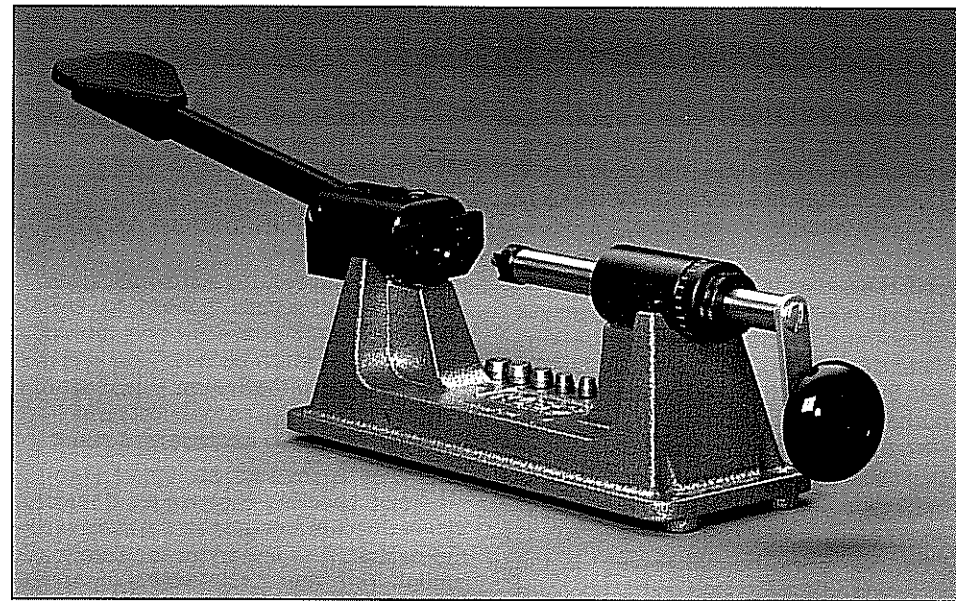


RCBS[®]

**TRIM PRO[®] MANUAL
CASE TRIMMER**



PRODUCT INSTRUCTIONS

IMPORTANT

Before using the RCBS Trim Pro Case Trimmer, read this instruction manual carefully to learn how to safely operate the product. Failure to properly operate the trimmer may result in personal injury and/or equipment damage. If you have read these instructions and still do not understand some operation, call us at 800-533-5000 or 530-533-5191 and a technician will assist you. Our customer service hours are listed on the back of this instruction manual.

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.

A 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.
- Don't 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. Develop a reloading routine to avoid mistakes. Don't 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 use of the SPEER Reloading Manual.
- OBSERVE ALL WARNINGS ABOUT THE USE OF MAXIMUM LISTED LOADS.

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.
- This product is intended for use by persons familiar with proper handloading practices and their own loading equipment. If you are uncertain as to the operation of any of your equipment, contact the equipment manufacturer for additional assistance.

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

GENERAL INFORMATION ABOUT CASE TRIMMING

Repeated firing, resizing and reloading results in the brass of a case "flowing" toward the case mouth and the case therefore growing in length. A case which becomes too long may enter the throat of the firearm. If this happens, the case cannot release the bullet correctly on firing and pressures increase as a result.

Whenever a case grows longer than the maximum specified case length, it must be trimmed back to a length near the minimum for the caliber. It is important for safety and chambering that cases not exceed the maximum specified length. There are case length specifications for every cartridge and a current copy of the SPEER Reloading Manual is an excellent source for this information.

Certain characteristics that reloaders look for in a case trimmer are:

- Consistent repeatable trim lengths . . . the trimmer should trim cases to the same length.
- The trimmer should cut the case mouth "squarely" which means the cut is perpendicular to the longitudinal axis of the

case. We have retained the case pilot system to align cases for "square" cuts.

- The trimmer should be easy to set-up and adjust.
- It should be quick and easy to change from one caliber to another.

The trimmer should be easy to use and not cause pain or discomfort.

