

RCBS®

AMMOMASTER-2 SINGLE STAGE RELOADING PRESS



PRODUCT INSTRUCTIONS

⚠ WARNING

Before using the RCBS AmmoMaster-2, 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.

LIMITED LIFETIME WARRANTY

Your AmmoMaster-2 is warranted to be free from defects in material or workmanship for as long as the original owner owns it. This warranty is extended only to 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 AmmoMaster-2 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 AmmoMaster-2 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 LIMITED LIFETIME 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 LIMITED LIFETIME 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 press. 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.
- DO NOT attempt to prime military cartridge cases with crimped/staked primer pockets until the crimp/staking has been removed with a reamer or by swaging.

Attempting to seat primers into staked/crimped primer pockets can result in primer detonation, which can cause serious personal injury.

- DO NOT decap live primers. This is extremely dangerous and can result in primer detonation causing serious personal injury.
- 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.

GENERAL INFORMATION

The single-stage AmmoMaster-2 is a large, strong press that provides the handloader with all the clearance, strength, and leverage to reload all rifle and pistol calibers. With the RCBS legendary compound leverage system and massive 1 1/2" diameter ram, the AmmoMaster-2 will form cases or swage bullets. The 7/8"-14 top thread allows the use of standard reloading dies and many RCBS accessories. With 7" between the top plate and the main press frame, the AmmoMaster-2 will easily handle the longest standard cartridge including the .50 BMG (additional products required).

UNPACKING

Unpack the press carefully and look for the items listed below. Refer to the parts list for identification.

- Press
- Handle and handle nut
- Primer catcher
- Ram Priming Unit

INSTALLATION

Mount the AmmoMaster-2 Press to a sturdy workbench or table with three bolts of sufficient length to penetrate the press base and bench. Install the threaded portion of the handle through the toggle block as shown in Photo 1. Attach the handle nut and tighten firmly. The handle nut must remain tight at all times to avoid damage to the handle and toggle block. To correctly position the primer catcher, snap it onto the rear post as shown in Photo 2. Spent primers drop through the partially hollow ram and into the primer catcher. The AmmoMaster-2 ram accepts removable type shell holders. To install a shell holder, insert and rotate the shell holder into the adapter until it snaps into place.



Photo 1



Photo 2

DIE INSTALLATION

Refer to the instructions received with your reloading die set for the proper installation of dies. Adjust the dies the same as you would in any single stage press. See Photos 3, 4 and Photo 5.



Photo 3 - Installing Size Die



Photo 4 - Size die to shell holder contact



Photo 5 - seating

PRIMING with the RAM™. Priming Unit

The AmmoMaster-2 is supplied with a Ram Priming Unit. The unit includes the RAM Priming Body, Primer Rod Holder, large and small Primer Rod Assemblies, Hex Lock Nut and Shell Holder Spring. The RAM Priming Body threads into the 7/8" – 14 threaded insert in the top of the press and accepts standard Shell Holders. The Primer Rod Holder snaps into the press ram and holds the Primer Rod Assembly.

Described here are two methods for primer seating using the RAM Priming Unit. Priming should be accomplished following either procedure precisely.

The first method of primer seating, known as "seating primers by feel," is as follows:

1. Remove standard Shell Holder from press ram.
2. Install Primer Rod Holder in ram. Photo 6.

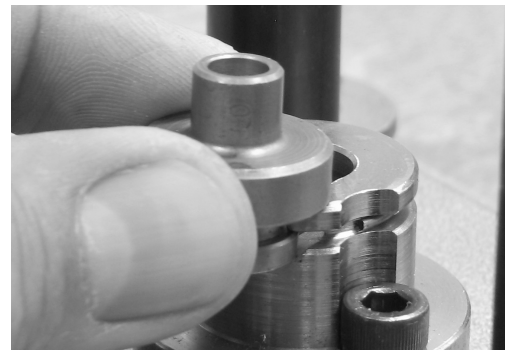


Photo 6

3. Thread the RAM Priming Body into the press, positioning it so the Die Lock Ring is even with the top of the threads of the body and the shell holder slot is facing the front. Secure by tightening the Die Lock Ring. Photo 7.



Photo 7

4. Insert appropriate Shell Holder (not supplied) into RAM Priming Body. Photo 8

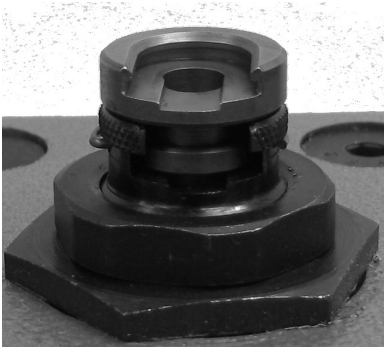


Photo 8

5. Assemble large or small Primer Rod Assembly as appropriate. To assemble the Primer Rod Assemblies: Select the correct primer plug and sleeve (large or small). Drop the primer plug through the sleeve. Place the spring on top of the primer rod. Screw the primer plug into the top of the primer rod. Tighten the assembly with a small nail or straightened paper clip through the hole in the primer plug. Do not over-tighten. Place assembly into Holder. Photo 9



Photo 9

6. Position the ram at the top of its stroke. The Primer Plug Assembly should come to rest extending approximately 1/2 inch above the Shell Holder. Photo 10.



