

# 650 Bearing Indexer Block

## For Dillon XL 650 Presses

(Item #T1705)

### Installation Instructions

- 1) With the press ram up, use a 7/32" hex wrench to remove the two (2) Cap Head Screws that attach the Indexer Block (#13989) to the Press Frame. Set the Indexer Block aside but keep the screws.
- 2) Position the 650 Bearing Indexer Block against the Press Frame and install the Cap Head Screws. Leave the screws just loose enough that you can adjust the position of the 650 Bearing Indexer Block.
- 3) Lower the ram slowly and check that the Ring Indexer (#13677) engages the 650 Bearing Indexer Block and that the Shellplate indexes smoothly and that the Index Ball (#13891) has engaged the detent in the Shellplate. Then press forward on the operating handle (as if seating a primer) and observe that the Primer Punch is centered within the hole in the Shellplate. If the Index Ball is not engaging the detent, or the primer punch is off center, adjust the position of the 650 Bearing Indexer Block as needed.
- 4) Once the adjustment is satisfactory, tighten the Cap Head Screws.
- 5) Slowly cycle the press through all five stations while watching that each station is indexing properly.

NOTE: You may wish to remove any residual lubrication from the surface of the Ring Indexer. With the 650 Bearing Indexer Block installed, lubrication will no longer be needed.