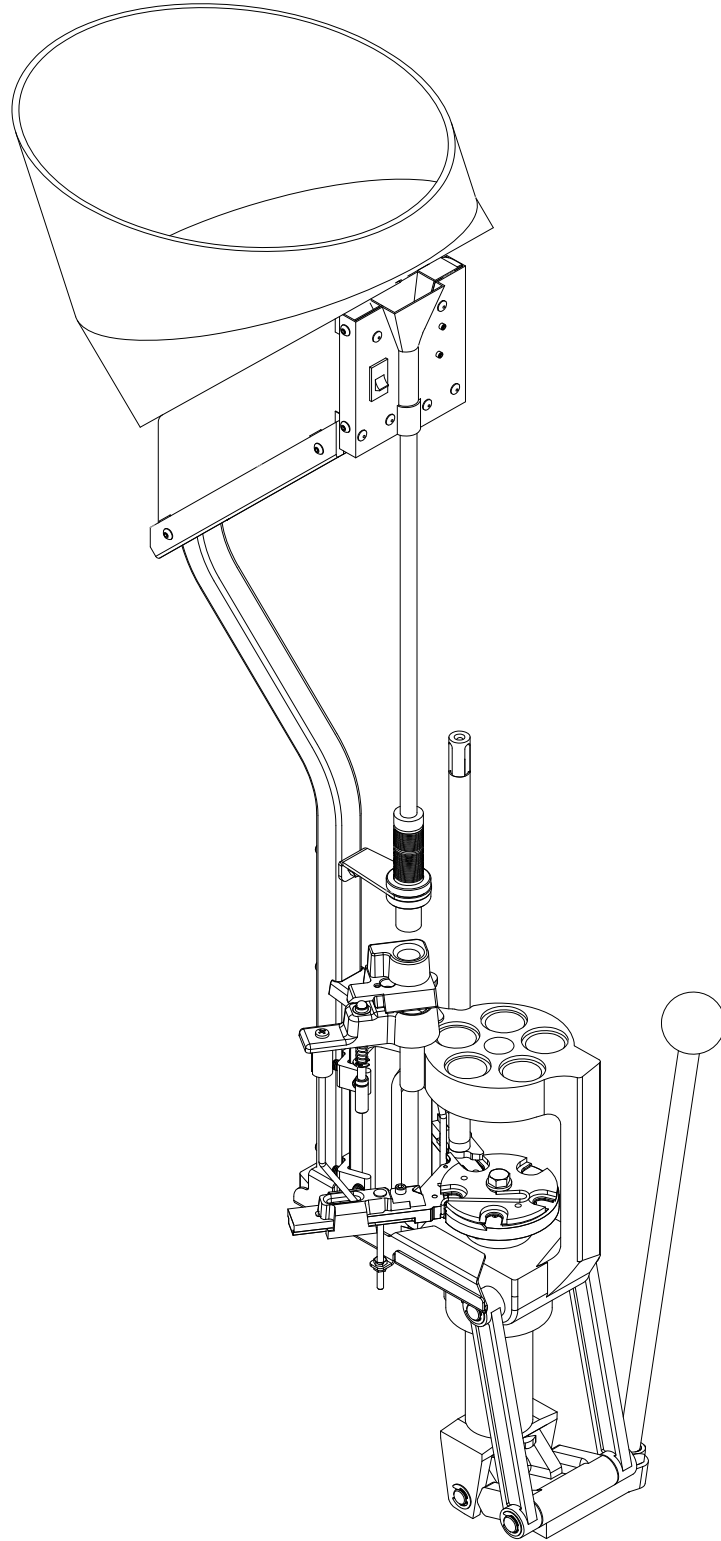


# Lock-N-Load Auto Progressive *Case Feeder*



**OPERATION MANUAL**

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## **Hornady Lock-N-Load Auto Progressive**

Your new AP Case Feeder has been packaged to insure minimal shifting and damage during transportation.

Remove all the parts from the shipping box and spread them out over a large flat surface. Refer to the parts list on pages 28-29 to make sure all necessary parts are identified.

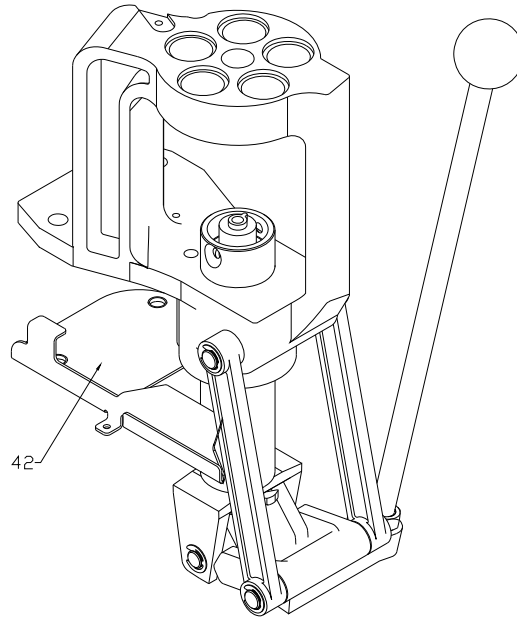
The manual provides step-by-step instructions and suggestions that make set-up and operation easy and understandable.

- *Remember, everything is designed and machined to fit easily together without modification. If you find that it is necessary to force parts together, stop and check the instructions and illustrations we have provided.*

### **List of needed hand tools:**

- **3/8" wrench**
- **7/16" wrench**
- **9/16" wrench**
- **1/8" Allen wrench**
- **5/32" Allen wrench**
- **3/16" Allen wrench**
- **Pliers or vise grips**
- **Small hammer**

## Step 1: Mounting the Lock-N-Load Auto Progressive *with* Case Feeder



**Figure 1: AP with main bracket.**

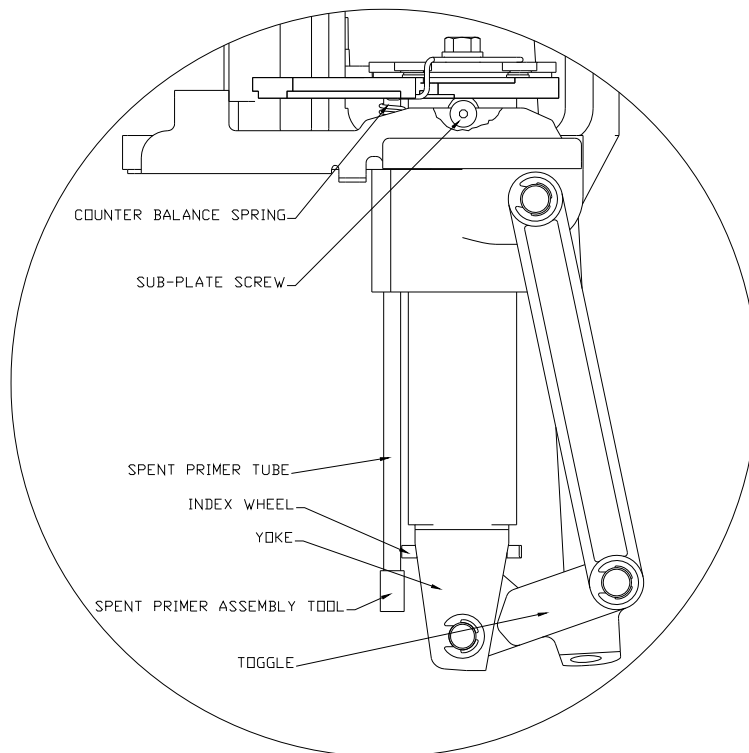
- Your work area should be well lit and have plenty of room for your reloading accessories. Your Hornady Lock-N-Load AP should be mounted securely to the edge of a solid level bench approximately 2 ¼” from the center of holes to the front edge of the table when using the optional case feeder.
- While facing the bench and using the Main Bracket (#42) for a pattern, mark and drill the mounting holes. Mount the press using (2) 5/16” bolts that are long enough to secure the press to the bench with plenty of clearance for the nuts. (*Due to variations of benches we have chosen to not provide these items*) We also recommend using 5/16” flat washers at both ends of the bolts with lock washers on the bottom side of the table. Washers are required on the two mounting bolts when using the case feeder system.
- Place the Main Bracket (#42) on the bench and verify that the mounting holes line up with the holes. Place the Bracket on the underside of the Press Frame. Place one of the 5/16 bolts through the mounting hole from the top. Place the press and bracket on the bench, and run the bolt down through the appropriate hole and secure it to the bench with a nut and washer assembly (finger tight is good for now). Align the second hole, and using the second bolt, secure it to the bench. Operate the press; to make sure that the bench does not interfere with it’s operation. If everything is functioning proper, tighten the nuts on the bolts to finish securing the press and mounting plate to the bench.

***See Figure 1 for details.***

**Step 2: Changing the Sub-Plate.**

**(This step is necessary only if you are installing the case feeder to an existing press, with a serial number lower than 07000.) The new Sub-Plate (Part Number 398309) is sold separately. The new priming system (Part Number 095210) is also sold separately for presses with serial # prior to 07000.**

- Raise the Eject Wire (#46) to move it out of the way.
- Use a 9/16” end wrench to remove the bolt holding down the shell plate and remove the shell plate.
- Remove the case retainer spring.
- Remove the primer feed assembly.
- Unhook the extension spring from the primer slide and remove it from the Sub-Plate (#44).
- Remove the primer slide from the Sub-Plate.



