

RCBS[®]

Pro Chucker[®]

PROGRESSIVE RELOADING PRESS



PRODUCT INSTRUCTIONS

 **WARNING!**

Before using this product, read and follow these instructions carefully. Failure to do so could result in serious injury or death, or property damage.

If you have any questions while assembling or operating this product, call us at
1-800-379-1732 (US or Canada)

Hours: Monday - Friday, 5:00am - 5:00pm Pacific Time

Or email us at rcbs.tech@vistaoutdoor.com

This instruction manual contains important safety and operating information. Keep this as a permanent part of your reloading equipment. If lost, contact us for a replacement.

RELOADING SAFETY

NOTICE - This manual is not intended to provide comprehensive instructions or safety information on how to reload, or handle or use reloading components. Always read and thoroughly understand a reloading manual before attempting to reload ammunition.

Reloading is an enjoyable and rewarding hobby when conducted safely. But, as with many hobbies, carelessness or negligence can make reloading hazardous. When reloading, always follow these safety guidelines to minimize the risk of personal injury or death.

- Always wear safety glasses.
- Understand what you are doing and why. Read handbooks and manuals on reloading. Talk to experienced reloaders. Write or call suppliers of equipment or components if you have questions or are in doubt.
- Read and understand all warnings and instructions accompanying your equipment and components. If you do not have written instructions, request a copy from the manufacturer. Keep instructions for future reference.
- Don't rush or take short cuts. Establish a routine and follow it at a leisurely pace.
- Keep complete records of reloads. Label each box showing the date produced, and the type of primer, powder and bullet used.
- Do not smoke while reloading, or reload near sources of heat, sparks or flame.
- Observe good housekeeping in the reloading area. Keep tools and components neat, clean and orderly. Promptly and completely clean up any spills.
- Keep all reloading equipment and components out of reach of children.
- Stay alert. Reload only when you can give your undivided attention. Do not reload when tired, ill, rushed or under the influence of drugs or alcohol.

 **WARNING! Keep away from children.**

- This device is not intended for use by those with restricted physical, mental or sensory capabilities or those with a lack of experience and/or knowledge, including children.
- Store device out of reach of children.
- Keep device and packaging material away from children.

Because RCBS has no control over the choice, assembly or use of components or other reloading equipment, RCBS assumes no liability, express or implied, for the use of ammunition reloaded with this product.

LOADING DATA

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

 **CAUTION! OBSERVE ALL WARNINGS ABOUT THE USE OF MAXIMUM LISTED LOADS.**

WORKING WITH CARTRIDGE CASES

- Examine empty cases to be sure they are in good condition before reloading. Thin, split, deformed, or badly corroded or pitted cases may be structurally weak, and result in a dangerous condition. Pay particular attention to splits in the mouth, separation between the case and the head, and dents in the shoulder.
- Do not store cartridge cases or ammunition near harsh chemicals such as gasoline, household cleaners, or cat urine. The fumes can weaken the metal and present a dangerous condition.
- Do not clean cases with chemicals other than those specifically designed for the purpose.
- Do not attempt to clean loaded ammunition or primed cases. Doing so can cause corrosion, and weaken the case, or cause a misfire/ hangfire condition.
- Ensure cases have proper primer pocket sizes; remove primer staking/crimp if necessary. Attempting to seat a primer into an undersized pocket or pocket with staking/crimping can result in detonation.
- Do not ream out or enlarge flash holes of cartridge cases. This may change the ignition rate and result in dangerous pressures.
- Resize and trim fired cases to ensure reliable chambering and obtain proper bullet tension and crimp.
- Never attempt to guess at the identity of your ammunition.



WARNING! - Do not attempt to resize a primed case with decapping pin installed.

WORKING WITH PRIMER PICKUP TUBES

In rare circumstances, primers can become lodged in tubes that are obstructed, damaged or improperly maintained.



WARNING! Never force or pound/tap on live primers, tap or pound on loaded primer tubes, or otherwise attempt to clear obstructions on your own. Doing so can cause serious injury.

If you experience a feeding problem in a Primer Tube, follow these steps:

1. Ensure no primers are in the white plastic pickup tip.
2. Remove the white tip with pliers.
3. If possible, carefully pour the primers out of the tube and return primers to original packaging. Do not use the tube.
4. If a stuck primer(s) remains, handle with care and take to your local hazardous waste disposal facility.
5. Replacement tubes can be purchased online at RCBS.com or through an authorized dealer. Warranty claims can be made by calling RCBS at 1-800-379-1732 (US or Canada).


To avoid primer feeding problems, always follow these precautions:

- Before use, always inspect tube for damage or interior obstructions.
- Never use bent, damaged or obstructed tubes.
- Ensure tube is free from primer residue buildup. Periodically clean inside of Tube using soap and warm water. Allow Tube to dry completely before using.

PRIMER WARNINGS

 **WARNING! Primer detonation can occur if misused. To avoid serious injury, always follow these precautions:**


- Always wear safety glasses when using this or any other reloading tool.
- Never attempt to seat or reseal a primer in a loaded cartridge. Prime empty cases only.
- Before priming, ensure the case's primer pocket is properly sized. Minimum diameter is 0.1730 inch for small primers and 0.2085 inch for large primers.
- Completely remove pocket crimp from brass/case with crimped/staked primer pockets (e.g., mil spec brass).
- Never force primer into a case primer pocket. Apply slow, steady, gentle pressure and STOP if you encounter resistance.
- Make sure all reloading tools are in good condition and used in accordance with the manufacturer's instructions.
- Before each use, ensure device is clear of primer dust and other foreign objects. Disassemble and clean periodically (at least every 500 rounds).
- Seat primers flush with or below the case head to avoid inadvertent detonation by shearing or crushing.

 **DANGER! If misused, primers can explode and cause serious injury or death. Always follow these precautions:**

- Handle primers with extreme care. Do not drop or subject to heat, flame, friction, electricity, percussion (e.g., hammering, pounding, dropping) or other impact. Never smoke around primers.
- Always wear safety glasses when working with or around primers.
- To avoid the risk of multiple primers detonating, handle and use primers individually unless with a reloading tool specifically designed to safely handle multiple primers.
- Do not use primers of unknown identity or that have signs of corrosion, damage, or deformation.
- Do not decap live primers.

 **DANGER! To avoid death, serious injury or property damage, follow these storage precautions:**


- Store primers in a cool, dry environment free from wide temperature variations and under 150°F. Do not store primers in a building without temperature control (e.g., garage, shed) or where they can be exposed to direct sunlight.
- Never store primers near heat sources, electricity sources, electrical equipment or other ignition sources.
- Never store primers near gunpowder, gasoline, chemicals or other flammable or explosive material.
- To reduce the chance of multiple primers detonating, never store primers in direct contact with one another. Store primers only in the original factory container, which is specifically designed to reduce the chance of multiple primers detonating. Return unused primers to the same factory packaging for safety and to preserve their identity.
- Storage cabinets containing only primers are recommended. These cabinets should be ruggedly constructed of lumber at least 1" nominal thickness to delay or minimize the transmission of heat in the event of fire. SAAMI recommends against storing primers in sealed or pressurized containers.
- Dispose of unused primers in accordance with applicable regulations for hazardous materials.

 **DANGER!** Primer dust accumulation can detonate and cause death or serious injury. Before each use, inspect all reloading equipment and clean regularly with a damp cloth or sponge; allow surface to dry before use; thoroughly clean and rinse cloth after use. Never clean primer dust with a vacuum cleaner.


Lead Warning: Use of Primers may result in exposure to lead and other substances known to cause birth defects, reproductive harm, and other serious physical injury. Wash hands thoroughly after exposure.

PRIMER SEATING DEPTH

During priming, check cases occasionally to be sure the primers are seated to the bottom of the primer pocket. Optimum seating depth is .003 inches to .005 inches below the case head. The base of a correctly primed case will sit flat when placed on a level surface. If it rocks, the primer needs to be seated deeper. Primer residue can build up in the primer pocket of fired cases, leading to high primers. Use an RCBS® Primer Pocket Brush or Primer Pocket Uniformer of the appropriate size to clean the primer pocket of your cases before attempting to seat the primer.

 **WARNING!** An improperly seated primer can cause misfires, out-of-battery firings, delayed firings, or inadvertent detonations during storage, handling, or use and cause serious injury or property damage.

CARE AND MAINTENANCE

 **DANGER!** Small particles of priming compound can collect on surfaces in the form of yellow or gray primer dust. This accumulation of residue is extremely dangerous. Clean products regularly with a damp cloth or sponge. Allow surfaces to dry thoroughly before use. Clean and rinse cloth thoroughly after use. Do not use a vacuum cleaner. Failure to do so could cause a detonation resulting in death, serious injury, or property damage.

Clean Primer Tubes, Primer Dispensers, Primer Transfer Bars, and surrounding areas on the Shell Plate Holder every 500 rounds to prevent the build-up of primer dust. If you need additional help or replacement parts, call RCBS.

GUNPOWDER WARNINGS


 **WARNING!** Keep out of reach of children

 **WARNING!** DO NOT smoke while reloading.

- Store powders in their original package in a cool, dry environment free from wide temperature variations.
- Keep containers tightly sealed and labels intact.
- Mark date of purchase on container, for future reference. Use older stock first.
- Never use glass as a storage container. This may cause a “greenhouse effect” raising the temperature in the container and degrade the powder.
- Check container and powder for signs of degradation. Many powders will exhibit a fine red-brown dust on the granules and/ or inside the container when this happens. If it does, do not use propellant; dispose of it properly in compliance with local regulations.

- DO NOT have more than one canister of powder on the bench at one time. Powder containers 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. Properly discard all mixed powders and those of uncertain identity in compliance with local regulations.
- If you use a powder measure, after the Powder Hopper has been filled, replace the lids on both the Powder Hopper and Powder container .
- 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 (10) 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.

MACHINERY

 **WARNING** Avoid wearing *loose clothing and jewelry which can be drawn into moving/rotating components*

 **CAUTION!** Avoid pinch points on tool; keep fingers clear of moving parts.

- Keep children and others away from machinery.
- Be sure that all moving parts are shielded and all guards are in place before operating any equipment.

UNPACKING

Refer to the list below to Identify parts as you unpack your new Pro Chucker Auto Index Progressive Reloading Press.

