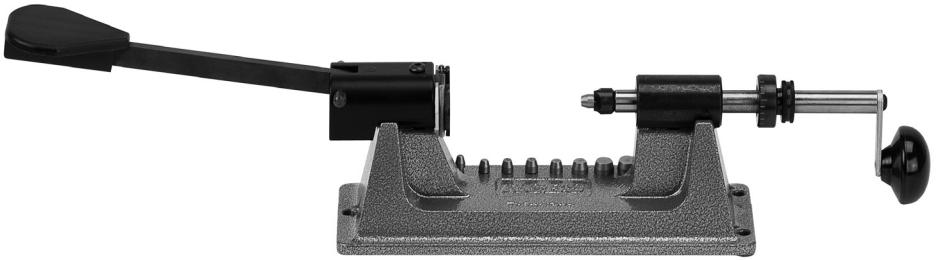


RCBS®

Trim Pro—2 Case Trimmer



PRODUCT INSTRUCTIONS

 **WARNING!**

Before using the RCBS Trim Pro—2 Case Trimmer, read these instructions carefully to fully learn how to safely operate the related reloading equipment. Failure to properly operate the related reloading equipment can result in severe personal injury and/or equipment damage.

**If you have any questions while assembling or operating this tool,
Call us at 1-800-533-5000 or 1-530-533-5191
Monday – Thursday 6:30 am – 4:00 pm Pacific Time
(hours may vary)
Or email us at rcbs.tech@atk.com**

This instruction manual contains specific safety and operating information. It should be considered a permanent part of your reloading equipment and remain with the equipment at all times for easy reference.

LIFETIME LIMITED WARRANTY

Your Trim Pro—2 Case Trimmer is warranted to be free from defects in material or workmanship for lifetime of the original consumer purchaser. All RCBS products are intended for non-commercial use by hobbyists. Any other use of these products will void the warranty. Should you believe that your Trim Pro—2 Case Trimmer is defective in material or workmanship, you must return it to Ammunition Accessories Inc. through its Oroville operation (hereinafter “Oroville Operations”) postage paid for evaluation. If defective, the product will be repaired or replaced at Oroville Operations’ option, at no charge.

Send a dated proof of purchase to Oroville Operations for return shipping and handling, along with the Trim Pro—2 Case Trimmer to:

Ammunition Accessories Inc.,
Oroville Operations
605 Oro Dam Blvd East
Oroville, California 95965

Warranty services cannot be provided without meeting the above requirements.

THIS LIFETIME LIMITED WARRANTY DOES NOT COVER DEFECTS OR DAMAGE RESULTING FROM: CARELESSNESS, MISUSE, COMMERCIAL USE, ABUSE, IMPROPER INSTALLATION, MODIFICATION, OR NORMAL WEAR AND TEAR. THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE LIMITED TO THE DURATION OF THIS LIFETIME LIMITED WARRANTY. OROVILLE OPERATIONS IS NOT LIABLE FOR DAMAGES IN EXCESS OF THE PURCHASE PRICE OF THE PRODUCT AND UNDER NO CIRCUMSTANCES SHALL OROVILLE OPERATIONS BE LIABLE FOR CONSEQUENTIAL OR INCIDENTAL DAMAGES. HOWEVER, SOME STATES DO NOT ALLOW LIMITATIONS ON INCIDENTAL, OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

The above warranty provides the sole and exclusive warranty available to the customer in the event of a defect in material or workmanship in the reloading product. This warranty gives you specific legal rights, and you may also have other rights which vary from State to State.

SAFETY

Reloading is an enjoyable and rewarding hobby that can be conducted safely. But, as with any hobby, carelessness or negligence can make reloading hazardous. This product has been designed from the beginning with the user's safety in mind. When reloading, safety rules must be followed. By observing these rules, the chance of a hazardous occurrence causing personal injury or property damage is minimized.