Your new Trim Pro has been designed to address each of these needs. We have also included a section on how to adjust a case trimmer to trim cases to the correct length. Call us if you have any questions at any time while assembling or operating this equipment. Our toll-free number is: 1-800-533-5000. Our regular phone number is: 530-533-5191.

TRIM PRO MANUAL CASE TRIMMER INSTRUCTIONS

Carefully unpack the manual case trimmer and look for the following items:

- Trim Pro Manual Case Trimmer
- Case Holder Accessory Handle
- Handle pin
- Four Trim Pro shell holders and nine case trimmer pilots if purchased as a "kit"

There are several options for mounting the case trimmer to the work surface. One method is to mount the case trimmer directly to a sturdy bench or table, using three screws of sufficient length to hold it securely in place. See photo #1. Another way is to use an RCBS Accessory

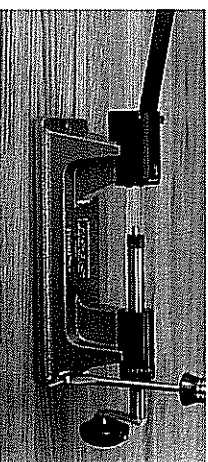


Photo #1

Base Plate-2 (#09280) or the RCBS Case Trimmer Stand (#90360). The Accessory Base Plate-2 is a great way to save time and eliminate a benchtop full of holes. The plate attaches to your bench. Then, using the pre-tapped, letter-coded holes you can quickly mount or unmount a variety of RCBS tools, including a Trim Pro Manual Case Trimmer.

The RCBS Case Trimmer Stand is designed specifically to hold the Rotary Case Trimmer, Rotary Case Trimmer-2 or the Trim Pro Manual

Case Trimmer. In addition to a sturdy mounting surface, the stand provides more working room for hand clearance. There is also storage space for extra Trim Pro shell holders, case trimmer pilots, cutter heads, etc. See photo #2.

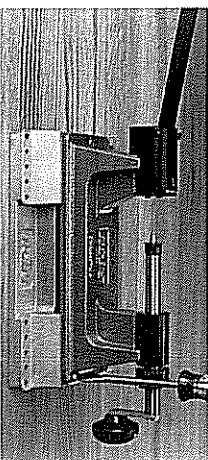


Photo #2

After mounting the case trimmer to a solid surface, attach the case holder handle by slipping the end into the slot of the handle support and inserting the knurled pin. See photo #3.

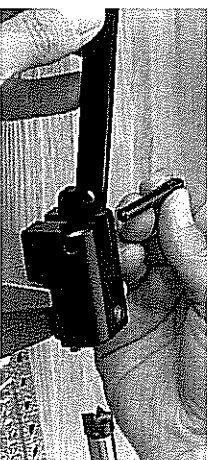


Photo #3

Next, select the proper shell holder. Refer to the Reference Table beginning on page 7. Trim Pro shell holders use the same numbering system as the shell holders used with RCBS loading dies. So, if you are reloading 30-06 cases (which takes a #3 shell holder) you would use a #3 Trim Pro shell holder in the trimmer. Hold the shell holder with the "RCBS" letters and number stamp facing the cutter and the slot facing up. Press down on the case holder handle and slide the "keyholes" in the shell holder over the two matching posts on the case holder, making sure the shell holder slips down firmly into position. See photo #4. Check to be certain the shell holder is properly aligned on the posts before you start to trim cases.



Photo #4

To insert a case, press down on the case holder handle and place the rim of the case between the shell holder and the face of the case holder. See photo #5. Release the pressure on the handle and the case will be securely held in position for trimming.

