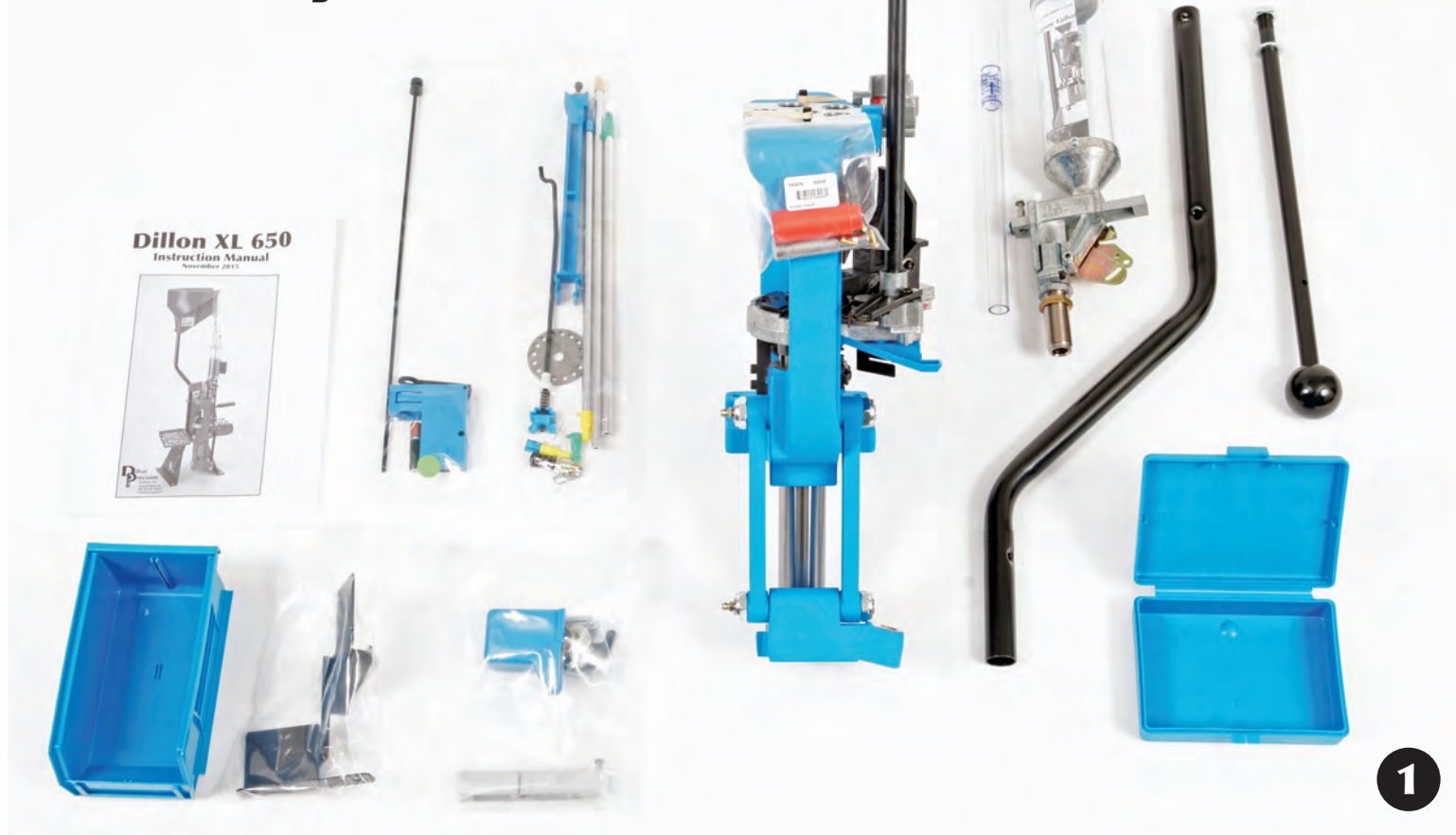




# Get Ready to RELOAD!

## It's Easy to Assemble Your New XL 650 Reloader



**1**

Your XL 650 Reloader includes all of the items shown in the photo above.



1 a. Low Primer Alarm



1 d. Chute/Bin Bracket



1 g. Casefeed Tube



1 j. Casefeed Mounting Post



1 b. Primer Tube Pack



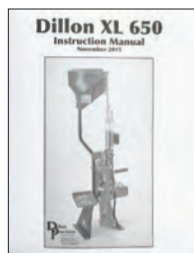
1 e. Loaded-Cartridge Bin



1 h. Casefeed Tube Adapter, Powder Funnel and Locator Buttons.



