



HAND CASE NECK TURNER & CASE HOLDER



PRODUCT INSTRUCTIONS

SAFETY

Reloading is an enjoyable and rewarding hobby that is easily conducted with safety. But carelessness or negligence can make reloading hazardous. This product has been designed from the beginning with the user's safety in mind.

As with any reloading operation, safety rules must be followed. By observing these few rules, the chance of hazardous occurrence causing damage or injury becomes extremely remote.

GENERAL

- Use the equipment as the manufacturer recommends. Study the instructions carefully and become thoroughly familiar with the operation of the product. Don't take short cuts.
- Observe "good housekeeping" in the work area. Keep tools and components neat, clean and orderly. Promptly clean up any powder spills.
- Always wear adequate eye protection.
- If any unusual resistance is encountered when moving the operating handle, STOP IMMEDIATELY and investigate the cause. To proceed against unusual resistance may damage equipment and/or cause serious injury!

LOADING DATA

- Use only laboratory tested data. We highly recommend the use of the SPEER Reloading Manual.
- OBSERVE ALL WARNINGS ABOUT THE USE OF MAXIMUM LISTED LOADS.

POWDER HANDLING

- WARNING: Primers are designed to explode and will do so when subjected to heat or percussion.
- Do not decap live primers!
- Never attempt to seat or reseat a primer in a loaded cartridge.
- Store primers and powder beyond the reach of children and away from heat, dampness, open flames and electrical equipment.
- DO NOT use any powder unless its identity is positively known. Discard all mixed powders and those of uncertain or unknown identity.
- Before charging cases, settle the powder in the powder hopper. Throw and check the weight of at least ten charges. This will assure you that the correct powder charge is being thrown.
- After a reloading session ends, return the remaining powder back into its original factory container. This will preserve the identity and shelf life of the powder.
- DO NOT SMOKE while handling powder or primers.

RECORD KEEPING

- Keep complete records of reloads. Apply a descriptive label to each box showing the date produced, and the primer, powder and bullet used. Labels for this purpose are packed with SPEER bullets.

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

GENERAL INFORMATION

The Hand Case Neck Turner and Case Holder from RCBS is the most convenient case neck turning tool you can get your hands on. The neck turning tool features the ability to 'zero' the cutter to the pilot/mandrel, allowing for the precise case neck thickness to be dialed in for the cut. The micrometer cutter is graduated in adjustments of .0005" and can be locked in place once the desired setting is achieved. The pilot/mandrel (sold separately) is designed so that you can set it as a case mouth stop insuring uniformity over the length of the cut.

The unique 2" diameter Case Holder is comfortable to use and quick to change cases. The small collet will fit cases from .22 Hornet to 7.63X54R. The large collet will fit cases from .308 Winchester/.30-06 Springfield to Weatherby Magnum/Lapua Magnum. The case guide plug helps to center the case and expose a consistent amount of the case neck and shoulder. Cases can also be held exposing the base of the case for preparation of the primer pocket on the Trim Mate Case Prep Center (sold separately).

Unpack the Hand Case Neck Turner Tool carefully. Look for and identify the following items:

- Hand Case Neck Turner Body
- Part bag #1 with the following parts: Micrometer assembly and Spring
- Part bag#2 with the following parts: Brass lock ring, cutter, hex wrench, 10/32x3/16" and 10/32x3/8" set screws
- Case Holder Body
- Case Holder Cap
- Case Holder Lock Nut
- Case Holder Guide Plug
- Case Holder Collet – Large
- Case Holder Collet – Small
- Case Holder Guide Plug "O"Rings(2)

ASSEMBLY

Hand Case Neck Turner(HCNT)

Open part bags #1 and #2 and lay out pieces in an orderly fashion. Thread the brass lock ring about $\frac{3}{4}$ of the way up onto the threads of the micrometer body. Slide cutter spring over the cutter shaft and insert into bottom of Micrometer Body. Carefully thread the Micrometer Assembly about half way into the cutter shaft hole(see photo 1) Continue threading the micrometer assembly in until about $\frac{1}{4}$ " of the cutter is exposed. Rotate until the flat part of the cutter is facing "up". (see photo 1). Install the $\frac{3}{8}$ " long socket head set screws(SHSS) into the body until it just touches the flat part of the cutter shaft(see photo 2). The cutter should still be able to slide in and out. Slide the appropriate pilot/mandrel(sold separately) into the tool body and secure with the $\frac{3}{16}$ " SHSS. The pilot/mandrel should be secured so that the larger diameter stop portion does not interfere with the cutter.