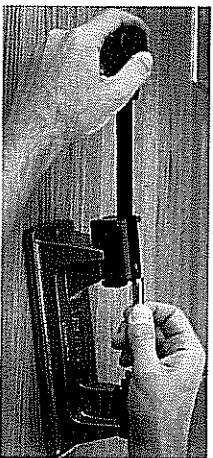


Photo #5

Now, attach the appropriate case trimmer pilot. See photo #6. Pilots are interchangeable and available in a variety of sizes to fit most everything from a .17 caliber to a .45 caliber case. Each size of pilot is machined to the caliber of the resized case mouth. This snug fit helps eliminate case wobble and insures alignment of the case while it's being trimmed. If the case mouth fails to line up with the pilot, press down on the case holder handle and slide the pilot into the case mouth. Secure the pilot to the case trimmer cutter with the setscrew located on the side of the cutter.



Photo #6

CASE TRIMMER ADJUSTMENT

The first step in case trimming is determining whether the cases need to be trimmed. The RCBS dial caliper is an excellent companion for the case trimmer and will provide accurate case length measurements. Use the calipers to measure your cases. See photo #7. If any cases exceed the maximum length it is a good idea to trim all the cases in the lot so they are all a uniform length.

For example: Let's say you have measured your case and found it is over the maximum recommended length by 0.003". The suggested trim length is 0.010" less than the maximum length. You will need to remove

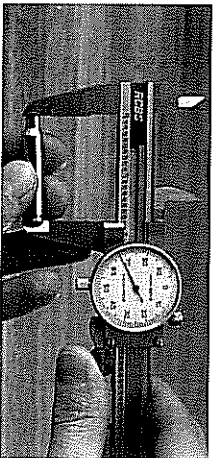


Photo #7

0.013" from the length of the case to bring the case back into specification. That is the 3 thousandths the case is over maximum case length and the ten thousandths under maximum that is the recommended trim length.

The trim length is controlled by the rough and fine adjustment bushings which are mounted on the cutter shaft. The fine adjustment bushing (the larger of the two) is threaded onto the rough adjustment bushing. See photo #8. Both bushings have setscrews to hold them securely in place. The location of the bushings on the cutter shaft will determine the length of a trimmed case.

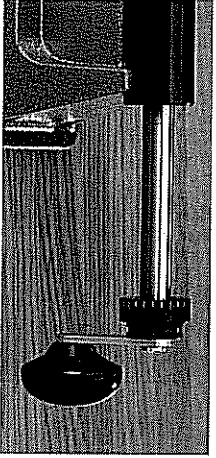


Photo #8

Start by placing the case in the shell holder on the trimmer. See photo #9. Make sure there



Photo #9

is a pilot installed on the cutter. Loosen the setscrews on both the rough and fine adjustment bushings. This should let the bushings move freely on the cutter shaft. As stated earlier, the fine adjustment bushing is threaded on the rough adjustment bushing. While looking at the right-hand end of the tool, hold the fine bushing (see photo #10) and turn

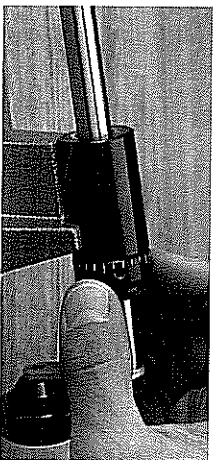


Photo #10

the rough bushing two or three turns counter-clockwise. With the cutter firmly against the case mouth, push the bushings all the way against the cutter guide. It is this contact that will stop the cutting process. Secure the setscrew on the rough bushing. You probably noticed small white lines on the fine bushing and a "witness" mark or dimple on the cutter guide in front and near the casting. Each of the white lines represent approximately 0.001" and the witness mark is used as a point-of-reference. One complete turn of the fine bushing equals 0.025" of cutter blade movement. The maximum case length and trim-to-length for popular calibers are shown in the reference table beginning on page 7.

When you turn the fine bushing counter-clockwise you will notice a small gap appears between the fine bushing and the cutter guide. This gap represents the amount the case will be trimmed. Remember in our example we wanted to remove 0.013". Turn the fine bushing counter-clockwise until 13 marks have passed and secure the setscrew. Your trimmer should now be very close to the correct setting.

