAT A PRIMER INTO A POWDER CHARGED CASE.**

**DECAPPING LIVE PRIMERS IS EXTREMELY DANGEROUS AND IS NOT RECOMMENDED.**

## PRIMING

To use the Universal Primer Arm, first make sure the correct size primer plug and sleeve are in position. To install the primer plug and sleeve, drop the primer plug through the sleeve. Place the spring on the primer arm body. Thread the plug and sleeve into the primer arm body and tighten the assembly with a small nail or paper clip through the cross hole in the primer plug. Do not over tighten. Check from time to time to be sure the primer plug remains tight.

To prime, simply place the correct size primer, anvil side up, into the primer sleeve. See photo #5. Next, lower the press handle and push the primer arm into the slot cut in the main ram. See photo #6. Then, gently and slowly raise the press handle. As the case is drawn out of the die it will be lowered onto the live primer, seating it to the bottom of the primer pocket.

After the primer is seated, lower the press handle enough to let the primer arm out of the slot. Be sure not to lower the handle too far or the decapping pin in the die will punch the live primer back out. Now raise the handle and remove the case from the shell holder. Always inspect the primed case to make certain the primer is properly seated.

The two setscrews in the Accessory Pack are for installation of the optional Automatic Primer Feed. This and other accessories for the Rock Chucker Press are available from your gun dealer.

## MAINTENANCE

This press was lubricated at the factory. However, it is necessary to lubricate all moving parts from time to time with gun oil. If rust spots appear, swab lightly with gun oil and wipe dry. Care should be taken not to apply oil where it could come in contact with primer pockets or primers. Oil will deactivate primers. It is a good practice to clean the press prior to lubrication to remove grit and other residue. You will note the ease at which the epoxy enamel paint wipes clean. This finish is impervious to oil and is extremely chip and fade resistant.