**Figure 2: Spent primer tubes dismantle / assembly.**

- Place the spent primer assembly tool in the bottom of the spent primer tube. Take a pair of pliers or vise grips and clamp onto the spent primer tube approximately 1/4” from the end and *tap* the pliers with a hammer to remove the spent primer tube. Be careful not to lose the Counter Balance spring.

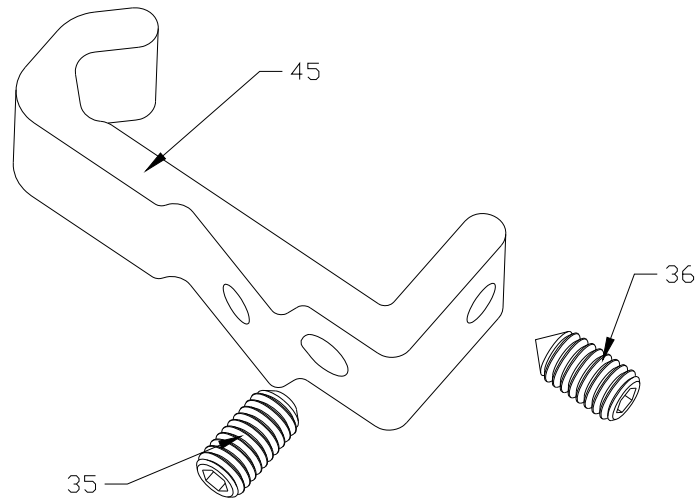
**See Figure 2 for more details.**

- Raise the ram to the top of the stroke and “Block” it into place

- The Ram can be blocked into place by inserting the handle of a medium sized screw driver between the “Toggle” and the “Yoke” near the pawls. Be careful not to put extreme pressure on the Index wheel as you may damage it.
- Use a 5/32” Allen wrench to remove the two screws that secure the Sub-Plate onto the ram.
- Remove the “Block” and lower the ram and remove the “Sub-Plate”.
- Install the new “Sub-Plate”, raise the ram and replace the “Block” before installing the screws and tightening them very tight. (Be careful not to strip the socket or damage the threads.)
- Once again, remove the “Block”, lower the ram and replace all parts in the reverse order that you removed them.

*The instructions thru Step 5 are for a Lock-N-Load Auto Progressive Frame without the new machined bosses on the frame, serial # 07279 and later.*

**Step 3: Assemble the square tubing brackets.**  
*See Figure 3 for more details.*

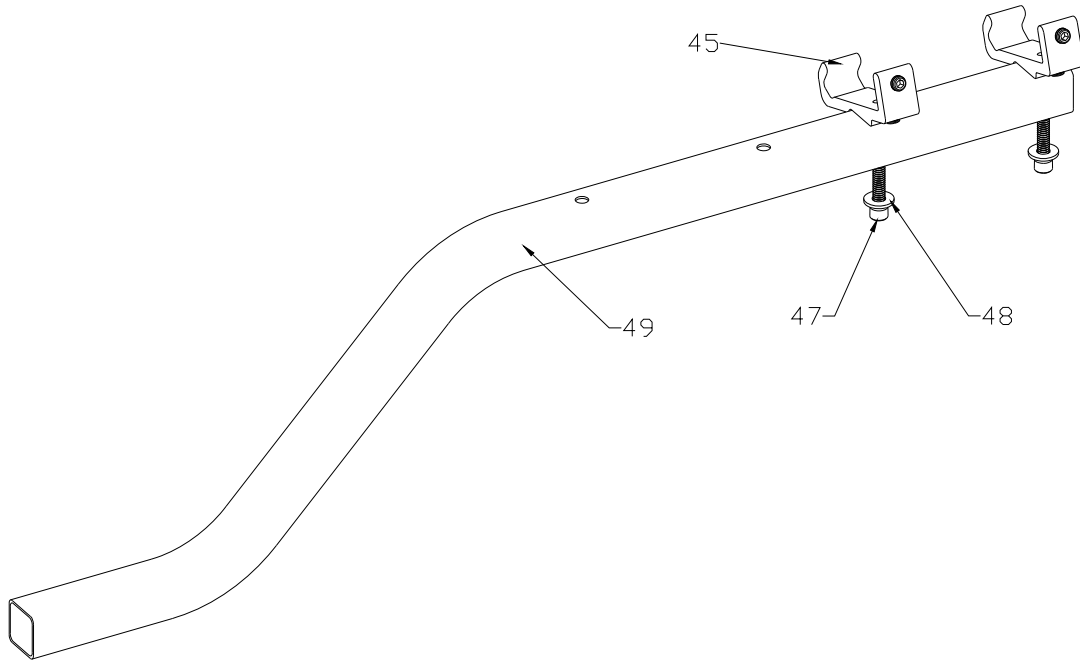


**Figure 3: Square tubing bracket with set screws.**

- Lay the two Brackets (#45) in front of you along with two 5/16-18 x 5/8 *Cup* Set Screws (#35) and two 5/16-18 x 5/8 *Cone Point* Set Screws (#36).
- Place one *Cone Point* Set Screw (#36) into the side of the Square Tubing Bracket (#45) until the point is just flush with the inside surface of the Bracket.
- Place one (#35) *Cup* Set Screw in the back of the Bracket until the cup point is just flush with the inside of the Bracket.
- Repeat these steps for the second Bracket.

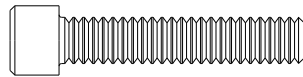


**Step 4: Mounting the square tubing brackets on to the square tubing.**  
*See Figure 4 for more details.*



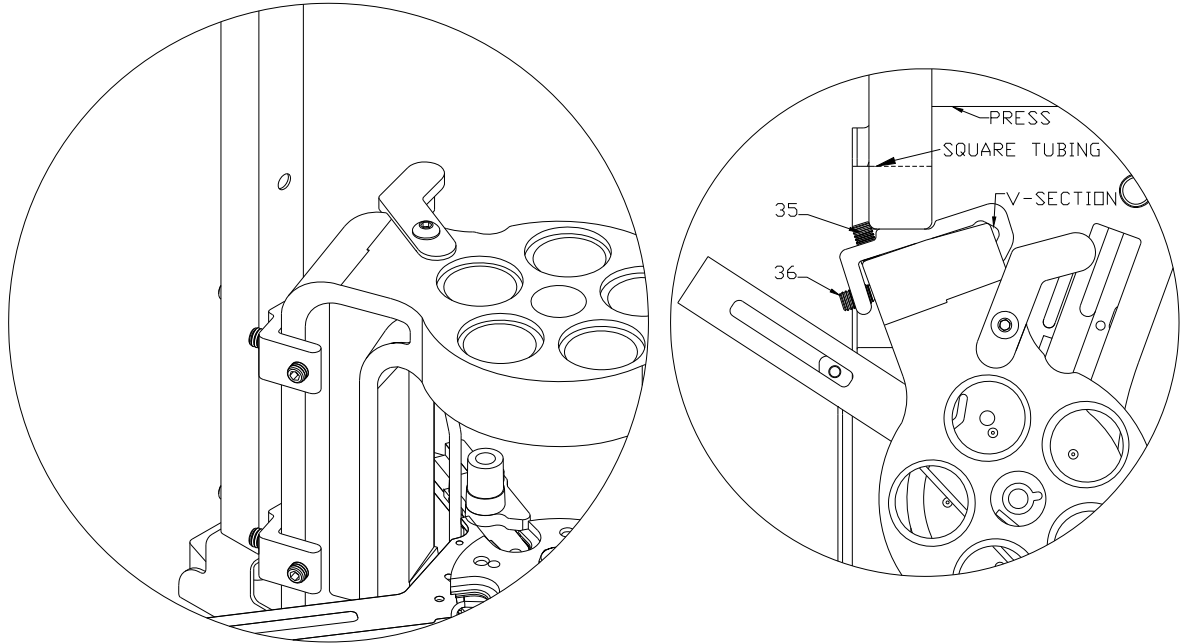
**Figure 4: Square tubing brackets with square tubing.**

- Place the 1/4" Flat Washers (#48) on the 1/4-20 x 1 1/4" Socket Head Cap Screw (SHCS) (#47).
- Place one SHCS thru the Square Tubing (#49) and into one of the Square Tubing Brackets (#45) as shown and tighten finger tight.
- Repeat for the second Bracket.