Trim the first case by turning the handle on the trimmer. When the case is finished being trimmed, remove the case from the shell holder and chamfer and deburr with your deburring tool. Use your dial caliper to check the case length. If a final adjustment is necessary, remember to turn the fine bushing. Turning it counter-clockwise will result in a shorter case and turning it clockwise will result in a longer case.

Now secure both setscrews and you are ready to trim a quantity of cases.

An alternative method for setting the trimmer to the proper length is to save one of your trimmed cases to use as a "reference." Put this "reference" case in the shell holder and loosen the setscrew on both the rough and fine bushing. With the cutter all the way to the left, push the bushings so they are flush against the cutter guide and secure both setscrews.

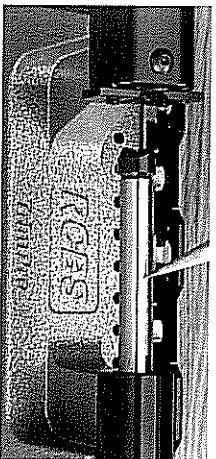
The reference case is acting as a guide and will make for easy set-up in the future.

CASE TRIMMING HINTS

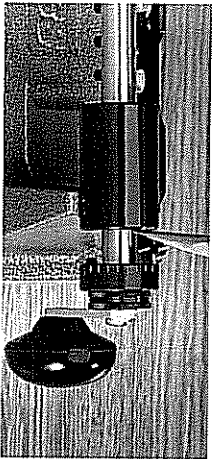
- Typically trimming is done after the cases are full-length resized. However, the Trim Pro is designed so cases can be trimmed before resizing if you prefer.
- Trimmed case mouths should be chamfered inside and out with an RCBS deburring tool before loading. Trimming leaves burrs which, if not removed, can complicate the loading process.
- If you trim cases of several different calibers, keep one case of each caliber to use as a guide when adjusting the trimmer. This will become your "reference" case and should be stored in the die box with your reloading dies.

CARE AND MAINTENANCE

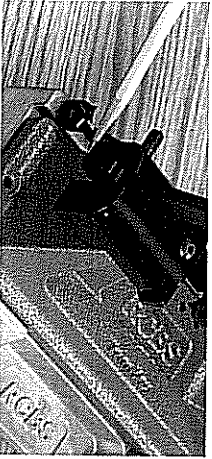
- Make sure the face of the compression pin is clean and free of dirt and foreign material.
- After trimming every 300 cases lubricate the following areas with a light oil. Also, if the trimmer has not been in use for 2 months or more, lubricate the same areas.



Lubricate the case trimmer shaft.