Photo 1

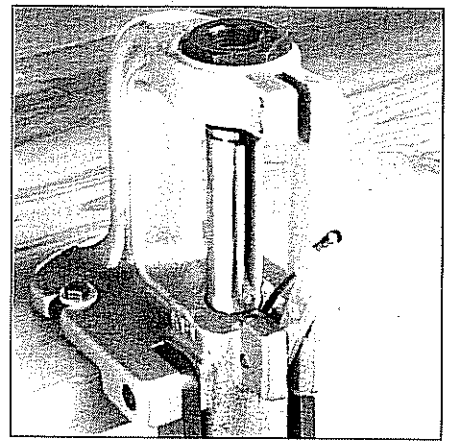


Photo 2

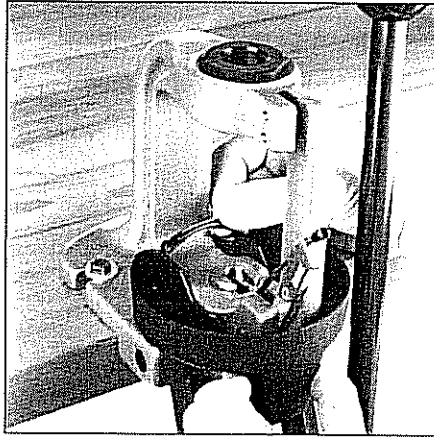


Photo 3

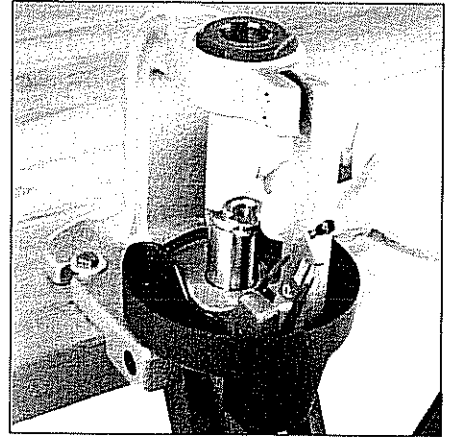


Photo 4

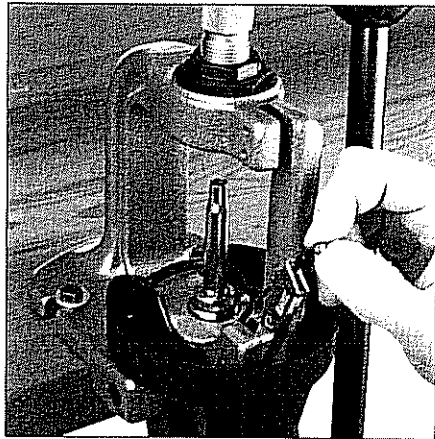


Photo 5

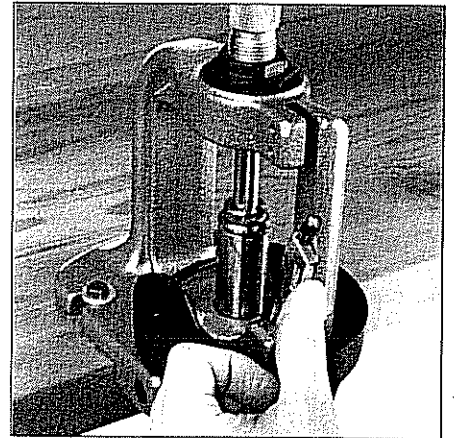
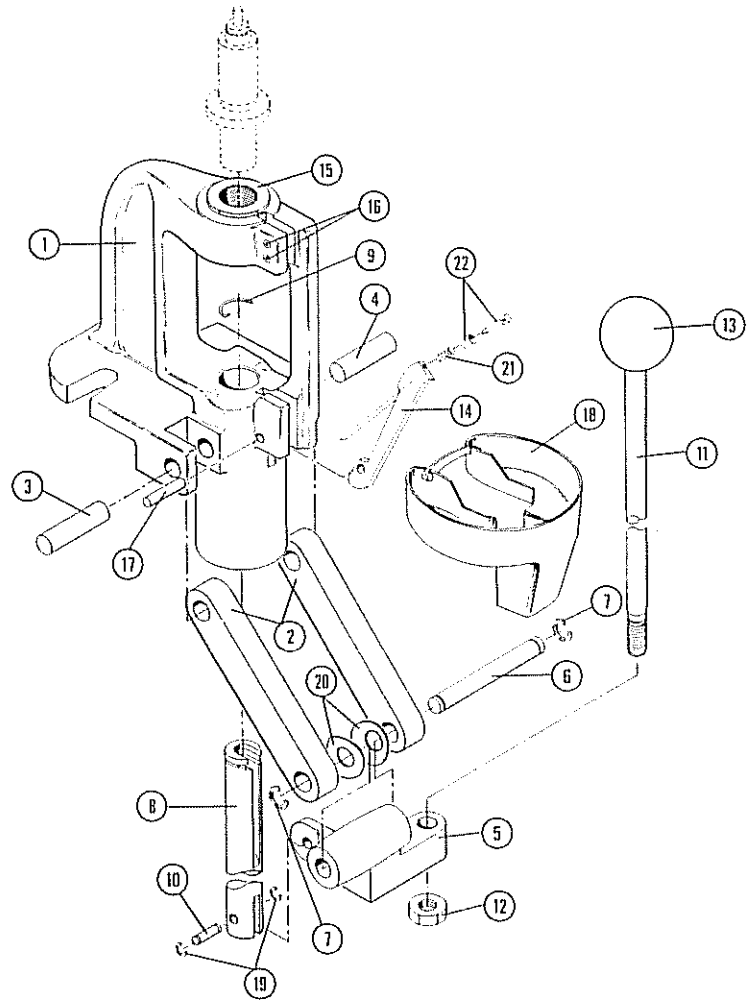


