

# CNC Machined Toolheads

With UniqueTek Toohead Clamp Kit Installed  
For Dillon 550, 650 and 750 Reloading Presses

Item No.: T1333-xx

## Instructions for both 550 and 650/750 toolheads.

### Die Installation

1. Remove the clamp screws with washers from the toolhead.
2. Insert the toolhead into the press frame.
3. Insert the toolhead clamp screws, down through the toolhead pin holes in the press frame and engage the threaded inserts in the toolhead, but leave them loose by two full turns.  
**Important!:** The rounded face of the washer must be against the head of the screw and the flat face against the top of the press frame.
4. Install and set up dies. The toolhead clamp screws should remain loose. This allows the toolhead to float and makes die set up easier.
5. Once you have all dies installed and set up, stop cycling the press with the ram fully up and all dies engaged by a cartridge.
6. With the ram still in the up position tighten the toolhead clamp screws.

**CAUTION:** Do not over tighten screws. Do not use a ball end hex key. The screws do not need to be super tight to provide effective clamping.

**NOTE:** You may need to make minor adjustments to the seating and crimp die once the toolhead is clamped. You will not need to make such adjustments on subsequent installations of the toolhead.

### Toolhead/Caliber Change

1. Insert the toolhead into the press frame.
2. Insert the toolhead clamp screws, down through the toolhead pin holes in the press frame and engage the threaded inserts in the toolhead, but leave them loose by at least two full turns.  
**Important!:** The rounded face of the washer must be against the head of the screw and the flat face against the top of the press frame.
3. Finish setting up the press as you normally would when preparing to reload.
4. Once you have started cycling rounds through the press and have all dies occupied, stop cycling the press with the ram fully up and each die engaged by a cartridge.
5. With the ram still in the up position tighten the toolhead clamp screws.

**CAUTION:** Do not over tighten screws. Do not use a ball end hex key. The screws do not need to be super tight to provide effective clamping.

**Note:** The clamp screws have been pre-coated with a dry-film moly anti-seize coating. Inspect the screws frequently. If the coating has worn off, it should be touched up with a dry-film moly lubricant such as Dri-Slide *Improved Weapons Lubricant* available at UniqueTek.com.

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