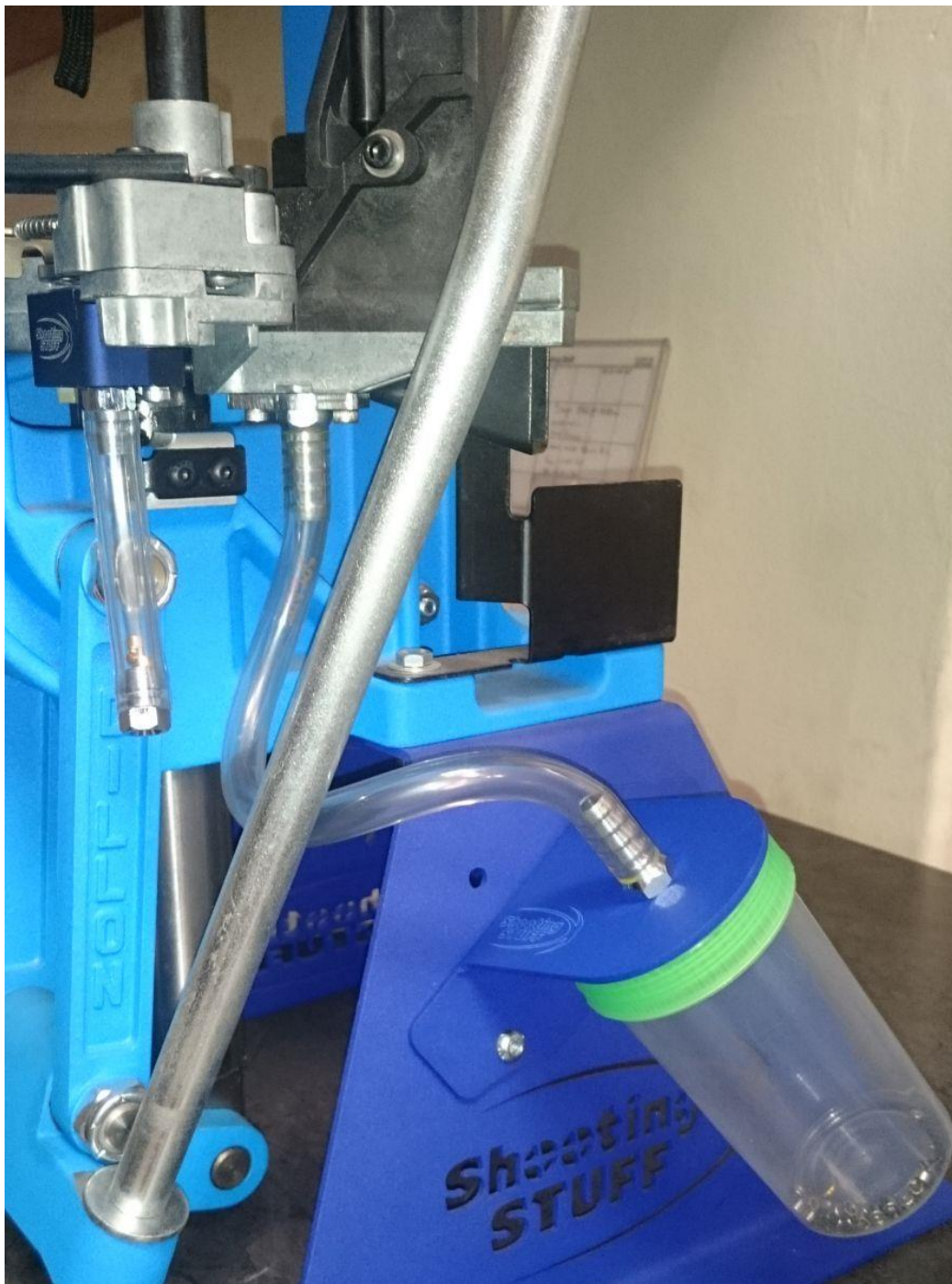


Installation Instructions for Shooting Stuff's *NoSpill* Primer Kit for XL650

This kit is suitable for the Dillon XL 650 progressive reloading machine mounted on a machine mount or directly to the reloading bench.