1 k. Operating Handle Assembly with washer and lock nut



1 c. XL 650 Instruction Manual



1 f. Spent Primer Cup, Lg. Powder Bar, Casefeed Mounting Post Hardware and Die Lock Rings



1 i. Powder Measure with Small Powder Bar Installed



1 l. Empty Conversion Kit Box

Part #62285



**2**

When you open your XL 650 box, you should see: Instruction Manual, Primer Early Warning System bag, and Primer System parts bag. Lift this packaging foam out of the box.

**3**

Now you see: Powder Measure, Empty Caliber Conversion Box, Casefeed Mounting Post, Casefeed Tube and Operating Handle Assembly.

**4**

Remove the second layer of packaging foam and you'll note there is more packaging foam you need to remove.

**5**

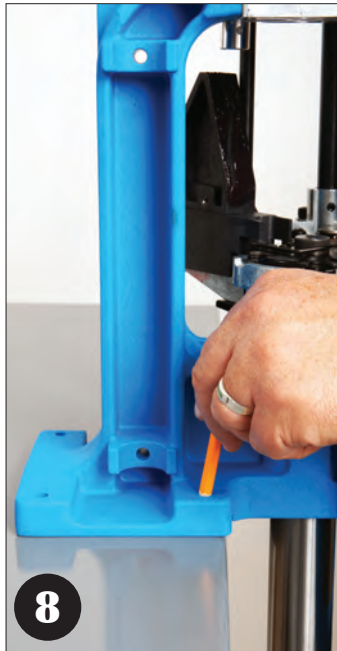
This layer contains the XL 650 Machine and an Accessory Box, the contents of which are shown below in photo 7. The XL 650 is packed in a plastic bag to prevent weather damage during shipping.

**6**

The photo above shows everything you should have in your XL 650 box before opening the Accessory Box. (See photo 7 for the contents of the Accessory Box.)

**7**

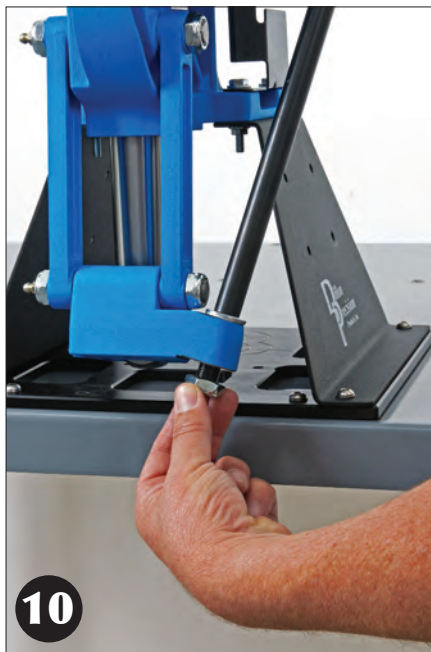
Verify that you have everything in photos 6 and 7. If anything is missing, call us at 800-223-4570 or 480-948-8009.



If you are mounting your XL 650 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 XL 650 Strong Mount accessory, refer to the instructions that came with it.



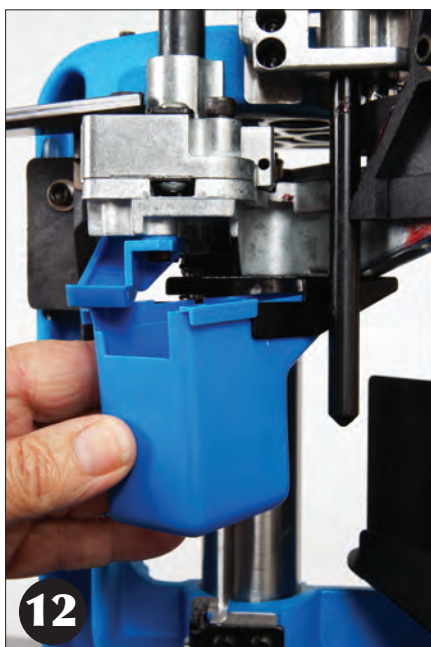
Place the Chute/Bin Bracket on the right side of the machine as you are bolting the machine to the bench. (Note: From this point on, we will be using an XL 650 Strong Mount for ease of photography.)



