

RCBS®

Pro 2000® Auto Index Upgrade Kit



PRODUCT INSTRUCTIONS

⚠ WARNING

Before using the RCBS Pro 2000 Auto Index Upgrade Kit, 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 – 3:00 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.

LIMITED LIFETIME WARRANTY

Your Pro 2000 Auto Index Upgrade Kit is warranted to be free from defects in material or workmanship for as long as the original owner owns it. 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 Pro 2000 Auto Index Upgrade Kit 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 Pro 2000 Auto Index Upgrade Kit to:

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

Warranty services cannot be provided without meeting the above requirements.

THIS LIMITED LIFETIME 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 LIMITED LIFETIME 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 press. 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 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

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

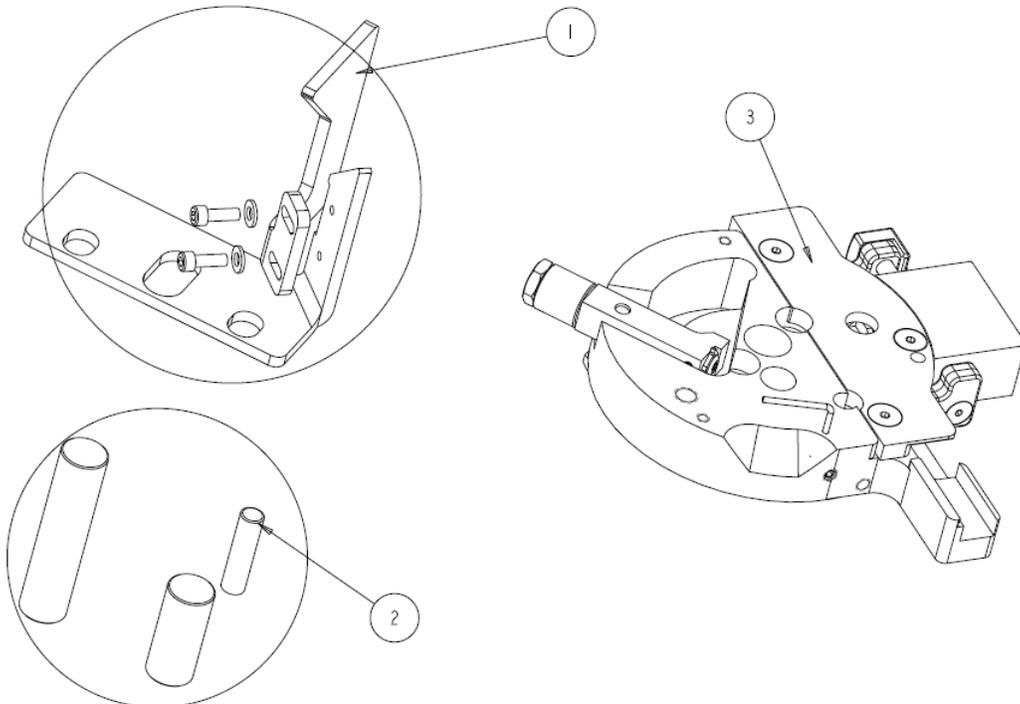
- Keep complete records of reloads. Apply a descriptive label to each box showing the date produced, and the primer, powder and bullet used. Labels for this purpose are packed with SPEER bullets.
- Never attempt to guess at the identity of your ammunition.

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

UNPACKING

Refer to the list below to Identify parts as you unpack your Pro 2000 Auto Index Upgrade Kit.

- Parts bag #1 – Diagram 1
 - Lower Cam Bracket
 - Upper Cam Bracket
 - 5-40 X 3/8" Socket Head Cap Screw (2)
 - #5 Flat Washer (2)
- Parts bag #2 – Diagram 2
 - Set up Gage Pin #2, Short
 - Set up Gage Pin #1, Long
 - Locating Pin
- Auto Index Shell Plate Holder Assembly – Diagram 3



PRO2000 AUTO INDEX UPGRADE KIT INSTALLATION

1. Safely remove and store all reloading components from your Pro2000 Progressive Press. Remove the Die Plate to allow for more room when converting the press.