Photo 6

# ROCK CHUCKER PRESS PARTS LIST



| Key | Part# | Description                  | Key | Part# | Description                   |
|-----|-------|------------------------------|-----|-------|-------------------------------|
| 1   | 09124 | Frame                        | 14  | 09551 | Universal Primer Arm Body     |
| 2   | —     | Linkage Arm (2)              | 15  | 09138 | Bushing                       |
| 3   | 09127 | Linkage Arm Pin, Left        | 16  | 09099 | Setscrew, 10/32" x 1/4" (2)   |
| 4   | 09128 | Linkage Arm Pin, Right       | 17  | 09113 | Universal Primer Arm Pin      |
| 5   | 09145 | Toggle Block                 | 18  | 09114 | Primer Catcher                |
| 6   | —     | Toggle Block Pin             | 19  | 09143 | Retaining Ring 3/8" Small (2) |
| 7   | 09105 | Retaining Ring 1/2" (2)      | 20  | 09144 | Bow Washer 134-5-20 (2)       |
| 8   | 09134 | Main Ram Assembly            | 21  | 09508 | Coil Spring                   |
| 9   | 09111 | Shell Holder Ram Clip Spring | 22  | 09552 | Plug and Sleeve, Large        |
| 10  | 09142 | Main Ram Pin                 | 22  | 09553 | Plug and Sleeve, Small        |
| 11  | 09120 | Handle                       | —   | 86855 | Spade Handle Assembly         |
| 12  | 09136 | Handle Nut                   | —   | 09122 | Bail Handle Assembly          |
| 13  | 09121 | Handle Ball                  | —   | 09550 | Universal Primer Arm          |