1/4-20 1 1/4" Cap Screw (Full Size)

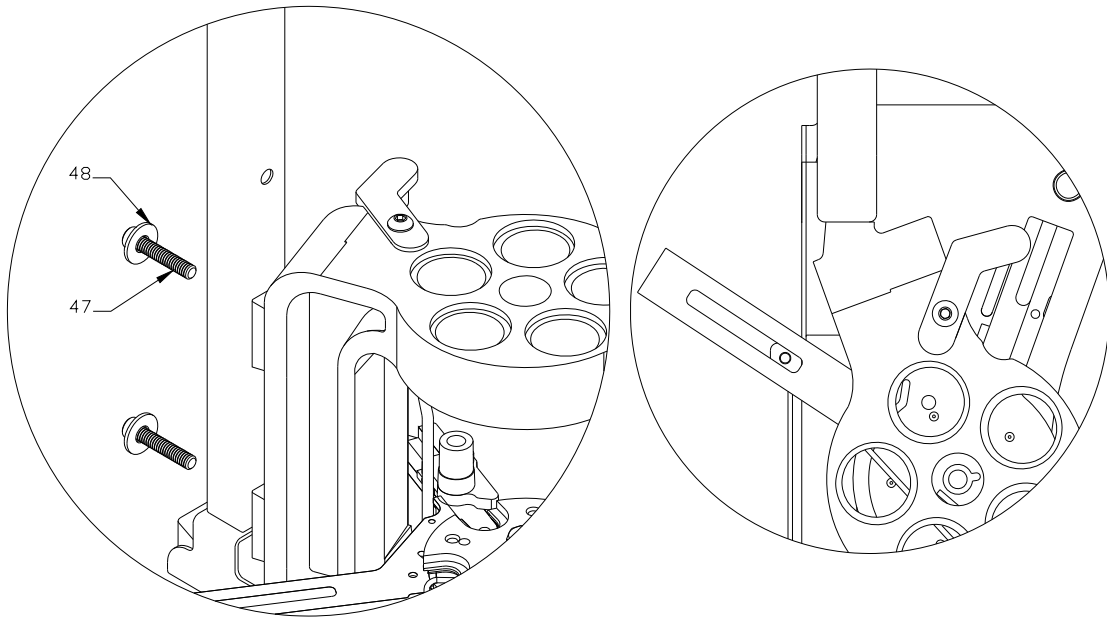
**Step 5: Assemble the square tubing and brackets to the frame of the AP Press.**  
*(This step is a preliminary adjustment and will be completed later in the assembly.)*  
 See Figure 5 for more details.



**Figure 5: Square tubing brackets to the frame.**

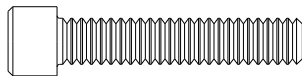
- While standing to the left side of the press, (your left), hook the v-section of bracket to the rib *on the corner of the frame*.
- Rotate the square tubing with the brackets counter clockwise (CCW) around the corner of the press. *Make sure that the tube rests on the tab of the mounting bracket.*
- Tighten the two (Cone Point) set screws (#36) until about half of the angled point is past the corner of the rib on the press.
- Tighten the two (Cup Point) set screws (#35) until the square tubing assembly is *secure*.
- Finish by tightening the screws (#47) on the Square tubing and bracket assembly.
- The back of the square tubing should be parallel to the back edge of the frame. If it is not, you will need to readjust it using the set screws.
- The assembly can be rotated clockwise by loosening the Cone Point screws (#36) and tightening the Cup Points (#35), and *visa versa* to rotate it Counter Clockwise. *Complete the installation by tightening the Cup Point Set Screws (#35).*

**Step 6: Assemble the square tubing to the frame of the AP Press.  
(For serial numbers beyond 07279.)**



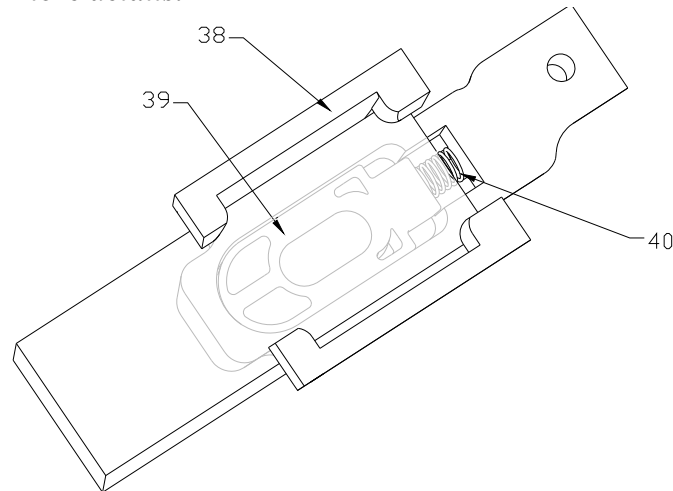
**Figure 6: Square tubing to the frame.**

- Place the ¼” Flat Washers (#48) on the ¼-20 x 1 ¼” Socket Head Cap Screw (SHCS) (#47).
- Place one SHCS thru the Square Tubing (#49) and thread into the Frame.
- Repeat for the second Bracket.
- Tighten both screws down using a 3/16” Allen wrench.



¼-20 1 ¼” Cap Screw (Full Size)

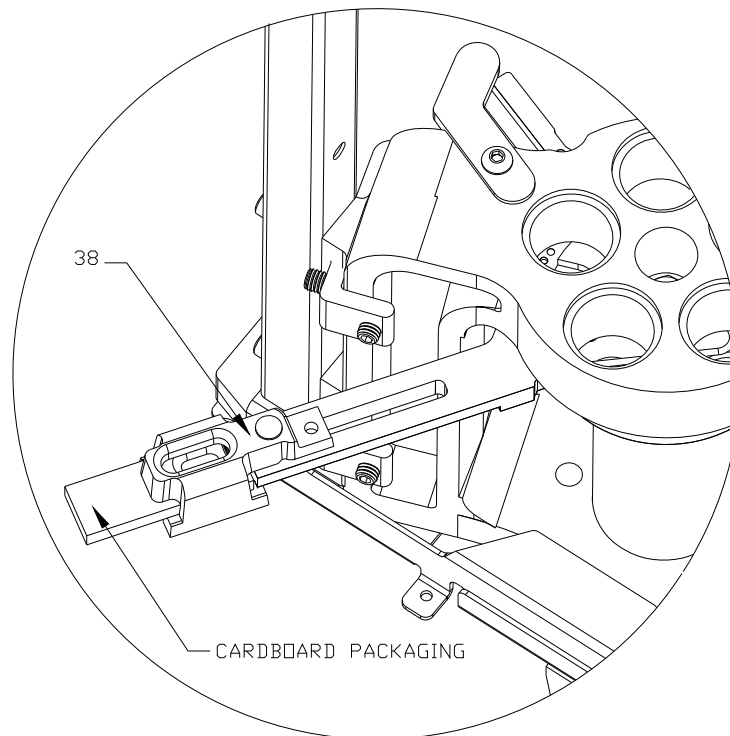
**Step 7: Adding the case slide on to the sub-plate.**  
*See Figure 7b for more details.*



**Figure 7a: Case slide assembly.**

- While holding the case slide (#38) upside down in one hand, *pull the cardboard packaging rearward till the front edge bi-sects the foot at the front of the slide.*

**See Figure 7a for more details.**



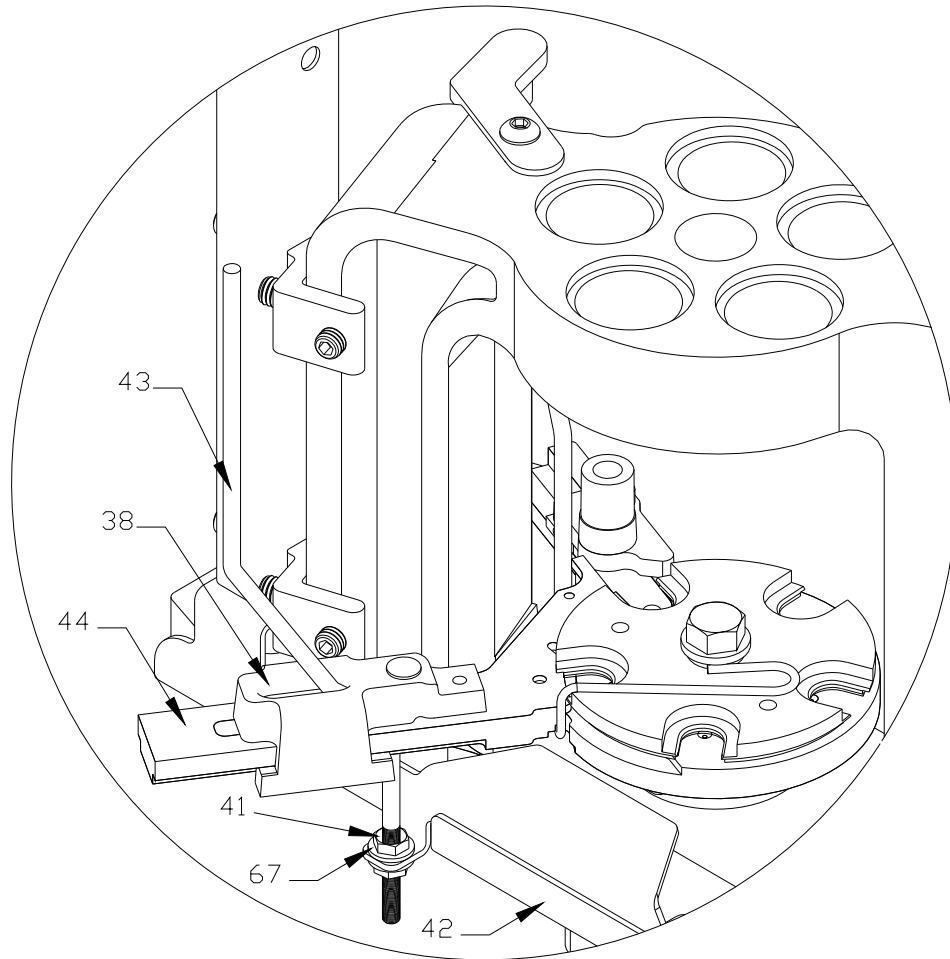
**Figure 7b: Case slide and sub-plate assembly.**

- Turn the Case Slide (#38) right side up and start the slide onto the rail of the sub-plate. While holding the end of the cardboard, push the slide onto the rail. *You may need to push up on the bottom of the cardboard while you are pushing it on the sub-plate.*

- If now or anytime in the future the guide and spring come out of the slide, they can be assembled by placing the spring in the relief of the slide and hooking the relief of the guide onto the end of the spring. Slide the guide forward and compress the spring until the guide fits into the pocket. You may need to hold the “guide and spring” into the Slide with your finger as you slide the assembly back onto the “Sub-Plate.”