Photo 2

2. If you used the four 1/4" mounting holes to secure your Pro2000 to your loading bench, you will have to remove the front left bolt. This hole is used to locate the base of the auto Index Cam bracket. The auto Index Cam bracket is secured to the press by using the left mounting slot in the casting.

3. Insert the Locating Pin into the front left 1/4" mounting hole and place the auto Index Cam bracket over the Pin. See Photo 1(A).

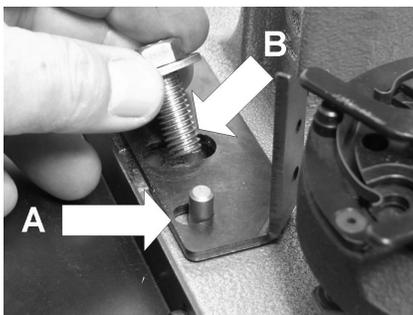


Photo 1

4. Use a 3/8" bolt, length to be determined by the thickness of your reloading bench (mounting hardware not included), to mount the auto Index Cam bracket to the left side mounting slot of the Pro2000 casting. Do not completely tighten this bolt at this time. See photo 1(B).

5. Using a 7/16" wrench (not included), remove the Primer Seat Plug assembly from the bottom of the Shell Plate Holder assembly and set aside. See photo 2.

6. Using a 5/64" hex wrench, loosen the SHSS in the shell plate holder to remove the Spent Primer Tube, Return Spring and Return Spring Plate. Set these parts aside. See photo 3.



Photo 3

7. Using a 5/64" hex wrench, loosen the SHSS in the shell plate holder and move the Case Eject Wire away from the Shell Plate. See photo 4.

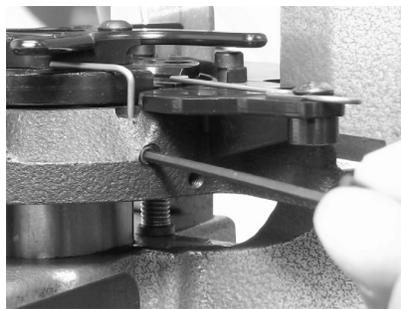


Photo 4

8. Using a 5/16" hex wrench, remove the Shoulder Bolt that secures the Shell Plate to the Holder. Remove the Shell Plate from the press. See photo 5.



Photo 5

9. Using a 3/16" hex wrench, remove the two SHCS that secure the Shell Plate Holder to the ram. Remove the Shell Plate Holder assembly from the press. **CAUTION: Do not lose the Detent Ball and Spring when removing the assembly from the ram.** See photo 6.



Photo 6

10. Remove the three Funnel Head Cap Screws that secure the Retaining Bracket to the Shell Plate Holder Assembly and transfer these parts over to the Auto Index Shell Plate Holder Assembly. See Photo 7