1. Press Assembly
2. Powder Measure with CAPM* Linkage and Die
 - *CAPM: Case Activated Powder Measure

3. Spent Primer Tube
4. Safety Shield and Cap
5. Primer Tubes (4)
6. Die Plate
7. Ammo Bin/Shrunk Wrap
8. Handle Assembly
9. Parts Bags (5)

- Loose parts bags include:
- QCPM Drain Tube Attachment
 - QCPM Lock Pin Assembly
 - QCPM Large Metering Screw Assembly
 - QCPM Small Metering Screw Assembly



PRESS ASSEMBLY



PC7 POWDER MEASURE W/ CAPM LINKAGE AND DIE



PC5 POWDER MEASURE W/ CAPM LINKAGE AND DIE



QCPM SM METERING SCREW ASSEM

QCPM LOCK PIN ASSEM

QCPM LG METERING SCREW ASSEM

QCPM DRAIN TUBE



SPENT PRIMER TUBE



SAFETY SHIELD & CAP



PRIMER TUBES

- Pro2000 Parts Bag:
- CAPM* Spacer Bushing (2)
 - CAPM* Powder Bushing Large Rifle
 - CAPM* Powder Bushing Small Rifle
 - CAPM* Powder Bushing Pistol
 - Cylinder Link
 - 10-32 x 3/8 BHCS (2)



PC7 DIE PLATE



AMMO BIN/SHRUNK WRAP



10-32 X 3/8 BHCS

SPACER BUSHINGS

PISTOL BUSHING

CYLINDER LINK

SM. RIFLE

LG. RIFLE



PC5 DIE PLATE



HANDLE ASSEMBLY

Ammo Bin (Contains the following parts)

Pro Chucker parts bag #1 (Diagram A)

- Primer Plug Assembly Small
- Primer Plug Assembly Large
- Primer Dispenser
- Primer Transfer Bar Return Spring

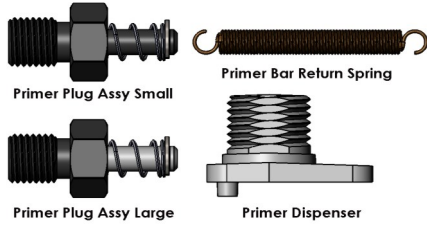


Diagram A

Pro Chucker parts bag #2 (Diagram B)

- Transfer Bar Guide
- 8-32 x 1/4" Socket Head Set Screw
- 8-32 x 3/8" Button Head Cap Screw
- 10-32 x 3/8" Button Head Cap Screw
- Nyloc Nut 7/16-20
- Shell Plate Washer
- Detent Ball 3/8"
- Index Ball Spring
- #8 Wood Screw (2)
- #10 Lock Washer

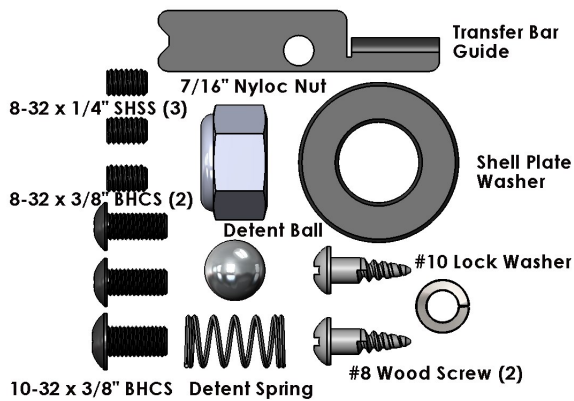


Diagram B

Pro Chucker parts bag 5 Station (Diagram C)

- Primer Transfer Bar 5 Small (2)
- Primer Transfer Bar 5 Large (2)
- Primer Transfer Bar Actuator 5
- 8-32 x 7/8" Flat Head Cap Screw (4)

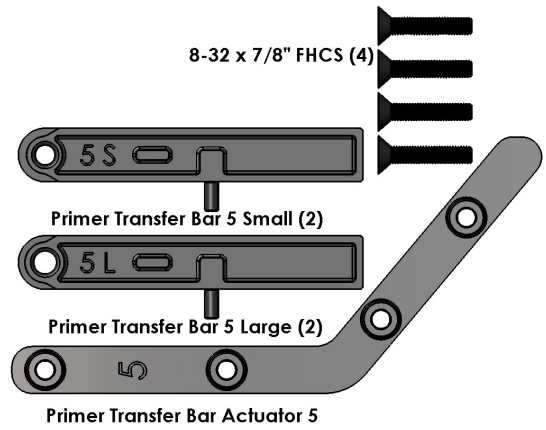


Diagram C

Pro Chucker parts bag 7 Station (Diagram D)

- Primer Transfer Bar 7 Small (2)
- Primer Transfer Bar 7 Large (2)
- Primer Transfer Bar Actuator 7
- 8-32 x 3/8" Flat Head Cap Screw (4)

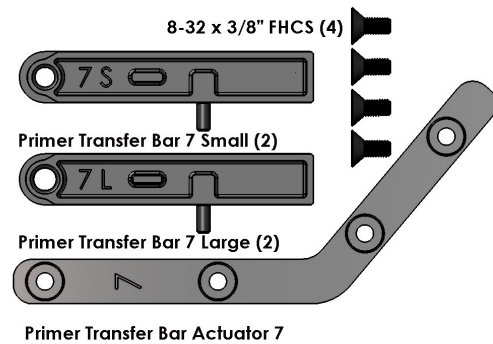


Diagram D

And the following:

- QCPM Cylinder
- Cartridge Discharge Chute
- Box Bracket

PRESS ASSEMBLY

1. Select a solid bench on which to mount the Pro Chucker Auto Index Press. You must use the three holes for mounting holes (use casting as a template). For benches with limited space, or to increase the rigidity of your bench, try our Accessory Base Plate 3, (#09282), available through your local dealer. See photo below.



RCBS Accessory Base Plate 3

2. Select an area with approximately one foot of clearance on each side of the Pro Chucker Press. Install with three 3/8" bolts, *see photo 1*, length to be determined by the thickness of your reloading bench (mounting hardware not included).



Photo 1

3. Install the Pro Chucker Handle by threading into Toggle Block. Tighten with a 9/16" wrench. **Be sure the handle is installed before proceeding. The following steps require raising of the ram.** *See photo 2.*



Photo 2

4. After the press is securely mounted to a bench or Accessory Base Plate 3, remove the plastic tie securing the Lock Out Pin to the Ram and remove the Lock Out Pin. The Lock Out Pin can be used with a small lock (not included), to secure the press when not in use. *See photo 2A.*



Photo 2A

5. Pull Handle down to bring Ram up to top of stroke. Install appropriate Primer Plug (for small or large primers) and tighten with 7/16" wrench. *See photo 3.*

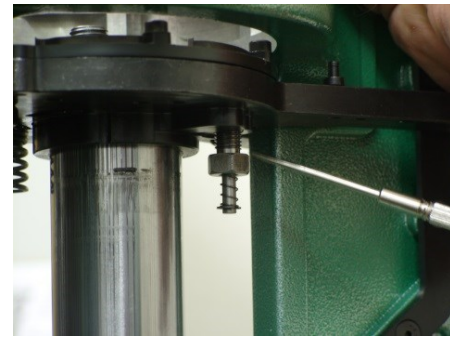


Photo 3

6. Bring Handle back up to lower Ram to bottom of stroke. Install Primer Actuator Arm on side of Press with four 8-32x7/8 FHCS, (5 Station), or four 8-32 x 3/8 FHCS, (7 Station) using 3/32" hex key wrench. Bias Actuator Arm toward rear of press as you secure FHCS. *See photo 4.*



Photo 4

7. Raise Ram to top of stroke, install the Primer Transfer Bar (5S, 5L, 7S or 7L), depending which press and what size primer is used. Ensure the Rear Post is pointing upward. The Side Post needs to be placed to the rear side of the actuator. See photo 5.

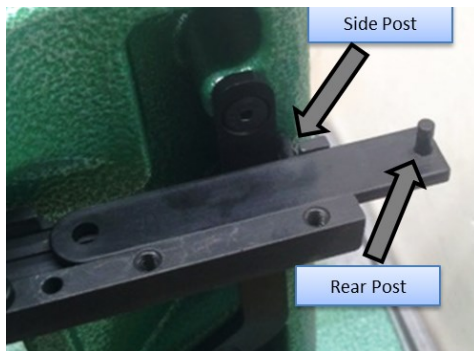


Photo 5

8. Next install the Primer Dispenser ensuring the post on the bottom side is inserted into the front hole on the Shell Plate Holder. Push on side of Primer Dispenser to bias it's location toward the Primer Transfer Bar. Secure the Dispenser with a 8-32x3/8" BHCS using a 3/32 hex key wrench. See photo 6.



Photo 6

9. Loosely install Transfer Bar Guide using another 8-32x3/8" BHCS in the hole at the end of the Primer Transfer Slot. See photo 7. Before operating the press, it's position may need to be adjusted (See section on Transfer Bar Alignment).



Photo 7

10. Install the black steel Primer Safety Shield by threading onto Primer Dispenser. See photo 8.



Photo 8

11. Install appropriate sized aluminum Primer Tube (for small or large primers) by inserting down through Safety Shield and into Dispenser. Aluminum Tube should extend approximately 1/4" above Safety Shield. Install threaded Safety Shield Cap to secure Primer Tube. Thread onto Safety Shield gently. Ensure Primer Tube and Safety Shield Cap are aligned by visually inspecting through top of Safety Shield Cap. See photo 9.



Photo 9

12. Lower Ram and push Primer Transfer Bar forward. Install Transfer Bar Spring by slipping the ends of the spring over the two posts. See photo 10. A small screwdriver or hex key wrench is helpful.



Photo 10

13. Raise ram to middle of stroke. Set the Shell Plate Holder on top of Lock Pin to keep it elevated above the Index Arm. See *photo 11*. This will prevent the Index Arm from being damaged when tightening Shell Plate.

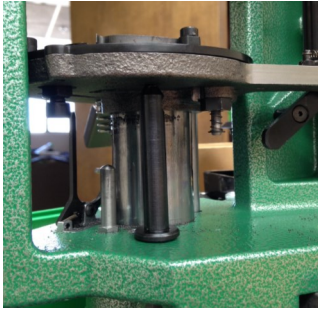


Photo 11

14. Insert Detent Spring and Ball Bearing into the hole on the Shell Plate Holder. Ensure Case Retaining springs and Case Eject Spring are positioned outward to allow room for the Shell Plate, as shown in *photo 12*.

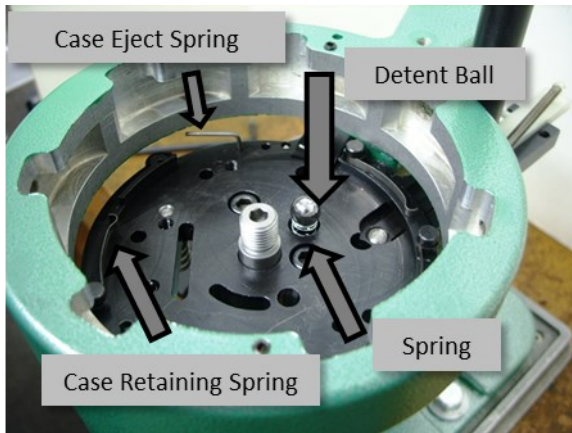


Photo 12

15. Place appropriate Shell Plate for your particular cartridge on top of the Shell Plate Holder. Install washer and nyloc nut on Shoulder Bolt. Thread the nut down until snug. Insert a 3/16" hex key wrench into the Shoulder Bolt and back the nut off 1/4 turn. Be sure the Shoulder Bolt remains tight. See *photo 13, 14*

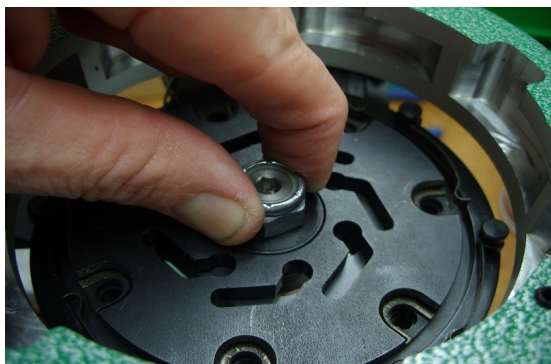


Photo 13



Photo 14

16. Manually index the Shell Plate to successive stations. Be sure the Shell Plate indexes fully and smoothly. If further tightening or loosening of the nyloc nut is necessary, be sure to use a 3/16" hex key wrench in the Shoulder Bolt. This is to keep the Shoulder Bolt from 'backing out' and becoming loose. Do not over tighten or the Shell Plate will not advance and damage to the Index Arm may occur.

17. Remove the Lock Pin from beneath the Shell Plate Holder and slowly lower the ram to ensure that the Index Arm passes up thru the Shell Plate Holder and Shell Plate. See *photo 15*.

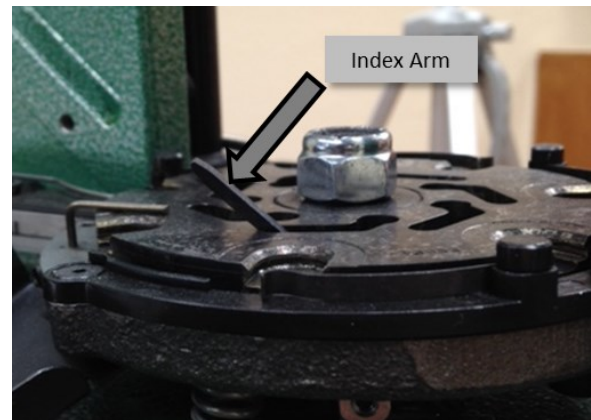


Photo 15

- a. Although the Index Arm is set at the factory, it can be biased slightly if necessary by removing the nut and screw and installing the flat washer on opposite side of Indexer Arm.