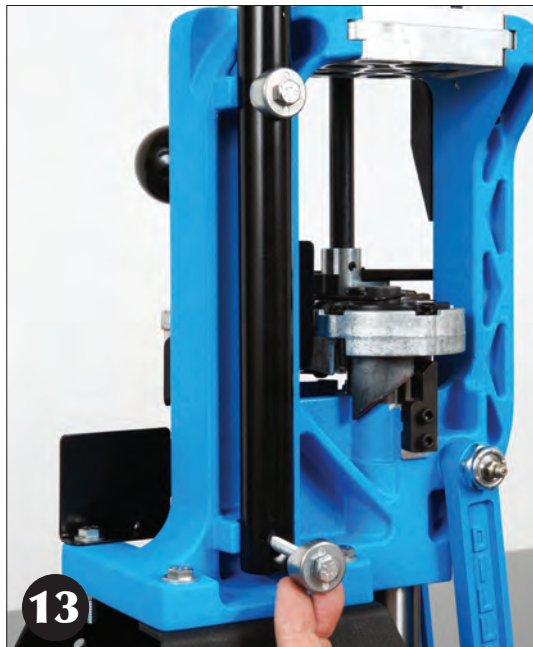
Remove the washer and lock nut from the handle assembly. Hold the washer over the hole in the right side of the crank and insert the handle. Start the lock nut on the handle with your fingers.



Place a 5/32" Allen wrench or a screw driver through the hole in the handle to hold it while you tighten the lock nut using a 7/8" (or an adjustable) wrench.



Operate the handle and raise the platform. Slide the spent primer cup onto the rails as shown. Make sure that it's seated on both rails.



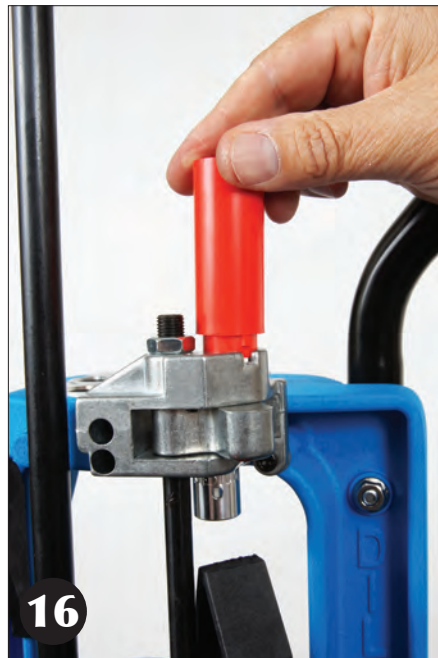
Using the bolts, nuts and clamps that came in the same bag with the spent primer cup, attach the casefeed post to the left side of the machine.



If you ordered your XL 650 with the optional automatic casefeed assembly, please refer to the instructions that came with it. If not, attach the casefeed tube bracket (found in the primer tube pack) to the upper hole in the casefeed post as shown.



Using a 5/32" Allen wrench, tighten the casefeed tube bracket to the casefeed post as shown. *Again, if you have an automatic casefeed assembly, you won't need to use the casefeed tube bracket.*



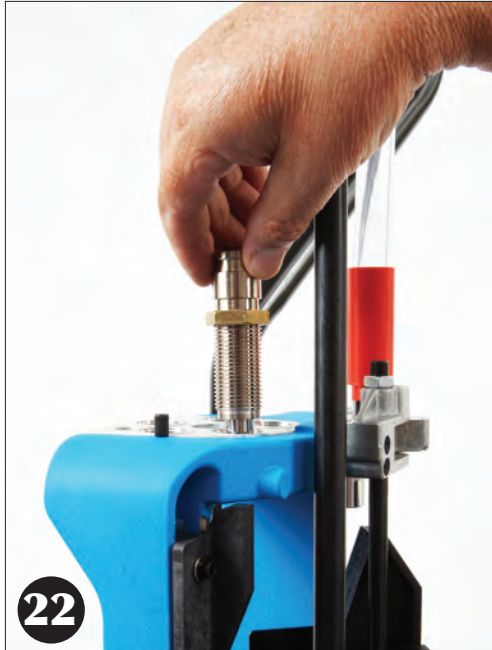
The casefeed tube adapter was in a bag temporarily attached to the toolhead of the machine before it was shipped. Now, you can attach it to the casefeed body. *Note how the key molded into the casefeed tube adapter fits into the notch on the casefeed body.*



Place the bottom opening of the casefeed tube – the sticker is nearer the top of the tube – into the casefeed tube adapter and snap the top end into the casefeed tube bracket.



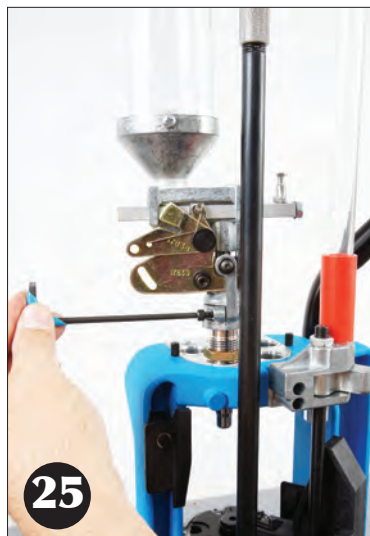
Use a 5/32" Allen wrench to loosen the two collar clamp screws on the powder measure and remove the powder die. Place the powder funnel (packed in the same bag as the casefeed tube adapter) into the powder die with the grooved end toward the top of the powder die as shown. The powder funnel should move up and down freely.