GENERAL

- Use all equipment as the manufacturer recommends. Study the instructions carefully and become thoroughly familiar with the operation of the product. If you do not have written instructions, request a copy from the equipment manufacturer.
- Do not take short cuts. Attempting to bypass established procedures is an invitation to an accident.
- Observe "good housekeeping" in the reloading area. Keep tools and components neat, clean and orderly. Promptly and completely clean up primer and powder spills.
- Reload only when you can give your undivided attention. Do not reload when fatigued or ill, or under the influence of medications or alcohol.
- Develop a reloading routine to avoid mistakes which may prove hazardous. Do not rush - load at a leisurely pace.
- Always wear adequate eye protection to protect your eyes from flying particles. You assume unnecessary risk when reloading without wearing safety glasses.

LOADING DATA

- Use only laboratory tested reloading data. We highly recommend the current Speer Reloading Manual.



OBSERVE ALL WARNINGS ABOUT THE USE OF MAXIMUM LISTED LOADS.



WARNING/ CAUTION

PRIMERS AND POWDER

- Store primers and powder beyond the reach of children and away from heat, dampness, open flames and electrical equipment. Avoid areas where static electricity is evident.
- DO NOT use primers of unknown identity.
- Dispose of unknown primers in accordance with applicable regulations.
- Keep primers in the original factory container until ready to use. Return unused primers to the same factory packaging for safety and to preserve their identity. Primer packaging is designed to provide safe storage.
- DO NOT store primers in bulk. The blast of just a few hundred primers is sufficient to cause serious injury to anyone nearby.
- DO NOT force primers. Use care in handling primers.
- DO NOT have more than one can of powder on the bench at one time. Powder cans should be stored away from the bench to avoid picking up the wrong one.
- DO NOT use any powder unless its identity is positively known. The only positive identification is the manufacturer's label on the original canister. Discard all mixed powders and those of uncertain identity.
- If you use a powder measure, replace the lids on both the powder hopper and powder can after the powder hopper has been filled.
- When using a powder measure, settle the powder in the powder hopper before charging any cases. Throw and check the weight of at least ten charges. This will assure you that the correct powder charge is being thrown.

- When you finish a reloading session, pour any remaining powder back into its original factory container. This will preserve the identity and shelf life of the powder.
- DO NOT smoke while reloading.

RECORD KEEPING

- Keep complete records of reloads. Apply a descriptive label to each box showing the date produced, and the primer, powder and bullet used. Labels for this purpose are packed with Speer bullets.
- Never attempt to guess at the identity of your ammunition

Because RCBS has no control over the choice of components, the manner in which they are assembled, the use of this product, or the firearms in which the resulting ammunition may be used, we assume no responsibility, expressed or implied, for the use of ammunition reloaded with this product.

USE

The RCBS Trim Pro—2 Case Trimmer is designed to cut cartridge case length to manufacturer recommendations. Repeated firing, resizing, and reloading of cases cause them to grow in length. Whenever a case grows longer than the manufacturer's maximum specified case length, it must be trimmed back to an acceptable length for that cartridge.

There are case length specifications for every cartridge. A current copy of the Speer Reloading Manual is an excellent source for this information. To order one, contact RCBS or see our website (www.rcbs.com).