**Step 8: Inserting the cam wire into the assembly.**

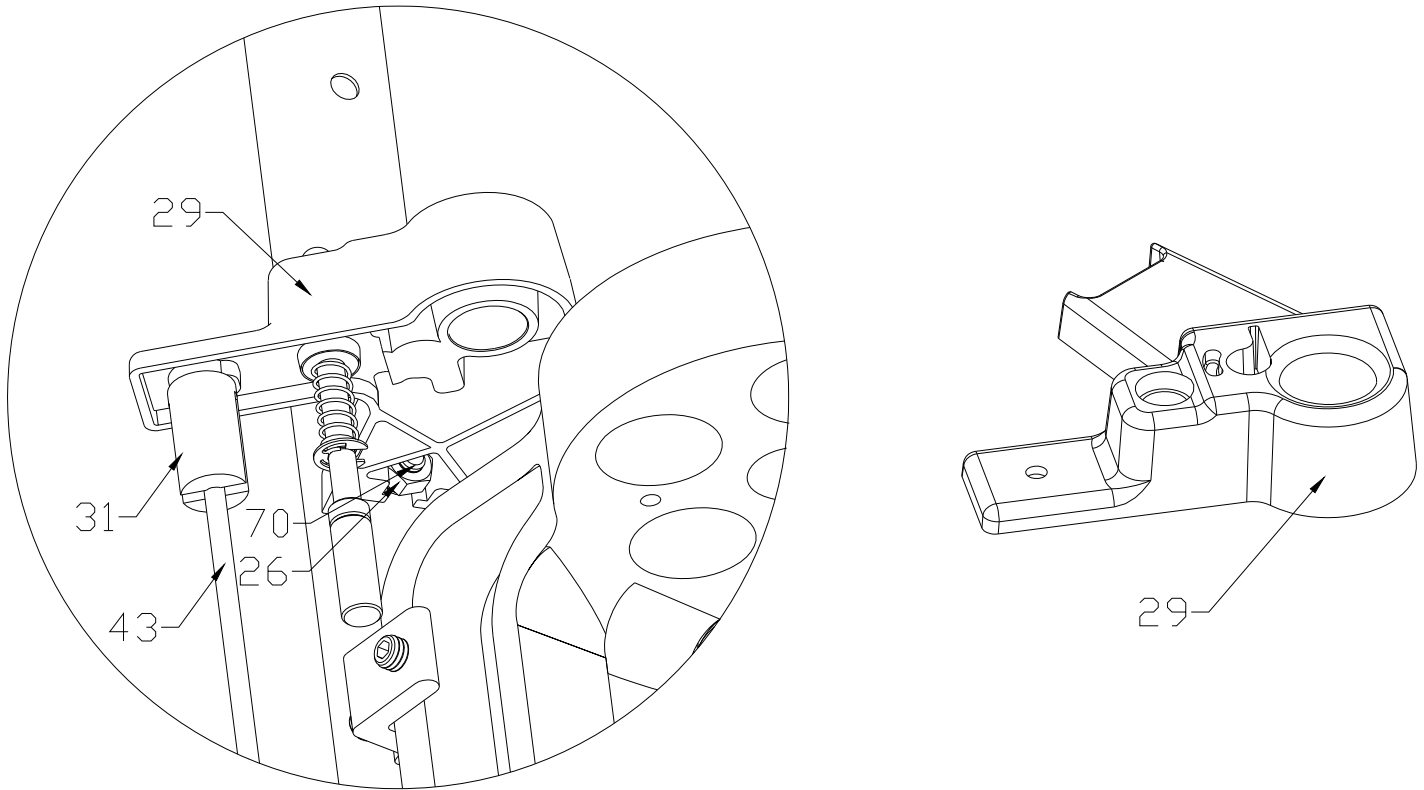
*See figure 8 for more details.*



**Figure 8: Assembly of cam wire.**

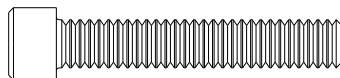
- Raise the ram to the top of the stroke.
- Screw one #10-32 Hex Nut (#41) on to the Cam Wire (#43) approximately 1” from the end.
- Place one of the #10 Flat Washers (#67) onto the Cam Wire (#43).
- From the bottom of the Sub-Plate (#44), slide the non threaded end of the Cam Wire (#43) through the slot of the Sub-Plate (#44) and through the Case Slide (#38).
- Insert the threaded end of the Cam Wire through the hole of the tab on the Main Bracket (#42).
- Insert the other Flat Washer (#67) and Hex Nut (#41) onto the bottom of the Cam Wire (#43) and tighten finger tight.
- Lower the ram.

**Step 9: Case escapement bracket assembly.**  
*See Figure 9 for details.*



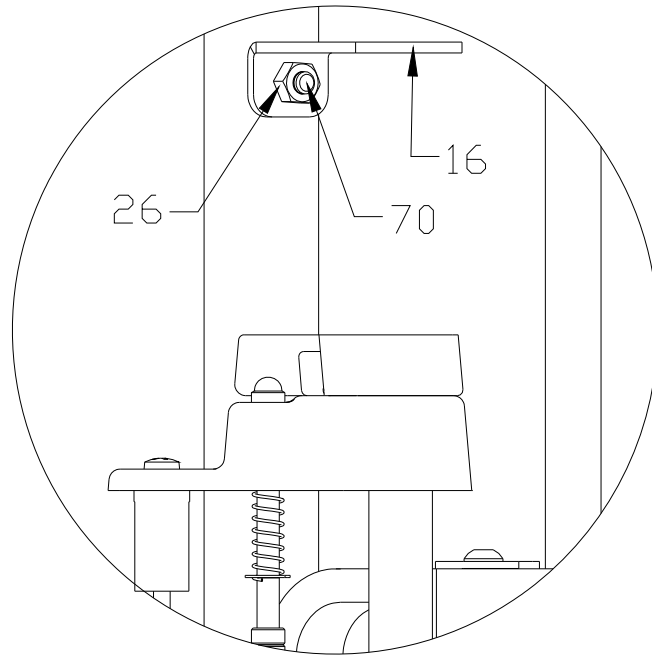
**Figure 9: Assembling Case escapement bracket on square tubing.**

- Put a ¼” Flat Washer (#48) on the ¼-20 X 1 ½” Cap Screw (#70).
- Slide the Cap Screw (#70) thru the Square Tubing and thread the Hex Nut (#26), on approximately the length of the nut.
- Slip the Case Escapement Body (#29) over the Cap Screw so the Hex Nut (#26) is in the slot on the back of the Case Escapement Body. (#29)
- Slip the Cam Wire (#43) into the Cam Wire Support (#31).
- Tighten the Cap Screw (#70) while holding the Bracket level with the top of the frame.



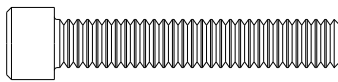
¼-20 x 1 ½” Cap Screw (Full Size)

**Step 10: Feed Tube Mounting Bracket to the square tubing.**  
*See Figure 10 for more details.*



**Figure 10: Feed Tube Mounting Bracket with square tubing.**

- Put a ¼” Flat Washer (#48) on a ¼-20 X 1 ½” Cap Screw (#70).
- Slide the Cap Screw (#70) thru the Square Tubing and place the Feed Tube Mounting Bracket (#16) over the Cap Screw (#70), then insert the Hex Nut (#26) on the Cap Screw and tighten. Make sure that the top of the Feed Tube Mounting Bracket (#16) is level. Check with a small level if you are unsure.



