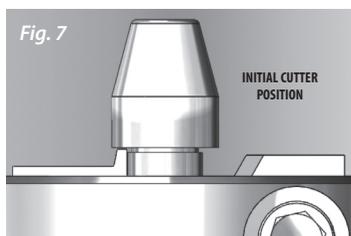
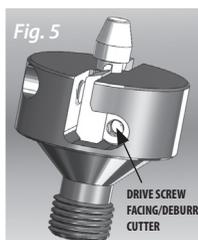
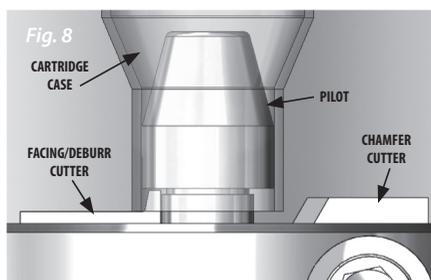




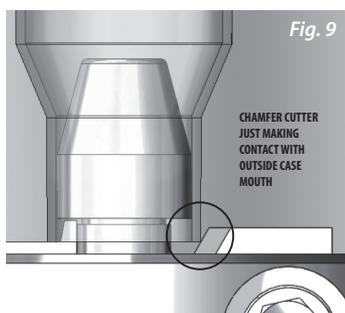
3. Using a 3/32" hex wrench, rotate the two Drive Screws to position the cutters as shown, in **Fig. 5-7**. Clockwise rotation advances cutter towards pilot and counterclockwise rotation advances cutter away from pilot. This initial adjustment is to move the cutters into a position that will allow for the cutter to be set for the desired case to be trimmed.



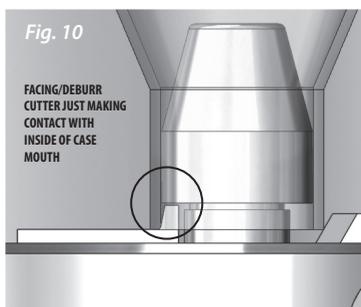
4. Using a sized and expanded cartridge case, place over the pilot and onto the Facing/Deburr Cutter as shown in **Fig. 8**. This case will be used to adjust cutters.



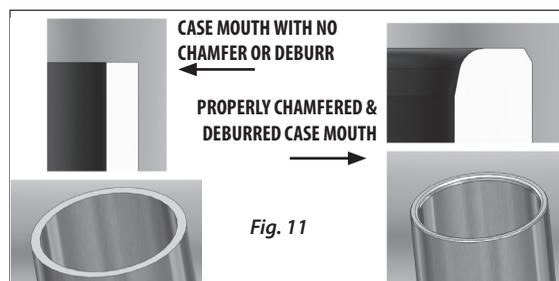
5. Using a 3/32" hex wrench rotate Drive Screw to **position Chamfer cutter to where it is just making contact with the outside of the cartridge case**, this will aid in supporting the case. Once cutter is positioned properly secure cutter in place with the 10-32 SHSS (**see Fig. 9**).



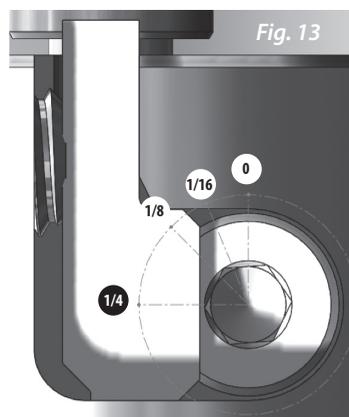
6. Using a 3/32" hex wrench rotate Drive Screw moving the Facing/Deburr Cutter outward to where the cutter just makes contact with the inside of the case mouth, **DO NOT EXCEED**. Once cutter is positioned properly secure cutter in place with the 10-32 SHSS (**see Fig. 10**).



7. Test cutter on case to ensure all cutting edges are making contact and brass is being removed on the face and on the inside and outside of case mouth, to the desired amount. **DO THIS BY HAND TO ENSURE THE CUTTERS ARE SET PROPERLY AND TO PREVENT DAMAGING BRASS IF CUTTERS WERE SET INCORRECTLY.** Excessive chamfer and deburr will produce an undesirable sharp edge, if this happens readjustment of cutter is required (**see Fig. 11 & 12**).