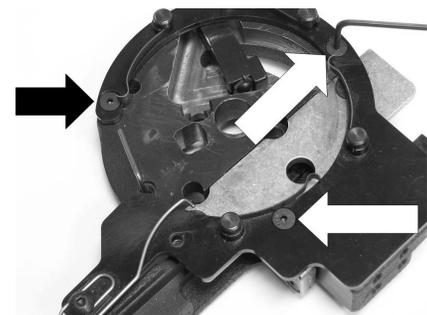


Photo 7

11. Place the Auto Index Shell Plate Holder onto the Ram and secure the two SHCS with a 3/16" hex wrench.

12. Re-install the detent spring and ball into shell plate holder. See photo 8.

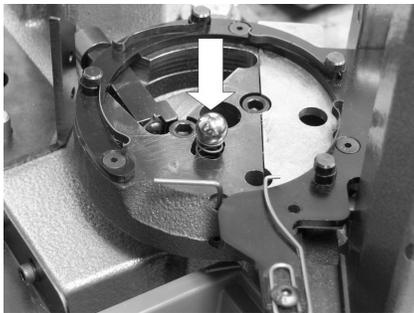


Photo 8

13. Remove the Star Wheel from your Shell Plate. Install the Shell Plate onto the Auto Index Shell Plate Holder assembly with the shoulder bolt and 5/16" hex wrench. **Before tightening the Shoulder Bolt, make sure that the Index Bar Pawl is engaged in one of the bottom detents of the Shell Plate.** See photo 9. **Manually cycle the Index Bar a few times to make sure that the Shell Plate rotates properly** NOTE: You cannot use the Auto Index with the Index Star Wheel attached to the Shell Plate.



Photo 9

14. Loosen the 5/64" SHSS in the Shell Plate Holder Assembly. Adjust Case Eject Wire to point to the rear of the shell holder slot and tighten SHSS using the included 5/64" hex key wrench. See photo 10.



Photo 10

15. Install Large or Small Primer Plug Assembly, depending on need, into the bottom of the Shell Plate Holder.

16. Tighten the Primer Plug assembly with a 7/16" open-end wrench (not included). See photo 2.

17. Insert a case into station 1. Loosen the 3/32" BHCS, adjust station 1 Case Holder Spring to barely touch the rim of the case, hold the Spring in place and tighten BHCS. Use included 3/32" hex key wrench. Remove the case. See photo 11. *NOTE: This adjustment must be made each time you change shell plates.*



Photo 11

18. Raise the Press Ram slightly to place the shorter #2 Gage Pin under the Shell Plate Holder. This Gage is used to prop up the Shell Plate Holder allowing you to use both hands to adjust the auto Index Cam bracket. Push the Index Bar to the right; orient the Index Cam bracket to the right until it firmly touches the Index Bar. See parts diagram to identify parts. *NOTE: You may have to loosen the right side press mounting bolts to properly position the Index Cam bracket to touch the Index Bar Roller.* Keeping pressure on the Index Bracket against the Index Bar; secure the left side press mounting bolt to lock the lower bracket in place. Remove and store the #2 Gage Pin. See photo 12.

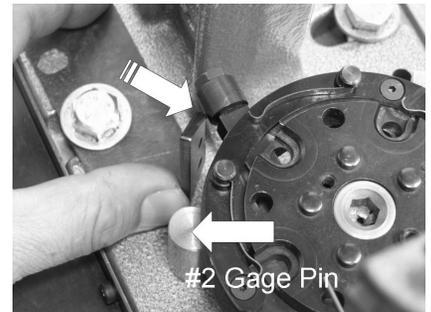


Photo 12

19. Raise the Ram slightly and place the longer #1 Gage Pin under the Shell Plate Holder. Attach the upper Return Cam bracket using the two SHCS and washers. Pull the Index Bar to the left and bring the upper Return Cam bracket left to firmly touch the Bar. Secure the two SHCS. Remove and store the #1 Gage Pin. See photo 13.

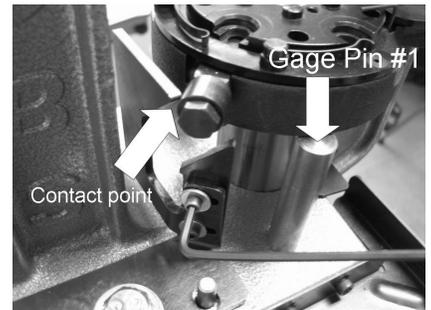


Photo 13

20. Raise the Ram to the top of the press stroke and re-install the Return Spring Plate, Spring, Spent Primer Tube and Bottle Assembly by securing the SHSS in the side of the Shell Plate Holder.

21. The auto indexing feature should now be properly installed and adjusted. Cycle the handle a few times to insure that the Shell Plate is indexing correctly. If it does not index correctly, review steps 18 and 19 again.