¼-20 x 1 ½” Cap Screw (Full Size)



**Step 11: Determine which cartridge case you are going to be loading.**

**Chart 1 below shows what parts are needed for different size of cases.**

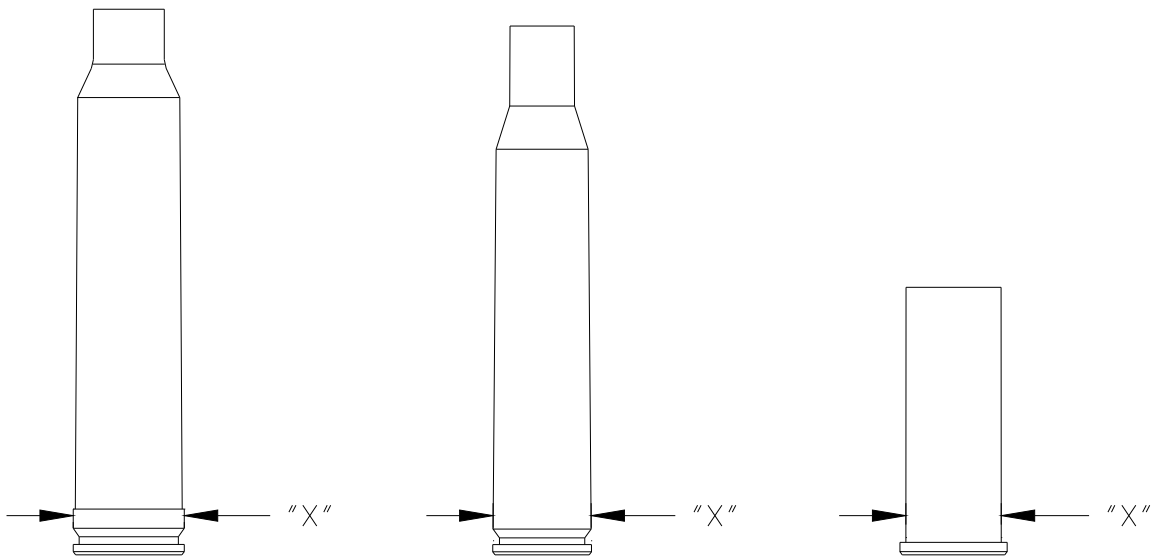
Cases	Item #'s Required Pg. 28 & 29	Notes
Small Pistol (9mm, 40 S&W, etc..)	66,14,50,52,53	Cases smaller than .43" maximum diameters
Large Pistol (.357 Mag., .44 Mag, etc..)	13,15,22	Cases larger than .43" maximum diameters
Small Rifle (.223, 22 Hornet)	66,14,50,18,51,52,53	Cases smaller than .43" maximum diameters
Large Rifle (243 Win., 45-70 Govt., etc..)	13,15,18,22	Cases larger than .43" maximum diameters

**Chart 1: Cartridge Case change over chart.**

*If you find that some cases such as the 40 S&W are tight in the Feed Tube –Small (#14), you may need to use the part of both the large and small feed tubes. For example, 40 S&W could use item numbers 13, 15, 19 and 53.*

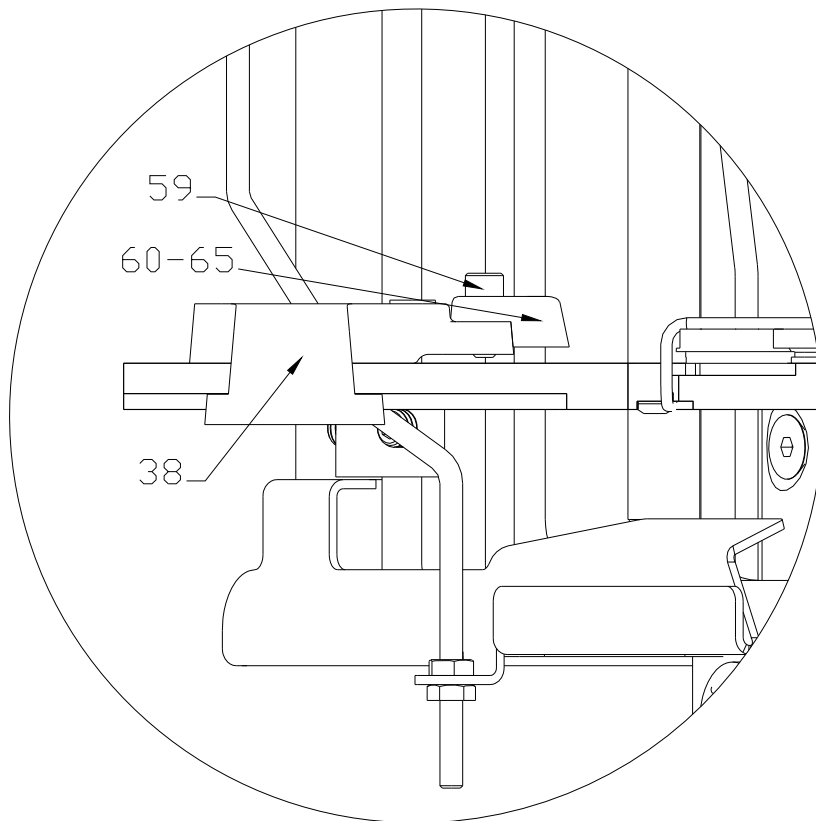
*See figure 11 for more details on selecting the V-Block.*

CASES	DIAMETERS "X"	V-BLOCK #	V-BLOCKS P/N:
22 Hornet	.27-.30	1	398292
9mm, .223	.37-.39	2	398293
44 Mag.	.35-.38	3	398294
30-06	.42-.47	4	398295
458 Win. Mag.	.46-.58	5	398296
10mm	.41-.44	6	398297



**Figure 11: V-Block selection chart.**

**Step 12: Installing the V-Block onto the case slide.**



**Figure 12: Inserting the V-block.**

- With the ram at the bottom of the stroke (idle position), set the V-Block (item #60-#65) onto the Case Slide (#38).
- Place the #10-24 X 1/2 Cap Screw (#59) through the hole of the V-Block and screw it into the Case Slide. Before you tighten the Cap Screw, push the V-Block back into the Case Slide and snug the Cap Screw with your fingers.

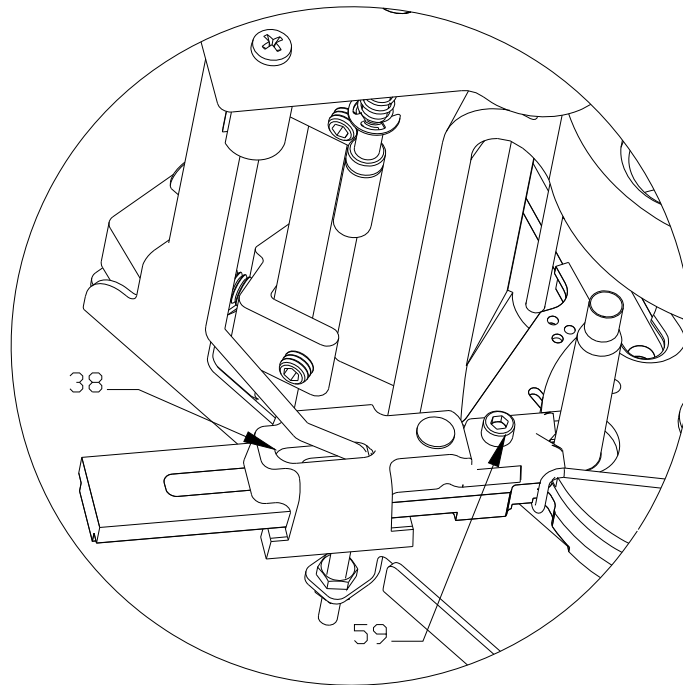
**Step 13: Determine which shell plate is required for your application.**  
*See Chart 2 below to help with this selection.*

<b>SHELL PLATE NO. 1</b>	358 Win.	7MM Merrill	38/357/357 Max.	<b>SHELL PLATE NO. 14</b>	204 Ruger	<b>SHELL PLATE NO. 36</b>
<b>Item No. 392601</b>	9.3x57			<b>Item No. 392614</b>		<b>Item No. 392636</b>
5.6x57	9.3x62	<b>SHELL PLATE NO. 5</b>	<b>SHELL PLATE NO. 7</b>	33 Win.	<b>SHELL PLATE NO. 22</b>	32 S&W Long/Short/H&R
22/250	44 Auto Mag.	<b>Item No. 392605</b>	<b>Item No. 392607</b>	338/378 Wby.	<b>Item No. 392622</b>	300 Win. Short Mag
240 Wby.	45 ACP/WM	257 Wby. 6.5 Rem. Mag.	218 Bee	460 Wby.	30 M1 Carbine	
243 Win.	260 Rem.	264 Win. Mag.	25/20 Win.	45/70 Govt.	32 ACP	<b>SHELL PLATE NO. 40</b>
244/6MM		270 Wby.	32/20 Win.	416 Wby.		<b>Item No. 392640</b>
6MM int.	<b>SHELL PLATE NO. 2</b>	7MM Rem. Mag.		480/475 Linebaugh	<b>SHELL PLATE NO. 26</b>	50 AE
6MM/284	<b>Item No. 392602</b>	7MM Wby.	<b>SHELL PLATE NO. 8</b>		<b>Item No. 392626</b>	
6MM Br	219 Zipper	300 H&H	<b>Item No. 392608</b>	<b>SHELL PLATE NO. 15</b>	35 Remington	<b>SHELL PLATE NO. 41</b>
250 Sav.	5.6x52R	300 Win. Mag.	30 Luger	<b>Item No. 392615</b>		<b>Item No. 392641</b>
25/06	22 Sav. HP	300 Wby.	9MM Luger	376 Steyr	<b>SHELL PLATE NO. 29</b>	45 Schofeild
257 Rbts.	25/35 Win.	300 Re. Ul. Mag.	9x18 Makarov		<b>Item No. 392629</b>	
25/284	30/30 Win.	308 Norma Mag.	38 Super Auto	<b>SHELL PLATE NO. 16</b>	41 Mag.	<b>SHELL PLATE NO. 43</b>
6.5/06	30 Herrett	8MM Rem. Mag.	9x23	<b>Item No. 392616</b>		<b>Item No. 392643</b>
6.5 x 57	32 Win. Spl.	338 Win. Mag.		17 Rem.	<b>SHELL PLATE NO. 30</b>	338 Lapua
270 Win.	8.15x46 R	340 Wby.	<b>SHELL PLATE NO. 9</b>	17/222	<b>Item No. 392630</b>	
7x57 (7MM mau.)	357 Herrett	350 Rem. Mag.	<b>Item No. 392609</b>	17/223	6.5x68	<b>SHELL PLATE NO. 44</b>
7MM/08	375 Win.	358 Norma Mag.	38/40 Win.	221 Rem.	8x68 S	<b>Item No. 392644</b>
7MM Rem. BR	7x30 Waters	375 H&H	44/40 Win.	222 Rem.	7.5 Swiss	500 S&W
7x64	32/40	416 Rem. Mag.		222 Rem. Mag.	357/44 B&D	
7MM Exp/280		458 Win.	<b>SHELL PLATE NO. 10</b>	5.6x50 Mag.	44 Spl./44 Mag.	
284 Win.	<b>SHELL PLATE NO. 3</b>	450 Marlin	<b>Item No. 392610</b>	223 Rem.		
300 Sav.	<b>Item No. 392603</b>		10MM Auto	6MM/223	<b>SHELL PLATE NO. 32</b>	
308 Win.	22 Hornet	<b>SHELL PLATE NO. 6</b>	40 S&W	6x47 Rem.	<b>Item No. 392632</b>	
30/06	22-K Hornet	<b>Item No. 392606</b>		6.5MM TCU	45 Long colt	
7.7 Jap.		22 PPC	<b>SHELL PLATE NO. 11</b>	7MM TCU	454 Casull	
8MM Mau.	<b>SHELL PLATE NO. 4</b>	22 RCFM-Jet	<b>Item No. 392611</b>	7MM/223 Ingram		
8MM /06	<b>Item No. 392304</b>	256 Win.	303 British	7x47 Helm	<b>SHELL PLATE NO. 35</b>	
8x60 S	220 Swift	6MM PPC	30/40 Krag	380 Auto	<b>Item No. 392635</b>	
35 Whelen	225 Winchester	7.62x39		6MM TCU	6x61 S&H	