Photo 1



Photo 2

Case Holder

First you must determine the body diameter of the cases you are turning. Cases with body diameters between .22 Hornet and 7.62x54R should use the 5 fingered Small collet. Cases from .30-06 to WBY Mag diameter should use the 6 fingered Large collet. Insert the appropriate collet into the bottom of the case holder and secure with the lock nut (see photo 3). Install two rubber "O" rings onto the guide plug and install guide plug assembly into the bottom of the locknut with the cupped end in towards the collet(see photo 4). Thread the cap onto the holder.

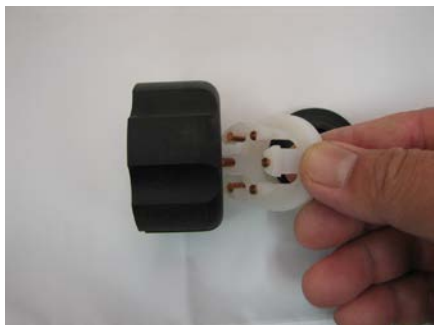


Photo 3



Photo 4

CASE PREPARATION

Cases must be sized, trimmed for Over-All Length(OAL) and the case mouths chamfered and deburred for use with the HCNT. Remove case lubricant from cases. The Case Holder will not be as effective if cases still have case lubricant on them.

TO USE

The Hand Case Neck Turner is designed so that the case is rotated around the pilot/mandrel though you can choose to rotate the cutter assembly around the case. The assembly instruction above is for holding the HCNT in your left hand and rotating the case, in a clockwise direction with your right hand. You can change the tool for left handed operation by removing the cutter SHSS, rotating the cutter 180 degrees and reinstalling the SHSS into the other side. Rotation then would be counter clockwise.

With the proper pilot/mandrel installed(sold separately), temporarily lock into place with the SHSS. To set the length of the cut, slide a sized, trimmed for OAL and chamfered case onto the pilot/mandrel up to the stop. Bring the cutter assembly down until the cutter is just shy of contacting the case neck. Loosen the pilot/mandrel SHSS and adjust the pilot/mandrel in or out until the leading edge of the cutter is at the desired point on the case neck/shoulder junction (see photo 5). Lock the pilot/mandrel SHSS.



Photo 5



Photo 6

Remove the case from the pilot/mandrel. Set the micrometer to 0-0(see photo 6). Screw the micrometer body down until the cutter contacts the pilot/mandrel and lock the micrometer body in place with the brass lock ring.

Adjust the micrometer to the desired thickness of the cut. This thickness can be determined in two ways.

Using a ball (tube) micrometer, measure the case neck thickness at various points around the neck. Measure at least 5-10 cases in the lot of brass to be reloaded. The smallest measurement would be what you want to set the cutter for to have uniform case neck thickness for the entire lot of brass cases.

Another way is to measure the loaded diameter of a cartridge. We will use 6mm as an example. Using an outside micrometer, if the loaded diameter is .269, subtract .243 for the bullet diameter leaving you with .026". Divide that in half and that would give you a case neck thickness of .013".

Lock the cutter with the SHSS. It is recommended that if more than .001" of the case neck is to be cut away or 'peeled', two or more passes are made only cutting .001" of the neck or less.

Case neck brass will be cut or "peeled" on the forward and back motion over the cutter. Do not cut to the base of the neck and then just pull the case off of the cutter. Continue to rotate the case as you back down off of the pilot shaft. See photo below of neck being "peeled" and a properly turned case neck.



The Case Holder is designed to allow you to quickly insert and remove cases. The design also allows you to rotate the case and put forward pressure to advance the case neck to the cutter.

The Guide Plug in the base of the Case Holder helps to center the case and provide a reference so that a uniform amount of the case is exposed.

Loosen the cap enough to allow a case to pass through the collet fingers. Tighten the cap to secure the case. Guide case neck over pilot/mandrel and begin cutting or 'peeling' the case neck.

Do not hold cases near the shoulder or case mouth, the clamping force of the case holder could damage thinner walled cases.





PRECISIONEERED RELOADING EQUIPMENT

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

If you agree, please tell your friends.