18. Cycle press to ensure the Shell Plate indexes smoothly around at all stations. Ensure that the Primer Transfer Bar is actuating properly and that the Primer Plug is coming up thru the Transfer Bar and Shell Plate. See *photo 16*.

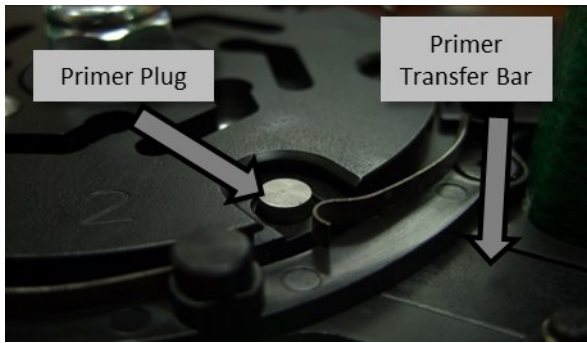


Photo 16

19. Adjust the Case Eject Spring approximately as shown by loosening and then securing the 8-32 x 1/4 SHSS. Case eject Spring should be set to approximately .030" above the Shell Plate. Check for ease of ejection. Some adjustment may be necessary. *See photos 17 and 18.*

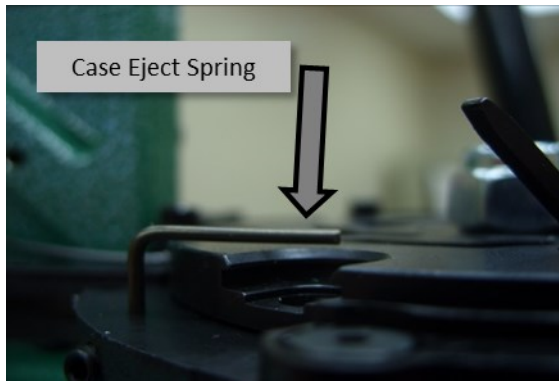


Photo 17

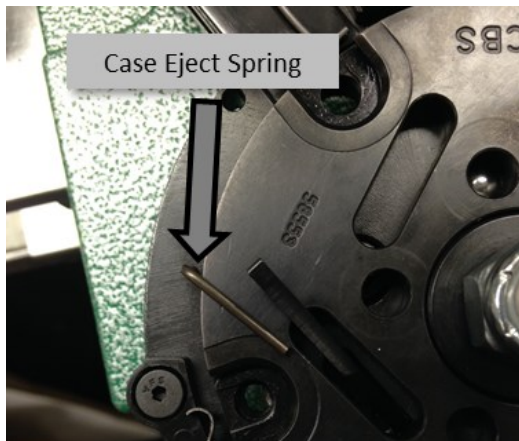


Photo 18 Top View of Case Eject

20. With the ram in the lowered position, insert the Spent Primer Tube in the hole on the underside of the press. The Spent Primer Tube will pass through the Press Frame and into the Shell Plate Holder. Ensure the Spent Primer Tube is fully inserted into the Shell Plate Holder and secure with the 8-32 x 1/4" SHSS (already installed) in the side of the Shell Plate Holder using a 5/64" hex key wrench. *See photo 19.* Place a trash receptacle under Spent Primer Tube to collect

old primers.

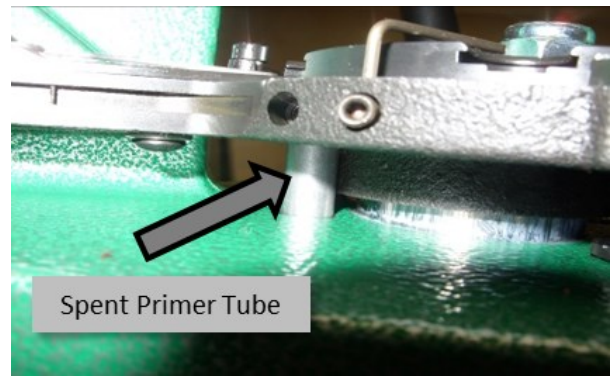


Photo 19

21. Raise the ram to the top of the press stroke. Attach the Discharge Chute to the underside of the Shell Plate Holder with a 10-32 x 3/8" BHCS and #10 Lock Washer using a 1/8" hex key wrench. *See photo 20.* Vary its orientation as needed to function effectively.



Photo 20

22. Insert the Die Plate into the top of the press. Insert the Die Plate lugs into the openings and turn clockwise. *See photo 21.* Secure with the three 8-32 x 1/4" SHSS. Start with the upper left and lower right SHSS. Be sure that the setscrews are in the countersinks on the Die Plate. This is to ensure alignment between the dies and cases. Secure the lower left SHSS last.



Photo 21

NOTE: The 5 Station Die Plate needs to be inserted with the die hole marked with the #1 in the size station. See *photo 21*.

The 7 Station Die Plate does not require a specific orientation.

23. The Pro Chucker Press comes with an Ammo Bin to catch the finished cartridges. A Box Bracket holds the bin. Mount the Box Bracket at bench top level using two #8 x 1/2" screws, with the right edge approximately 3/4" from the Press Frame. See *photo 22*.



Photo 22

This will place the Ammo Bin as shown in *Photo 23*, to catch your loaded cartridges.



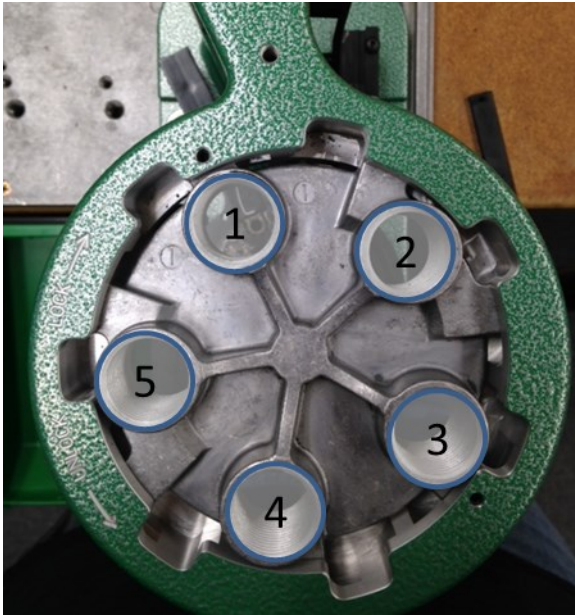
Photo 23

RELOADING DIES SET-UP

Refer to reloading Die instructions for individual adjustment and set-up. See diagram for position and rotation.

Automatic Indexing is in a clockwise direction.

STATION SET-UP OPTIONS (5 Station)



Station 1:

1. Sizing Die

Station 2:

1. Expander Die for straight wall cases.
2. No die for bottleneck cartridges.

Station 3:

1. Powder charging. Refer to Powder Measure instructions on **page 14**.

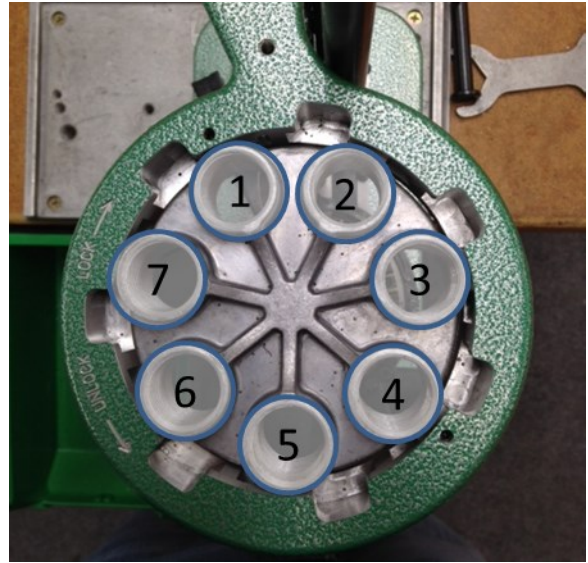
Station 4:

1. Lock Out Die (optional for pistol calibers 9mm and larger).
2. Powder Checker Die (optional, for most rifle and pistol calibers).
3. Seat Die.

Station 5:

1. Seat die or seat/crimp die
2. Crimp die (optional if you choose to seat and crimp separately).

STATION SET-UP OPTIONS (7 Station)



Station 1:

1. Sizing Die

Station 2:

1. Expander Die for straight wall cases.
2. No die for bottleneck cartridges.

Station 3:

1. Powder charging. Refer to Powder Measure instructions on **page 14**.

Station 4:

1. Lock Out Die (optional for pistol calibers 9mm and larger).
2. Powder Checker Die (optional, for most rifle and pistol calibers).

Station 5:

1. Bullet Feeder (Tube or Power, pistol only)
2. Seat die or seat/crimp die

Station 6:

1. Seat die or seat/crimp die

Station 7:

1. Crimp die (optional, if you choose to seat and crimp separately).

DIE ADJUSTMENT

Refer to the Reloading Die Instructions that came with your Dies. Contact the Die manufacturer for a copy if you are unable to find them or have any questions about setup or operation.

POWDER MEASURE

A Powder Measure is a device which measures powder by volume, not weight. However, before you start dispensing smokeless powder with a Powder Measure, the first several charges must always be weighed on a scale to verify the desired charge.

Accurate powder measure charges will also depend upon the size and uniformity of the powder kernels used.

⚠ DANGER: DO NOT use the Uniflow or Quick Change Powder Measure with black powder! Doing so can cause serious injury or death.

Helpful Tip: The consistency of the powder and static electricity are causes of erratic powder charges. Slowly roll the powder container several times to homogenize it before pouring it into the Powder Hopper. Static electricity can be reduced by wiping down the Powder Hopper with an anti-static cloth.

⚠ CAUTION: All internal components of the Powder Measure assembly must be thoroughly cleaned of rust preventatives applied at the factory. Failure to do this will cause powder charges to be inconsistent and provide erratic performance of your reloads. *See Diagram F for the following items that you must clean and dry before use:*

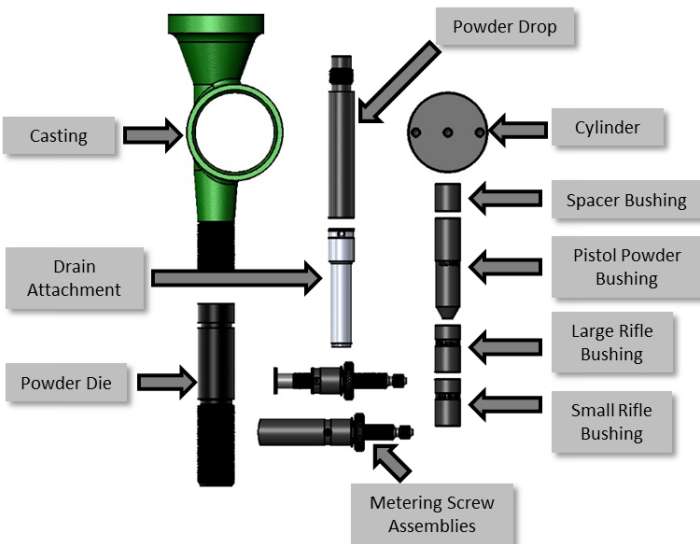


Diagram F. POWDER MEASURE ASSEMBLY COMPONENTS

A dependable powder scale should be used to set the first charges in the Powder Measure. It is not necessary to empty the Powder Hopper each time you change charges unless a different powder is required.

POWDER MEASURE ASSEMBLY

⚠ CAUTION: DO NOT leave powder in the Powder Measure, as it will deteriorate and may clog and jam the Measuring Cylinder and etch the Powder Hopper.

