

FRANKFORD ARSENAL™

UNIVERSAL PRECISION CASE TRIMMER

Product #1092514

Instructions #1094712 Rev. A

CARE & USAGE INSTRUCTIONS



STOP!

If you have a problem with this product, **DON'T RETURN IT TO THE STORE WHERE YOU PURCHASED IT.**



1800 North Route Z
Columbia, MO 65202

Have an issue with this product? Please contact customer service by filling out the form on the contact page of our website at www.BTlbrands.com/ or call us at: 1-877-509-9160

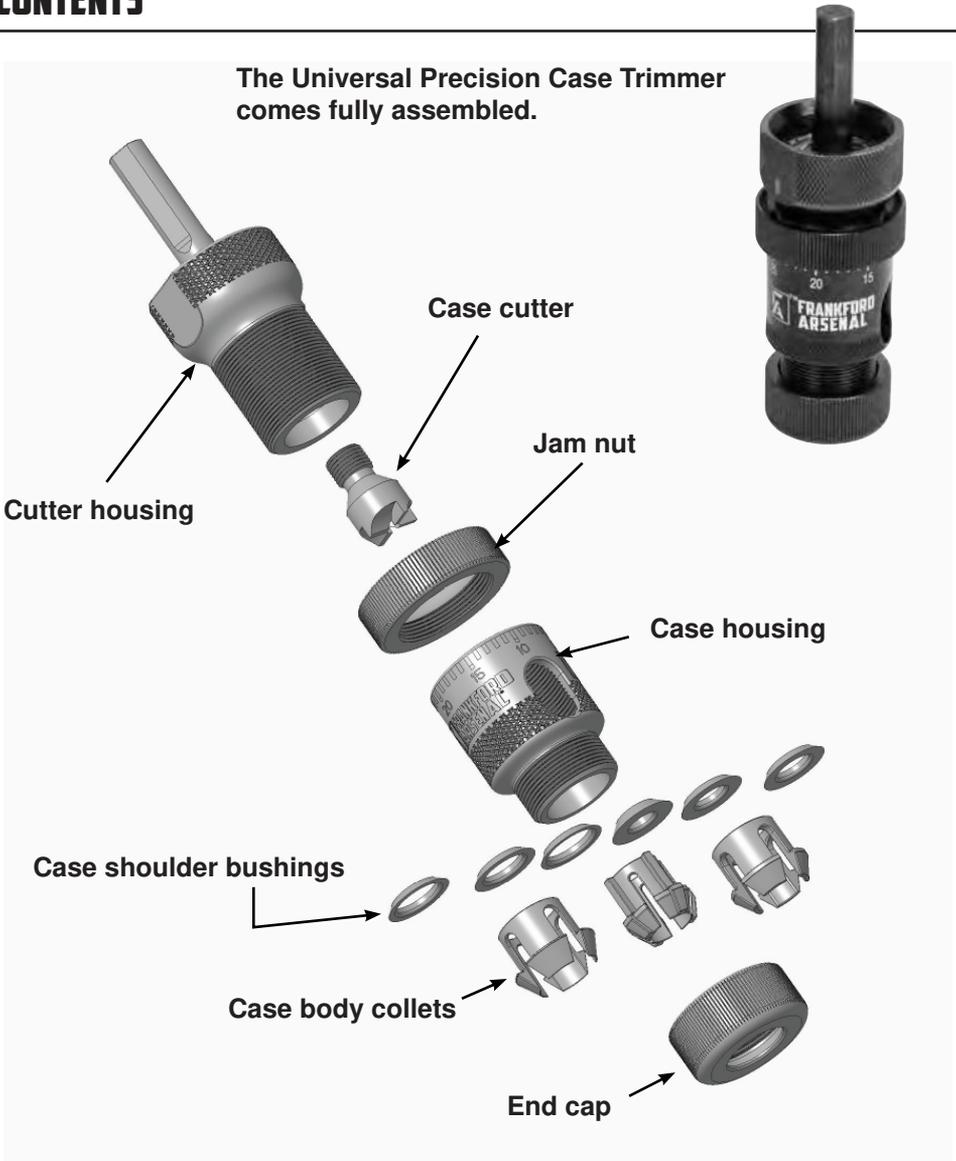
NOT WARRANTED AGAINST MISUSE, ABUSE, OR COMMERCIAL USE.

