

Dillon Variable Speed Casefeeder Instruction Manual

June 2019



VARIABLE SPEED CASEFEEDER

Thank you for purchasing the Dillon Variable Speed Casefeeder. This manual will cover how to setup and adjust the Casefeeder.

- Remove the parts bag, Casefeeder Assembly and Power Supply from the box, (actual Casefeed Plate may vary).



- Slide the Casefeed Bowl onto the Casefeed Post and thread the Locking Screw into the Casefeeder (do not tighten at this point).



- From your Caliber Conversion Kit, insert the Casefeed Adapter into the Casefeed Body. Casefeed Adapters are caliber specific, verify your Casefeed Adapter with the Caliber Conversion Chart from your machine manual. Note how the alignment tab fits into the notch on the Casefeed Body.



- Align the Casefeed Bowl so the Spring Clamp is directly over the Casefeed Adapter. Place the Casefeed Tube into the Casefeed Adapter then snap the Casefeed Tube into the Clamp (Fig. 1), rotate the Bowl side to side to get the Casefeed Tube as perpendicular as possible (Fig. 2). One end of the casefeed tube is beveled on the inside and must be installed with the Dillon decal lettering facing up.



- Once you have the Casefeeder in place, using a 5/32" hex wrench to snug (5-7 inch pounds) the Locking Screw against the Casefeed Post to prevent the Casefeeder Bowl from rotating.



Power Supply Setup

- The new Variable Speed Casefeeder utilizes a Universal Power Supply that works on 110-240V AC 50/60 Hz and comes with several Wall Socket Adaptors. Choose the Adaptor for the utility power in your area (Fig. 1). Install the Adaptor into the Power Supply, by inserting the side with the raised edge opposite the sliding latch and press into the pocket until the latch locks in place (120V AC Adaptor pictured) (Fig.2).



Fig. 1

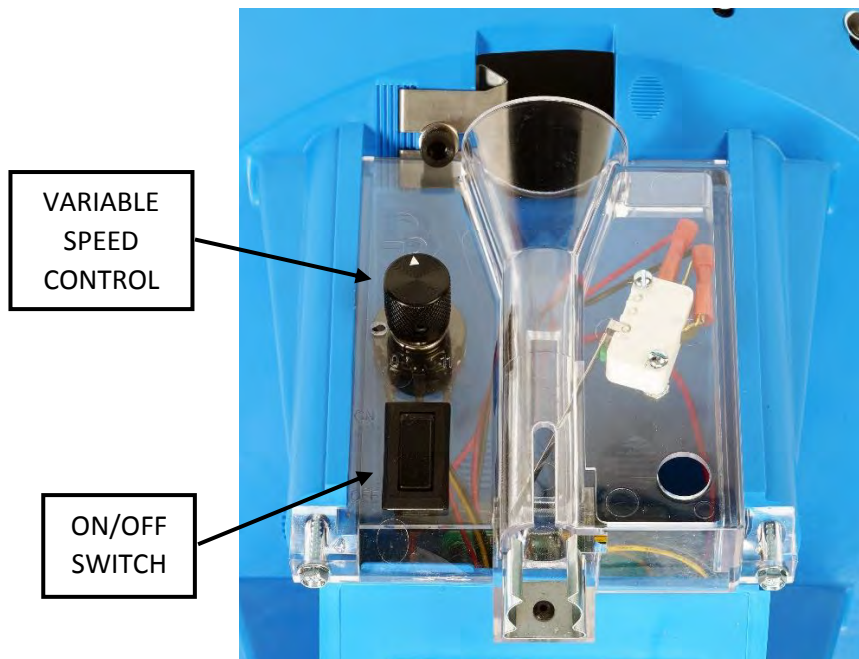


Fig. 2

- Connect the Power Supply Power Cord into the Casefeeder by pushing the small Barrel Plug Adaptor into the Socket on the bottom face of the Casefeeder (Fig. 3). Now plug in the Power Supply.