**Chart 2: Shell Plate selection chart.**

**Changing and installing the shell plate.**  
*(Refer to the operations manual for the AP Press.)*

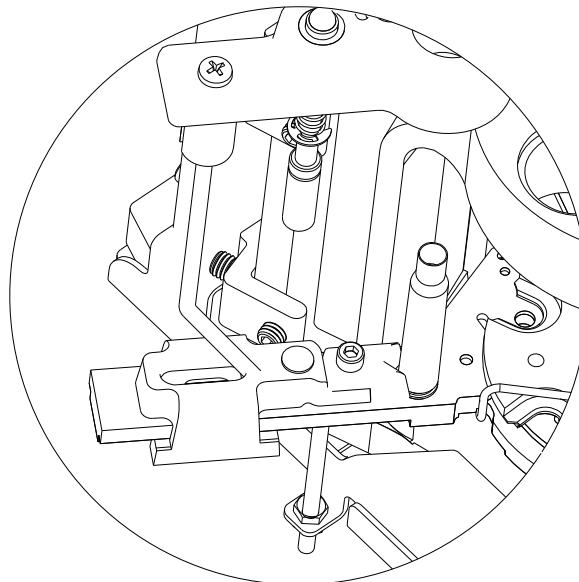
**Step 14: Setting the timing of the cam wire.**



**Figure 13: Adjusting the V-block.**

- Place a case of the proper size into the shell plate and manually push the Case Slide (#38) and V-Block into the case. Loosen the Cap Screw (#59) and continue to push the Case Slide into the case. Tighten the Cap Screw (#59) with a 3/16" allen wrench.

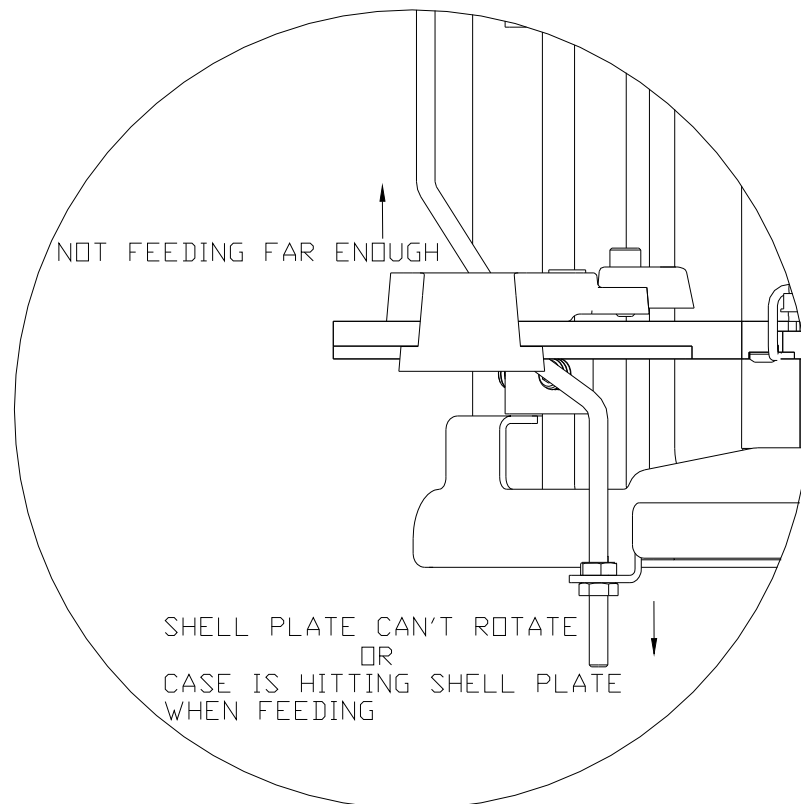
*See Figure 13 for more details.*



**Figure 14: Feeding a case.**

- Raise the ram until the shell plate rotates and place a case (of the proper size) in-front of the V-Block on the Sub-Plate. Lower the ram so the Case Slide will advance the case into the shell plate.

See Figure 13 for more details.



**Figure 15: Cam rod adjustment.**

If the “Cam Wire” is too high, it will:

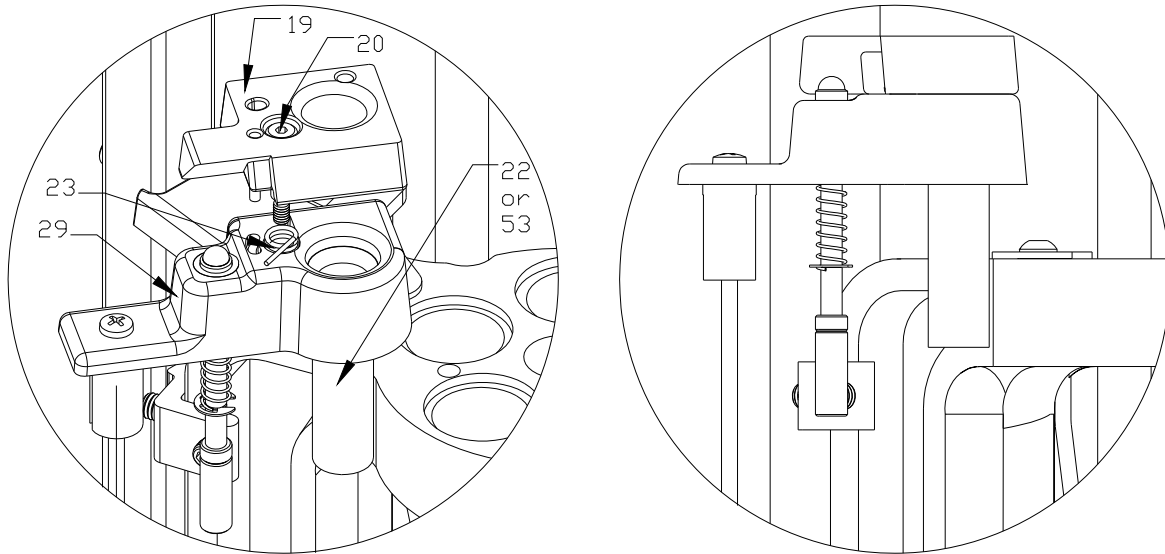
1. Not allow the “Shell Plate” to advance. Loosen the upper nut several turns and pull the wire down.
2. The case will hit the “Shell Plate” before it rotates. Again, loosen the upper nut and move the wire down, but do this in small increments, as you are close.