Last update 5/21/2015

1. Thread Powder Measure into Die Plate at desired station approximately five full turns.
2. Install the Quick Change Locking Pin Assembly 2-3 threads into the threaded hole on the side of the Measuring Cylinder. *See photo A.*



Photo A

3. Install the Cylinder into main Casting. Make sure the screw holes are oriented facing toward the Linkage Assembly before you slide it into the Main Casting. Carefully insert the Cylinder into the Main Casting. This is a precise fit, do not force the Cylinder into the Casting. *See Photo B.*

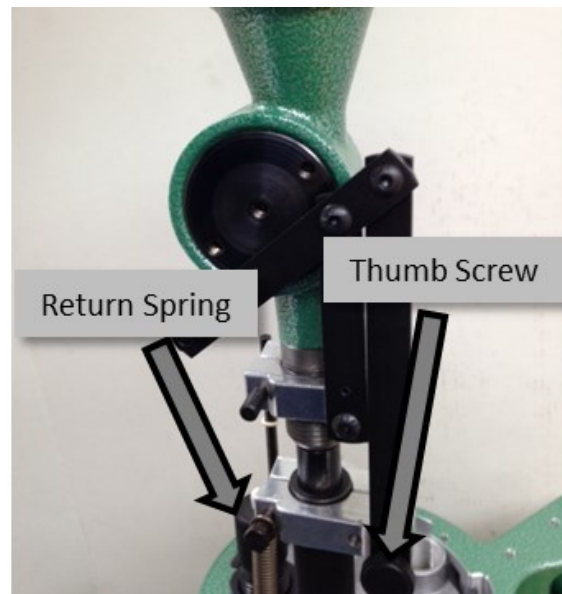


Photo B

4. Remove Thumb Screw and top end of Return Spring.
5. Slip the slotted portion of Cylinder Link over the Drive Pin. *See photo C.*



Photo C

- Align holes in Link with nearest holes in Cylinder. Install two 10-32x3/8" button socket head cap screws using an 1/8" Hex Key wrench. See Photo D.



Photo D

- Install appropriate Metering Screw in Cylinder. Notice the tapered hole on the side of the Metering Screws. This is the locking point for the Quick Change Locking Pin. Pull the spring-loaded plunger on Locking Pin Assembly while inserting Metering Screw body into the Cylinder bore. See Photo E. Release the plunger on the Locking Pin. Try to rotate the Metering Screw body to insure it is locked in place. The Metering Screws have the following dispensing range:
 Large = 10-110 grains
 Small = 0.5-40 grains

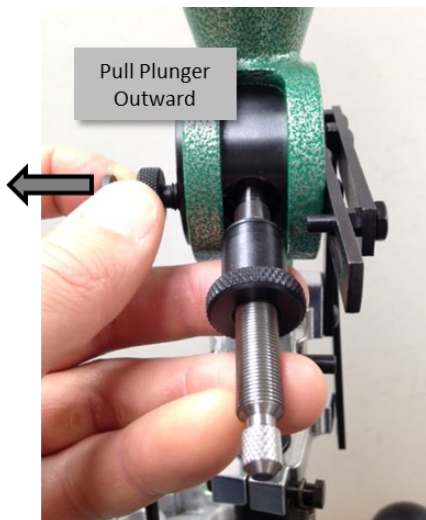


Photo E

- Lift the Powder Measure Assembly up and out of the Powder Die. Select the correct Powder Bushing, Small Rifle 22-270, Large Rifle 7mm-45, or Pistol. Install Bushings with the funnel end up. See photo F. See Powder Bushings in Diagram F on page 14 for correct orientation.



Photo F

- Install Powder Measure Assembly into Powder Die. See photo G.



Photo G

- Connect the Powder Measure Linkage and tighten the Thumb Screw. See photo H. NOTE: Periodically check Thumb Screw for tightness during the loading session.



Photo H

Do not install the Return Spring yet.

- Insert a sized and trimmed case in the station below the Powder Measure and raise Ram. Adjust powder dump in relation to case height by threading the Powder Measure

assembly down on the case until a full stroke of the Powder Measure is achieved. NOTE: Full stroke is within 1/16" to barely touching the top of the slot in the Uniflow Powder Measure casting. See *photo I*. This allows the Powder Die to turn one full turn to orient the Powder Measure to a convenient position.



Photo I

Should the Powder Die hit the Shell Plate before the full powder measure stroke is achieved, back off the Powder die nine turns and install the spacer on top of the Powder Bushing. Thread the Powder Die down until full stroke on the Powder Measure is achieved.

12. Lower the Ram and attach the Return Spring. See *photo J*.

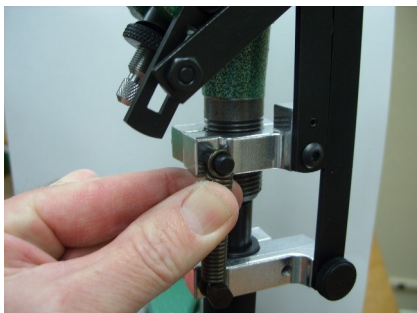


Photo J

13. Tighten the 7/8-14" lock ring on the Powder Die. Powder Measure installation is now complete.

CAUTION: Before reloading cartridges, verify powder charge weight consistency by dispensing powder into appropriate cartridge cases several times, weighing the powder on a calibrated scale.

TO REMOVE POWDER MEASURE FROM PRESS

To remove the Powder Measure from the Press, simply remove the Thumb Screw and Return Spring, then, lift off the Powder Measure Assembly.

METERING SCREW ASSEMBLY CHANGE

If the same gunpowder is to be used, but you wish to change the Metering Screw Assembly for another one, it is not necessary to empty the Powder Hopper.

Dispense the remaining charge and hold the Metering Screw Assembly in the "up" position as in *Photo I*. Loosen the knurled Lock Pin Retainer, pull the Lock Knob and remove the Metering Screw Assembly. Align the Lock Pin hole on the side of the other

Metering Screw Assembly and insert into the Metering Cylinder. Release the Lock Knob and rotate the Metering Screw Assembly to insure that the Lock Pin is in place. Tighten the knurled Locking Pin Assembly. Dispense several charges and weigh them to be sure that you have the correct Metering Screw adjustment.

NOTICE: If the Metering Screw Assembly is in the "down" position when the Metering Screw Assembly is removed, the powder will flow through the Metering Cylinder and spill out of the powder measure!

TO DRAIN POWDER HOPPER

It is not necessary to empty the powder hopper each time you change charges unless a different powder is to be used.

Powder should not be left in the measure as it will deteriorate and may clog and jam the Metering Cylinder and etch the Powder Hopper. The measure can be emptied without taking it off the press by using the provided Quick Change Drain Attachment.

Dispense the remaining charge and hold the Metering Screw Assembly in the "up" position. Loosen the knurled Lock Pin Retainer, pull the Lock Knob and remove the Metering Screw Assembly. Align the Lock Pin hole on the side of the Drain Attachment and insert into the Metering Cylinder, release the Lock Knob. Try to rotate the Drain Attachment to insure that the Lock Pin is in place. Tighten the knurled Locking Pin Retainer. Place the correct powder container near the end of the Drain Attachment and slowly rotate the Metering Cylinder to the "down" position. The powder will flow through the Metering Cylinder and Drain Tube Attachment and back into your powder container.

NOTICE: If the Metering Screw Assembly is in the "down" position when the Metering Screw Assembly is removed, the powder will flow through the Metering Cylinder and spill out of the powder measure!

TO REMOVE A CYLINDER

To remove a Metering Cylinder for cleaning, first empty the powder hopper. Loosen the knurled Lock Pin Retainer, pull the Lock Knob and remove the Drain Tube Attachment. Next remove the two Link screws and the Cylinder Link. Then carefully slide out the Metering Cylinder.

POWDER BRIDGING

Helpful Tip: When using some extruded (long grain) or large flake powder, bridging can occur. This happens when the powder jams (bridges) together and stops the flow of powder. This is caused by the powder dumping too quickly from the Powder Measure Cylinder into the Drop Tube. It can also occur when lube/ oil is present on any surface contacting smokeless powder.

To eliminate this possible problem, slow down the Press Handle swing, which slows the Cylinder rotation and pours the powder from the Powder Measure Cylinder at a slower rate. Otherwise, a fast dump may cause the powder to bridge in the Powder Bushing. To prevent bridging, slow down the Press Handle swing halfway through its stroke.

FILLING PRIMER TUBES

PRIMER TUBE WARNINGS

In rare circumstances, primers can become lodged in tubes that are obstructed, damaged or improperly maintained.

⚠ WARNING! Never force or pound/tap on live primers, tap or pound on loaded primer tubes, or otherwise attempt to clear obstructions on your own. Doing so can cause serious injury.

If you experience a feeding problem in a primer tube, follow these steps:

1. Ensure no primers are in the white plastic pickup tip.
2. Remove the white tip with pliers.
3. If possible, carefully pour the primers out of the tube and return primers to original packaging. Do not use the tube.
4. If a stuck primer(s) remains, handle with care and take to your local hazardous waste disposal facility.
5. Replacement tubes can be purchased online at RCBS.com or through an authorized dealer. Warranty claims can be made by calling RCBS at 1-800-533-5000.

To avoid primer feeding problems, always follow these precautions:

Before use, always inspect tube for damage or interior obstructions.

Never use bent, damaged or obstructed tubes. Ensure tube is free from primer residue buildup. Periodically clean inside of tube using soap and warm water.

We recommend the RCBS Primer Tray-2 to be used in conjunction with the Primer Tube. This plastic primer tray and cover have been designed to orient primers for fast, easy handling and primer pick-up.

Step 1. Scatter the primers onto the grooved surface of the primer tray. Then, gently shake the tray horizontally until all the primers are positioned anvil side up. Place the cover on the tray, while holding the tray and cover together, turn the tray upside down. The primers will now be oriented anvil side down for easy pick-up with the appropriate size priming tube assembly. See *Photo K*.



Photo K.

Step 2. Insert the primer feed tube cotter pin into the cross hole before picking up any primers.

⚠ WARNING: It is the responsibility of the operator to insure that all primers are properly oriented. Attempting to seat a primer upside down in a case may cause the primer to detonate, causing serious personal injury or damage to the equipment. Primer residue is dangerous when exposed to heat, impact and/or static electricity. Therefore, it is important to keep the primer tubes clean. We recommend periodic cleaning with soap and warm water.

Step 3. Use the plastic tipped end of the tube opposite the cotter pin for primer pick-up. After filling, place the tube, cotter pin end down, onto the top of the safety tube cap. While holding the tube, remove the cotter pin, dropping the primers into the top of the safety tube cap. Be sure all primers are transferred into the Priming Tube. See *Photo L*.

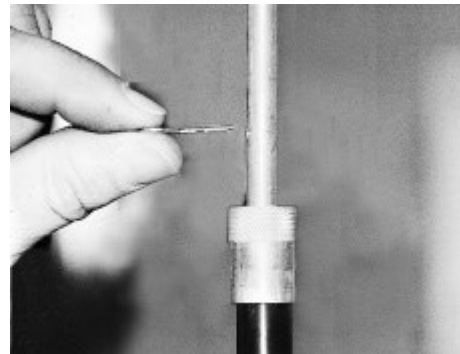


Photo L.

TRANSFER BAR ALIGNMENT

The Transfer Bar uses an offset spring and may require an alignment offset to function properly.

For Initial Setup; ensure Ram is at top of stroke. Apply minimal force to pivot the Transfer Bar Guide, in direction of arrows shown in *photo M*, to bring end of Transfer Bar Guide into slight contact with Transfer Bar, secure by tightening 8-32 x 3/8 BHCS.

NOTE: this should not shift the position of the Transfer Bar.

