

# 550 Primer System Mount Upgrade Kit

– For Dillon RL 550 Presses

**Item #: T1803**

- ✓ Works on all RL 550 press versions.
- ? May be used on RL 450 Presses that have been upgraded with the RL450 Upgrade Auto Prime System (#20055) but this has not been tested.
- ✗ Cannot be used on BL 550 or AT 500 Presses.

**Kit Includes:**

- 2, #10-24 Threaded Studs\*
- 2, #10 Flat Washers
- 2, #10-24 Knurled/Allen Nuts

\* Loctite® 248 (Blue) is pre-applied to the threads.

When Dillon Precision designed the XL 750 press, they recognized the customer requests from RL 550 press owners for a faster and easier way to mount the Primer System onto the press frame. Instead of socket head cap screws that must be inserted upward from beneath the press frame, they installed threaded studs in the Primer System and provided knurled finger nuts to secure the Primer System to the press.

A major advantage of this upgrade is that, once the threaded studs are engaged into the holes in the press frame, the Primer System is much less likely to accidentally topple off the press frame and become damaged during installation or removal. This is especially handy for those who frequently change between Small Primer and Large Primer.

This kit provides all the parts needed to make this upgrade to the RL 550 Primer System.

Note: Refer to the User Manual for your press to identify the Dillon part numbers referenced below.

## Preparation for Installation

- 1) Remove all primers from RL 550 Primer System.
- 2) Remove Spent Primer Cup (#13650) and set aside. This will give you more clearance to work
- 3) Disconnect the Primer Slide Return Spring (#13928) from the post on the bottom of the Primer Slide Assembly (#14281 Large Primer / #14282 Small Primer).
- 4) Raise the press ram about 1", pull the Primer Slide out to its limit and then lower press ram. This removes tension from the 550 Op Rod (#13869).
- 5) Remove the 550 Op Rod and set aside.
- 6) Raise the press ram until it is fully up.
- 7) Push the Primer Slide in as far as it will go. This will prevent the Primer Slide from falling off the frame when the Primer System is lifted off the press.
- 8) Using a 5/32" Hex Key, remove the two (2) #10-24x875 Socket Head Cap Screws (#14014) and then lift the Primer System (#20263) off the Press Frame.  
**CAUTION:** Be sure to support the Primer System during removal of the screws to ensure that it doesn't topple off the press frame and become damaged.
- 9) Lift the Primer Slide Assembly and Primer Track Bearing (#14015) off the press frame and set aside ... just to prevent them from being accidentally knocked off the frame and damaged.

## Modifying the Primer System

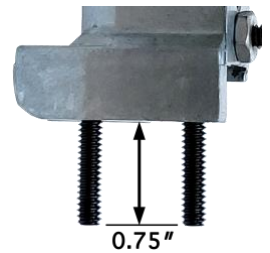
- 1) Using a 3/32" Hex Key, install the two (2) #10-24 x 1-1/4" threaded studs into the holes in the bottom of the Primer System. Screw them in fully until they bottom out in the holes. Tighten snugly.

**IMPORTANT:** The threaded studs must be fully bottomed out in the holes. Confirm this by measuring the lengths of the exposed threaded studs. They should measure 0.75".

**CAUTION: Do not overtighten!** The body of the Primer System Assembly is a pot metal casting and overtightening the studs could strip the threads.

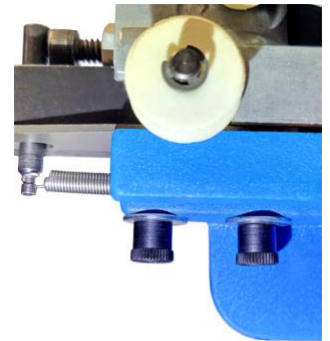
**TIP:** You may wish to clean up the threads in the Primer System casting using a #10-24 Thread Tap before installing the Threaded Studs.

**Note:** These Threaded Studs come with Loctite® 248 (Blue) pre-applied to the threads.



## Installation of Modified Primer System

- 1) Start with the Press Ram fully up.
  - 2) Set the Primer Track Bearing and Primer Slide Assembly into position onto the press frame.
  - 3) Set the Primer System over the Primer Slide Assembly and engage the two #10-24 studs into the holes in the press frame.
  - 4) Install a Flat Washer and Knurled/Allen Nut onto each of the two #10-24 Threaded Studs and tighten fingertip tight.
- TIP:** Due to limited clearance, it is easier to install a Flat Washer and Knurled/Allen Nut on the front stud first.
- 5) Pull the Primer Slide out to its limit and then lower the Press Ram.
  - 6) Reinstall the 550 Op Rod.
  - 7) Raise the Press Ram fully while making sure that the 550 Op Rod engages both the Small Roller (#13765) on the 550 Roller Bracket and the Large Roller (#13889) on the Primer Slide Assembly.
  - 8) Reconnect the Prime Slide Return Spring to the Primer Slide.
  - 9) Slowly lower the Press Ram making sure that the Primer Cup smoothly engages the hole in the Shellplate.
  - 10) Make sure the Primer System is positioned correctly and operating smoothly, and then tighten the Knurled/Allen Nuts firmly finger-tight. Overtightening may bind the Primer Slide.



Knurled/Allen Nuts Installed  
(Op Rod removed for photographic clarity.)

NOTE: If you can't get the Knurled/Allen Nuts tightened firmly with your fingers, you can use a 3/16" Hex Key.

### Do not overtighten!

- 11) Cycle the press multiple times and check that the Primer Slide Assembly operates smoothly.
- 12) Reinstall Spent Primer Cup.

## FAQs

**Q:** Does this installation make any permanent modifications to my Primer System?

**A:** No. If needed, the threaded studs can be removed, and the Primer System installed using the original #10-24 Socket Head Cap Screws.

**Q:** The rear screw is so close to the press frame that it is difficult to get my fingers in there to tighten the Knurled/Allen Nut.

**A:** That is why we use Knurled/Allen Nuts. It has both a knurled rim for finger tightening and a hex socket for a 3/16" Hex Key. But caution should be taken to not overtighten the Knurled/Allen Nut when using a Hex Key.

**Q:** Why do you use fully threaded studs instead of studs with a shank in the middle ... like those used on the XL 750?

**A:** Fully threaded studs mimic the original fully threaded cap head screws ... thus providing the same range of position adjustment of the Primer System.

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