Package Contents

Figure 1 illustrates the package contents:

- 1x Bottle Mounting Bracket assembly (blue with bottle)
- 1x 120cm Long PVC tubing
- 1x 25cm Short PVC tubing
- 1x Spent primer fitting (silver, left in figure 2)
- 1x Live primer fitting assembly (blue with tube, right in figure 2)
- Fasteners (detailed in figure 3)
 - 1x Allen key
 - 1x Long socket head cap screw (SHCS)
 - 2x Short socket head cap screws (SHCS)
 - 2x ¼" Round head cap screw (RHCS)
 - 2x ¼" Tensi-lock nut

Note on the PVC tubes

- The short PVC tube was pre-cut to length to suit machines that are mounted onto any of the Dillon Strong Mounts or Shooting Stuff Machine Mounts.
- The long PVC tube is for users mounting directly to the reloading bench, and also serves as spare tubing for those using the Dillon Strong Mount or Shooting Stuff Machine Mount.



Figure 1



Figure 2



Figure 3

Instructions

To avoid any potential reloading errors, we suggest that you first remove all cartridges and partially loaded cartridges from your XL 650. Switch off the case feeder and empty the case feed tube. Remove the tool head from the machine and store this safely – Dillon's cast tool head stand is ideal. It is safest to conduct the installation of the *NoSpill* Primer Kit without any primers in the priming system, so please consult the Dillon XL650 manual to achieve this.

Once you have verified the package contents and prepared for the installation, proceed to Step 1.

Step 1

Lower the handle to raise the platform for your XL650, making it easier to access the underside of the platform. Remove the spent primer cup (#16211) from its bracket.

Remove the spent primer cup bracket (#16209) from the platform by unscrewing the two primer cup bracket screws (#14689) using a 3/32" Allen wrench from your XL650 Toolkit.

Remove the live Primer Chute (#16210) by unscrewing the two 8-32x3/8 cap screws (#14013) using a 9/64" Allen wrench from your XL650 Toolkit.

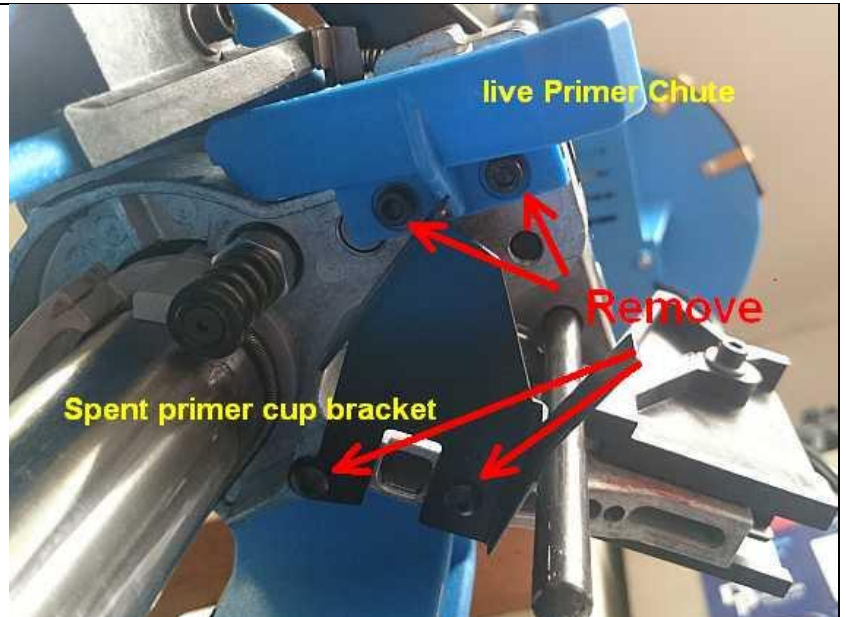


Figure 4

Step 2

As illustrated in Figure 6, install the new spent primer fitting (the silver one, Figure 5) in place of the spent primer cup bracket, using the two short socket head cap screws (SHCS) and the Allen key that came with your *NoSpill* Primer Kit. The screws need to be tightened just enough to ensure that the fitting is held securely in position; take care not to over tighten these screws.