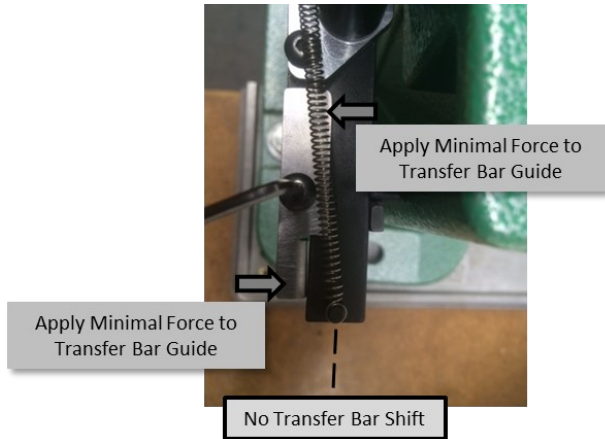


Photo M

Insert 5 primers into Primer Tube and cycle press to ensure primers are being picked up by Transfer Bar. If the Transfer Bar gets stuck in the rearward position, as shown in *photo N*, or does not pick up a primer, loosen BHCS in Transfer Bar Guide and apply more force to Transfer Bar Guide as shown in *photo O*.

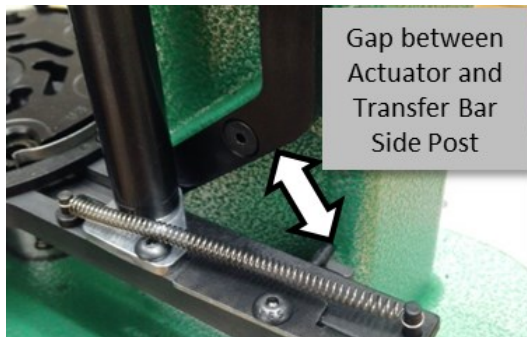


Photo N

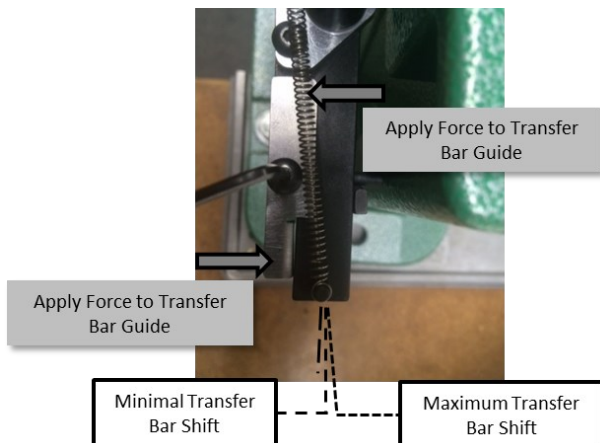


Photo O

Repeat process to verify alignment by inserting 5 primers into Primer Tube and cycle press to ensure primers are being picked up correctly by Transfer Bar.

INITIAL PRESS OPERATION

We recommend that several cases be completely reloaded one at a time before proceeding with full operation. This will help you to become familiar with the loading process.

⚠ WARNING! DO NOT UNDER ANY CIRCUMSTANCE attempt to reseal high primers, in loaded cartridges (a case with the primer, powder and bullet in place). Pull the bullet, dump the powder and then seat the primer to the correct depth.

⚠ WARNING! Never attempt to seat a primer in an under-sized primer pocket. Decrimp military-specification cases and commercial cases with staked/ crimped primer pockets before use.

⚠ WARNING! To prevent primer detonation, if you encounter any unexpected resistance during seating, STOP! Discontinue priming until the problem is found and corrected.

Step 1:

Insert clean, trimmed case into Station #1. This is the sizing station on both the 5 and 7 Station Pro Chucker Press. See *photo P*.



Photo P

The Case Feed Ramp, black plastic part holding the Case Retaining Spring #1, is reversible. The press is assembled with the Case Feed Ramp as shown in *photo Q*. The case is inserted into Station 1 by placing the case down on the Case Retaining Spring #1 and inserting into the Shell Plate.



Photo Q

Inserting the case into Station 1 with the Case Feed ramp reversed requires the Case Retaining Spring #1 to be pushed to the

side to insert the case into the Shell Plate. Either method works, this is an operator option. See photo R.



Photo R

To reverse the Case Feed Ramp, remove the two 8-32 x 3/8" BHCS and flat washers from the underside of the Shell Plate Holder. See photo S. Also remove the 8-32 x 3/8" BHCS on the upper side that is holding the Case retaining Spring #1. Note: Take care in removing the Case Feed Ramp from the Shell Plate Holder. These parts fit snugly and the Case Feed Ramp can break if pried up on one end. A 3/16" hex key wrench pushed slowly thru the screw holes on the underside will move the Case Feed Ramp up enough for removal. Also take care in securing the Case Feed ramp to the Shell Plate Holder. Tighten the two 8-32 x 3/8" BHCS to just snug. Do not over tighten, as the threads in the Case Feed Ramp will strip and be destroyed.



Photo S

Be sure that the Case Retaining Spring #1 is adjusted to keep the case in the Shell Plate but not to drag on the Shell Plate. See photo T.

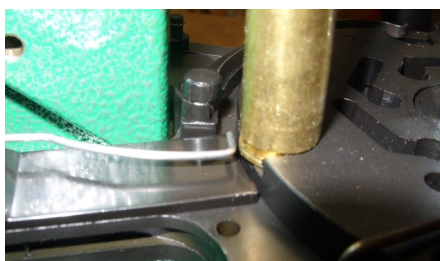


Photo T

Step 2:

With a properly lubricated case in Station 1, lower the handle to raise the case into the Sizing Die. The case will be sized and the spent primer will be ejected. Now raise the handle to lower the case and index the shell plate to Station 2. Firmly press the handle all the way to the rear to insert a new primer into the case. Allow the handle to return to the neutral position.

The primer is seated in the last 1/2" of the handle stroke below the shell plate neutral position. Remove the case and inspect primer depth. Adjust Primer Stop if necessary. See photo U.

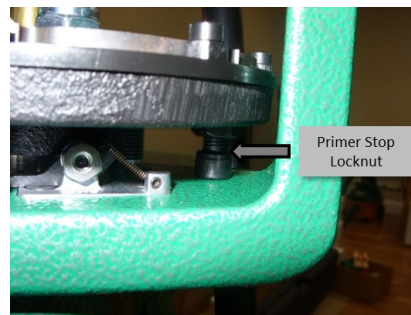


Photo U

NOTE: Primer depth can be set by the primer depth adjustment screw. Primers can also be seated by "feel" by simply adjusting the stop out of the way.

Step 3:

Lower the handle to raise case into Station 2 to expand and flare/bell the mouth of the case.

NOTE: Station 2 is for expanding straight wall rifle/ pistol cases and is an empty station for bottleneck rifle/ pistol cases.

Step 4:

Cycle the handle to index case and raise it into Station 3 (Powder Measure) to charge the sized and primed case with powder. Remove the case and weigh powder on a scale to verify that the powder charge is correct. Refill case with powder and funnel. Reinsert the case back into the Shell Plate at station 4. Check every fifty rounds to ensure the powder charge has not changed. *NOTE: Refer to Powder Measure instructions for adjustment.*

Step 5:

Cycle the handle to move the case through Station 4. *NOTE: This is an extra station that allows options such as a Powder Checker Die or Lock-Out Die or to seat and crimp bullets in separate operations. You may choose to have this as an empty station.*

Step 6:

When the case is at Station 5, Insert a bullet onto the case mouth, lower the handle to seat and crimp the bullet. Raise the Handle to index the Press and the loaded cartridge will be ejected onto the Discharge Chute and slide down into the Ammo Bin. See photo V.



Photo V

Pro Chucker 7 Station Press

Stations 4, 5, and 6 are extra stations for options such as Powder Checker Die, Lock Out Die, Pistol Bullet Feeder and to seat and crimp in separate operations.

Pro Chucker Operating Instructions

Now that you have read the instructions and are familiar with your Pro Chucker Progressive Reloading Press, you are ready to reload!

Based on our experience, we will explain the most efficient way to use your new Pro Chucker Progressive Reloading Press. You may choose to change your technique as you become more accustomed to the function of this tool, but for now, we strongly suggest you use the following operating procedure.

Have your bullets and cases positioned on the left side of the press. The Ammo Bin will be used to catch the loaded ammunition as it is ejected from the press.

Fill the primer tube as instructed on page 18.

With your right hand on the Handle Ball, pick up an unsized case with your left hand and slide it fully into Station 1. Be sure the case holder spring is adjusted to barely touch the rim of the case.

Now smoothly pull the Handle down. This will size and deprime the case in Station 1. Raise the handle to the top of the stroke and smoothly push the handle fully to the rear, the Shell Plate will automatically index and you will be able to feel the primer being seated in the case. You now have a sized and reprimed case in Station 2. Insert another unsized case into Station 1 and lower the handle. Again, this will size and deprime the case in Station 1, while at the same time, expand the case in Station 2. Raise the handle and push fully to the rear to reprime the case in Station 2. Let the Handle return to the neutral position.

You now have a sized and reprimed case in Station 2 and an expanded case in Station 3. Insert another case into Station 1 and lower the handle. Station 1 and 2 will repeat the same operation while the powder charge is being dispensed in Station 3. Next, raise the handle and push fully to the rear and let it return to the neutral position.

You now have a sized and reprimed case in Station 2, an expanded case in Station 3, and a powder charged case in Station 4. Insert another case in Station 1 and lower the handle. Stations 1, 2 and 3 will repeat the same operations. Station 4 may perform a variety of operations, depending on your preferred reloading technique. In the case of rifle calibers, this may be an empty station or you may use a Powder Checker Die. In the case of pistol calibers, you may select to seat in Station 4 and crimp in Station 5. As another option, if loading pistol rounds, you may use an RCBS Lock-Out Die in Station 4, then, seat and crimp in one operation in Station 5.

If using a Pro Chucker 7 Progressive Reloading Press for pistol, Station 4 could be configured with a Lock-Out Die, Station 5 a

Pistol Bullet Feeder, Station 6 a Seat Die and Station 7 a Crimp Die.

Whichever method you choose is fine. Versatility is a big advantage of owning a five or seven station progressive press.

By now you should be getting the hang of the sequence of operating your Pro Chucker Progressive Reloading Press. Once the Shell Plate has a case in all five stations, the basic operating procedure remains the same time after time. Always follow the procedure below :

Bullet, Case, Size, Index, Prime.

It will help you to repeat these words to yourself each time you cycle the press:

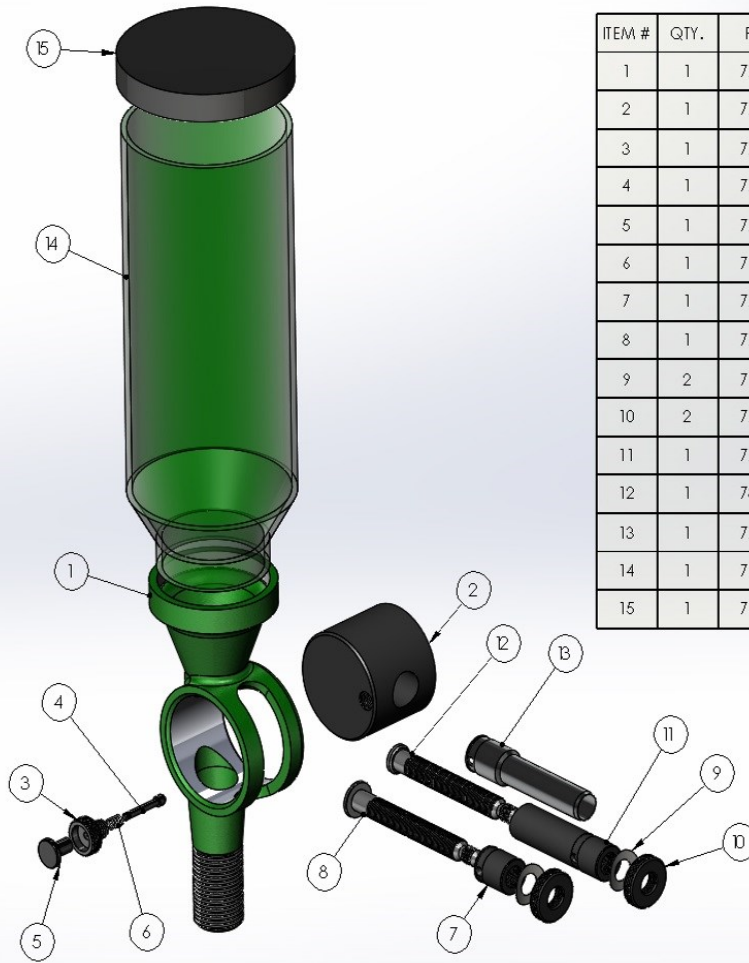
Bullet, Case, Size, Index, Prime:

1. Bullet: Place bullet on case under seat die.
2. Case: Place unsized case in Station 1.
3. Size: Lower Handle and raise case into Dies.
4. Index: Raise Handle to lower cases and Index the Shell Plate.
5. Prime: Push Handle fully to rear to prime case in Station 2.