# REFERENCE TABLE

| Caliber                          | Shell Holder Number | Primer Plug & Sleeve Size | Caliber                      | Shell Holder Number | Primer Plug & Sleeve Size |
|----------------------------------|---------------------|---------------------------|------------------------------|---------------------|---------------------------|
| .17 Remington                    | 10                  | Small                     | .308 Norma Magnum            | 4                   | Large                     |
| .218 Bee                         | 1                   | Small                     | .308 Winchester              | 3                   | Large                     |
| .22 Hornet                       | 12                  | Small                     | 7.5mm Schmidt-Rubin          | 2                   | Large                     |
| .22 K-Hornet                     | 12                  | Small                     | 7.62mm x .39-.308/311        | 32                  | Large                     |
| .22 PPC                          | 32                  | Small                     | 7.62mm x 54R Russian         | 13                  | Large                     |
| .22 Remington Jet                | 6                   | Small                     | 7.65mm x 53 Belgian Mauser   | 3                   | Large                     |
| .22 Savage High-Power            | 2                   | Large                     | 7.7mm x 58 Japanese Arisaka  | 3/2                 | Large                     |
| .22-250 (.22 Varminter)          | 3                   | Large                     | .32 Automatic (7.65mm Auto)  | 17                  | Small                     |
| .220 Swift                       | 11                  | Large                     | .32 H&R Magnum               | 23                  | Small                     |
| .221 Remington Fire Ball         | 10                  | Small                     | .32 Smith & Wesson Long      | 23                  | Small                     |
| .222 Remington                   | 10                  | Small                     | .32 Winchester Special       | 2                   | Large                     |
| .222 Remington Magnum            | 10                  | Small                     | .32-20 Winchester            | 1                   | Small                     |
| .223 Remington (5.56mm)          | 10                  | Small                     | .32-40 Winchester            | 2                   | Large                     |
| .224 Weatherby Magnum            | 27                  | Small                     | 8mm Remington Magnum         | 4                   | Large                     |
| .225 Winchester                  | 11                  | Large                     | 8mm-06                       | 3                   | Large                     |
| 5.6mm x 50 Rimmed                | 6                   | Small                     | 8mm x 57 Mauser (8mm Mauser) | 3                   | Large                     |
| .240 Weatherby Magnum            | 3                   | Large                     | 8mm x 68S Magnum             | 34                  | Large*                    |
| .243 Winchester                  | 3                   | Large                     | .338 Winchester Magnum       | 4                   | Large                     |
| 6mm PPC                          | 32                  | Small                     | .340 Weatherby Magnum        | 4                   | Large                     |
| 6mm Remington (.244 Remington)   | 3                   | Large                     | .348 Winchester              | 5                   | Large                     |
| .25 Auto (.25 ACP)               | 29                  | Small                     | .35 Remington                | 9                   | Large                     |
| .25-06                           | 3                   | Large                     | .35 Whelen                   | 3                   | Large                     |
| .25-20 Winchester                | 1                   | Small                     | .350 Remington Magnum        | 4                   | Large                     |
| .25-35 Winchester                | 2                   | Large                     | .356 Winchester              | 2                   | Large                     |
| .250 Savage (.250-3000 Savage)   | 3                   | Large                     | .357 H&R                     | 2                   | Large                     |
| .256 Winchester Magnum           | 6                   | Small                     | .357 Magnum                  | 6                   | Small                     |
| .257 Roberts                     | 3/11                | Large                     | .357 Remington Maximum       | 6                   | Small                     |
| .257 Roberts Improved .40"       | 3/11                | Large                     | .357 Sig                     | 27                  | Small                     |
| .257 Weatherby Magnum            | 4                   | Large                     | .358 Norma Magnum            | 4                   | Large                     |
| .264 Winchester Magnum           | 4/26                | Large                     | .358 Winchester              | 3                   | Large                     |
| 6.5 Remington Magnum             | 4                   | Large                     | 9mm Luger                    | 16                  | Small                     |
| 6.5mm-06                         | 3                   | Large                     | 9mm Makarov                  | 16                  | Small                     |
| 6.5mm x 50 Japanese Arisaka      | 15                  | Large                     | 9mm x 21                     | 16                  | Small                     |
| 6.5mm x 52 Cascade               | 9                   | Large                     | 9mm x 23 Winchester          | 16                  | Small                     |
| 6.5mm x 54 Mannlicher-Schoenauer | 9                   | Large                     | 9.3mm x 62 Mauser            | 3                   | *                         |
| 6.5mm x Swedish Mauser           | 2                   | Large                     | 9.3mm x 74R                  | 4                   | Large                     |
| 6.5mm x 57                       | 3                   | Large                     | .375 H&H Magnum              | 4                   | Large                     |
| 6.5mm x 68S                      | 34                  | Large*                    | .375 Winchester              | 2                   | Large                     |
| .270 Weatherby Magnum            | 4                   | Large                     | .378 Weatherby Magnum        | 14                  | Large                     |
| .270 Winchester                  | 3                   | Large                     | .38 Colt Super Auto          | 39                  | Small                     |
| .280 Remington (7mm Exp. Rem.)   | 3                   | Large                     | .38 Smith & Wesson           | 6                   | Small                     |
| .284 Winchester                  | 3                   | Large                     | .38 Special                  | 6                   | Small                     |
| 7mm Bench Rest Remington         | 3                   | Small                     | .380 Automatic (ACP)         | 10                  | Small                     |
| 7mm Remington Magnum             | 4/26                | Large                     | .38-40 Winchester            | 35                  | Large                     |
| 7mm Shooting Times Westerner     | 4                   | Large                     | .38-55 Winchester & Ballard  | 2                   | Large                     |
| 7mm Thompson/Center Ugalde       | 10                  | Small                     | .40 S&W                      | 27                  | Small                     |
| 7mm Weatherby Magnum             | 4                   | Large                     | .40-65 Stihlsh Sharps-408"   | 14                  | Large                     |
| 7mm-08 Remington                 | 3                   | Large                     | .400 CorBon                  | 3                   | Large                     |
| 7mm x 57 Mauser (7mm Mauser)     | 3/11                | Large                     | 10mm Auto                    | 27                  | Large                     |
| 7mm x 64 Brenneke                | 3                   | Large                     | .41 Action Express           | 16                  | Small                     |
| 7mm x 65 Rimmed                  | 26                  | Large                     | .41 Magnum                   | 30                  | Large                     |
| 7-30 Waters                      | 2                   | Large                     | .416 Remington Magnum        | 4                   | Large                     |
| .30 M-1 Carbine                  | 17                  | Small                     | .416 Rigby                   | 37                  | Large                     |
| .30 Luger (7.65mm Luger)         | 16                  | Small                     | .44 Magnum                   | 18                  | Large                     |
| .30 Mauser (7.65mm Mauser)       | 16                  | Small                     | .44 Special                  | 18                  | Large                     |
| .30 Remington                    | 19                  | Large                     | .444 Mathin                  | 28                  | Large                     |
| .30-06 Springfield               | 3                   | Large                     | .44-40 Winchester            | 35                  | Large                     |
| .30-30 Winchester                | 2                   | Large                     | .45 Automatic (.45 ACP)      | 3                   | Large                     |
| .30-338 Winchester Magnum        | 4                   | Large                     | .45 Auto Rim                 | 8                   | Large                     |
| .30-378 Weatherby Magnum         | 14                  | Large                     | .45 Colt                     | 20                  | Large                     |
| .30-40 Krag                      | 7                   | Large                     | .45 Winchester Magnum        | 36                  | Large                     |
| .300 H&H Magnum                  | 4                   | Large                     | .45-70 U.S. Government       | 14                  | Large                     |
| .300 Savage                      | 3                   | Large                     | .454 Casull                  | 20                  | Large                     |
| .300 Weatherby Magnum            | 4                   | Large                     | .458 Winchester Magnum       | 4                   | Large                     |
| .300 Winchester Magnum           | 4/26                | Large                     | .460 Weatherby Magnum        | 14                  | Large                     |
| .303 British                     | 7                   | Large                     | .50 Action express           | 35                  | Large                     |
| .303 Savage                      | 21                  | Large                     | .50-70 U.S. Government       | 31                  | Large                     |
| .307 Winchester                  | 2                   | Large                     |                              |                     |                           |