Place the powder die/funnel assembly into position on station two of the XL 650 toolhead and screw it into place. A good starting point is to align the bottom of the die flush with the bottom of the toolhead.



Photo 22 shows the powder die/funnel assembly in place on station two. Leave the die lock ring loose for now and refer to the XL 650 instruction manual for final adjustments to your powder measure.

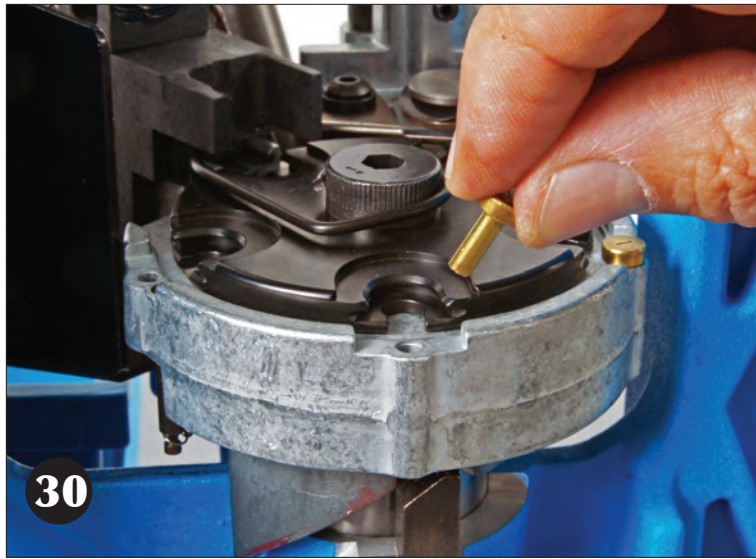


Reinstall the powder measure onto the powder die and finger-tighten the collar clamp screws. The top of the failsafe rod has a double 90-degree bend. Insert the top end of the rod first through the slotted hole in the rear lock-link, then through the small round hole in the front lock-link. The bottom of the rod fits into the failsafe return bracket as shown in photo 27.



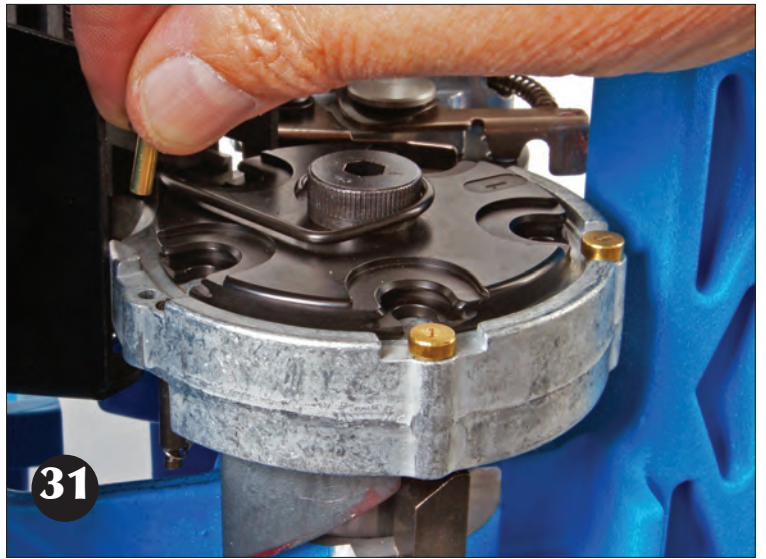
Properly installed, the rod lines up as shown in photo 28. Install the bushing, spring and blue wing nut as shown. **NOTE: This rod does not activate the powder measure. You must have a case in Station 2 to drop powder. This is addressed in the XL 650 instruction manual.**





**30**

Insert three brass locator buttons (found in the same bag as the powder funnel) into the holes on the platform at stations 3, 4 and 5.



**31**

These buttons retain the cartridge cases during loading and provide an easy way to remove a case at any stage without disturbing the other rounds.

Place the AAA battery that came with the Low Primer Alarm into the housing positive end up. Then, push the Low Primer Alarm onto the knurled cap at the top of the primer shield as shown in photos 33 and 34.



**32**



**33**



**34**

**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 page 10 or 18 of the XL 650 instruction manual to start reloading.



**35**

**NOTE:** The Dillon Bench Wrench shown here is sold separately. Any 7/16" wrench will work to adjust the powder measure.

