

Get Ready to RELOAD!

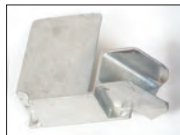
It's Easy to Assemble Your New Square Deal "B" Reloader



Your Square Deal "B" Reloader includes all of the items shown in the photo above.



1 a. Low Primer Alarm



1 d. Chute Bracket



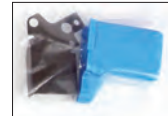
1 g. Allen Wrench Set



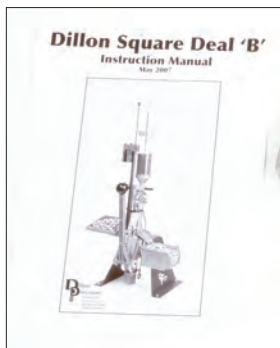
1 b. Primer Tube Pack



1 e. Powder Measure with Small Powder Bar Installed



1 h. Spent Primer Cup and Bracket



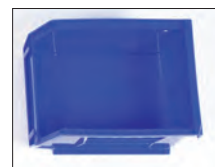
1 c. Square Deal Instruction Manual



1 f. Large Powder Bar (for powder charges in excess of 9 grains)



1 i. Empty Caliber Conversion Box



1 j. Loaded-Cartridge Bin

Part #62284



2

When you open your SDB box, you should see:
Manual, Chute Bracket, Primer Tube Pack.
Lift this out of the box.



3

Now you see: Powder Measure, Empty Caliber Conversion Box, SDB Machine, Loaded Cartridge Bin, Spent Primer Cup and Bracket Pack, Allen Wrench Set, and Large Powder Bar.



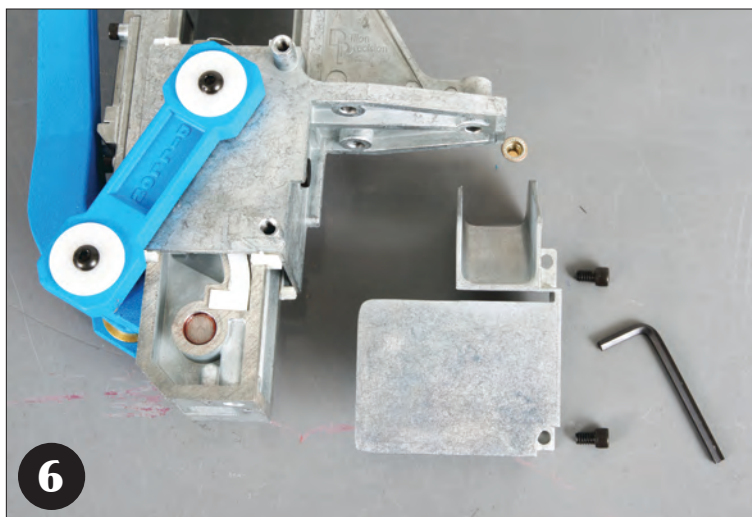
4

Your SDB is packed in a plastic bag to prevent water damage during shipping. Remove this bag.



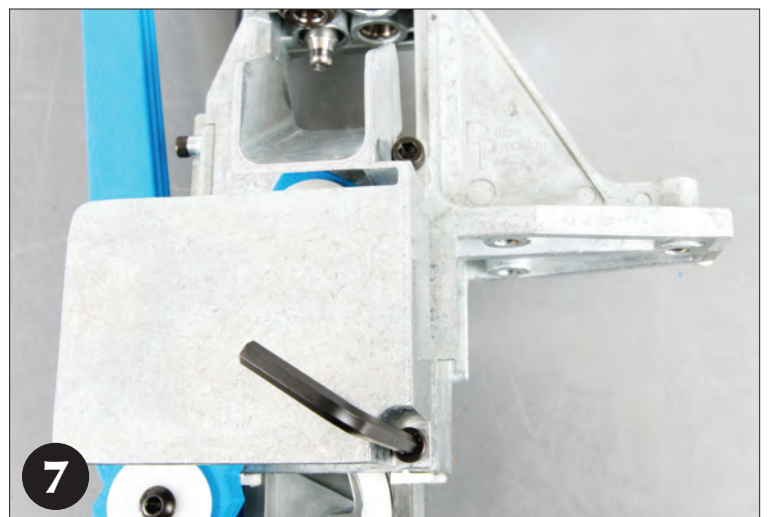
5

Verify that you have all of the above. If anything is missing, call us at 800-223-4570 or 480-948-8009.