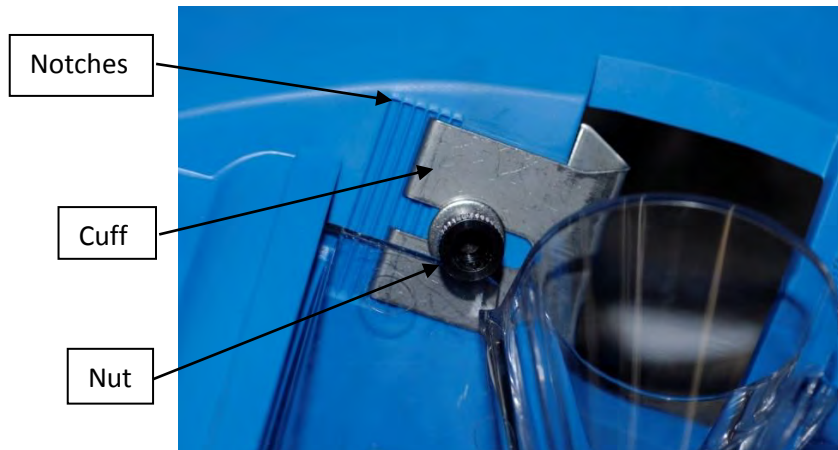


- The Casefeeder's speed is adjustable up to 8 rpm. Rotating the Dial fully counterclockwise will set the Motor at the lowest speed and rotating fully clockwise will set the Motor at its full speed. See the chart on page 11 for the window opening. Start with the dial in the middle of its rotation (about 4 rpm). Turn the Power Switch to the on position. Fine tune the Motor speed, as needed, for more or less rpm to optimize cartridge feeding.



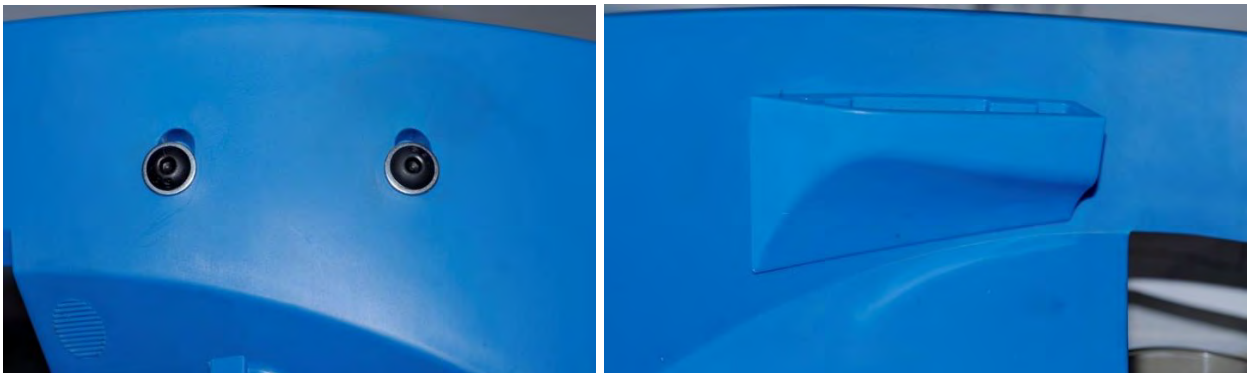
Casefeed Port Cuff

- The Casefeed Window Cuff is now adjustable. This allows for faster and more reliable case feeding of longer (i.e. 338 Lapua, 300 Win Mag) and shorter rifle cases (i.e. 300AAC Blackout, 7.62x39). The Window has six positions, the third position from the left will give you the standard opening width of the previous unit. This adjustment should work for all pistol and most standard rifle cartridges. The window adjusted to the full left position (fully open) allows for faster case feeding of larger rifle calibers (i.e. 338 Lapua, 300 Win Mag). The window adjusted to the full right position allows for case feeding of shorter bottle neck rifle cases (i.e. 300AAC Blackout, 7.62x39) utilizing standard rifle Casefeed Plates. The Cuff can be adjusted by loosening the Black Knurled Nut, which incorporates a 3/16" hex. Slide the Cuff into the desired position, making sure that the tab on the Cuff is in locked into the appropriate Adjustment Notch. Retighten the Nut to no more than 10-12 in.-lbs. to lock it into position.