Figure 5



Figure 6

Step 3

Install the new live primer fitting (the blue one) in place of the Primer Chute, using the single longer, socket head cap screw (SHCS) and the Allen key that came with your *NoSpill* Primer Kit. See Figures 7 and 8.

Whereas Dillon's plastic live Primer Chute had been attached with two screws, your new live primer fitting is attached to just the left side screw-hole using just one screw as illustrated in Figure 8. Again, take care not to over tighten the screw.



Figure 7



Figure 8

You are now ready to install the new Bottle Mounting Bracket. Depending on how your XL 650 is mounted, proceed to the appropriate part of Step 4:

4a) Using a Shooting Stuff XL 650 Machine Mount or similar Dillon XL 650 Strong Mount (#22052)

4b) Using a Shooting Stuff RL 550B Machine Mount or similar Dillon 550 / 650 Strong Mount (#22051)

4c) Mounted directly to the reloading bench, i.e. no mount.

Step 4a

You are now ready to install the new Bottle Mounting Bracket onto your Shooting Stuff Machine Mount (Figure 9), or similar Dillon XL 650 Strong Mount (#22052). The Bottle Mounting Bracket is mounted to the right side plate of the mount.

Unscrew the bottle from its cap, and set the bottle aside. Install the Bottle Mounting Bracket to the Machine Mount with the bottle's cap to the rear, using the two ¼" round head cap screws (RHCS) and their corresponding two ¼" Tensi-lock nuts. The Bottle Mounting Bracket is fitted to the Machine Mount using the lower-front and upper-rear pre-machined mounting holes, as illustrated in Figure 9 and Figure 10. The nuts should be positioned on the inside (left side) of the mount's right side plate. Use a 5/32" Allen wrench from your XL 650 Toolkit to tighten these screws; the nuts can be held with the closed 7/16" hexagonal-ring of the 1-inch Wrench that is also part of your XL 650 Toolkit.



Figure 9



Figure 10

Step 4b

You are now ready to install the new Bottle Mounting Bracket onto your “tall” Dillon 550 / 650 Strong Mount (#22051), or similar Shooting Stuff Machine Mount for the RL 550B. The Bottle Mounting Bracket is mounted to the right side plate of the mount.

Unscrew the bottle from its cap, and set the bottle aside. Install the Bottle Mounting Bracket to the Machine Mount with the bottle’s cap to the rear, using the two ¼” round head cap screws (RHCS) and their corresponding two ¼” Tensi-lock nuts. The Bottle Mounting Bracket is fitted to the Machine Mount using the centre and upper-rear pre-machined mounting holes, as illustrated in Figure 11 and Figure 12. The nuts should be positioned on the inside (left side) of the mount’s right side plate. Use a 5/32” Allen wrench from your XL 650 Toolkit to tighten these screws; the nuts can be held with the closed 7/16” hexagonal-ring of the 1-inch Wrench that is also part of your XL 650 Toolkit.



Figure 11



Figure 12

Should you have a different mounting system to any of these, you may be required to drill additional mounting holes for the *NoSpill* Primer Kit.

Step 4c

If your XL 650 is mounted directly to the reloading bench you may simply lay the Bottle Mounting Bracket Assembly safely on the floor under the bench, or find a suitable location to affix it to your reloading bench. Cable ties or self-drilling, self-tapping screws (not included) are suggested methods to affix the Bottle Mounting Bracket to the bench.