PRESS OPERATION

We recommend that several cases be completely reloaded one at a time before proceeding with full operation. This will help you to become familiar with the loading process. *NOTE: Place bullets in bullet tray and empty cases in the ammo bin on the left front of the bullet tray. Loaded rounds will fall into the ammo bin on the right front of bullet tray. See photo A.*



Photo A

Step 1:

Install an APS primer strip. With the handle in the full back position, feed the strip; hook end first and anvil side up, until it stops firmly against the Primer Plug. See strip in photo B. You should hear two “clicks” before contacting the primer plug.

Release pressure on the handle and let it return to the “neutral” position. *NOTE: Use a full stroke with each cycle of the press.* *NOTE: Strips can be connected for continuous loading. See photo C.*

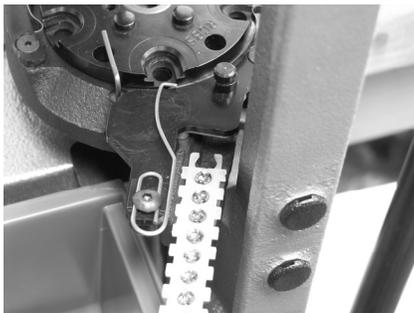


Photo B



Photo C

Step 2:

Place a case into Station 1, and lower the handle. The case will be sized and the spent primer will be ejected. Now raise the handle to index the shell plate and firmly press the handle all the way to the rear to insert a new primer into the case. Allow the handle to return to the neutral position. See photo D.

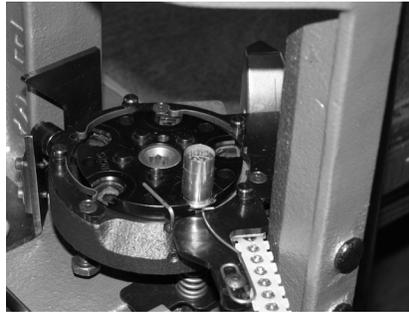


Photo D

The primer is seated in the last 1/2” of the handle stroke below the shell plate neutral position. Remove the case and inspect primer depth. Adjust primer stop if necessary. See photo E.

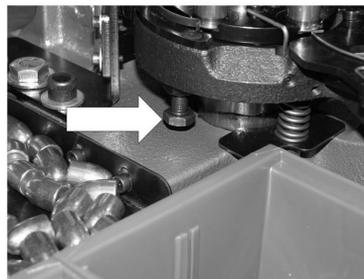


Photo E

NOTE: Primer depth can be set by the primer depth adjustment screw. Primers can also be seated by “feel” by simply adjusting the stop out of the way.

Step 3:

Lower the handle and raise case into Station 2 to expand and flare/bell the mouth of the case. *NOTE: Station 2 is for the expanding of straight wall rifle and pistol cases and is an empty station for bottleneck rifle and pistol cases.*

Raise the handle to index the press.

Step 4:

Cycle the handle to raise the case into Station 3 (Powder Measure) to charge the sized and primed case with powder. Remove the case to verify that the powder charge is correct. Reinsert the case into the Shell Plate. Check every fifty rounds to ensure that the powder charge has not changed. *NOTE: Refer to Powder Measure instructions for adjustment.*

Step 5:

Cycle the handle to move the case through Station 4. *NOTE: This is an extra station that allows options such as a Powder Checker Die or Lock-Out Die or to seat and crimp bullets in separate operations. You may choose to have this as an empty station.*

Step 6:

Insert a bullet onto the case mouth; cycle the handle to seat and crimp the bullet and the loaded cartridge will be ejected into the cartridge box. See photo F.

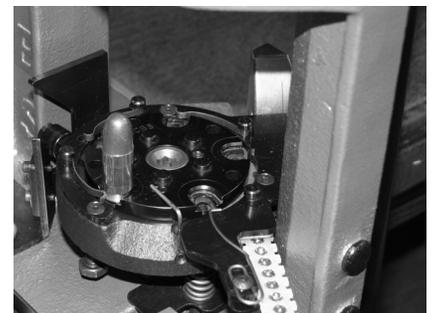


Photo F

PRO 2000 with AUTO INDEXING - OPERATING PROCEDURE

Now that you have read the instructions and are familiar with your upgraded Pro 2000 with Auto Indexing, you are ready to reload! Based on our experience, we will explain the most efficient way to use your upgraded Pro 2000 with Auto Indexing. You may choose to change your technique as you become more accustomed to the function of this tool, but for now, we strongly suggest you use the following operating procedure.