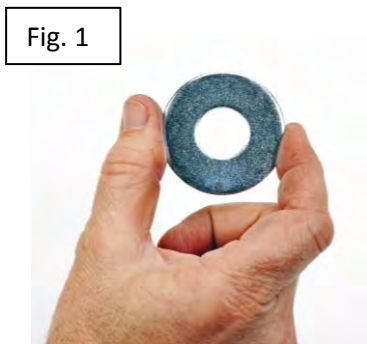
Case Deflector

- The Casefeed utilizes an Adjustable Case Deflector Block. The Deflector has two positions for operation, fully lowered for pistol and fully raised for rifle and shotgun cartridges. The block can be adjusted by loosening the two #8 screws with a 3/32" hex wrench, slide the Block to the desired position based on pistol or rifle cartridge, and tightening the two screw to no more than 5-7 in.-lbs. to lock it into position.



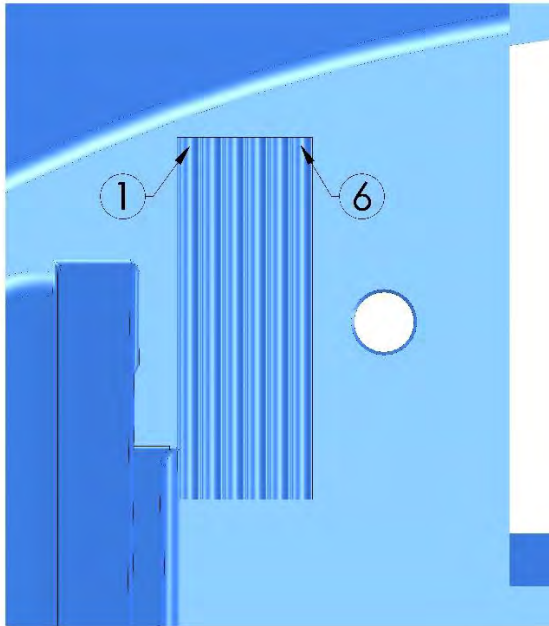
Casefeed Plate Spacer Washer

- Some calibers require a Spacer under the Casefeed Plate. Refer to the Caliber Conversion Chart for application on page 8. Installation of this Washer (Fig. 1) raises the Plate up to make the Feeder function properly with longer pistol cases. To install the Washer, remove the Casefeed Plate from the Casefeeder. Disassemble the Casefeed Plate Clutch by removing the two Clutch Screws (Fig. 2). Be careful to keep the washers together on the screws during disassembly (Fig.3). Install the Spacer Washer between the Lower Clutch and the Casefeed Plate (Fig. 4) and reassemble the Clutch. The Clutch tension will need to be adjusted, please follow the clutch adjustment procedure as follows.



Clutch Adjustment/Bowl Capacity

- The clutch comes factory adjusted. If you are experiencing a problem with feeding or have added the optional Space Washer, use the following steps to adjust the Clutch. The Casefeed Bowl is not designed to be completely filled with brass, it will not function reliably if it is fully loaded. The rated capacity of the Casefeeder is **no more than half full**. The two socket-head machine screws (#18866 Item 5 Page 10) should be just tight enough for the Clutch to drive the Casefeed Plate under a normal load of brass. The correct setting will stall the Casefeed Plate (causing the Clutch to slip on the Casefeed Plate) before stalling the motor, yet not slip when the casefeed bowl is no more than half full of brass. Using moderate finger pressure against the Casefeed Plate, with the Casefeeder half full of brass, you should be able to cause the clutch to slip without stalling the motor. Alternately tighten or loosen the two machine screws evenly, observing the effect on the holding power of the clutch.

