

650 Primer Feed Stop Switch For Dillon XL 650 Presses

(Item #T1703)

- Quickly & Easily Switches Primer Feed System ON or OFF.
- Simply Replaces Primer Cam (#13670)
- Easy Bolt-On installation
- No Modifications to Press Frame Required.

✓ For XL 650 press ONLY.

✗ Will NOT fit XL 750 press.

NOTE: Refer to the Dillon Precision XL 650 Instruction Manual to find the parts referenced below.

CAUTION: Make sure all primers have been removed from the Primer System before proceeding.

Installation Instructions

- 1) With press ram down, use a 5/32" hex wrench to remove the Cam Screw (#14037) and Stainless Flat Washer (#13738) that attaches the Primer Cam (#13670) to the Press Frame, and then remove the Primer Cam.
- 2) Slide the Cam of the 650 Primer Feed Stop Switch so that it is centered on the Base. This will ensure that the hole in the Base is clear for easy installation of the Cam Screw.
- 3) Position the 650 Primer Feed Stop Switch in the Press Frame and install the Cam Screw.
Do not use the Stainless Flat Washer.
- 4) Using the 5/32" hex wrench, tighten the Cam Screw just fingertip tight (no more than 12-15 inch-pounds). Since the SS Flat washer cannot be used, overtightening the Cam Screw can warp the plastic base of the 650 Primer Feed Stop Switch making it difficult to slide.
- 5) Slide the Cam of the 650 Primer Feed Stop Switch to the "ON" position (toward the rear of the press) until the ball detent engages. You can hear a "click" as the ball engages the detent hole.
- 6) Raise the ram slowly and check that the 650 Primer Feed Stop Switch cam engages the Primer Indexing Arm (#13662) and that the Rotary Primer Disk (#13431 or #13499) advances. Then lower the ram.
- 7) Slide the Cam of the 650 Primer Feed Stop Switch to the "OFF" position (toward the front of the press) until it stops. NOTE: There is no detent for the OFF position as the cam is stopped by the head of the Cam Screw.
- 8) Raise the ram slowly and check that the 650 Primer Feed Stop Switch Cam misses the Primer Indexing Arm (#13662) and that the Failsafe Bracket (#13367) clears the 650 Primer Feed Stop Switch cam.
NOTE: If the Failsafe Bracket rubs against the 650 Primer Feed Stop Switch when in the OFF position, loosen the two screws that attach the Failsafe Bracket to the Primer Feedbody Housing (#21279), pull the Failsafe Bracket slightly away from the 650 Primer Feed Stop Switch and then tighten the screws.
- 9) Lower the ram and slide the Cam of the 650 Primer Feed Stop Switch to the "ON" position. The press is now ready to use.

Using the 650 Primer Feed Stop Switch

- 1) If you need to stop the primer feed, slide the Cam of the 650 Primer Feed Stop Switch to the "OFF" position (toward the front of the press) until it stops.
- 2) To resume feeding primers, slide the Cam of the 650 Primer Feed Stop Switch to the "ON" position (toward the rear for the press) until the detent ball engages.

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.