Photo 10

To prime, with clean dry oil free hands, simply place the primer into the extended Primer Rod Assembly, photo 11. Raise the operating handle of the press slightly, so that the Primer Rod Assembly has dropped below the level of the Shell Holder. Insert a deprimed cartridge case, photo 12 and lower the operating handle until the primer is seated.



Photo 11



Photo 12

Proper primer seating requires that the primer be seated between .002 inch and .004 inch below the case head. Both insufficient and excessive primer seating depth greatly decrease primer sensitivity and can result in misfires. Due to the mechanical advantages of most presses, it is possible to over-seat or crush primers during seating. Great care must be exercised until you learn the proper "feel".

The second and perhaps more precise method of primer seating, known as "seating primers to a positive stop," is as follows:

7. Repeat steps 1 – 6.
8. Loosen the Hex Lock Nut and unscrew the Ram Priming Body approximately 1/2 inch until proper primer seating is achieved exactly at the end of the ram stroke. Proper adjustment can be achieved only by trial and error.

Subsequent primer seating depth using this second method will vary only as much as the variation in the rim thickness of your cartridge cases.

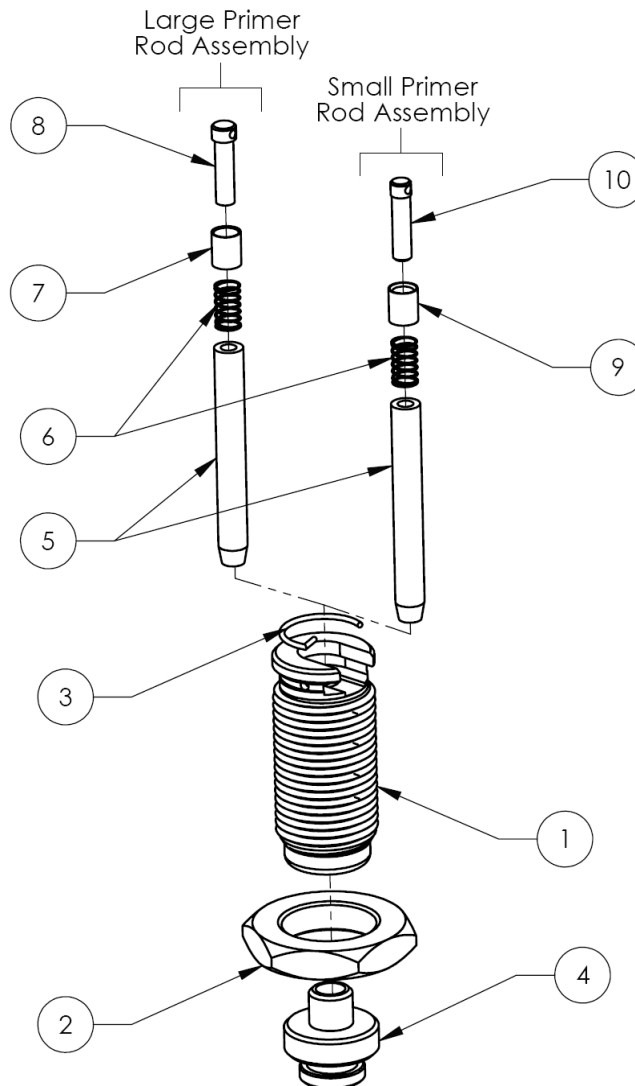
Again, priming should be accomplished following either procedure precisely.

MAINTENANCE

This press was lubricated when assembled at the factory. However, it is necessary to lightly lubricate all moving parts from time to time with a light lubricant such as RCBS Press Lube. If rust spots appear, swab lightly with lube and wipe dry. Care should be taken not to apply lube where it could come in contact with primer pockets or primers. Oils and grease will deactivate primers. It is a good practice to clean the press prior to lubrication to remove grit and other residue. You will note the ease at which the epoxy enamel paint wipes clean. This finish is impervious to oil and is extremely chip and fade resistant.