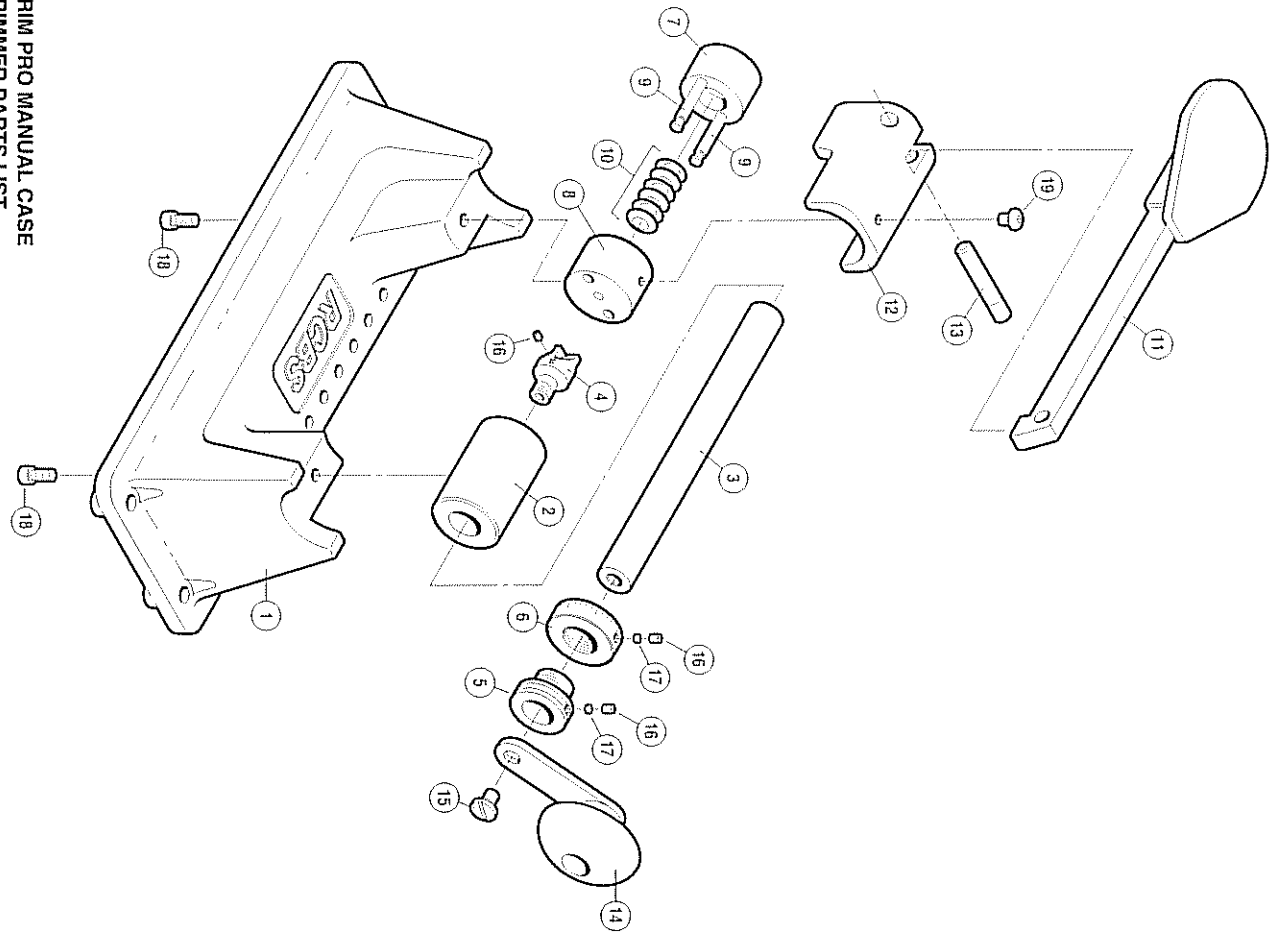
Apply some light oil between the cutter guide and the fine adjustment bushing.



Lubricate the case holder handle.