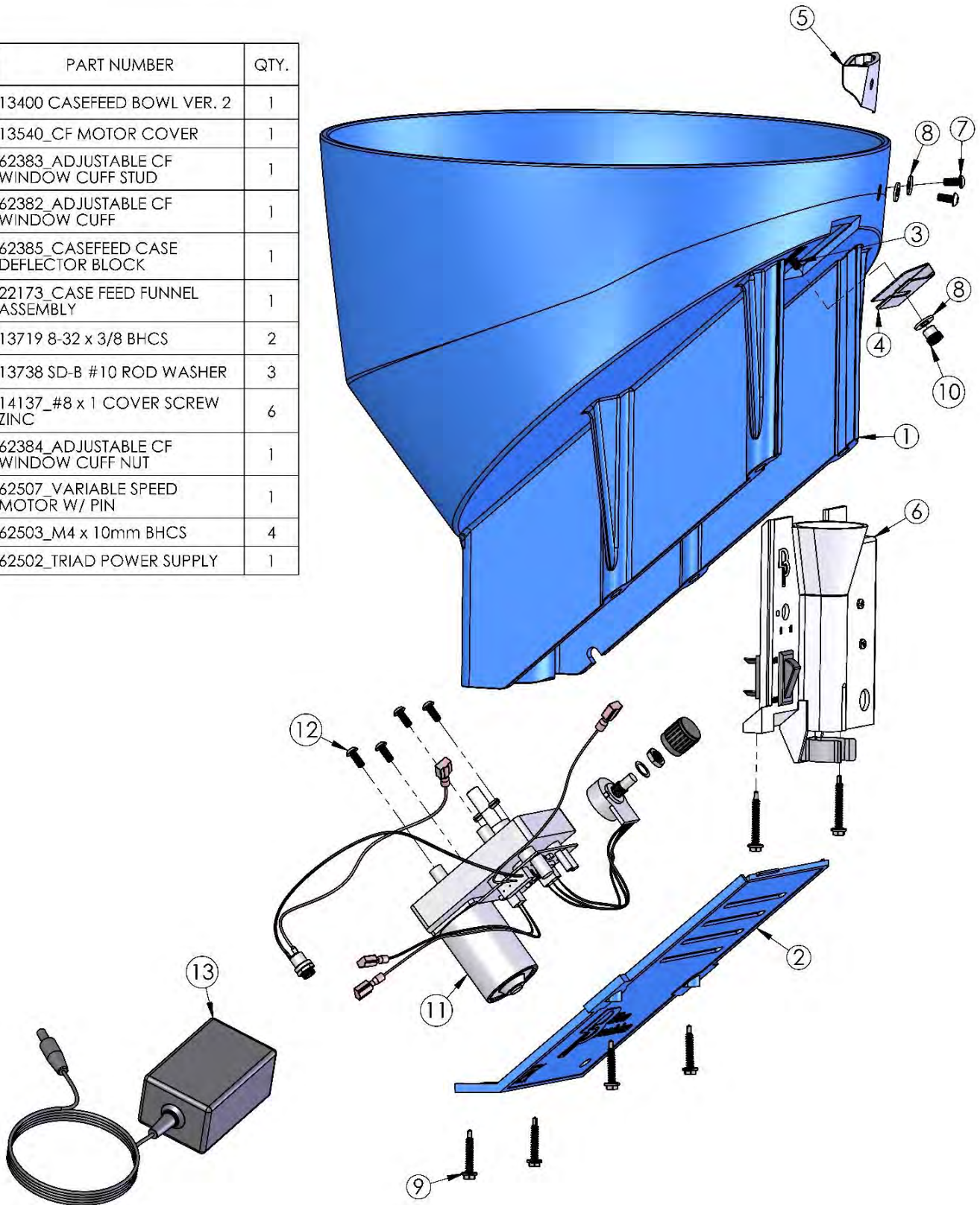


The chart below outlines the recommended casefeeder plate and starting positions for the window opening position and case deflector position. Adjustment to the window position and case deflector may be necessary dependent upon the variation of your setup.