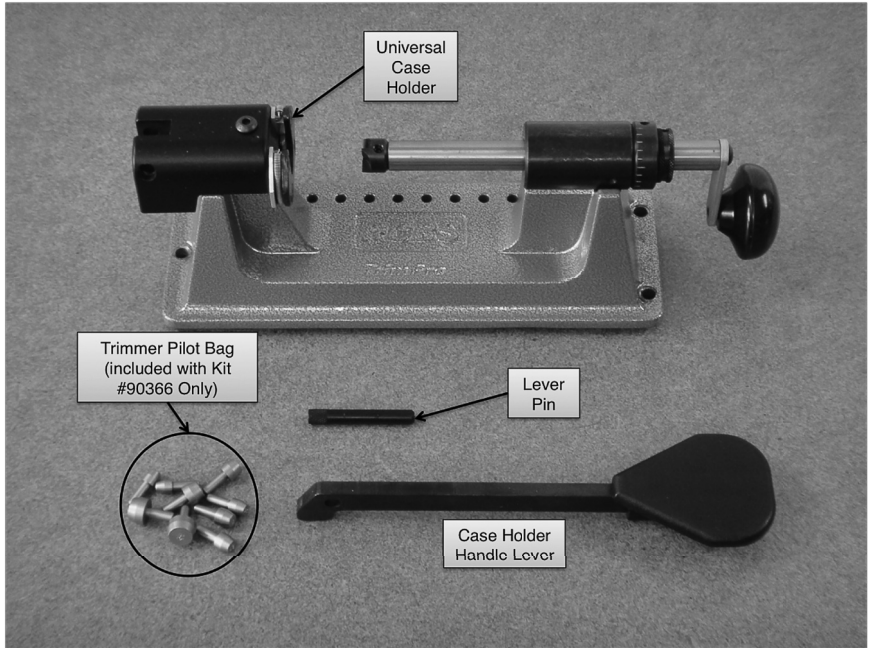
⚠ CAUTION *It is critical for safety that cases not exceed the maximum specified case length. A case that is too long can enter the throat of the firearm when chambered. If this happens, the case cannot release the bullet properly upon firing, resulting in excessive pressure increase.*

The Trim Pro—2 will give you a consistent repeatable trim. The case mouth will be cut square/ perpendicular to the longitudinal axis of the case. It is quick to setup, easy to use, easy to change from one caliber to another, and provide years of trouble-free service.

After trimming a case, chamfer/ debur the case mouth inside and out with an RCBS Debur Tool (sold separately). An optional Three-Way Cutter Tool (sold separately) can be used on the Trim Pro—2 unit to combine trimming and chamfering the inside and outside into one easy operation. To order either or find out more information, contact RCBS or visit our website (www.rcbs.com).

UNPACKING

Refer to the list below to identify parts as you carefully unpack your new Trim Pro—2 Case Trimmer:



Pilot Bag (included with Kit #90366 Only)



22 cal Pilot (1)
25 cal Pilot (1)
28 cal Pilot (1)
35 cal Pilot (1)

24 cal Pilot (1)
27 cal Pilot (1)
30 cal Pilot (1)
44 cal Pilot (1)
45 cal Pilot (1)

ASSEMBLY

Reference the part schematic on page 10 for more information.

Case Holder Handle Lever

Attach the Case Holder Handle by inserting it into the slot on the Case Holder. Align the holes and insert the Lever Pin (Photo 1).

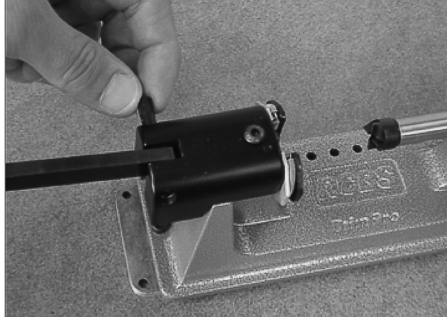


Photo 1. Assemble Case Holder Handle

Ensure the Lever Pin is fully inserted and engaging both sides of the slot in the Case Holder (Photo 2).



Photo 2.

Caliber Pilot

Fully insert the appropriate sized Case Trimmer Pilot into the end of the Cutter Head. Securely tighten the setscrew on the Cutter using a 1/8" hex key wrench (Photo 3).

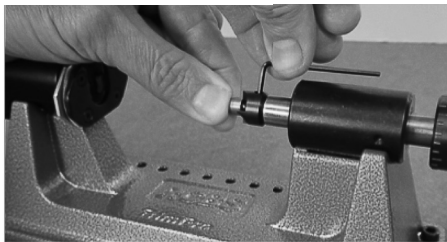


Photo 3. Installing Pilot

Pilots are interchangeable and available in a variety of sizes. Each Pilot is machined to the caliber size of the resized case mouth. The snug fit helps eliminate case wobble and ensures alignment of the case while it is being trimmed.

INSTALLATION

Note: Reference the part schematic on page 10 for more information.