REFERENCE TABLE

Caliber	Trim Pro		Maximum		Caliber	Trim Pro		Maximum	
	Shell	Pistol	Case	Trim-to		Shell	Pistol	Case	Trim-to
	Holder	Caliber	Length	Length	Holder	Caliber	Length	Length	
17 Rem	10	17	1.796	1.786	7mm-08 Rem	3	28	2.035	2.025
218 Bee	1	22	1.345	1.335	7mmx57 Mauser	3/11	28	2.235	2.225
22 Hornet	12	22	1.403	1.393	7mmx64	3	28	2.520	2.510
22 K-Hornet	12	22	1.403	1.393	7mmx65 Rimmed	26	28	2.559	2.549
22 Rem Jet	6	22	1.288	1.278	7-30 Waters	2	28	2.040	2.030
22 Savage HP	2	22	2.050	2.040	30 M-1 Carbine	17	30	1.290	1.280
22-250 Rem	3	22	1.912	1.902	30 Luger	16	30	.850	.840
220 Swift	11	22	2.205	2.195	30 Mauser	16	30	.990	.980
221 Rem Fireball	10	22	1.400	1.390	30 Rem	19	30	2.050	2.040
222 Rem	10	22	1.700	1.690	30-06 Springfield	3	30	2.494	2.484
222 Rem Mag	10	22	1.850	1.840	30-30 Win	2	30	2.039	2.029
223 Rem	10	22	1.760	1.750	30-338 Win Mag	4	30	2.533	2.523
224 Win Sup Short Mag	43	22	1.670	1.660	30-357 AET	6	30	1.630	1.620
5.6mmx50R	6	22	1.969	1.959	30-378 Why Mag	14	30	2.913	2.903
240 Why Mag	3	24	2.500	2.490	30-40 Krag	7	30	2.314	2.304
243 Win	3	24	2.045	2.035	300 H&H Mag	4	30	2.850	2.840
6mm PPC	32	24	1.503	1.493	300 Rem Short Uli Mag	38/4	30	2.015	2.005
6mm Rem	3	24	2.233	2.223	300 Rem Ultra Mag	38/4	30	2.850	2.840
25 Auto (25 ACP)*	--	--	--	--	300 Savage	3	30	1.871	1.861
25-06	3	25	2.494	2.484	300 Why Mag	4	30	2.825	2.815
25-20 Win	1	25	1.330	1.320	300 Win Mag	4/26	30	2.620	2.610
25-35 Win	2	25	2.043	2.033	300 Win Short Mag	43	30	2.100	2.090
250 Savage	3	25	1.912	1.902	303 British	7	31	2.222	2.212
257 Roberts	3/11	25	2.233	2.223	307 Win	2	30	2.015	2.005
257 Rbls Imp 40"	3/11	25	2.233	2.223	308 Norma Mag	4	30	2.559	2.549
257 Why Mag	4	25	2.549	2.539	308 Win	3	30	2.015	2.005
260 Rem	3	26	2.035	2.025	7.5mmx54 French MAS	2	30	2.126	2.116
264 Win Mag	4/26	26	2.500	2.490	7.5mm SR	2	30	2.185	2.175
6.5mm-06	3	26	2.494	2.484	7.62mmx39	32	30	1.528	1.518
6.5x52 Carcano	9	26	2.067	2.057	7.62mmx54R Russ	13	30	2.114	2.104
6.5mmx54 MS	9	26	2.112	2.102	7.65mmx53 BM	3	31	2.106	2.096
6.5mmx55 SM	2	26	2.165	2.155	7.7mmx58 JA	3/2	31	2.284	2.274
6.5mmx57	3	26	2.232	2.222	32 Auto	17	31	.680	.670
6.5mmx68S	34	26	2.657	2.647	32 H&R Mag	23	31	1.075	1.065
270 Why Mag	4	27	2.550	2.540	32 S&W Long	23	31	.920	.910
270 Win	3	27	2.540	2.530	32 Win Spec	2	32	2.040	2.030
270 Win Short Mag	43	27	2.100	2.090	32-20 Win	1	31	1.315	1.305
280 Rem	3	28	2.540	2.530	32-40 Win	2	32	2.130	2.120
284 Win	3	28	2.170	2.160	Bnm Lebel French Revolver	1	32	1.079	1.069
7mm BR Rem	3	28	1.520	1.510	Bnm Rem Mag	4	32	2.850	2.840
7mm Rem Mag	4/26	28	2.500	2.490	Bnm-06	3	32	2.494	2.484
7mm Rem Short Uli Mag	38/4	28	2.035	2.025	Bnmx57 Mauser	3	32	2.240	2.230
7mm Rem Ultra Mag	38/4	28	2.850	2.840	Bnmx65S Mag	34	32	2.658	2.648
7mm STW	4	28	2.850	2.840	338 Lepua	14/37	33	2.724	2.714
7mm TCU	10	28	1.749	1.739	338 Rem Ultra Mag	38/4	33	2.760	2.750
7mm Why Mag	4	28	2.549	2.539	338 Win Mag	4	33	2.500	2.490
7mm Win Short Mag	43	28	2.100	2.090	338-06	3	33	2.494	2.484



