

FailSafe Bracket Kit

For Dillon RL 650 Presses

By Photo Escape, Inc.

- Eliminates Bending of original Failsafe Bracket.
- Provides more positive return of Powder Bar to the same position every cycle of the press.
- Easy installation.
- All hardware Included.

Item No: T1677

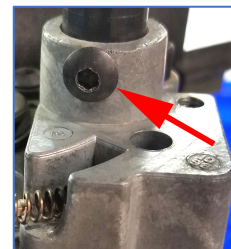
Please refer to your Dillon XL 650 Instruction Manual for the part numbers referenced in the following instructions.

Removing Original Failsafe Bracket:

1. Disconnect Failsafe Rod (#13629) from Failsafe Bracket (#18726 or #13367). Completely remove the Stripper Wing Nut (#13799), Rod Spring (#14033) and Shoulder Washer (#18086) from the Failsafe Rod (#13629). All parts will be reused except the Shoulder Washer. It is not necessary to disconnect the Failsafe Rod from the Powder Measure.
2. Remove the Failsafe Bracket (#18726) from the Primer System by removing the 10-24x1/4" BH Screw (#13964) and the front Primer System Mounting Bolt (#14138). Do not remove the rear Primer System Mounting Bolt. The screw and bolt will not be used with the new FailSafe Bracket.

Modification for Older Model Presses Only:

1. Some older XL 650 presses have a Button Head Screw securing the Magazine Shield (#17) into to Primer Feedbody Housing (#21279) [See photo at right]. The head of this screw interferes with installation of the new FailSafe Bracket. Remove the screw and replace it with a 10-24x3/16" set screw (not included). If your press does not have a Button Head Screw in this location, proceed to the installation steps.



Installing New FailSafe Bracket Kit:

1. Orient the new FailSafe Bracket for installation, then insert the end of the Failsafe Rod (#13629) down through the Brass Shoulder Washer. The Stripper Wing Nut (#13799) and Rod Spring (#14033) will be installed later.
2. Position the FailSafe Bracket on the Primer System and install the replacement bolts in their respective holes. These bolts are longer than the original bolts to accommodate the increased thickness of the new FailSafe Bracket. Tighten both bolts.
NOTE: If the lock washer under the head of the Indexing Arm Spring retainer Bolt (the bolt that is preinstalled in the FailSafe Bracket) interferes with the head of the front Primer System Mounting Bolt (the 1/4-28x1-3/8" Cap Head Screw), simply loosen the Indexing Arm Spring Retainer Bolt slightly (just enough for the lock washer to slide), tighten the Primer System Mounting Bolt, then tighten the Indexing Arm Spring Retainer Bolt.
3. Install the Rod Spring (#14033) and Stripper Wing Nut (#13799) on the Failsafe Rod (#13629). Adjust as described in in your Dillon XL 650 Instruction Manual.

NOTE: The Failsafe Rod must be as vertical as possible to operate smoothly. To make this adjustment, loosen the screws on the Body Collar Clamp (#13939) and rotate the powder measure on the powder die until the Failsafe Rod is vertical. Then tighten the screws. No adjustment of the Powder Die is needed.

Toolhead Changes:

When changing Toolheads, the two (2) set screws securing the Brass Shoulder Washer must be loosened and the Brass Shoulder Washer slid out of the FailSafe Bracket.

OR

If you detach the Powder Measure from the Toolhead before removing the Toolhead from the press frame, you can leave the Brass Shoulder Washer in place and, instead, remove the Stripper Wing Nut (#13799) and Rod Spring (#14033) then lift the Powder Measure vertically off the Powder Die until the Failsafe Rod disengages from the Brass Shoulder Washer.

TIP: Once the Powder Measure has been removed from the Toolhead, you can easily and securely park it on a Dillon Toolhead Stand by using a UniqueTek Powder Measure Stand Adapter (Item No. T1573).

Disclaimer: UniqueTek, Inc. is not liable for damages or personal injury that may be incurred as a result of using this product in an improper way or on a reloading press that has been improperly maintained or operated. It is your responsibility to ensure that your reloading equipment is properly assembled, is maintained in proper working condition, and is used according to the manufacturer's instructions and safe reloading practices.

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