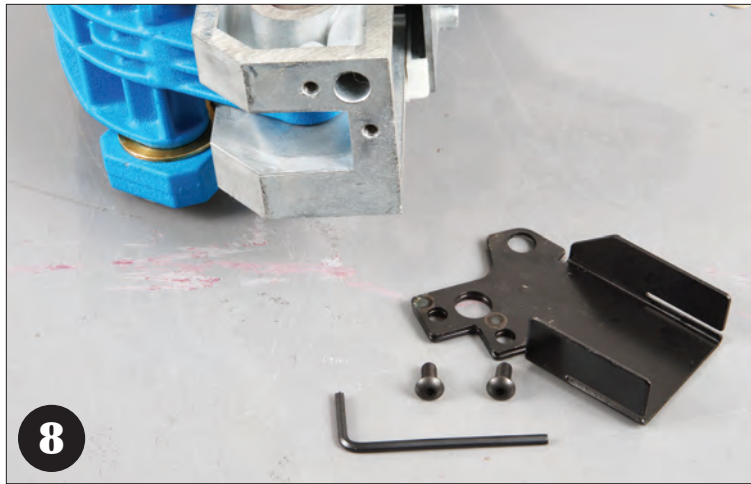
6

Select the Chute Bracket, open the Tube Pack, remove the two 1/4-20 x 3/8" mounting screws, and find the appropriate Allen wrench.



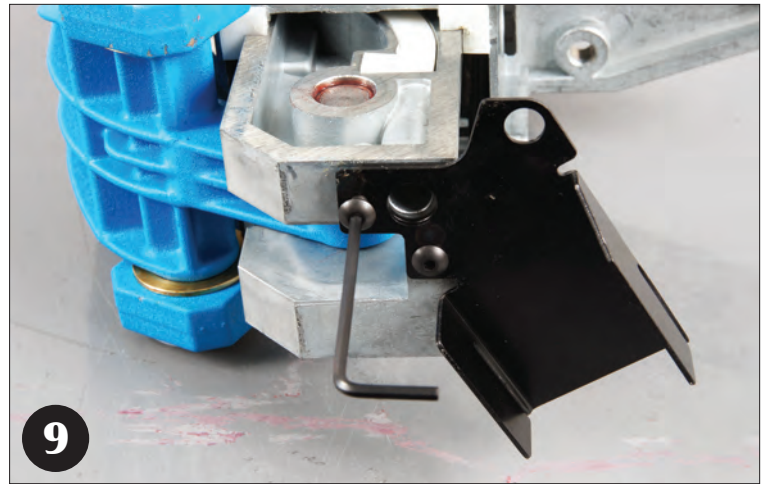
7

Use these screws to secure the Chute Bracket to the right side of the frame.



8

Select the Spent Primer Bracket from the Primer Cup and Bracket Pack and the two 3/32 x 3/8" cap screws from the Allen Wrench bag. Find the appropriate Allen Wrench.



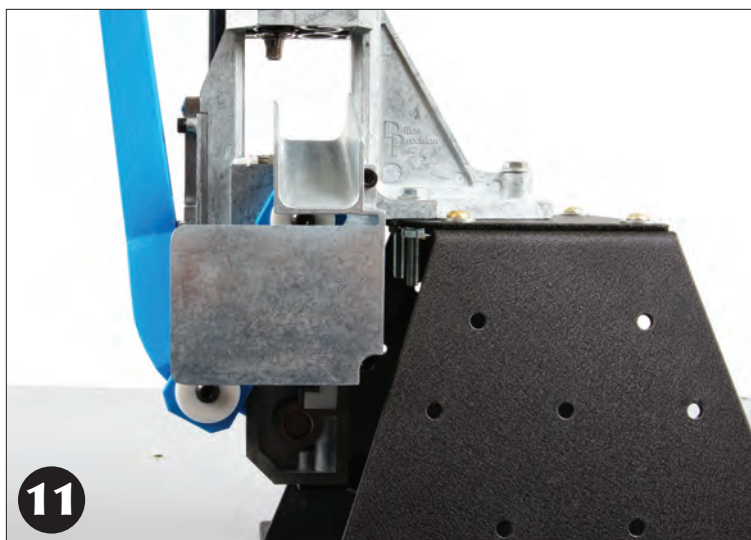
9

Mount this bracket to the bottom of the square shaft as shown above.



