

650 Primer Feed Stop Switch

For Dillon XL 650 Presses

(Item #T1703)

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, then remove the Primer Cam.
- 2) Position the 650 Primer Feed Stop Switch in the Press Frame and install the Cam Screw. **Do not use the Stainless Flat Washer.**
- 3) Make sure that the 650 Primer Feed Stop Switch is in the "ON" position (slid toward the rear for the press) and the ball detent is engaged.
- 4) 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.
- 5) Slide the 650 Primer Feed Stop Switch cam to the "OFF" position (toward the front of the press until it stops). There is no ball detent for the OFF position as the cam is stopped by the head of the Cam Screw.
- 6) 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.
- 7) Lower the ram and slide the 650 Primer Feed Stop Switch cam 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, simply Slide the 650 Primer Feed Stop Switch cam to the "OFF" position (toward the front of the press until it stops).
- 2) To resume feeding primers, slide the 650 Primer Feed Stop Switch cam to the "ON" position (toward the rear for the press) until the ball detent engages.