Mount the Trimmer

Securely mount your Trim Pro—2 Trimmer to your reloading bench at a location of your preference. Use three screws (not provided), or other suitable method, at the hole locations shown (Photo 4). Allow sufficient room around the Trimmer to operate it comfortably and safely.

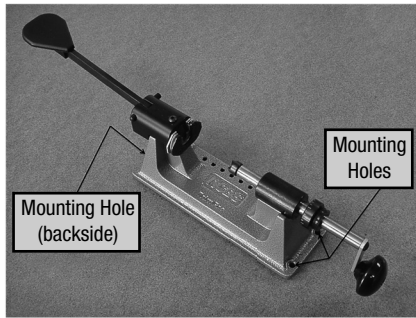


Photo 4. Mounting Trimmer

Other mounting options include using the RCBS Trim Pro Case Trimmer Stand (#90360) or the RCBS Accessory Base Plate—2 (item #09280), both sold separately. To order either or find out more information, contact RCBS or visit our website (www.rcbs.com).

FUNCTION

If you determine that any of your cases need to be trimmed, it is recommended to trim all cases in the lot so they are all equal length. This will provide better repeatability in your ammo's performance.

⚠ CAUTION *It is critical for safety that cases not exceed the maximum specified length. A case that is too long can enter the throat of the firearm when chambered. If this happens, the case cannot release the bullet properly upon firing, resulting in excessive pressure increase.*

Load a resized case into the Universal Case Holder by pushing down and holding the Case Holder Lever with one hand, while inserting the case base with the other hand (Photo 5). Ensure the case base is flush with the Case Holder Knurl Face (Photo 6). The Case Holder has two spring-loaded 'fingers' that engage the Case's Extractor Groove/ Rim. Release Case Holder Lever.

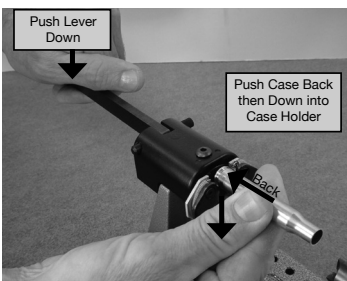


Photo 5. Inserting Case into Universal Holder



Photo 6. Case Holder 'Fingers'

Proceed to the **ADJUSTMENT** section of this manual to fine-tune the Trim Length for your case. To operate the Trimmer, slide the Cutter Shaft toward the Case Holder until the Pilot and Cutter engages the mouth of the case. Grasp the Cutter Knob and begin cranking the cutter in a clockwise direction. Continue to turn the Cutter Knob with uniform forward pressure (toward the case) until complete. The trimming operation is finished when the Trimmer Adjustment Bushings contacts the Cutter Guide (Photo 7). Slide the Cutter Shaft to the right.

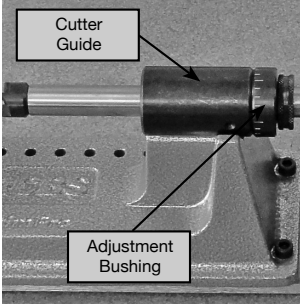


Photo 7.

Remove the trimmed case from the Universal Case Holder by pressing down on the Case Holder Lever and lifting the case out.

Chamfer/ Debur the case mouth inside and out with an RCBS Debur Tool (sold separately). An optional Three-Way Cutter Tool (sold separately) can be used to combine trimming and chamfering the inside and outside into one easy operation. Contact RCBS for more information.

ADJUSTMENT

Note: Reference the part schematics on page 9 of this booklet for more information.

Trimmer Length Adjustment

Final adjustments are controlled by the Trimmer’s Adjustment Bushing mounted on the Cutter Shaft. The Fine Adjustment Bushing (larger of the two) is threaded into the Coarse Adjustment Bushing. The location of this Bushing Assembly creates a hard-stop for the Cutter Shaft and determines the final case length.

First, install a sized case into the Universal Case Holder and the correct Pilot in the Cutter Head. Loosen the setscrew on the Coarse Adjustment Bushing (Photo 8) and the setscrew on the Fine Adjustment Bushing (Photo 9).