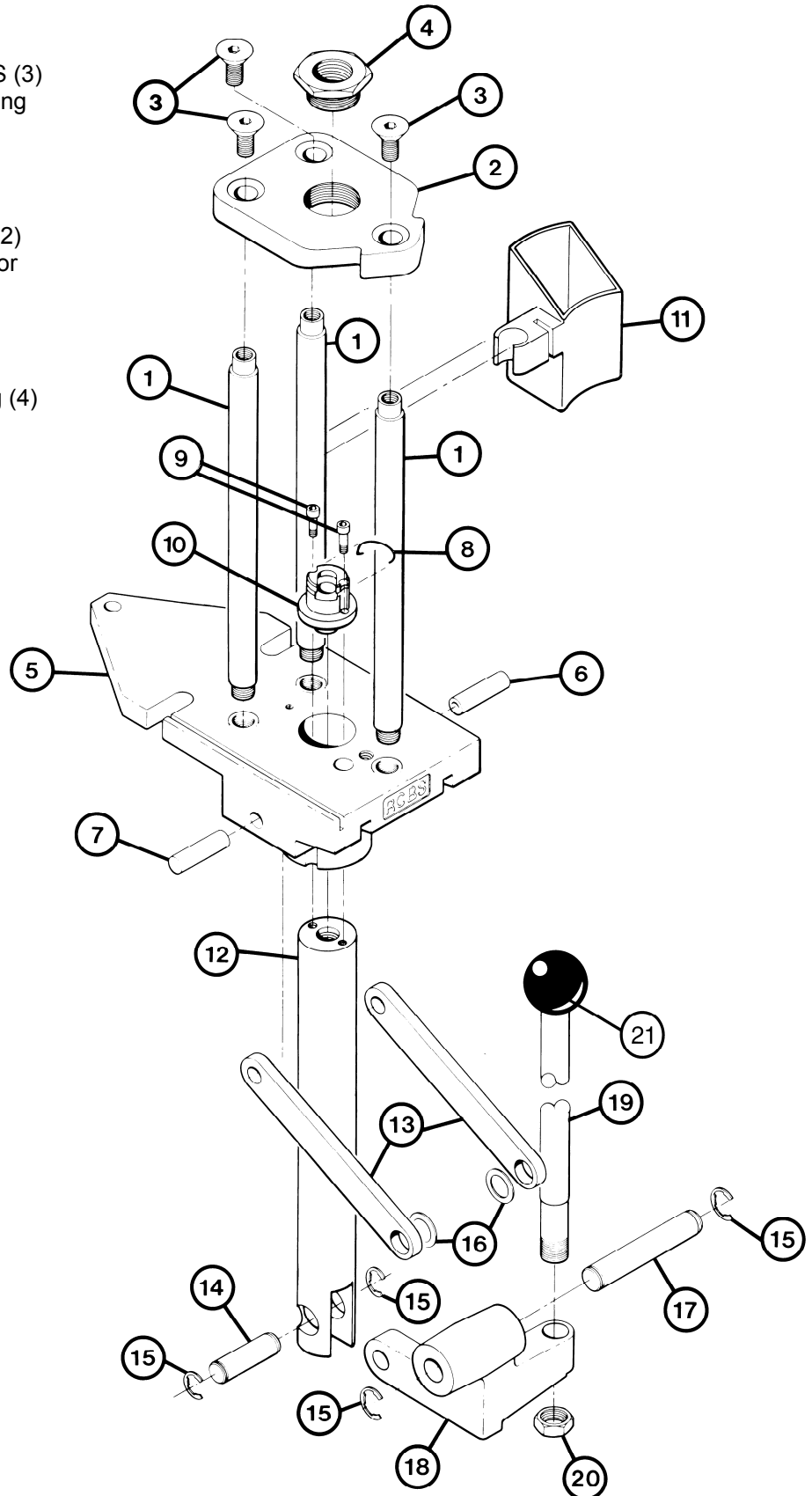
⚠ WARNING Periodically disassemble and clean the priming system to remove primer mix residue. This is particularly necessary when using tube priming systems to reduce the chance of mass primer detonation which can result in serious injury or property damage.

ITEM #	PART #	DESCRIPTION
1	7709175	Ram Priming/ Shell Holder Die
2	7109187	Hex Lock Nut, 7/8-14
3	7109112	Shell Holder Clip Spring
4	7709176	Priming Rod Holder
5	7709463	Priming Rod
6	7109508	Primer Plug Spring
7	7709506	Primer Sleeve, Large
8	7709554	Primer Plug, Large
9	7709507	Primer Sleeve, Small
10	7709555	Primer Plug, Small



AMMOMASTER-2 SINGLE-STAGE RELOADING PRESS PARTS LIST

KEY	PART #	DESCRIPTION
1	7788722	Support Rod (3)
2	7788731	1-1/2" Top Plate
3	7188750	3/8"-16 x 1" FHSCS (3)
4	7788748	1-1/2" to 7/8" Bushing
5	7788710	Base
6	7709128	Link Pin, Right
7	7709127	Link Pin, Left
8	7109112	Ram Clip Spring
9	7187159	SHCS 1/4"-28 x 3/4" (2)
10	7788715	Shell Holder Adaptor
11	7188732	Primer Catcher
12	7788714	Ram
13	7188719	Linkage Arms (2)
14	7787166	Ram Pin
15	7109105	1/2" Retaining Ring (4)
16	7109144	Bow Washer (2)
17	7788712	Toggle Block Pin
18	7788711	Toggle Block
19	7786867	Handle
20	7109136	Handle Lock Nut
21	7109121	Handle Ball





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, 6:30am - 4:00pm Pacific Time
(hours may vary)

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

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ALLIANT POWDER - CCI - CHAMPION TRAPS & TARGETS
EAGLE - ESTATE CARTRIDGE - FEDERAL AMMUNITION - FUSION AMMUNITION
GUNSLICK PRO - NITREX - OUTERS - RCBS - RAMLINE
SHOOTERS RIDGE - SPEER - WEAVER

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