This is the sequence that will be repeated over and over as you operate your Pro Chucker Progressive Reloading Press. By now, everything should be working great. If not, re-read this portion of the instructions. If you are still experiencing problems, give us a call, we'd be glad to help.

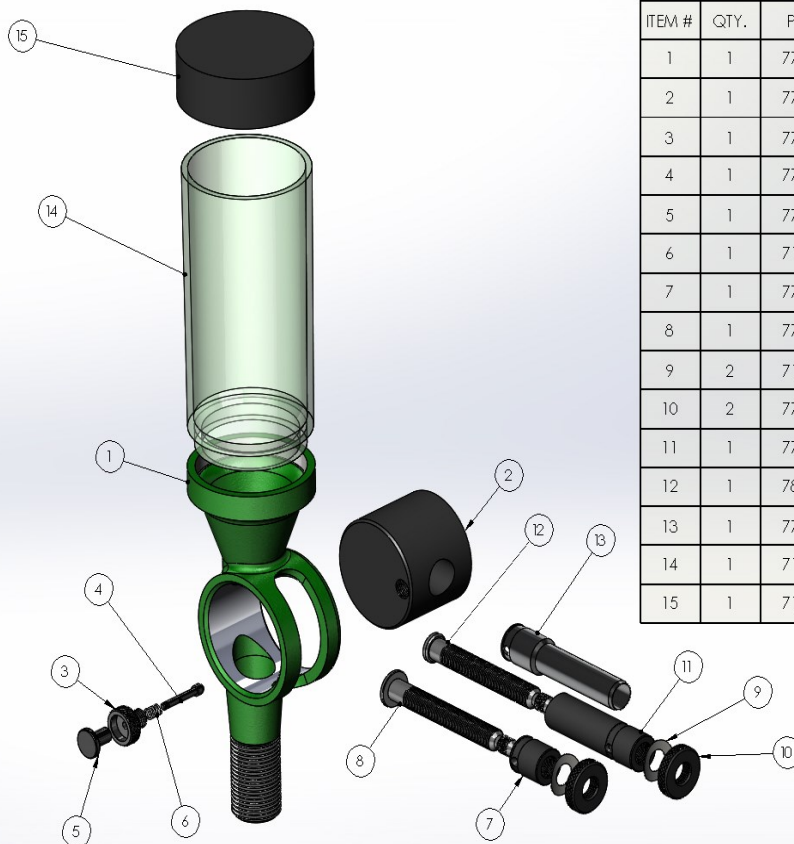
IMPORTANT: Your Pro Chucker Progressive Reloading Press has been designed and manufactured to be an automatic indexing reloading press.

Any alteration or attempt to alter the function of this press will void any and all warranties offered by RCBS. We specifically warn against any attempt to convert this press to any motorized method of operation.



| ITEM # | QTY. | PART # | PART NAME |
|--------|------|---------|------------------------------|
| 1 | 1 | 7709025 | Powder Measure Body |
| 2 | 1 | 7798843 | QC Metering Cylinder |
| 3 | 1 | 7798847 | QC PM Pin Retainer |
| 4 | 1 | 7798846 | QC PM Locking Pin |
| 5 | 1 | 7798848 | QC PM Knob |
| 6 | 1 | 7109029 | QC PM Spring |
| 7 | 1 | 7798844 | QC PM Cylinder Bushing Large |
| 8 | 1 | 7798854 | QC PM Metering Screw Large |
| 9 | 2 | 7109260 | Bow Washer 3/8 ID |
| 10 | 2 | 7709014 | UPM Metering Screw Lock Ring |
| 11 | 1 | 7798845 | QC PM Cylinder Bushing Small |
| 12 | 1 | 7809008 | UPM Metering Screw Small |
| 13 | 1 | 7798852 | QC PM Drain Tube Attachment |
| 14 | 1 | 7109025 | QC PM Powder Hopper |
| 15 | 1 | 7189029 | SS Powder Hopper Cap |

**Powder Measure Assembly
Pro Chucker 7 Station**



| ITEM # | QTY. | PART # | PART NAME |
|--------|------|---------|------------------------------|
| 1 | 1 | 7709025 | Powder Measure Body |
| 2 | 1 | 7798843 | QC Metering Cylinder |
| 3 | 1 | 7798847 | QC PM Pin Retainer |
| 4 | 1 | 7798846 | QC PM Locking Pin |
| 5 | 1 | 7798848 | QC PM Knob |
| 6 | 1 | 7109029 | QC PM Spring |
| 7 | 1 | 7798844 | QC PM Cylinder Bushing Large |
| 8 | 1 | 7798854 | QC PM Metering Screw Large |
| 9 | 2 | 7109260 | Bow Washer 3/8 ID |
| 10 | 2 | 7709014 | UPM Metering Screw Lock Ring |
| 11 | 1 | 7798845 | QC PM Cylinder Bushing Small |
| 12 | 1 | 7809008 | UPM Metering Screw Small |
| 13 | 1 | 7798852 | QC PM Drain Tube Attachment |
| 14 | 1 | 7109026 | UPM Powder Hopper |
| 15 | 1 | 7109030 | UPM Hopper Cap |

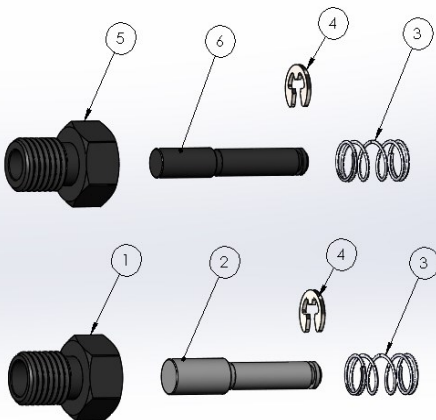
**Powder Measure Assembly
Pro Chucker 5 Station**

Case Actuated Powder
Measure Linkage, Powder
Die Assembly



| ITEM # | QTY. | PART # | PART NAME |
|--------|------|---------|---------------------------------|
| 1 | 1 | 7788928 | CAPM Powder Die |
| 2 | 1 | 7788950 | CAPM Lower Front Bracket |
| 3 | 2 | 7788949 | CAPM Back Bracket |
| 4 | 2 | 7187210 | 10-32 x 1-1/4" BHCS |
| 5 | 2 | 7187211 | 10-32 x 1" BHCS |
| 6 | 1 | 7788941 | CAPM Bottom Spring Anchor |
| 7 | 1 | 7109187 | Hex Lock Ring 7/8-14 No Hole |
| 8 | 1 | 7187214 | Century Spring #80584 |
| 9 | 1 | 7788951 | CAPM Top Front Bracket |
| 10 | 1 | 7788947 | CAPM Pivot Link |
| 11 | 5 | 7186144 | 10-32 x 3/8" BHCS |
| 12 | 1 | 7187213 | Roll Pin 1/8" x 3/8" Black |
| 13 | 1 | 7788945 | CAPM Drive Link |
| 14 | 2 | 7788916 | CAPM Linkage Nut |
| 15 | 1 | 7788946 | CAPM Long Link |
| 16 | 1 | 7788944 | CAPM UPM Drive Pin |
| 17 | 1 | 7109603 | Hex Nut 10-32 |
| 18 | 1 | 7186146 | 10-32 x 1/2" Thumb Screw |
| 19 | 1 | 7788940 | CAPM Top Spring Anchor |
| 20 | 1 | 7788948 | CAPM Cylinder Link |
| 21 | 1 | 7788939 | CAPM Powder Bushing Pistol |
| 22 | 2 | 7788936 | CAPM Spacer Bushing |
| 23 | 1 | 7788934 | CAPM Powder Bushing Small Rifle |
| 24 | 1 | 7788938 | CAPM Powder Bushing Large Rifle |
| 25 | 1 | 7788935 | CAPM Drop Tube |

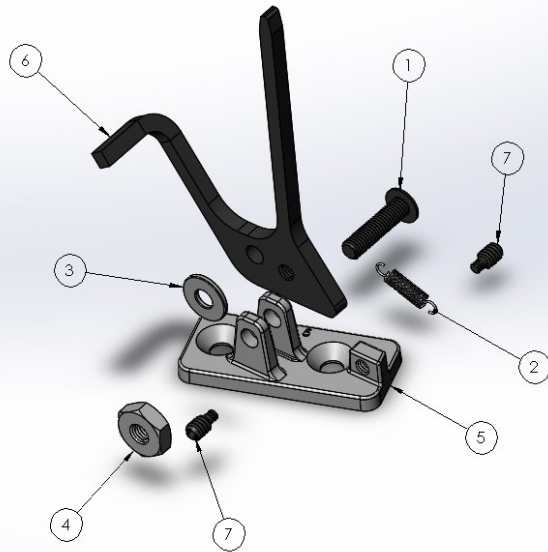
Primer Plug Assembly
Large and Small



| ITEM # | QTY. | PART # | PART NAME |
|--------|------|---------|-----------------------------|
| 1 | 1 | 7784219 | Primer Plug Holder Large |
| 2 | 1 | 7784221 | Primer Plug Large |
| 3 | 2 | 7181291 | Primer Plug Spring #70464 |
| 4 | 2 | 7181294 | Retaining Ring E Clip 5/32" |
| 5 | 1 | 7784220 | Primer Plug Holder Small |
| 6 | 1 | 7784222 | Primer Plug Small |

Index Mount Assembly

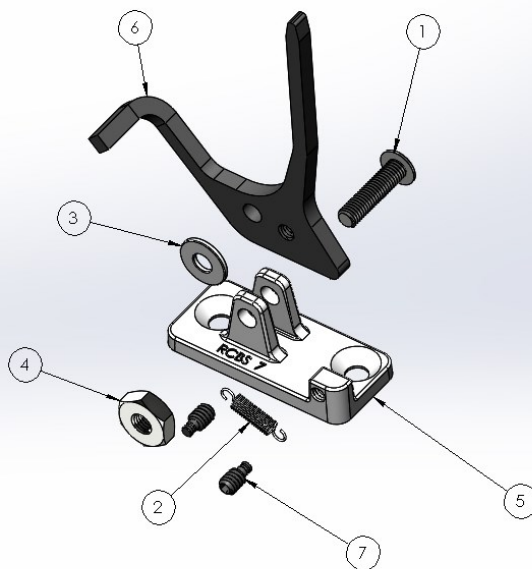
5 Station



| ITEM # | QTY. | PART # | PART NAME |
|--------|------|---------|-----------------------------|
| 1 | 1 | 7186269 | 5-40 x 1/2 BHCS |
| 2 | 1 | 7181290 | Index Return Spring #80033 |
| 3 | 1 | 7187052 | #4 Flat Washer |
| 4 | 1 | 7189069 | 5-40 Machine Screw Nut Zinc |
| 5 | 1 | 7784206 | Index Mount 5 |
| 6 | 1 | 7784208 | Indexer 5 |
| 7 | 2 | 7784215 | Index Return Screw |