10

If you are mounting your SDB directly to your bench, use the mounting holes in the frame as a template. Use 1/4" diameter bolts (not included) to attach your machine to your bench. Use washers on the top and bottom. Use a 5/16" drill (aka "drill bit") to drill the holes in your bench. Do not use wood screws to secure the machine to your bench. If you are using the SDB Strong Mount accessory, refer to the instructions that came with it. (Note: From this point on, we will be using a Strong Mount for ease of photography.)



11

This shows the bracket that the Loaded Cartridge Bin attaches to.

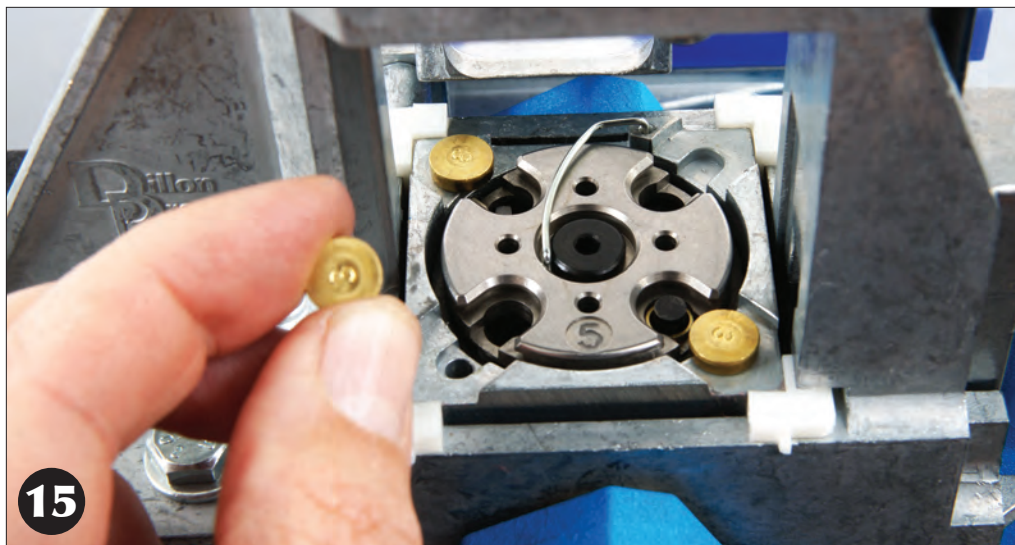


12

Slide the lip on the back of the Loaded Cartridge Bin over the bracket.



Secured to the top of the primer tube shield is a bag containing four brass locator buttons (one is a spare, and they should ALL have the same number stamped on them), a spare depriming pin, alternative bullet seating stem (.38/.357 includes two stems), a sample case with an inert primer seated to proper primer seating depth, and a dummy cartridge showing what bullet type your machine is set up for.



Install three of the brass locator buttons into the holes in the corners of the top of the square shaft, around the shellplate as shown. The fourth one is a spare.



Remove the plastic cap from the top of the die at station two as shown.



Removal of the cap exposes the mounting location where the powder measure attaches.



18

Using the appropriate Allen wrench, remove the cap screw from the base of the measure as shown in 18 and 19.



19



20

Slide the measure over the top of the die at Station Two as shown.



21

Reinstall the measure clamp and screw. Do not over-tighten this screw.

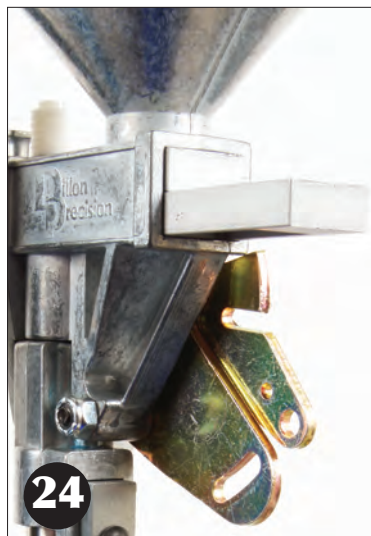


22

From the Primer Tube Bag, remove the Failsafe Rod Assembly. Remove the blue wing nut, spring and bushing from this rod, insert the rod into the hole in the spent primer bracket as shown in photo 23.