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

Customer Service

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

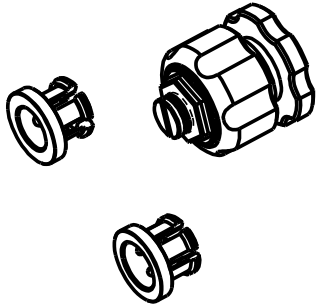
Hours: Monday - Thursday, 6:30am - 3:00pm Pacific Time
(hours may vary)

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

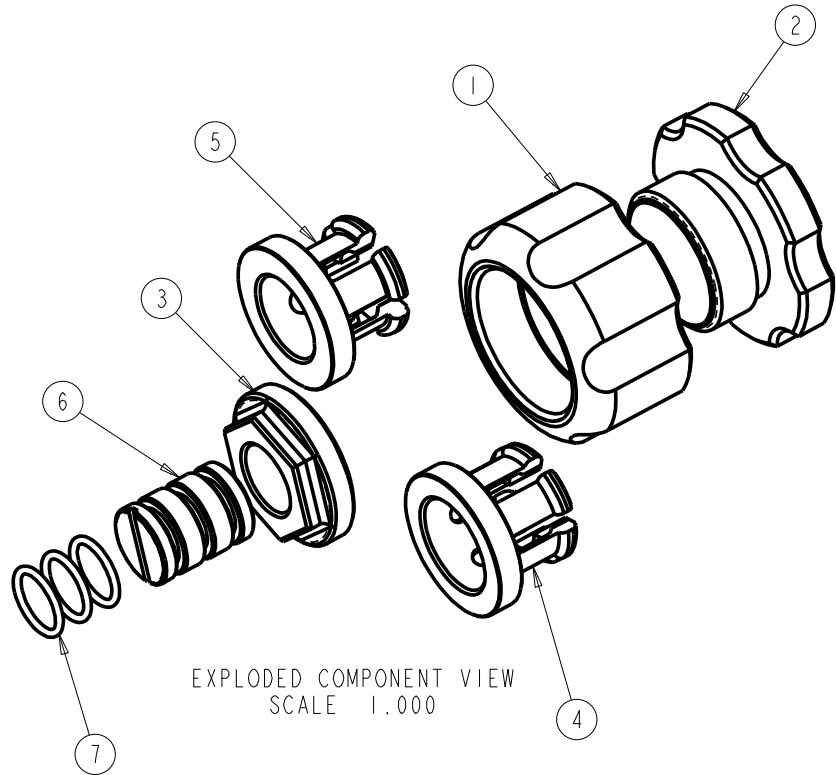
RCBS, 605 Oro Dam Blvd., Oroville, CA 95965

CCI - SPEER - RCBS
OUTERS - RAMLINE - ORBEX - FEDERAL

DWG. NO.: 90402



SHIPPING CONFIGURATION
SCALE 0.500



EXPLODED COMPONENT VIEW
SCALE 1.000

SPECIFICATIONS AND NOTES

Item	Qty	Part#	Description
1	1	109435	HOLDER BODY
2	1	109436	HOLDER HANDLE
3	1	109437	NUT, HCNT
4	1	109441	OVERMOLD RUBBER COLLET, LARGE
5	1	109442	OVERMOLD RUBBER COLLET, SMALL
6	1	109445	CASE STOP PLUG
7	3	O-RING	0.551" ID x 0.070" THK, Buna-N

	6/16/06	RELEASE EN N3113	DBS
A	6/12/06	NEW PART NUMBERS FOR OVERMOLD DESIGN	DBS
NO.	DATE	REVISION	BY APP.

CLASSIFICATION OF MIL-STD-105D A Q L EXPRESSED IN PERCENT DEFECTIVE
 ● CRITICAL
 ● MAJOR
 ● MINOR
 ○ ENVELOPE DIM. - INSPECTION LIMITED TO FIRST PARTS ONLY
 ○ CLASSIFICATION WILL APPLY TO ALL CHARACTERISTICS

DIMENSIONING PRACTICES AND STANDARD POSITIONAL AND FORM SPECIFICATIONS BASED ON MIL-STD-8C AND ANSI Y14.5
 ALL DIMENSIONS ARE GIVEN IN INCHES AND DEFINE THE FINISHED PART
 ALL DIMENSIONS LOCATING TRUE POSITION ARE BASIC