If the wire is too low, it will:

1. Not advance the case into the shell plate. Loosen the Lower nut and tighten the upper one to move the cam down.

Once the timing is correct, snug both nuts to the bracket and make sure the cam is centered in the Slide. This can be adjusted manually by rotating it around the threaded end a small amount. Tighten the nuts to complete the timing process. ***This timing setting is adequate for all cartridges, and it should not be necessary to make future changes.***

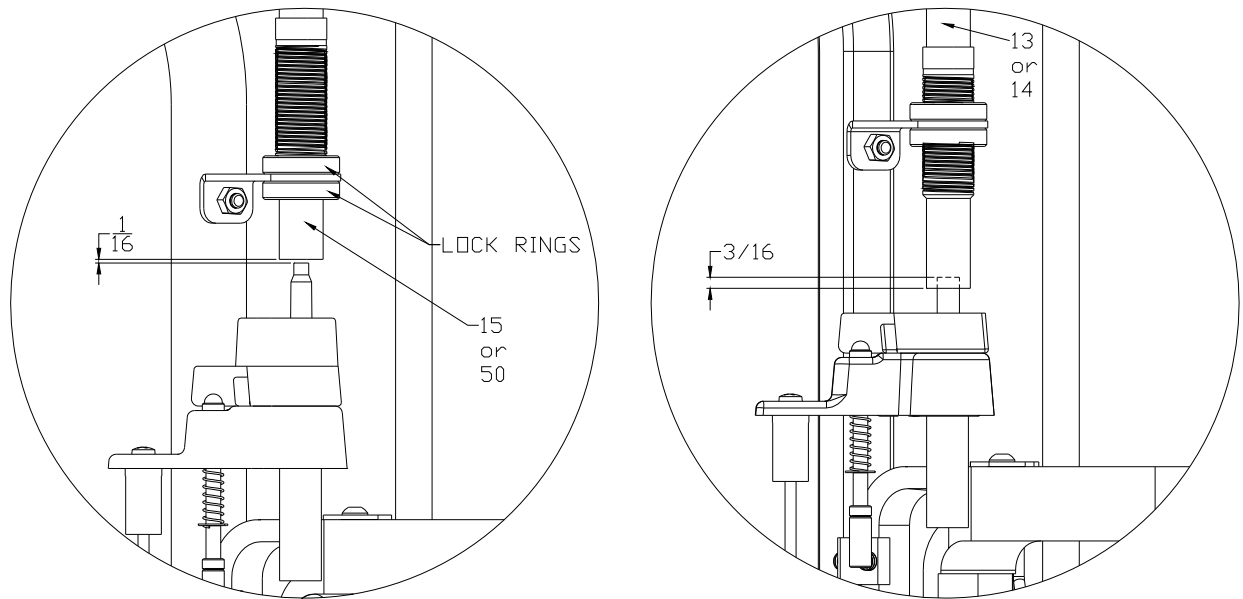
**Step 15: Assembling the feed tube end and pivot.**  
*See Figure 15 for more details.*



**Figure 16: Pivot Assembly.**

- If the maximum case diameter is larger than .43 you will need to use the large tube (#22). If it is smaller, you will need the small tube (#53). Place the correct one into the pivot block (#29).
- Place the torsion spring (#23) into the slot in the pivot block (#29), leaving the long leg on the top side. The spring will only fit one way.
- Set the pivot (#19) on top of the pivot block. Make sure you line up the under cut on the cam with the torsion spring. The leg of the torsion spring will fit into the slot on the cam.
- When this fits together the pivot should fit on top of the pivot block. The dowel pin in the cam will fit into the curved slot on the cam block.
- Then insert the shoulder bolt (#20) into the pivot and into the pivot block and tighten with an allen wrench.
- Actuate the pivot by hand to make sure it will rotate properly.
- For small rifle cases place the pivot adapter bushing (#51) into the hole of the pivot adapter. See pg. 25 for more details.
- Place the pivot adapter (#18) on top of the pivot for rifle cases (See pg. 25 for more details).

## Step 16: Placing the Feed tube end on the assembly.



17a.

17b.

Figure 17: Setting the Feed tube end.

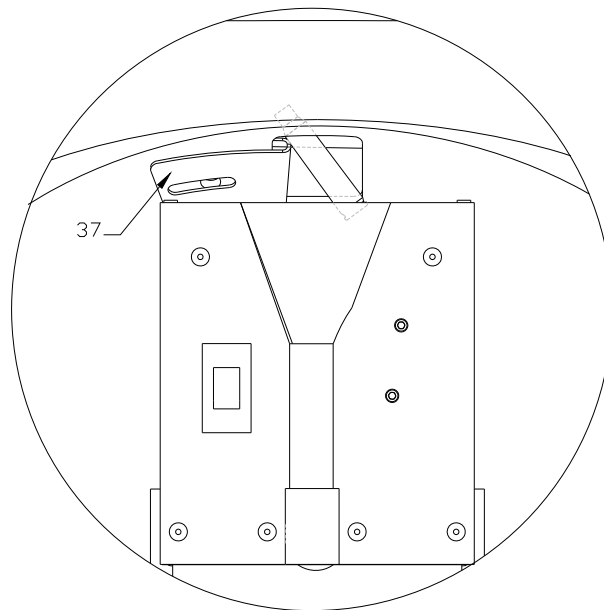
- Select the tube for your application (#15 or #50), see pages 25 and 26.
- Screw one lock ring on the tube.
- Place it thru the hole on the feed tube mounting bracket. Adjust the height of the tube to have approximately 1/16" below the bottom of the tube to the case mouth. *(See Figure 16a for more details.)* With some cases such as the 357 Mag. it may be necessary to adjust the tube to where the case mouth sits up inside of the tube approximately 3/16". *(See Figure 16b for more details.)* These are both starting points, and for your particular case, it may need to be adjusted a little differently. *(Long skinny cases, which are shorter than 1.50" long will not work with the Pivot Adapter (#18). They may need to be supported at the mouth of the case by the Feed Tubes (#15 or #50). This will allow the case to feed down the Drop Tubes (#22 or #53) with out falling over and causing double or triple feeds.*
- Screw on the other lock ring.
- Select the proper "Feed Tube" (#13 or #14) and insert it in the top of the "Feed Tube End" (#15 or #50). If you select The Small Feed Tube (#14), you will have to use the Plastic Feed Tube Small Bushing (#66), see pages 25 and 26. *(When feeding some cases (such as the 357 Mag.) you may notice that the base of the case will not fall into the hole of the pivot every-time. The base will ride on the radius of the pivot hole. You can operate the press with the cases doing this and when the push rod (#24) starts to rotate the cam, the case will fall into the hole).*

**Step 17: Selecting the case feed wheel for your application.**  
*See Chart 3 for more details.*

Small Pistol Case Feed Wheel	Large Pistol Case Feed Wheel	Small Rifle Case Feed Wheel	Large Rifle Case Feed Wheel	Large Rifle Cont.	Large Rifle Cont.	Large Rifle Cont.
P/N: 095310	P/N: 095312	P/N: 095314	P/N: 095316			
9mm	10mm Auto	7.62 X 39	6mm Rem.	.284 Win.	.356 Win.	.300 Rem. Saum
9 X 21	.357 Mag.	.17 Rem.	6.5mm Rem. Mag.	.30 Rem.	.358 Win.	.300 WSM
.38 Super	.357 Rem. Max.	.218 Bee	6.5 X 55 Swedish Mauser	.30-06 Springfield	.375 H&H Mag.	.300 Dakota
9 X 18 Makarov	.38 Long Colt	.222 Rem./Rem Mag.	7mm Mauser (7 X 57)	.30-30 Win.	.375 Win.	.300 Rem. Ultra Mag.
9mm Win Mag	.38 Short Colt	.223 Rem (5.56mm)	7mm Rem. Mag.	.30-40 Krag	.38-55 Win.	.338 Rem. Ultra Mag.
.30 Luger	.38 S&W	.30 Carbine	7mm WBY Mag.	.300 H&H Mag.	.416 Rem. Mag.	.340 WBY Mag.
.32 ACP	.38 Spl.	.32-20 Win.	7mm-08 Rem.	.300 Savage	.416 Rigby	.378 WBY Mag.
.32 H&R Mag	.41 Rem. Mag.	.351 Win Self Loading	7-30 Waters	.300 WBY Mag.	.444 Marlin	.404 Jeffery
.32 Long Colt	.44 Spl/Mag.	.25-20 Win.	8mm Mauser (8 X 57)	.300 Win. Mag.	.45-70 Govt.	.460 WBY Mag.
.32 Short Colt	.45 ACP		8mm Rem. Mag.	.303 British	.458 Win. Mag.	500 S&W
.32 S&W	.45 Auto Rim.		.22-250	.303 Savage	.458 Lott	
.32 S&W Long	.45 Colt		.220 Swift	.307 Win.	.450 Marlin	
.380 Auto	.45 Win. Mag.		.225 Win.	.308 Win.	.376 Steyr	
.22 Hornet	.454 Casull		.243 Win.	.32 Rem.	.405 Win.	
40 S & W	9 X 25		.25-06	.32 Win. Spl.	.240 WBY Mag.	
	.22 Rem. Jet		.25-35 Win.	.32-40 Win.	.257 WBY Mag.	
	.256 Win. Mag.		.250 Savage	.338 Win. Mag.	.270 WBY Mag.	
	.475 Linebaugh		.257 Roberts	.348 Win.	.270 WSM	
	.480 Ruger		.264 Win. Mag.	.35 Rem.	7mm Rem Saum	
	.38-40 Win.		.270 Win.	.35 Whelen	7mm STW	
	.44-40 Win.		.280 Rem.	.350 Rem.	7mm Rem. Ultra Mag.	