*Note: When two Shell Holders are listed, the most popular is shown first. It may be necessary to use the alternate, depending on the manufacturer and/or lot of cases being used.*

*Note: \* Cases may be headstamped. Depinning and priming must be done by hand. If cases were formed from cases having boxer-type primers, use the appropriate Shell Holder for that caliber.*

# SHELL HOLDER CHART

Note: RCBS Shell Holder numbers do not correspond to those of other manufacturers.

**09201 #1**  
 218 Bee  
 25-20 Winchester  
 32-20 Winchester  
 8mm French Lebel Revolver

**09202 #2**  
 22 Savage High Power  
 25-35 Winchester  
 6.5mmx55 Swedish Mauser  
 7-30 Waters  
 30-30 Winchester  
 307 Winchester  
 7.5mmx54 French MAS  
 7.5mmx55 Schmidt-Rubin  
 7.7mmx58 Japanese Ariska  
 32 Winchester Special  
 32-40 Winchester  
 356 Winchester  
 375 Winchester  
 38-55 Winchester & Ballard

**09203 #3**  
 22-250 Remington (22Varminter)  
 240 Weatherby Magnum  
 243 Winchester  
 6mm Remington (244 Remington)  
 25-06  
 250 Savage (250-3000 Savage)  
 257 Roberts  
 257 Roberts Improved (40")<sup>[1]</sup>  
 260 Remington  
 6.5mm-06  
 6.5mmx57  
 270 Winchester  
 280 Remington (7mm Exp. Rem.)  
 284 Winchester  
 7mm Bench Rest Remington  
 7mm-08 Remington  
 7mmx57 Mauser (7mm Mauser)  
 7mmx64 Brenneke  
 30-06 Springfield  
 300 Savage  
 308 Winchester  
 7.65mmx53 Mauser (Belgian)  
 8mm-06  
 8mmx57 Mauser (8mm Mauser)  
 338-06  
 35 Whelen  
 358 Winchester  
 9.3mmx62 Mauser  
 38 Casull  
 400 CorBon  
 45 Automatic (.45 ACP)