TOLERANCES AND SPECIFICATIONS UNLESS OTHERWISE NOTED

FRACTIONS		SURFACE ROUGHNESS .125	✓
DECIMALS		FILLET RADI	
00	±.010	BREAK ALL SHARP CORNERS MAX .007 R	
000	±.005	OR MAX .015	
ANGLES	±1°		

ENGR.	DR BY	CHK BY	APP BY	DATE	SCALE
DBS	DBS			3/01/06	1.000

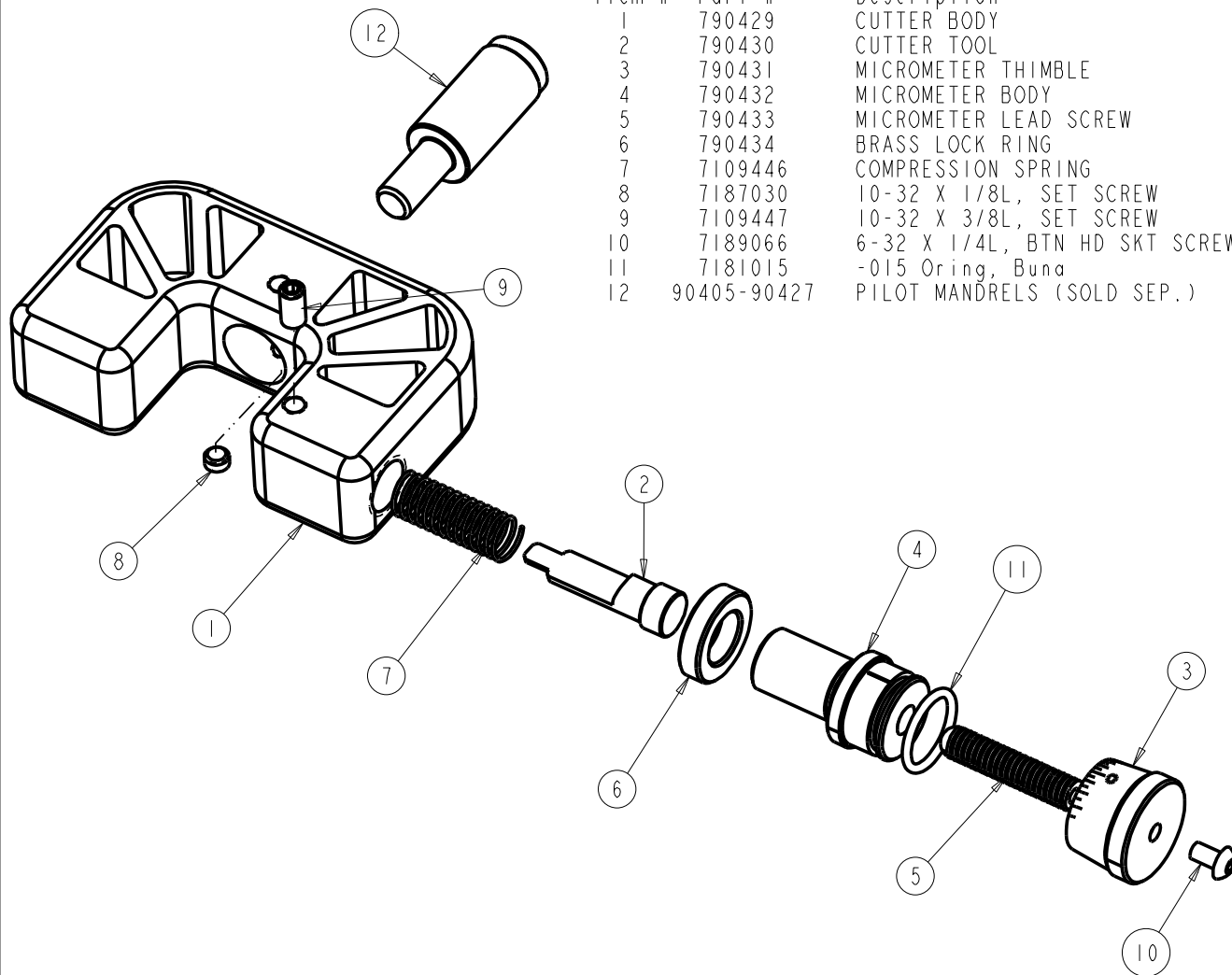
TITLE: QUICK CHANGE CASE HOLDER

USAGE: HAND CASE NECK TURNER

PART NO.: 90402 DWG NO.: 90402

Ammunition Accessories Inc. 605 ORO DAM BLVD.
 RCSB Operation OROVILLE, CA 95965

DWG. NO.: 790403



Item #	Part #	Description
1	790429	CUTTER BODY
2	790430	CUTTER TOOL
3	790431	MICROMETER THIMBLE
4	790432	MICROMETER BODY
5	790433	MICROMETER LEAD SCREW
6	790434	BRASS LOCK RING
7	7109446	COMPRESSION SPRING
8	7187030	10-32 X 1/8L, SET SCREW
9	7109447	10-32 X 3/8L, SET SCREW
10	7189066	6-32 X 1/4L, BTN HD SKT SCREW
11	7181015	-015 Oring, Buna
12	90405-90427	PILOT MANDRELS (SOLD SEP.)

SPECIFICATIONS AND NOTES

MATERIAL:

HEAT TREAT:

FINISH:

QUANTITY PER 1000:

-	6/16/06	RELEASE EN N3113	DBS
NO.	DATE	REVISION	BY APP.

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 ● CRITICAL
 ● MAJOR