**Chart 3: Case feed wheel selection chart.**

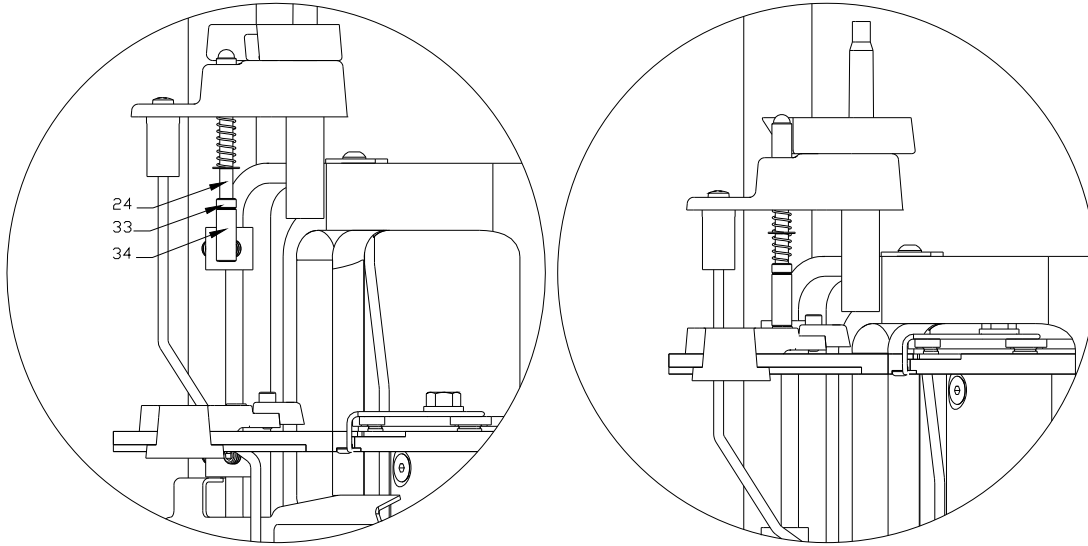




**Figure 18: Case feed bowl door adjustment.**

- Select the Case Feed Plate (item #54-57) for your application and place it on the motor shaft. The clutch on the plate will slip onto the motor shaft fitting flush to the bottom of the Case Feed Bowl (#1).
  - Place the O-Ring onto the Feed Tube Large (#13) approximately 2” from one end. The O-Ring when pushed down on top of the Feed Tube End (#15) will hold the feed tube into the funnel on the case feed bowl.
  - Set the Case Feed Bowl (#1) on top of the Square Tubing (#49) while inserting the Feed Tube (#13 or #14) into the Case Feed Funnel Assembly (#8) and plug it into a power outlet.
  - If you are loading **rifle** cartridges you will need to adjust the Case Feed Door (#37).
  - Loosen the ¼” Button Head Cap Screw (#68) and slide the Case Feed Door Adjustment (#37) so the opening is approximately ¾ the length of the case. *This is a preliminary setting.* Place a hand-full of cases into the Case Feed Bowl (#1).
  - Turn the motor on and observe to see if the cases will fall base first. If they do not, readjust the Case Feed Bowl Door Adjustment (#37) until they do with out hanging up or getting caught.
  - Re-tighten the ¼” Button Head Cap Screw (#68).
  - To load pistol cases, completely open the Case Feed Door Adjustment.
- See figure 17 for more details.*

## Step 18: Adjusting the push rod.



**Figure 19: Push Rod adjustment.**

- Screw the Push Rod Nut (#33) and the Push Rod Lower (#34) onto the Push Rod (#24) until the Push Rod Lower (#34) bottoms out on the thread.
- Place a case in the hole of the Pivot (#19) and the Escapement Height adjuster (#18) (if required).
- Raise the ram to the top of the stroke slowly, so the Case Slide (#38) will actuate the Push Rod (#24) and Pivot (#19). The Pivot (#19) should rotate far enough to drop a case down the Feed tube (#13-14). If it does not, lower the ram just far enough to take the pressure off of the Push rod (#24). Screw the Push Rod Lower (#34) down a couple of turns and retry. When the Pivot (#19) is dropping a case thru the Feed Tube, screw the Push Rod Nut (#33) down on top of the Push Rod Lower (#34) and tighten with your fingers.
- If the case is falling on top of the V-Block, refer to step Step 5.

### Single case operation

*(To feed cases singly without using the case feeder.)*

- Remove the Push Rod Lower (#34).

This will allow the press to be cycled without dropping cases.

### Fail-safe mechanism

The Cam Wire (#43) has a fail-safe mechanism at its top (Cam Wire Support #31). The Cam Wire Support (#31) holds the Cam Wire (#43) in place. If a malfunction occurs, the Cam Wire (#43) is able to snap out of the support to prevent damage to the Cam Wire.

## Maintenance of the Lock-N-Load A/P Case Feeder

As with all equipment, proper and routine maintenance will provide smooth operation and a longer life for your reloading press and Case Feeder. At the end of each reloading session, wipe off all spilled powder, any dirt, etc., from the press. Check all moving parts for dirt or spilled powder and remove with a clean rag.

### Tips for trouble-Free operation

<b>Problems</b>	<b>Solutions</b>	<b>Step</b>
Cases are hitting the back corner of the shell plate when feeding into the shell plate.	Slow timing down <b>or</b> Re-adjust V-Block location	13
Cases are not feeding into the shell plate far enough	Speed timing up <b>or</b> Using the wrong V-Block	13
Cases are tipping when going into the shellplate	Re-adjust V-Block location	13
Cases are falling on top of the V-Block	Re-adjust the Bracket, Square Tubing	5
Drop tube is tight against the AP Frame; will not allow changing of tubes	Re-adjust the Bracket, Square Tubing	5
Cases are falling mouth first out of the bowl	Close the door adjustment	16
Cases are getting caught in the open hole on the bowl	Open the door adjustment	16
The shell plate is hitting the V-Block when it's rotating	Lower the Cam Wire	13

**Chart 4: Trouble free operation.**

## Bill of Materials

Item No.	Production Part Number	Qty.	Description	Item No.	Production Part Number	Qty.	Description
1	398327	1	CASE FEED BOWL	37	398285	1	CASE FEED DOOR ADJUSTMENT
2	398313	4	10-32 x 3/4 FHSCS	38	398291	1	CASE SLIDE
3	398374	8	10-24 "U" Nut	39	398307	1	CASE SLIDE ROD GUIDE
4	398415	8	#8 x 1/2 SHEET METAL SCREW PAN HEAD PHILIPS	40	398308	1	CASE SLIDE ROD GUIDE SPRING
5	398326	1	MOTOR HOUSING	41	392011	2	10-32 HEX HEAD NUT
6	398375	2	4-40 HEX HEAD LOCK NUT	42	398289	1	MAIN BRACKET
7	398333	1	MICRO SWITCH	43	398299	1	CAM WIRE
8	398369	1	CASE FEED FUNNEL ASSEMBLY	44	398309R	1	SUB-PLATE (ON PRESS OR WITH RETROFIT KIT)
9	398376	1	4-40 X 5/8 BHSCS	45	398287	2	BRACKET, SQ. TUBING
10	398332	2	ROCKER SWITCH	46	398345	1	EJECT WIRE (ON SUB-PLATE #44)
11	398331	1	MOTOR	47	398312	2	1/4-20 X 1.25 SHCS
12	398328	1	MOTOR COVER	48	390128	4	1/4 FLAT WASHER ZINC PLATED
13	398320	1	FEED TUBE - LARGE	49	398284	1	CASE FEED STAND
14	398321	1	FEED TUBE - SMALL	50	398304	1	FEED TUBE END - SMALL
15	398303	1	FEED TUBE END - LARGE	51	398300	1	PIVOT ADAPTER BUSHING
16	398286	1	FEED TUBE MOUNTING BRACKET	52	398301	1	PIVOT BUSHING
17	396440	2	LOCK RING	53	398306	1	DROP TUBE - SMALL
18	398298	1	PIVOT ADAPTER	54*	095310		CASE FEED PLATE- SMALL PISTOL
19	398290	1	PIVOT	55*	095312		CASE FEED PLATE - LARGE PISTOL
20	398310	1	1/4-3/4 SHOULDER BOLT	56*	095314		CASE FEED PLATE - SMALL RIFLE
21	398311	1	3/0 X 3/4 TAPER PIN	57*	095316		CASE FEED PLATE - LARGE RIFEL
22	398305	1	DROP TUBE - LARGE	58	059100		AP PRESS
23	398288	1	SPRING, TORSION	59	392338	1	10-24 X 1/2 SHCS
24	398317	1	PUSH ROD	60	398293	1	V-BLOCK #1
25	398371	1	PUSH ROD TIP	61	398297	1	V-BLOCK #2
26	390178	2	1/4-20 HEX HEAD NUT	62	398294	1	V-BLOCK #3
27	398349	1	PUSH ROD BUSHING	63	398292	1	V-BLOCK #4
28	398364	1	10 X 1/2 SHEET METAL SCREW PAN HEAD PHILIPS	64	398295	1	V-BLOCK #5
29	398344	1	PIVOT BODY	65	398296	1	V-BLOCK #6
30	398363	1	PUSH ROD SPRING	66	398324	1	PLASTIC FEED TUBE SMALL BUSHING
31	398343	1	CAM WIRE SUPPORT	67	390651	2	3/16" FLAT WASHER SAE
32	398425	1	E CLIP 1/4	68	390410	1	10-24 x 1/4 BHSCS
33	398373	1	PUSH ROD NUT	69	398370	1	CASE FEED BOWL BUSHING
34	398372	1	PUSH ROD LOWER	70	398388	2	1/4-20 X 1.50 SHCS
35	398314	2	5/16 -18 X 5/8 SET SCREW CUP	71	398416	1	O-RING 7/8 OD, 11/16 ID
36	398315	2	5/16 -18 X 5/8 SET SCREW CONE POINT (45 DEG.)	72	398550	6	RIVET POLY BLACK

**Chart 5: Bill of Materials.**

(\*" Sold Separately) ("Italics" Pre Assembled)

