

Swage It S650 Instructions for the Dillon XL650

Step 1. REMOVE ALL PRIMERS.

Step 2: Remove the spent primer cup.

Step 3: Remove the primer seater assembly

Step 4: Remove punch support bracket.

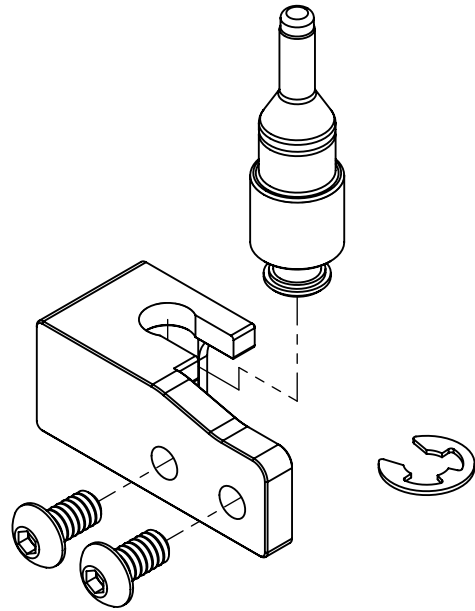
Step 5: Install the desired swage pin onto the mounting plate and attach with the e-clip.

Note: Make sure that the e-clip is installed on the topside of the mounting plate.

Step 6: Install the S650 onto the press with the supplied screws and do not tighten.

Step 7: Lower the platform assembly to ensure correct alignment with the S650, rotary primer disk and the shellplate.

Step 8: Tighten the exposed screw on the S650 then raise the platform and tighten the second screw. Lower the platform and double check for proper alignment.



- While swaging the brass gently push forward on the press handle to fully seat the swage pin into the brass.
- Do Not use excessive force as this may damage the brass case.