We suggest completing Step 5 (connect the PVC tubing from the bottle to the fitting that you installed in Step 2) before finalizing any mounting location on/under the bench. Select a location that would ensure that the PVC tube descends continuously from the XL 650 to the bottle, without looping up. The tube may be trimmed to length, if required. Remember to allow for the movement of the XL 650 platform!

Step 5

The final step is to connect the PVC tubing from the bottle to the fitting that you installed in Step 2. The PVC tubing is available in two lengths depending on the setup that you have.

- The long PVC tube is used when the XL 650 is mounted directly to the bench, and is usually a simple, direct connection and does not require any special twisting.

- The pre-cut, short tube should be used when you have the Bottle Mounting Bracket installed on the Machine Mount (or Dillon Strong Mount). In this case, stop – pause – and read the following first.

Please read this carefully before connecting any tubes to the fittings.

The PVC tubing needs to be twisted, roughly one revolution either clockwise or anticlockwise (depending on the tubing's natural coil). When fitting the tube you must consider where it will twist to and how it is going to be positioned as the handle is cycled up and down.

Start by pushing the short PVC tube fully onto the Bottle Bracket Fitting. Next, push the other end of the short tube roughly halfway onto the spent primer fitting (**not yet! Read through this section first**) and then inspect which way the tubes may need to be twisted to ensure that the correct amount of coiling and coil position are achieved. As illustrated in Figure 13, when the tube is correctly fitted the twist should position the tube “nicely” in the space between the right-side 650 link arm (#14922) and the handle shaft (#13855), or roller handle equivalent.

When you are satisfied with the routing, the tube should be pushed fully onto the fittings. The amount of twist may be adjusted slightly once they are fully seated by carefully twisting the tubing on the fitting. Take care not to bend the fitting during this process; try to twist perfectly in line with the fitting's axis.

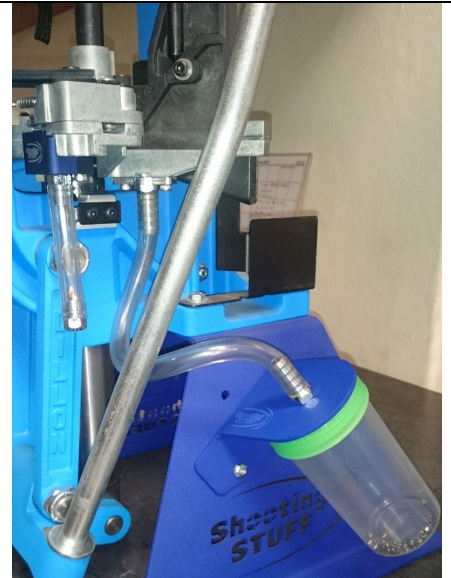


Figure 13

OK, now you can proceed with connecting the tubes to the fittings.

As illustrated in Figure 13, connect PVC tubing all the way on to the spent primer fitting. Inspect the installed tubes. Ensure that they are clear of any obstruction and any potential pinch points.

We have refined the design to reduce possible “clogging points”, but please take care to regularly inspect the PVC tubes for possible fouling / clogging up – especially during initial use. Remember to regularly empty the primers from the bottle, and especially from the live-primer tube.

Safety Considerations

- Take care when using this *NoSpill* Primer Kit; misuse may lead to injury.
- Follow proper safety procedures when handling live primers.
- Live primers should be properly stored in individual containers, as supplied by the manufacturer. They should never be stored in bulk.
- **The small live primer tube must be emptied frequently**, at least after every loading session.
- The small live primer tube must never be allowed to fill with more than a few primers as the explosive content / effect of primers is significant.

Warranty

Shooting Stuff fully supports Dillon's Lifetime No-B.S. Warranty and we offer a similar Lifetime No-B.S. Warranty on our products. Like Dillon, we offer a 1 year warranty on our brand of fabrics and electrical / electronic items.