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 ALL DIMENSIONS ARE GIVEN IN INCHES AND DEFINE THE FINISHED PART
 ALL DIMENSIONS LOCATING TRUE POSITION ARE BASIC

TOLERANCES AND SPECIFICATIONS UNLESS OTHERWISE NOTED

FRACTIONS	SURFACE ROUGHNESS .125	✓
DECIMALS	FILLET RADI	
.00	±.010	
.000	±.005	BREAK ALL SHARP CORNERS MAX .007 R
ANGLES	±1°	OR MAX .015

ENGR.	DR BY	CHK BY	APP BY	DATE	SCALE
DBS	DBS			5/2/06	0.500

TITLE: HAND CASE NECK TURNER, CUTTER ASSEMBLY

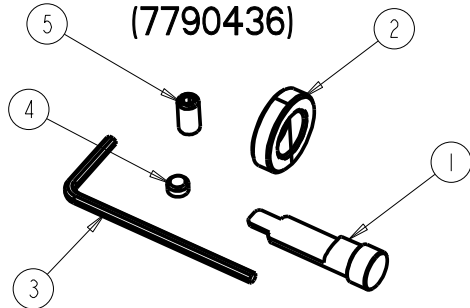
USAGE:

PART NO.:	790403	DWG NO.:	790403
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Ammunition Accessories Inc.
 RCB Operations

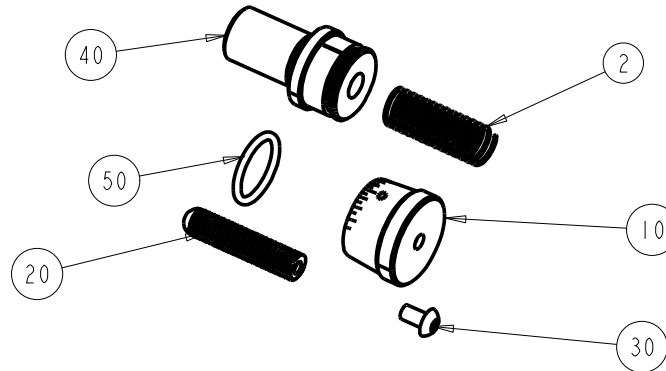
605 ORO DAM BLVD.
 OROVILLE, CA 95965

**PARTS BAG #2
(7790436)**



Item #	Part #	Description
1	7790430	CUTTER TOOL
2	7790434	BRASS LOCK RING
3	7109635	ALLEN WRENCH, 3/32
4	7187030	10-32 X 1/8L, SET SCREW
5	7109447	10-32 X 3/8L, SET SCREW

Item #	Part #	Description
1	7790428	MICROMETER ASSEMBLY
10	7790431	MICROMETER THIMBLE
20	7790433	MICROMETER LEAD SCREW
30	7189033	BUTTON HEAD SCREW, 6-32x 1/4"L
40	7790432	MICROMETER BODY
50	7181015	-015 Oring, Buna
2	7109446	COMPRESSION SPRING



**PARTS BAG #1
(7790435)**