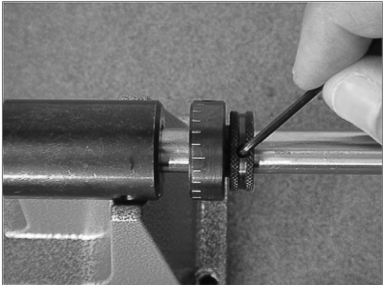


Photo 8. Coarse Adjustment Bushing

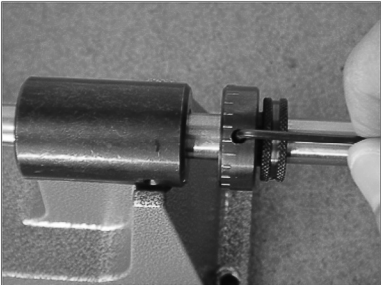


Photo 9. Fine Adjustment Bushing

Unscrew the Fine Adjustment Bushing 5-7 turns out from the Coarse Adjustment Bushing. Slide the Cutter Shaft/ Handle to the left until the Pilot enters the mouth of the case and the cutter blades come to a stop against the case mouth. Next slide the Bushing Assembly to the left to contact the Cutter Guide (Photo 7) and tighten the setscrew on the Coarse Adjustment Bushing. Then slide Pilot/ Cutter back to the right to remove it from the Case Mouth. Remove the sized case, measure its length (Photo 10).



Photo 10.

Calculate the amount of brass you want to remove from the case, based on Manufacturer's 'Trim-to-Length' specifications. Screw the Fine Adjustment Bushing in by that amount.

Note that each indication line on the Fine Adjustment Bushing represents approximately 0.001", and one full turn is approximately 0.025" of travel.

Tighten the setscrew on the Fine Adjustment Bushing. Reinstall the sized case, and trim. Remove the trimmed case and measure to verify length is correct. Make any additional adjustments as needed to the Fine Adjustment Bushing via this process until desired results are achieved.

For future set-up to make trim length adjustments easy, save a trimmed case in a known location (Die Box, etc.). Install this 'reference' case to quickly set the Bushing Assembly position on the Cutter Shaft.

MAINTENANCE

Occasionally clean your Trim Pro—2 Case Trimmer of brass shavings and debris to keep it operating smoothly.

Lightly lubricate your trimmer after trimming approximately 300 cases or before long periods of storage. Use a light-weight multi-purpose grease at the following locations (Photos 11-12):