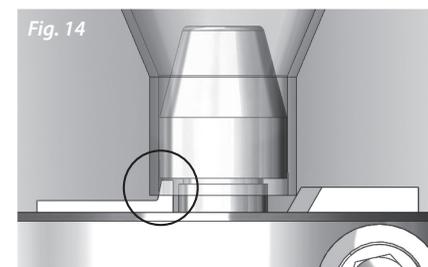
8. Slight adjustments may be necessary to increase/decrease chamfer on outside of case mouth or increase/decrease deburr on inside of case mouth. To do this simply loosen the 10-32 SHSS securing cutter and rotate drive screw in or out using small increments (1/16-1/8 of a turn) to reposition cutter, using the 3/32" hex wrench. The drive screw has a thread pitch of 48, meaning one complete revolution will advance the cutter in or out by .020", thus a quarter turn of the drive screw will yield .005" of inch of travel inward or outward (**see Fig. 13**).



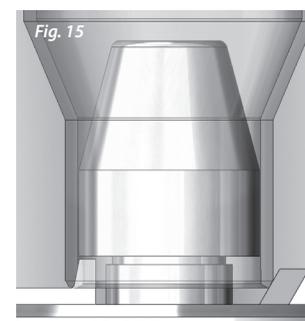
**ADJUST CUTTERS BY ROTATING DRIVE SCREW, 1/16-1/8 OF A TURN**

**Note:** before the 10-32 SHSS screw is loosened, remove the backlash in the thread by leaving the 10-32 setscrew tightened against cutter and rotate the drive screw in desired direction. *Example: If there is still a burr on the inside of the case mouth the cutter would need to be moved outward to remove more material from inside case mouth.* Leaving the 10-32 setscrew secured in place, rotate the drive screw counterclockwise taking up any backlash in thread. **DO NOT FORCE** as soon as you feel resistance stop, all backlash is removed. Loosen the 10-32 SHSS screw and rotate drive screw 1/16 of a complete rotation. Secure the 10-32 SHSS and repeat **Step 7**.

9. After test cut has been completed and desired results are achieved, ensure both 10-32 SHSS are secured in place.
10. It is important to note to not remove too much material, i.e., **do not force the cutters into the cartridge case as this will generate an excessive amount of material being removed and will damage the cartridge case.** Use small adjustments and when slight resistance is felt, i.e., cutter is in contact with case, secure cutter and conduct a test cut.
11. If the desired results are not being achieved using this process, and more of deburr or chamfer is desired, this can be done by simply lifting the case off of the cutting face slightly before advancing the cutters, then advance cutter until cutting edge is in contact with case (**see Fig. 14 & 15**). This will allow the cutter to be positioned to remove more material. If using this method perform a test cut by hand, if unable to rotate cutter and produce cut, then too much material is trying to be removed so the cutters will need to be repositioned to take less material. Remember small rotational adjustments are all that is required; 1/16-1/8 of a turn.



**RAISE CASE OFF FACING CUTTER AND ADVANCE CUTTERS, TO GENERATE MORE AGGRESSIVE CUT. THIS IS DONE IF UNABLE TO ACHIEVE DESIRED REMOVAL OF MATERIAL WITH STANDARD PROCESS.**



12. After cutter has been set correctly and desired results have been achieved it is time to place your VLD 3-Way Cutter on your Case Trimmer. Follow your case trimmer instructions for proper removal and installation of cutters.
13. Once cutter has been installed on the trimmer, and before desired trim to length is set, insert the same case previously tested by hand and run a test cut on trimmer, at low RPM. Inspect case and ensure cutter is producing the desired cut, if not readjust cutter as needed, following instructions above.
14. When all adjustments have been made and cutter is producing the desired results, loosen the 8-32 SHSS securing the pilot and lower pilot onto the top post of the Facing/Deburr cutter. Tighten the 8-32 SHSS to secure the pilot. Next, adjust your trimmer to the appropriate cartridge case trim to length and begin trimming your cases.

**PLEASE SEE STEP 15 ON OTHER SIDE OF SHEET**