**09204 #4**  
 257 Weatherby Magnum  
 264 Winchester Magnum<sup>[3]</sup>

270 Weatherby Magnum  
 7mm Remington Magnum<sup>[3]</sup>  
 7mm Shooting Times Westerner  
 7mm Weatherby Magnum  
 30-338 Winchester Magnum  
 300 Holland & Holland Magnum  
 300 Weatherby Magnum  
 300 Winchester Magnum<sup>[3]</sup>  
 308 Norma Magnum  
 8mm Remington Magnum  
 338 Winchester Magnum  
 340 Weatherby Magnum  
 350 Remington Magnum  
 9.3mmx74 Rimmed  
 375 Holland & Holland Magnum  
 416 Remington Magnum  
 450 Marlin  
 458 Winchester Magnum

**09205 #5**  
 348 Winchester

**09206 #6**  
 22 Remington Jet  
 5.6mmx50 Rimmed  
 357 Magnum  
 357 Remington Maximum  
 38 Smith & Wesson  
 38 Special

**09207 #7**  
 30-40 Krag  
 303 British

**09208 #8**  
 45 Auto Rim

**09209 #9**  
 6.5mmx52 Carcano  
 6.5mmx54 Mannlicher-Schoenauer  
 35 Remington

**09210 #10**  
 17 Remington  
 221 Remington Fire Ball  
 222 Remington  
 222 Remington Magnum  
 223 Remington (5.6mm)  
 7mm Thompson/Center Ugalde  
 380 Auto Pistol

**09211 #11**  
 220 Swift

**09212 #12**  
 22 Hornet  
 22 K-Hornet

**09213 #13**  
 7.62mmx54R Russian

**09214 #14**  
 30-378 Weatherby Magnum  
 338-378 Weatherby Magnum  
 338 Lapua  
 378 Weatherby Magnum  
 40-65 Shiloh-Sharps  
 45-70 U.S. Government  
 460 Weatherby Magnum

**09215 #15**  
 6.5mmx50 Japanese Arisaka

**09216 #16**  
 30 Luger (7.65mm Luger)  
 30 Mauser (7.65mm Mauser)  
 356 TSW  
 9mm Luger  
 9mm Makarov  
 9mmx21  
 9mmx23 Winchester

**09217 #17**  
 30 M1 Carbine  
 32 Auto (7.65mm Automatic)

**09218 #18**  
 44 Magnum  
 44 Special

**09219 #19**  
 30 Remington

**09220 #20**  
 45 Colt  
 454 Casull

**09221 #21**  
 303 Savage

**09222 #22**  
 11mm Mauser  
 43 Spanish

**09223 #23**  
 32 Harrington & Richardson Mag  
 32 Smith & Wesson Long

**09224 #24**  
 405 Winchester

**09225 #25**  
 8mm Nambu

**09226 #26**  
 7mmx65 Rimmed

**09227 #27**  
 357 SIG  
 40 S & W  
 10mm Auto

**09228 #28**  
 444 Marlin

**09229 #29**  
 25 Automatic (25 ACP)

**09230 #30**  
 41 Magnum

**09231 #31**  
 50-70 U.S. Government

**09232 #32**  
 6mm PPC  
 7.62mmx39

**09233 #33**  
 50 Action Express

**09234 #34**  
 6.5mmx68S  
 8mmx68S Magnum

**09235 #35**  
 38-40 Winchester  
 44-40 Winchester

**09236 #36**  
 45 Winchester Magnum

**09237 #37**  
 416 Rigby

**09238 #38**  
 7mm Rem Ultra Mag  
 300 Rem Ultra Mag  
 338 Rem Ultra Mag  
 375 Rem Ultra Mag

**09239 #39**  
 38 Colt Super Automatic

**09240 #40**  
 475 Linebaugh 1.400"

**09241 #41**  
 404 Jeffery

**09242 #42**  
 376 Steyr

Important: The boxed numbers shown in the table indicate the following:  
 [1] Shoulder angle of improved version.  
 [2] Some Browning, DWM Lapua, Norma, RWS and Sako cases require an RCBS #26 Shell Holder.

# RCBS

PRECISIONEERED® RELOADING EQUIPMENT

Customer Service

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

Hours: Monday - Friday, 6:30am - 4:00pm Pacific Time

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