23



24



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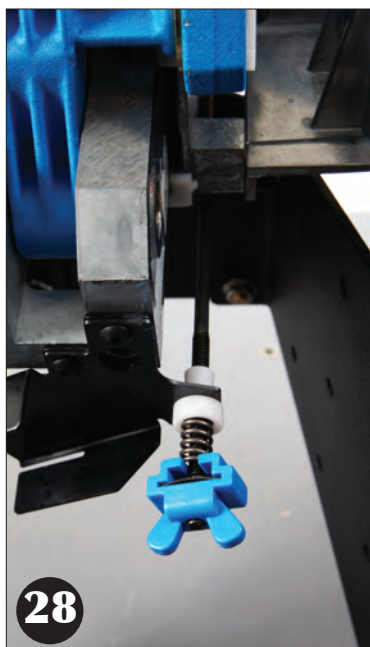


26

The top of this rod has a 90-degree bend. Remove the metal clip from the top of the rod. Insert the top end of the rod first through the slotted hole in the rear lock-link, then through the small round hole in the front lock-link. Insert the metal clip through the hole to retain it.



27

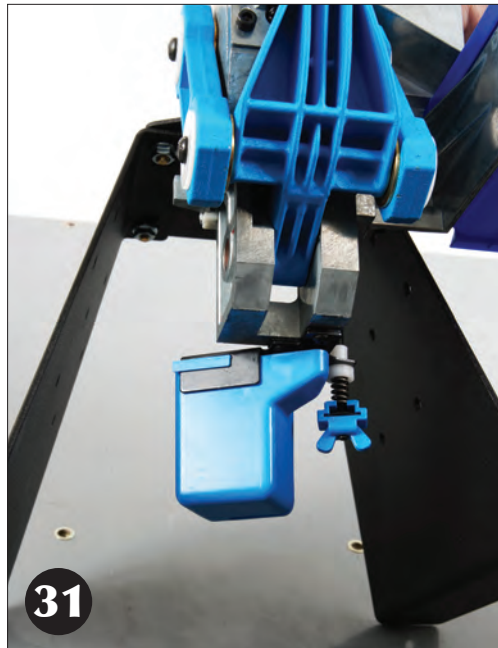
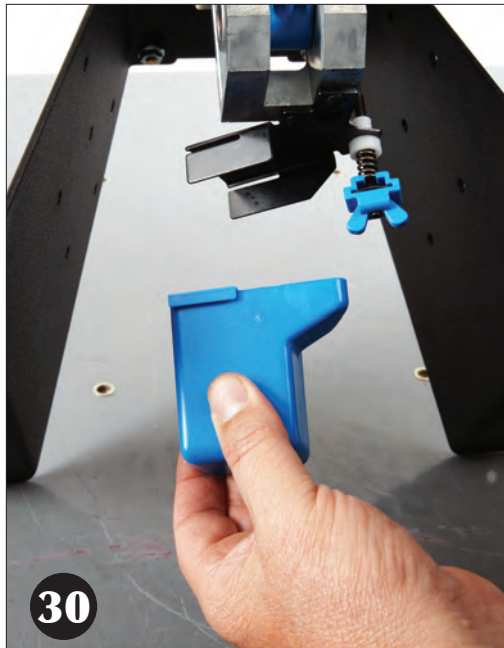


28



29

Properly installed, the rod lines up as shown in photo 29. Reinstall the bushing, spring and blue wing nut as shown. Push the handle forward, then tighten the blue wing nut until the coil spring above it is compressed enough to barely allow a business card to slip between the coils. **NOTE: This rod does not activate the powder measure. You must have a case in Station 2 to drop powder. This is addressed in the Square Deal "B" instruction manual.**



Slide the Spent Primer Cup onto the bracket as shown in 30 and 31.

Push the Low Primer Alarm onto the knurled cap at the top of the primer shield as shown in 32 and 33.



Do not put primers in until after you have read the manual. Placement of the Primer Follower Rod once the tube is filled with primers. Now that your machine is on your bench and fully assembled, you may refer to the Square Deal "B" instruction manual to start reloading.