CALIBER	CASEFEED PLATE	WINDOW POSITION	DEFLECTOR POSITION	CALIBER	CASEFEED PLATE	WINDOW POSITION	DEFLECTOR POSITION	CALIBER	CASEFEED PLATE	WINDOW POSITION	DEFLECTOR POSITION
.30 Luger, .30 Mauser	SMALL PISTOL	#3	DOWN	.22 Remington Jet	LARGE PISTOL	#3	DOWN	7.62x54	LARGE RIFLE	#1	UP
.32 ACP, 7.65MM	SMALL PISTOL	#3	DOWN	.218 Bee	LARGE PISTOL	#3	DOWN	.30 AR	LARGE RIFLE	#6	DOWN
.32 Short Colt	SMALL PISTOL	#3	DOWN	.220 Swift	LARGE RIFLE	#3	DOWN	.30M1 Carbine	SMALL RIFLE	#6	DOWN
.32 S&W	SMALL PISTOL	#3	DOWN	.222 Remington Magnum	SMALL RIFLE	#3	DOWN	.300 Blackout	SMALL RIFLE	#6	DOWN
.32 H&R Magnum	SMALL PISTOL	#3	DOWN	.22-250	LARGE RIFLE	#3	DOWN	.300 Wby./Win. Mag.	MAGNUM RIFLE	#1	UP
.327 Federal Magnum	SMALL PISTOL	#3	DOWN	.25-20 Winchester	SMALL PISTOL	#3	DOWN	.300 WSM/RSaum	MAGNUM RIFLE	#3	UP
7mm TCU	SMALL PISTOL	#3	DOWN	.223 Win./5.56x45mm	SMALL RIFLE	#3	DOWN	.300 Rem. Ultra Mag.	MAGNUM RIFLE	#1	UP
9mm, 9x21, .38 Super	SMALL PISTOL	#3	DOWN	.223 WSSM	LARGE RIFLE	#3	DOWN	.300H&H/.308 Norma Mag.	MAGNUM RIFLE	#1	UP
9x18 Makarov	SMALL PISTOL	#3	DOWN	.224 Wby. Mag.	SMALL RIFLE	#3	DOWN	.32-20 Winchester	SMALL PISTOL	#3	DOWN
9x25 Dillon	SMALL PISTOL	#3	DOWN	.243 Win./6mm Rem.	LARGE RIFLE	#3	DOWN	.303 British	LARGE RIFLE	#1	UP
.380 ACP	SMALL PISTOL	#3	DOWN	.243 WSSM	LARGE RIFLE	#4	DOWN	.30-30 Winchester	LARGE RIFLE	#1	UP
.38 Super Comp	SMALL PISTOL	#3	DOWN	.25-06, .257 Roberts	LARGE RIFLE	#3	DOWN	.308 Marlin Express	LARGE RIFLE	#1	UP
.38 Special,	LARGE PISTOL	#3	DOWN	.25 WSSM	LARGE RIFLE	#4	DOWN	.308 Win.	LARGE RIFLE	#1	UP
.357 Magnum	LARGE PISTOL*	#3	DOWN	.256 Win. Mag.	LARGE PISTOL	#3	DOWN	.30-06	LARGE RIFLE	#1	UP
.357 SIG	LARGE PISTOL	#3	DOWN	.257 Ack. Imp.	LARGE RIFLE	#3	DOWN	.30 T/C	LARGE RIFLE	#1	UP
10mm	LARGE PISTOL	#3	DOWN	.257 Wby. Mag.	LARGE RIFLE	#3	DOWN	.325 WSM	MAGNUM RIFLE	#4	UP
.40 S&W	LARGE PISTOL	#3	DOWN	6.5 Creedmoor	LARGE RIFLE	#5	DOWN	.338 Win./340 Wby.	MAGNUM RIFLE	#1	UP
.41 Mag.	LARGE PISTOL	#3	DOWN	6.5 Grendel	SMALL RIFLE	#6	DOWN	.338 Rem. Ultra Mag.	MAGNUM RIFLE	#1	UP
.44 Special, .44 Magnum	LARGE PISTOL	#3	DOWN	6.5 Rem. Mag.	LARGE RIFLE	#3	DOWN	.350 Rem. Mag.	LARGE RIFLE	#1	UP
.45 ACP	LARGE PISTOL	#3	DOWN	6.5x55	LARGE RIFLE	#3	DOWN	8x57 Mauser	LARGE RIFLE	#1	UP
.45 GAP	LARGE PISTOL	#3	DOWN	.264 Win. Mag.	LARGE RIFLE	#3	DOWN	.375 H&H Mag.	MAGNUM RIFLE	#1	UP
.45 Auto Rim	LARGE PISTOL	#3	DOWN	6.8mm SPC	SMALL RIFLE	#6	DOWN	.375 Rem. Ultra Mag.	MAGNUM RIFLE	#1	UP
.45 Colt/S&W, .454 Casull	LARGE PISTOL	#3	DOWN	7mm TCU	SMALL RIFLE	#3	DOWN	.38-40 Win.	LARGE PISTOL	#3	DOWN
.45 Win. Mag.	LARGE PISTOL	#3	DOWN	.270 Winchester	LARGE RIFLE	#1	UP	.444 Marlin	LARGE RIFLE	#1	DOWN
.460 S&W	LARGE PISTOL	#3	DOWN	.270 Wby. Mag.	LARGE RIFLE	#1	UP	.44-40 Win.	LARGE PISTOL	#3	DOWN
.475 Linebaugh, .480 Ruger	LARGE PISTOL	#3	DOWN	7mm Dkoka	MAGNUM RIFLE	#1	UP	.458 Bushmaster	LARGE RIFLE	#6	DOWN
.500 S&W Magnum	LARGE RIFLE	#6	DOWN	7mm Rem./Wby. Mag.	MAGNUM RIFLE	#1	UP	.458 SOCOM	LARGE RIFLE	#6	DOWN
.50 AE	LARGE PISTOL	#3	DOWN	7mm. Ult. Mag.	MAGNUM RIFLE	#1	UP	.458 Win. Mag.	MAGNUM RIFLE	#1	UP
.17 Remington	SMALL RIFLE	#3	DOWN	7mm Rem. SAUM	MAGNUM RIFLE	#1	UP	.45-70 Government	MAGNUM RIFLE	#1	DOWN
.204 Ruger	SMALL RIFLE	#3	DOWN	7MM STW	MAGNUM RIFLE	#1	UP				
.221 Remington Fireball	SMALL RIFLE	#3	DOWN	7mm WSM, .270 WSM	MAGNUM RIFLE	#1	UP				
.22 Hornet	SMALL PISTOL	#3	DOWN	7.62x39	LARGE RIFLE	#6	DOWN				