Place your bullets in the bullet tray and your empty cases in the left ammo bin. The right ammo bin will be used to catch the loaded ammunition as it is ejected from the press.

With the handle in the up and full back position, insert the primer strip into the APS Priming System. Push the primer strip in hook end first and anvil side up until it stops firmly against the Primer Plug. Now release the handle and it will return to the neutral position.

With your right hand on the handle ball, pick up an unsized case with your left hand and place it into Station 1. Be sure the case holder spring is adjusted to barely touch the rim of the case. Now smoothly pull the handle down. This will size and deprime the case in Station 1. Raise the handle to the top of the stroke and smoothly push the handle to the rear, the Shell Plate will automatically index and you will be able to feel the primer being seated in the case.

You now have a sized and reprimed case in Station 2. Insert another unsized case into Station

1 and lower the handle. Again, this will size and deprime the case in Station 1, while at the same time, expand the case in Station 2. Raise the handle and push to the rear to reprime the case and then let the handle return to the neutral position.

You now have a sized and reprimed case in Station 2 and an expanded case in Station 3. Insert another case into Station 1 and lower the handle. Station 1 and 2 will repeat the same operation while the powder charge is being dispensed in Station 3. Next, raise the handle and push to the rear and then let it return to the neutral position.

You now have a sized and reprimed case in Station 2, an expanded case in Station 3, and a powder charged case in Station 4. Insert another case in Station 1 and lower the handle. Stations 1, 2 and 3 will repeat the same operations.

Station 4 may perform a variety of operations, depending on your preferred reloading technique. In the case of rifle calibers, this may be an empty station or you may use a Powder Checker Die. In the case of pistol calibers, you may select to seat in Station 4 and crimp in Station 5. As another option, if loading pistol rounds, you may use an RCBS Lock-Out Die in Station 4, then, seat and crimp in one operation in Station 5.

Whichever method you choose is fine. Versatility is a big advantage of owning a five station progressive press.

By now you should be getting the hang of the sequence of operating your Pro 2000 Auto index. Once the Shell Plate has a case in all five stations, the basic operating procedure remains the same time after time. Always follow this same loading procedure:

Bullet, Case, Size, Index, Prime.

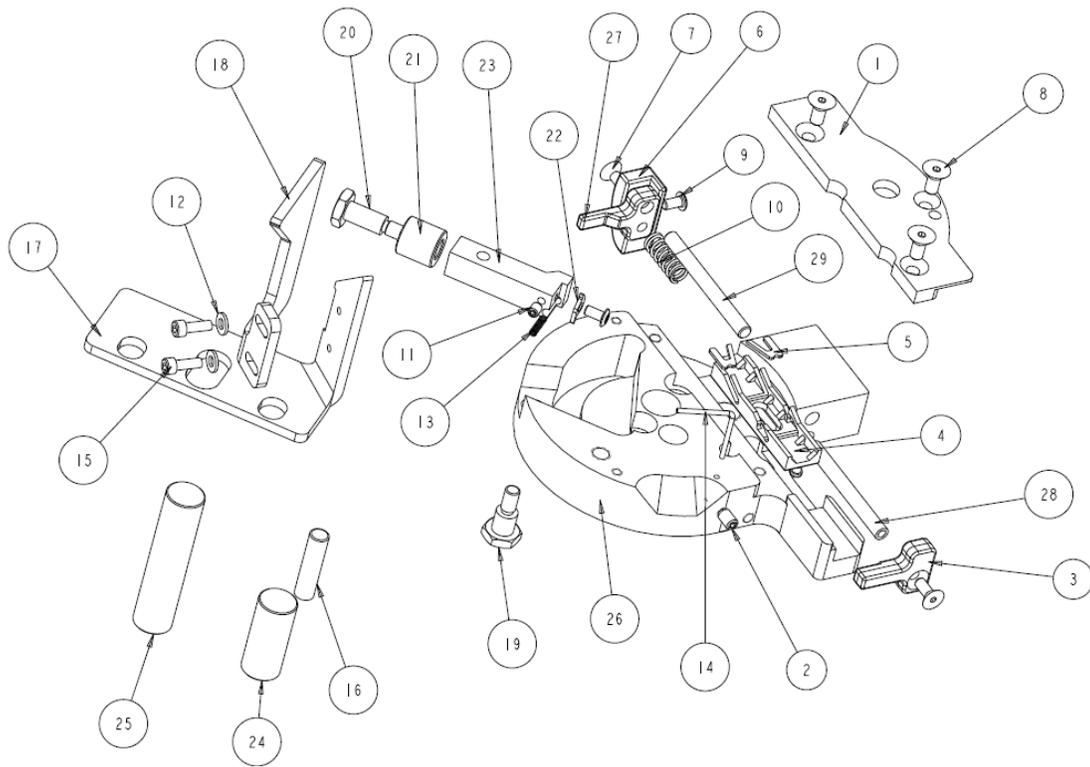
It will help you to repeat these words to yourself each time you cycle the press:

Bullet, Case, Size, Index, Prime:

1. Bullet: Place bullet on case under seat die.
2. Case: Place unsized case in Station 1.
3. Size: Lower Handle and size case.
4. Index: Raise Handle to Index the Shell Plate.
5. Prime: Push handle to rear to prime case in Station 2.

This is the sequence that will be repeated over and over as you operate your Pro 2000 Auto Index Upgraded Press. By now, everything should be working great. If not, reread this portion of the instructions. If you are still experiencing problems, give us a call, we'd be glad to help.

IMPORTANT: Your upgraded Pro 2000 Auto Index has been designed and manufactured to be an automatic indexing reloading press. Any alteration or attempt to alter the function of this press will void any and all warranties offered by RCBS. We specifically warn against any attempt to convert this press to any motorized method of operation.



PRO 2000 AUTO INDEX KIT			
Item #	Part #	Quantity	Description
1	102505	1	PRO 2000 PRIMING PLATE
2	109509	1	8-32 x 1/4 L SET SCREW
3	109700	1	PRO 2000 PUSHER BRKT LEFT
4	186264	1	APS HPT STRIP PUSHER
5	186265	2	APS HPT DETENT
6	187202	1	PRO 2000 CAM GUIDE
7	187215	2	6-32 x 3/8 FLAT SHCS
8	187218	3	8-32 x 3/8 FLAT SHCS
9	187222	2	5-40 x 1/4 BHCS
10	187225	1	APS STRIP ADVANCE SPRING
11	187238	1	5-40 x 1/8 SHSS
12	187239	2	#5 FLAT WASHER
13	187241	1	INDEX PAWL SPRING
14	188038	1	CASE EJECT SPRING
15	188109	2	5-40 x 3/8 SHCS
16	709113	1	LOCATING PIN
17	788682	1	INDEX CAM
18	788683	1	RETURN CAM
19	788684	1	INDEX SHOULDER BOLT
20	788685	1	ROLLER SHOULDER BOLT
21	788686	1	ROLLER
22	788687	1	INDEX PAWL
23	788693	1	INDEX BAR
24	788699	1	GAUGE PIN #2
25	788700	1	GAUGE PIN #1
26	788701	1	AUTO INDEX SHELL PLATE HOLDER
27	788908	1	PRO 2000 PUSHER BRKT RIGHT
28	788915	1	PRO 2000 PUSHER ROD
29	788960	1	PRO 2000 PUSHER ROD LONG



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, 6:30am - 3:00pm Pacific Time
(hours may vary)

e-mail: rcbs.tech@atk.com or visit our website at www.rcbs.com

RCBS 605 Oro Dam Blvd. Oroville, CA 95965

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