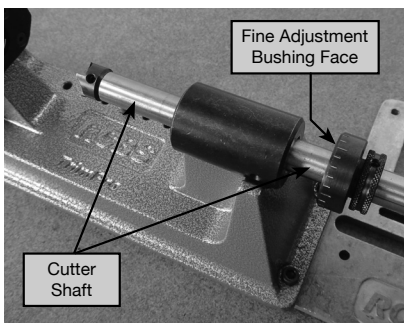


Photo 11. Lubricate Cutter Shaft and Fine Adjustment Bushing Face

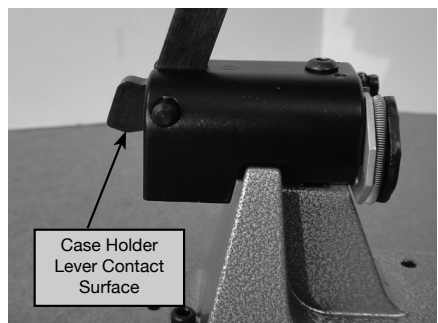
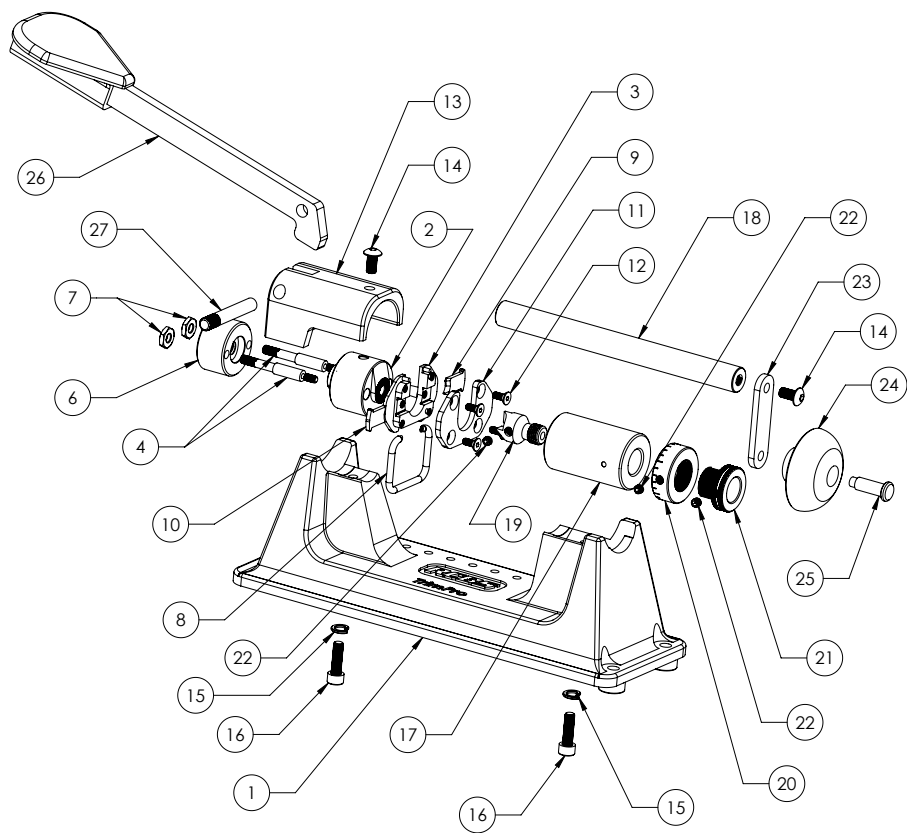


Photo 12. Lubricate Case Holder Lever



ITEM #	PART #	DESCRIPTION	QTY.
1	7786100	Base	1
2	7786124	Compression Pin	1
3	7786114	Case Holder Shelf	1
4	7786125	Actuating Rod	2
5	7186131	Belleville Washer	6
6	7786123	Spring Holder	1
7	7109603	10-32 Hex Nut	2
8	7186266	APS HPT Case Pawl Spring	1
9	7784138	APS HPT Case Holder Left	1
10	7784139	APS HPT Case Holder Right	1
11	7186263	APS HPT Case Holder Cap	1
12	7186157	5-40 x 5/16L FHCS	4
13	7786121	Handle Support	1
14	7186144	10-32 x 3/8L BHCS	2
15	7187051	#10 Lock Washer	2
16	7186624	10-32 x 5/8L SHCS	2
17	7798938	Cutter Guide	1
18	7709405	Cutter Shaft	1
19	7709406	Cutter Head	1
20	7709408	Fine Adjustment Bushing	1
21	7709407	Coarse Adjustment Bushing	1
22	7109409	8-32 x 1/8L Setscrew	3
23	7709412	TP Handle Link	1
24	7198943	TP Palm Knob	1
25	7798942	TP Handle Knob Pin	1
26	7786122	Handle Lever Assembly	1
27	7786107	Handle Lever Pin	1

RCBS[®]

PRECISIONEERED RELOADING EQUIPMENT

We think that we make the very best reloading equipment in the world.

If you agree, please tell your friends.

If you disagree, tell us we want to do something about it!

Customer Service

1-800-533-5000 (US or Canada) or 530-533-5191

Hours: Monday - Thursday, 6:30 a.m. - 4:00 p.m. Pacific Time
(hours may vary)

e-mail: rcbs.tech@atk.com or visit our website at www.rcbs.com

RCBS 605 Oro Dam Blvd. East Oroville, CA 95965

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