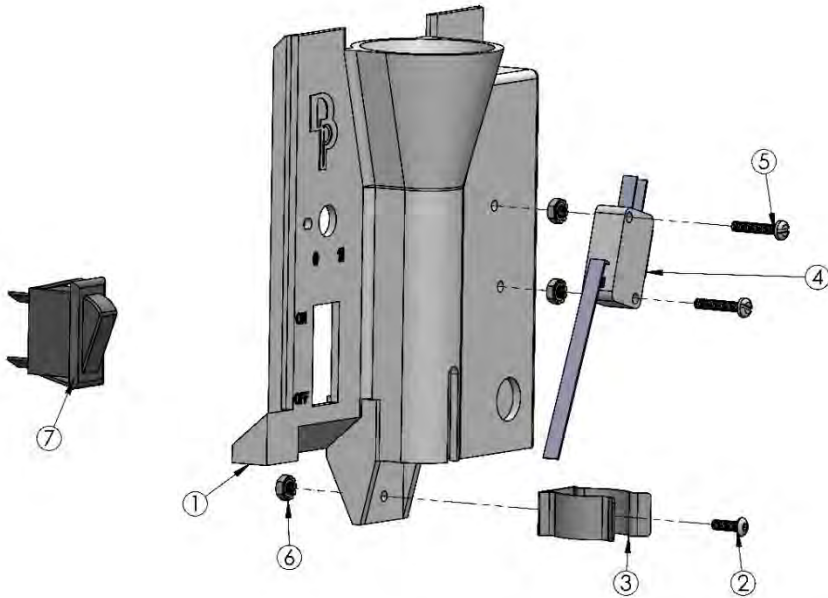
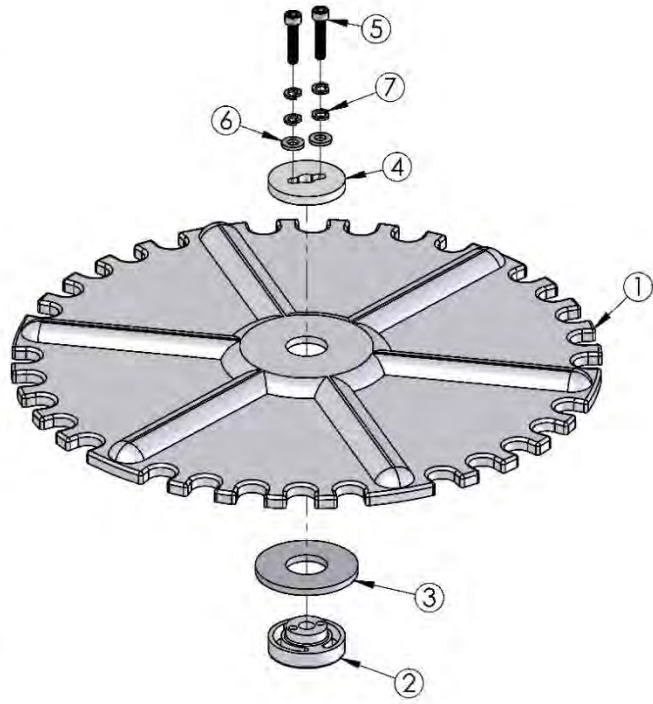
ITEMS WITH "*" REQUIRE THE SPACER WASHER (PART# 13703) BETWEEN THE CLUTCH AND PLATE

