

650/750 Bearing Camming Pin

For Dillon XL 650 & XL 750 Presses

(Item #T1706)

Installation Instructions

- 1) Raise the press ram fully up. This will hold the Case Insert Slide out of the way.
- 2) Remove the Casefeed Feed Tube (#13761) and Case Feed Adapter†. Removing these will give you access to the top of the Camming Pin (#13371).
(† Case Feed Adapters are caliber specific. See the Caliber Conversion table in your Instruction Manual for part numbers.)
- 3) Use a 9/16" wrench to loosen the Jam Nut (#13901) and then remove the Jam Nut completely from the Camming Pin.
NOTE: If the Camming Pin tends to turn, insert a 1/8" hex wrench into the top of the Camming Pin and use as a backing wrench to keep the Camming Pin from turning.
- 4) Unscrew the Camming Pin and remove from the Casefeed Body (#13558). It should unscrew by hand.
Note: The Camming Pin passes through the Casefeed Arm (#13716). Once the Camming Pin is removed, the Case Feed Arm will shift out of position. You can hold it in position with your hand or with a strip of adhesive tape until the 650/750 Bearing Camming Pin is inserted far enough to engage the hole in the Case Feed Arm.
- 5) Insert the 650/750 Bearing Camming Pin upward onto the Casefeed Body, making sure it passes through the pivot hole in the Case Feed Arm, and engages the threads of the Casefeed Body. Screw the 650/750 Bearing Camming Pin fully into the Case feed Body until the shoulder machined into the 650/750 Bearing Camming Pin just contacts the bottom of the Casefeed Body.
NOTE: It should screw in by hand, but you can insert a 3/16" hex wrench into the top of the 650/750 Bearing Camming Pin to assist turning it.
- 6) Lower the press ram.
- 7) Using the 3/16" hex wrench, rotate the 650/750 Bearing Camming Pin until the bearing is aligned with the Case Insert Slide (#13763).
- 8) Reinstall the Jam Nut just finger tight. It will be fully tightened later.
- 9) Cycle the press slowly several times and observe that the case feed mechanism is operating properly.
- 10) Adjust the Bearing Camming Pin as described in the instructions in your press manual.
(See Step 16 of the Caliber Conversion Section in the XL 650 manual or Section 10.5 in the XL 750 manual.)
- 11) Tighten the Jam Nut. Use the 3/16" hex wrench as a backing wrench to ensure that the 650/750 Bearing Camming Pin does not rotate out of alignment while the Jam Nut is tightened.
- 12) Reinstall the Casefeed Feed Tube and Case Feed Adapter.

NOTE: Remove any residual lubrication from the surface of the Case Insert Slide. With the 650/750 Bearing Camming Pin installed, lubrication will no longer be needed.

If the surface of the Case Insert Slide is heavily scarred, you may wish to clean it up by shaving it with a single-edge razor blade or sanding it with some fine (about 400 grit) sandpaper.