TRIM PRO MANUAL CASE TRIMMER PARTS LIST

Key	Part #	Description	Part #	Description
1	786100	Trim Pro Base	10	TP Disc Spring (6)
2	98936	RCT Cutter Guide	11	TP Handle Lever Assembly
3	9405	RCT Cutter Shaft	12	TP Handle Support
4	9406	RCT Cutter	13	TP Handle Pin
5	9407	RCT Adjustment Bushing	14	TP Palm Handle Assembly
6	9408	RCT Fine Adjustment Bushing	15	Screw, 10-32x1/4
7	786101	TP Spring Holder	16	Screw, 8-32x1/8 (3)
8	786102	TP Compression Pin	17	Brass Buffer (2)
9	786103	TP Actuating Rod (2)	18	Screw, 10-32x5/8 (2)
			19	Screw, 10-32x3/8

REFERENCE TABLE (cont.)

Caliber	Trim Pro Shell Holder	Pilot Caliber	Maximum Case Length	Trim-to Length	Caliber	Trim Pro Shell Holder	Pilot Caliber	Maximum Case Length	Trim-to Length
338-378 Wby Mag	14	33	2.913	2.903	380 Auto	10	35	.680	.67
340 Wby Mag	4	33	2.820	2.810	38-40 Win	35	40	1.305	1.29
348 Win	5	34	2.255	2.245	38-55 W&B	2	37	2.085	2.07
35 Rem	9	35	1.920	1.910	40 S&W	27	40	.850	.84
35 Whelen	3	35	2.494	2.484	40-65 Shiloh Sharps	14	40	2.100	2.09
350 Rem Mag	4	35	2.170	2.160	400 CorBon	3	40	.898	.88
356 TSW	16	35	.850	.845	405 Win	24	40	2.583	2.57
356 Win	2	35	2.015	2.005	10mm Auto	27	40	.992	.98
357 Mag	6	35	1.290	1.280	41 Mag	30	41	1.290	1.28
357 Rem Maxi	6	35	1.605	1.595	416 Rem Mag	4	416	2.850	2.84
357 SIG	27	35	.865	.855	416 Rigby	37	416	2.900	2.89
358 Win	3	35	2.015	2.005	44 Mag	18	44	1.285	1.27
9mm FAR	16	35	.950	.940	44 Special	18	44	1.160	1.15
9mm Luger	16	35	.754	.744	444 Marlin	28	44	2.225	2.21
9mm Makarov	16	35	.713	.703	44-40 Win	35	44	1.305	1.29
9mmx21	16	35	.830	.820	45 Auto (45 ACP)	3	45	.898	.88
9mmx23 Win	16	35	.900	.890	45 Colt	20	45	1.285	1.27
9.3mmx62 Mauser	3	36	2.441	2.431	45-70 US Gov't	14	45-R	2.105	2.09
9.3mmx74 R	4	36	2.941	2.931	450 Marlin	4	45-R	2.100	2.09
375 H&H Mag	4	37	2.850	2.840	454 Casull	20	45	1.383	1.37
375 Rem Ultra Mag	38/4	37	2.850	2.840	458 Win Mag	4	45-R	2.500	2.49
375 Win	2	37	2.020	2.010	460 Wby Mag	14	45-R	2.913	2.90
376 Steyr	42	37	2.362	2.352	475 Linebaugh	40	475	1.400	1.39
378 Wby Mag	14	37	2.913	2.903	480 Ruger	40	475	1.285	1.27
38 Casull	3	35	.939	.934	50 Action Express	33	50	1.285	1.27
38 Colt SA	39	35	.900	.890	500 Smith & Wesson	44	S/O	1.625	1.61
38 S&W	6	35	.775	.765	50-70 US Gov't*	--	--	1.772	1.76
38 Special	6	35	1.155	1.145	*This case cannot be trimmed on the Trim Pro.				



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