ITEM NO.	PART NUMBER	QTY.
1	13400_CASEFEED BOWL VER. 2	1
2	13540_CF MOTOR COVER	1
3	62383_ADJUSTABLE CF WINDOW CUFF STUD	1
4	62382_ADJUSTABLE CF WINDOW CUFF	1
5	62385_CASEFEED CASE DEFLECTOR BLOCK	1
6	22173_CASE FEED FUNNEL ASSEMBLY	1
7	13719_8-32 x 3/8 BHCS	2
8	13738_SD-B #10 ROD WASHER	3
9	14137_#8 x 1 COVER SCREW ZINC	6
10	62384_ADJUSTABLE CF WINDOW CUFF NUT	1
11	62507_VARIABLE SPEED MOTOR W/ PIN	1
12	62503_M4 x 10mm BHCS	4
13	62502_TRIAD POWER SUPPLY	1



ITEM NO.	PART NUMBER	QTY.
1	13402_LARGE PISTOL CASEFEED PLATE	1
1A	13465_SMALL PISTOL CASEFEED PLATE	
1B	13533_SMALL RIFLE CASEFEED PLATE	
1C	13290_LARGE RIFLE CASEFEED PLATE	
2	13736_CF LOWER CLUTCH	1
3	13703_CF SPACER	1
4	13632_CLUTCH DISC UPPER	1
5	18866_1032 x 875 SHCS CLUTCH SCREW	2
6	13738_SD-B #10 ROD WASHER	2
7	13813_CLUTCH SPRING WASHER	4

DESCRIPTION	
21072_LARGE PISTOL CASEFEED PLATE ASSEMBLY	SEE CONVERSION CHART FOR APPLICABLE SIZE
21073_SMALL PISTOL CASEFEED PLATE ASSEMBLY	
21074_SMALL RIFLE CASEFEED PLATE ASSEMBLY	
21075_LARGE RIFLE CASEFEED PLATE ASSEMBLY	



ITEM NO.	PART NUMBER	QTY.
1	11423_NEW CASE FEED FUNNEL V2	1
2	18918_550CF 4-40 x 3/8 BHCS	1
3	13859_CF TUBE CLIP	1
4	13779_MICRO SWITCH	1
5	13954_4-40 x 5/8 PAN HEAD SCREW	2
6	14038_4-40 KEPSNUT	3
7	62505_ON-OFF ROCKER SWITCH C1500ARBB	1