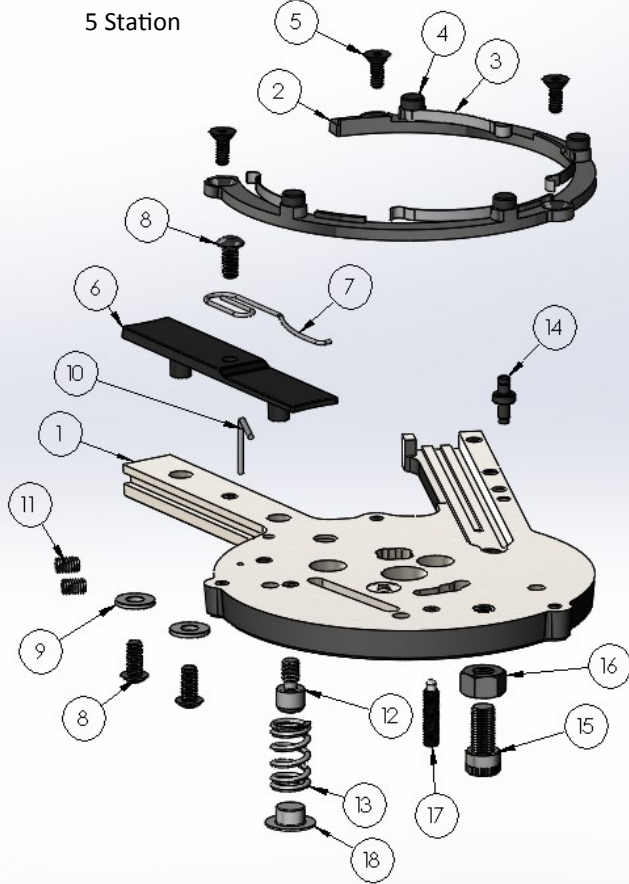
Index Mount Assembly

7 Station



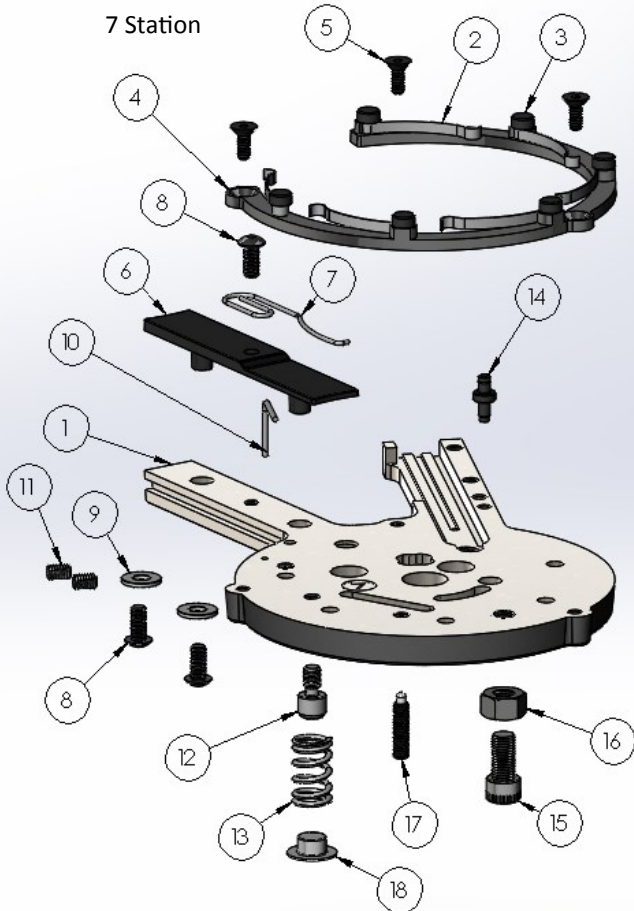
| ITEM # | QTY. | PART # | PART NAME |
|--------|------|---------|-----------------------------|
| 1 | 1 | 7186269 | 5-40 x 1/2 BHCS |
| 2 | 1 | 7181290 | Index Return Spring #80033 |
| 3 | 1 | 7187052 | #4 Flat Washer |
| 4 | 1 | 7189069 | 5-40 Machine Screw Nut Zinc |
| 5 | 1 | 7784207 | Index Mount 7 |
| 6 | 1 | 7784209 | Indexer 7 |
| 7 | 2 | 7784215 | Index Return Screw |

Shell Plate Holder Assembly

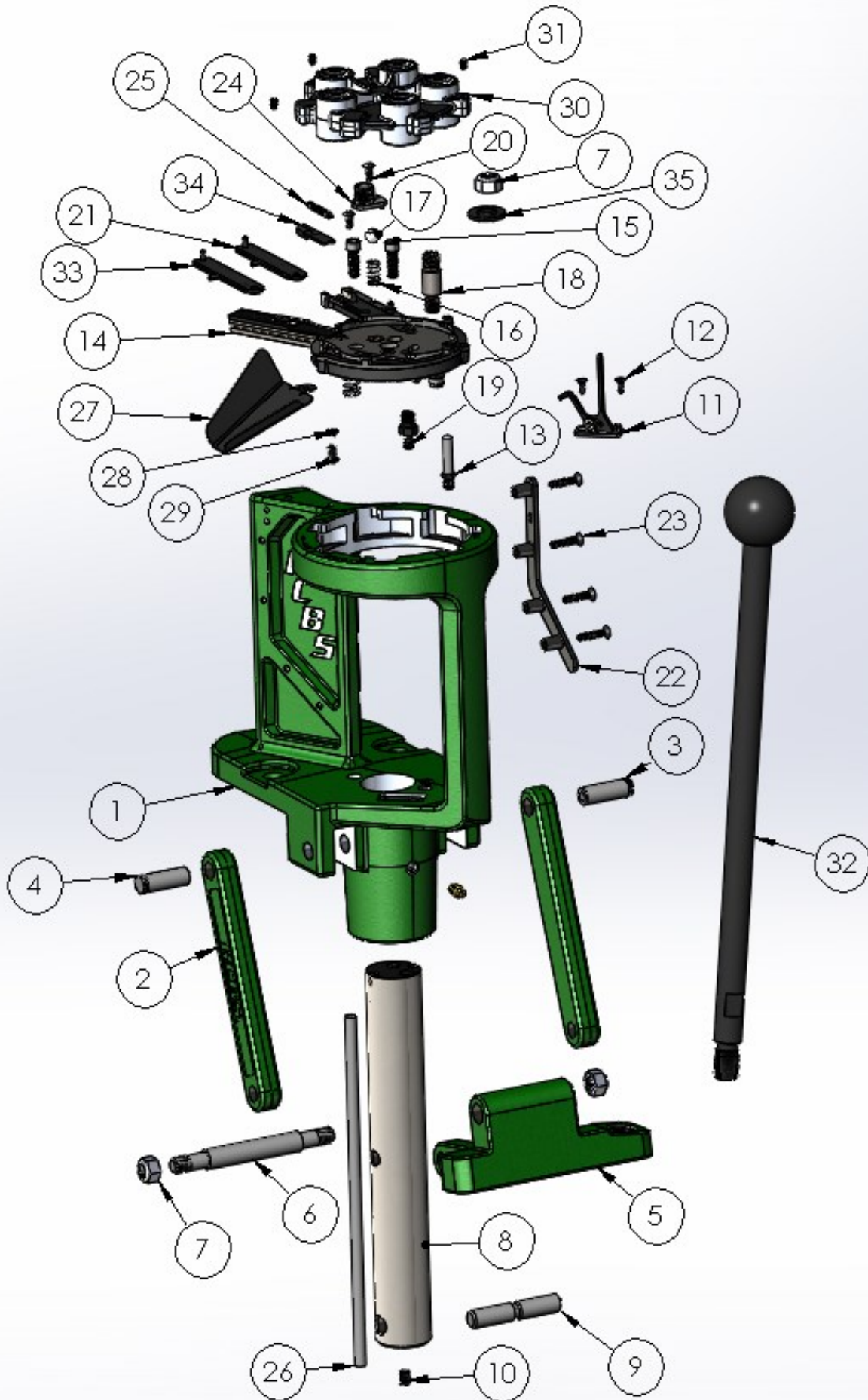


| ITEM # | QTY. | PART # | PART NAME |
|--------|------|----------|-----------------------------------|
| 1 | 1 | 7784202 | Shell Plate Holder 5 |
| 2 | 1 | 7181280 | Case Retaining Bracket 5 |
| 3 | 4 | 7187206 | Case Retaining Spring |
| 4 | 4 | 7788943 | Case Retaining Spring Plug |
| 5 | 3 | 7187215 | 6-32 x 3/8" FHCS |
| 6 | 1 | 7181288 | Case Feed Ramp |
| 7 | 1 | 7187208 | Case Retaining Spring Station # 1 |
| 8 | 3 | 7187217 | 8-32 x 3/8" BHCS |
| 9 | 2 | 7187216 | #8 Flat Washer |
| 10 | 1 | 7784226 | Case Eject Spring |
| 11 | 2 | 7109509 | 8-32 x 1/4" SHSS |
| 12 | 1 | 7784214 | Index Spring Holder |
| 13 | 1 | 7181293 | PC Index Spring #S-404 |
| 14 | 1 | 7784223 | Transfer Bar Return Pin |
| 15 | 1 | 7187159 | 1/4-28 x 3/4" SHCS |
| 16 | 1 | 7109604 | 1/4-28 Hex Nut |
| 17 | 1 | 7181295 | 8-32 x 5/8" Spring Plunger |
| 18 | 1 | 01003556 | Index Spring Plug |

Shell Plate Holder Assembly

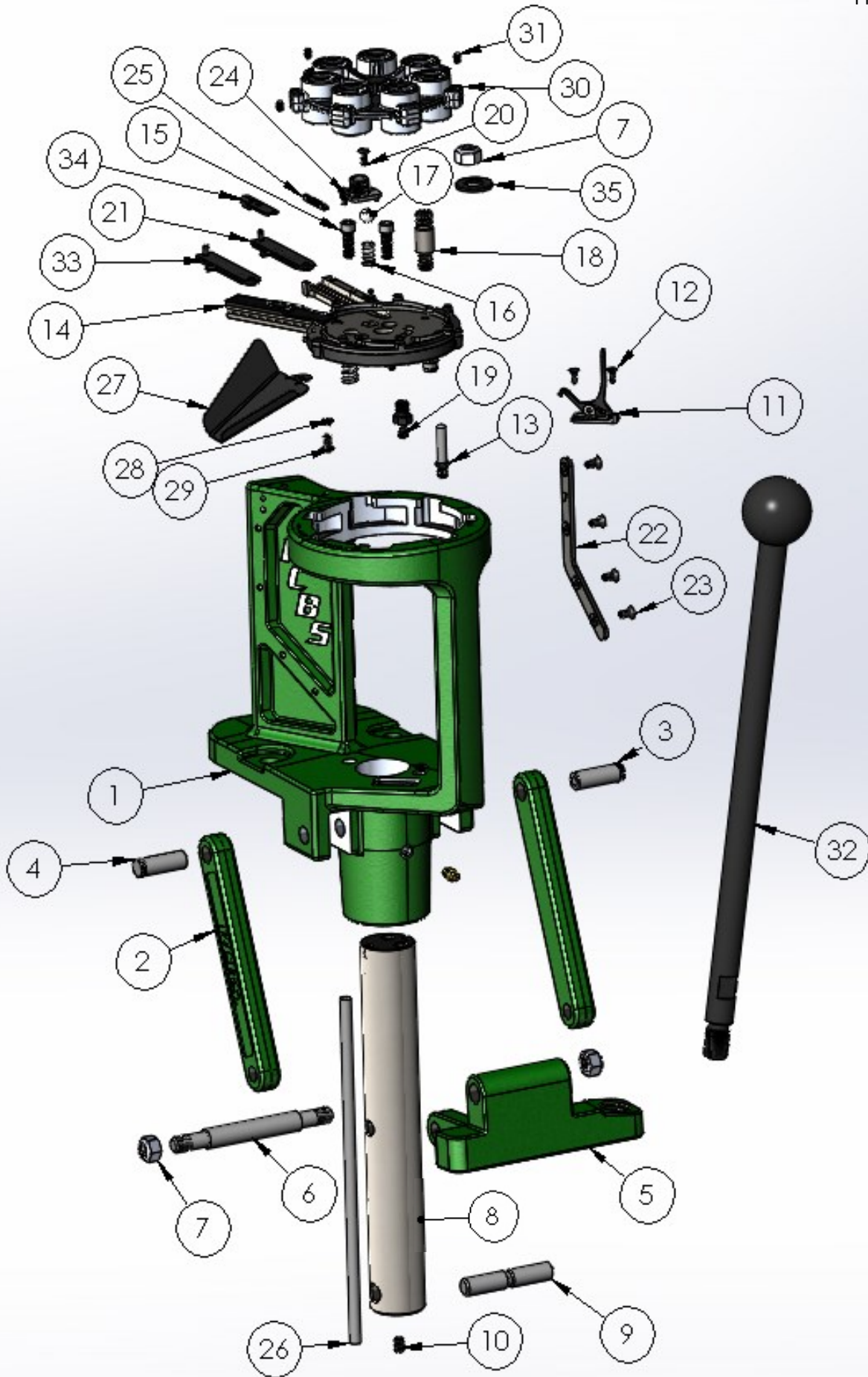


| ITEM # | QTY. | PART # | PART NAME |
|--------|------|----------|-----------------------------------|
| 1 | 1 | 7784203 | Shell Plate Holder 7 |
| 2 | 6 | 7187206 | Case Retaining Spring |
| 3 | 6 | 7788943 | Case Retaining Spring Plug |
| 4 | 1 | 7181281 | Case Retaining Bracket 7 |
| 5 | 3 | 7187215 | 6-32 x 3/8" FHCS |
| 6 | 1 | 7181288 | Case Feed Ramp |
| 7 | 1 | 7187208 | Case Retaining Spring Station # 1 |
| 8 | 3 | 7187217 | 8-32 x 3/8" BHCS |
| 9 | 2 | 7187216 | #8 Flat Washer |
| 10 | 1 | 7784226 | Case Eject Spring |
| 11 | 2 | 7109509 | 8-32 x 1/4" SHSS |
| 12 | 1 | 7784214 | Index Spring Holder |
| 13 | 1 | 7181293 | PC Index Spring #S-404 |
| 14 | 1 | 7784223 | Transfer Bar Return Pin |
| 15 | 1 | 7187159 | 1/4-28 x 3/4" SHCS |
| 16 | 1 | 7109604 | 1/4-28 Hex Nut |
| 17 | 1 | 7181295 | 8-32 x 5/8" Spring Plunger |
| 18 | 1 | 01003556 | Index Spring Plug |



Pro Chucker 5 Station BOM

| ITEM | QTY. | PART # | PART NAME | ITEM | QTY. | PART # | PART NAME |
|------|------|----------|-----------------------------------|------|------|---------|-----------------------------|
| 1 | 1 | 1002786 | PC Frame w/Zerk | | 2 | 7109509 | 8-32 x 1/4" SHSS |
| | 1 | 7784200 | Frame | | 1 | 7784214 | Index Spring Holder |
| | 1 | 7109213 | Zerk Fitting | | 1 | 7181293 | PC Index Spring #S-404 |
| 2 | 2 | 7788902 | Link | | 1 | 7784223 | Transfer Bar Return Pin |
| 3 | 1 | 7709128 | Link Pin Right | | 1 | 7187159 | 1/4-28 x 3/4" SHCS |
| 4 | 1 | 7709127 | Link Pin Left | | 1 | 7109604 | 1/4-28 Hex Nut |
| 5 | 1 | 7784201 | Toggle Block | | 1 | 7181295 | 8-32 x 5/8" Spring Plunger |
| 6 | 1 | 7788912 | Toggle Block Pin | | 1 | 7181282 | Primer Transfer Bar Small 5 |
| 7 | 3 | 7187212 | Nyloc Nut 7/16-20 | 15 | 2 | 7187159 | 1/4-28 x 3/4" SHCS |
| 8 | 1 | 7784211 | Ram | 16 | 1 | 7188037 | Index Ball Spring BB-97 |
| 9 | 1 | 7788919 | Ram Pin | 17 | 1 | 7187152 | Detent Ball 3/8 |
| 10 | 1 | 7187219 | 1/4-28 x 3/8" SHSS | 18 | 1 | 7784217 | Shell Plate Bolt |
| 11 | 1 | | Index Mount Assembly 5 | 19 | 1 | | Primer Plug Assembly Small |
| | 1 | 7784206 | Index Mount 5 | | 1 | 7784220 | Primer Plug Holder Small |
| | 1 | 7784208 | Indexer 5 | | 1 | 7784222 | Primer Plug Small |
| | 1 | 7186269 | 5-40 x 1/2 BHCS | | 1 | 7181291 | Primer Plug Spring #70464 |
| | 1 | 7189069 | 5-40 Machine Screw Nut Zinc | | 1 | 7181294 | Retaining Ring E Clip 5/64" |
| | 2 | 7784215 | Index Return Screw | 20 | 2 | 7187217 | 8-32 x 3/8" BHCS |
| | 1 | 7181290 | Index Return Spring #80033 | 21 | 1 | 7181282 | Primer Transfer Bar Small 5 |
| | 1 | 7187052 | #4 Flat Washer | 22 | 1 | 7181286 | Primer Bar Actuator 5 |
| 12 | 2 | 1002775 | 5-40 x 3/8" FHCS | 23 | 4 | 1002774 | 8-32 x 7/8" FHCS |
| 13 | 1 | 7784216 | Locating Pin | 24 | 1 | 7784210 | Primer Dispenser |
| 14 | 1 | | Shell Plate Holder 5 Assembly | 25 | 1 | 7181292 | Transfer Bar Return Spring |
| | 1 | 7784202 | Shell Plate Holder 5 | 26 | 1 | 7784224 | Spent Primer Tube |
| | 1 | | Case Retaining Bracket 5 Assembly | 27 | 1 | 7784225 | Discharge Chute |
| | 1 | 7181280 | Case Retaining Bracket 5 | 28 | 1 | 7187051 | Lock Washer #10 |
| | 4 | 7187206 | Case Retaining Spring | 29 | 1 | 7186144 | 10-32 x 3/8" BHCS |
| | 4 | 7788943 | Case Retaining Spring Plug | 30 | 1 | 7784204 | Die Plate 5 |
| | 3 | 7187215 | 6-32 x 3/8" FHCS | 31 | 3 | 7109509 | 8-32 x 1/4" SHSS |
| | 1 | 7181288 | Case Feed Ramp | 32 | 1 | | PC Handle Assembly |
| | 1 | 7187208 | Case Retaining Spring Station #1 | | 1 | 7784213 | Handle |
| | 3 | 7187217 | 8-32 x 3/8" BHCS | | 1 | 7109121 | Handle Ball |
| | 2 | 7187216 | #8 Flat Washer | 33 | 1 | 7181283 | Primer Transfer Bar Large 5 |
| | 1 | 7784226 | Case Eject Spring | 34 | 1 | 1003286 | Transfer Bar Guide |
| | 1 | 01003556 | Index Spring Plug | 35 | 1 | 7784218 | Shell Plate Washer |



Pro Chucker 7 Station BOM

| ITEM # | QTY. | PART # | PART NAME | ITEM # | QTY. | PART # | PART NAME |
|--------|------|----------|-----------------------------------|--------|------|---------|-----------------------------|
| 1 | 1 | 1002786 | PC Frame w/Zerk | | 1 | 7784226 | Case Eject Spring |
| | 1 | 7784200 | Frame | | 2 | 7109509 | 8-32 x 1/4" SHSS |
| | 1 | 7109213 | Zerk Fitting | | 1 | 7784214 | Index Spring Holder |
| 2 | 2 | 7788902 | Link | | 1 | 7181293 | PC Index Spring #S-404 |
| 3 | 1 | 7709128 | Link Pin Right | | 1 | 7784223 | Transfer Bar Return Pin |
| 4 | 1 | 7709127 | Link Pin Left | | 1 | 7187159 | 1/4-28 x 3/4" SHCS |
| 5 | 1 | 7784201 | Toggle Block | | 1 | 7109604 | 1/4-28 Hex Nut |
| 6 | 1 | 7788912 | Toggle Block Pin | | 1 | 7181295 | 8-32 x 5/8" Spring Plunger |
| 7 | 3 | 7187212 | Nyloc Nut 7/16-20 | 15 | 2 | 7187159 | 1/4-28 x 3/4" SHCS |
| 8 | 1 | 7784211 | Ram | 16 | 1 | 7188037 | Index Ball Spring BB-97 |
| 9 | 1 | 7788919 | Ram Pin | 17 | 1 | 7187152 | Detent Ball 3/8 |
| 10 | 1 | 7187219 | 1/4-28 x 3/8" SHSS | 18 | 1 | 7784217 | Shell Plate Bolt |
| 11 | 1 | | Index Mount Assembly 7 | 19 | 1 | | Primer Plug Assembly Small |
| | 1 | 7784207 | Index Mount 7 | | 1 | 7784220 | Primer Plug Holder Small |
| | 1 | 7784209 | Indexer 7 | | 1 | 7784222 | Primer Plug Small |
| | 1 | 7186269 | 5-40 x 1/2 BHCS | | 1 | 7181291 | Primer Plug Spring #70464 |
| | 1 | 7189069 | 5-40 Machine Screw Nut Zinc | | 1 | 7181294 | Retaining ring E Clip 5/64" |
| | 2 | 7784215 | Index Return Screw | 20 | 2 | 7187217 | 8-32 x 3/8" BHCS |
| | 1 | 7181290 | Index Return Spring #80033 | 21 | 1 | 7181284 | Primer Transfer Bar Small 7 |
| | 1 | 7187052 | #4 Flat Washer | 22 | 1 | 7181287 | Primer Bar Actuator 7 |
| 12 | 2 | 1002775 | 5-40 x 3/8" FHCS | 23 | 4 | 7187218 | 8-32 x 3/8" FHCS |
| 13 | 1 | 7784216 | Locating Pin | 24 | 1 | 7784210 | Primer Dispenser |
| 14 | 1 | | Shell Plate Holder 7 Assembly | 25 | 1 | 7181292 | Transfer Bar Return Spring |
| | 1 | 7784203 | Shell Plate Holder 7 | 26 | 1 | 7784224 | Spent Primer Tube |
| | 1 | | Case Retaining Bracket 7 Assembly | 27 | 1 | 7784225 | Discharge Chute |
| | 6 | 7187206 | Case Retaining Spring | 28 | 1 | 7187051 | Lock Washer #10 |
| | 6 | 7788943 | Case Retaining Spring Plug | 29 | 1 | 7186144 | 10-32 x 3/8" BHCS |
| | 1 | 7181281 | Case Retaining Bracket 7 | 30 | 1 | 7784205 | Die Plate 7 |
| | 3 | 7187215 | 6-32 x 3/8" FHCS | 31 | 3 | 7109509 | 8-32 x 1/4" SHSS |
| | 1 | 7181288 | Case Feed Ramp | 32 | 1 | | PC Handle Assembly |
| | 1 | 7187208 | Case Retaining Spring Station #1 | | 1 | 7784213 | Handle |
| | 3 | 7187217 | 8-32 x 3/8" BHCS | | 1 | 7109121 | Handle Ball |
| | 2 | 7187216 | #8 Flat Washer | 33 | 1 | 7181285 | Primer Transfer Bar Large 7 |
| | 1 | 01003556 | Index Spring Plug | 34 | 1 | 1003286 | Transfer Bar Guide |
| | | | | 35 | 1 | 7784218 | Shell Plate Washer |

Optional Accessories for Your Pro Chucker Progressive Reloading Press



82350 Bullet Feeder—Pistol Kit



Gold Medal Seat Die



87540 Lock Out Die



87590 Powder Check Die



82355 Tube Pistol Bullet Feeder
9mm/.38-.357(90-158)

82356 Tube Pistol Bullet Feeder
.38/.357 (158-180)

82357 Tube Pistol Bullet Feeder
40 S&W/10mm

82358 Tube Bullet Feeder
45 ACP



88879 Low Primer
Detector



9634 Die Lock Ring Wrench

LIFETIME LIMITED WARRANTY

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