Limited Warranty

Every Frankford product is warranted to be free of defects in materials and workmanship for a period of one (1) year from the date of original purchase. Frankford will, at its option, repair or replace without charge, except for transportation costs, parts that fail under normal use and service when operated and maintained in accordance with our Instructions. This warranty does not apply to normal wear or to items whose life is dependent upon their use and care. This warranty is in lieu of all other warranties, expressed or implied and releases Frankford, its affiliates, and its vendors from all other obligations and liabilities.

CONTENTS

The Universal Precision Case Trimmer comes fully assembled.



Contents:

- 1 Universal Precision Case Trimmer
- 6 Case shoulder bushings
- 3 Case body collets
- 1 Plastic storage case



SETTING UP THE TRIMMER

1. Remove the end cap from the trimmer
2. Use label on underside of container lid to choose the appropriate bushing and collet for desired caliber

Case Shoulder Bushings (6 total)

Caliber Range	Diameter
.17-.22	0.27"
.243-.27	0.32"
.284-.30	0.35"
.32-.375	0.42"
.40-.416	0.46"
.458	0.49"

Case Body Collets (3 total)

Collet Size	Case Sizes
Small	.223 Rem
Medium	.308Win/.30-06
Magnum	Magnum

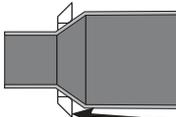
Choose the smallest collet that will still allow the case to slide freely though it

NOTE: More than one Bushing may be compatible with some cases

IDEAL:

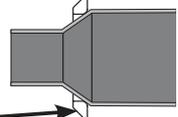
The Back edge of the bushing is centered on the case shoulder

Label #1038443



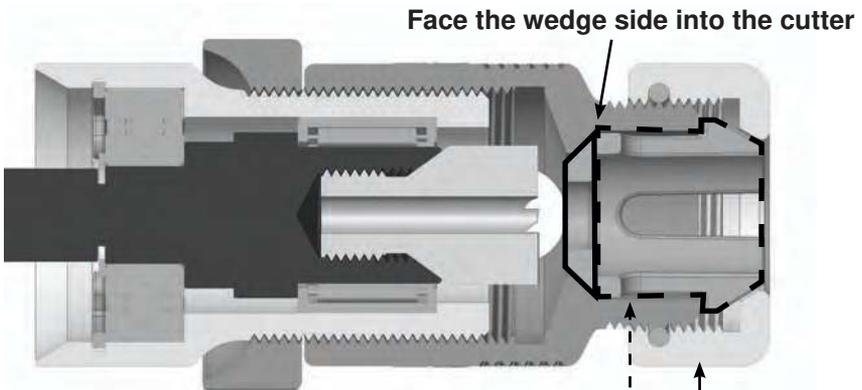
NOT IDEAL:

The Back edge of the bushing is NOT centered on the shoulder



Case Shoulder Bushing

3. Insert and center bushing inside case holder with wedge facing down.



4. Insert collet on top of bushing
5. Screw cap back on until collet starts to narrow

SETTING UP THE TRIMMER

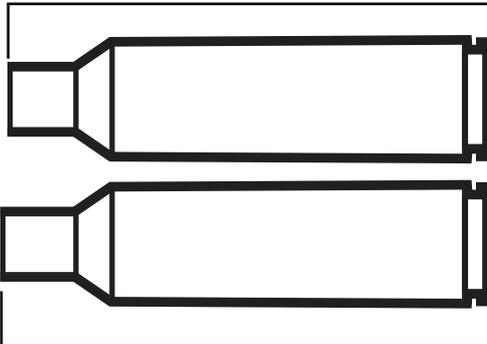
6. Insert brass case fully with neck protruding through bushing
7. Tighten the end cap until brass is snug and does not wobble

NOTE: do not over tighten the cap, make sure the brass can be removed with little pressure



8. Loosen the Jam nut, then advance or retract the case housing until the cutter touches the fully seated brass case.
9. Tighten the Jam nut making sure the case housing does not move.
10. Remove the brass case. Using a pair of calipers, find the overall length of that piece of brass. Using that measurement subtract the overall length you WANT the brass to be from the existing overall length measurement. The total is how far you need to advance the cutter from it's current location.

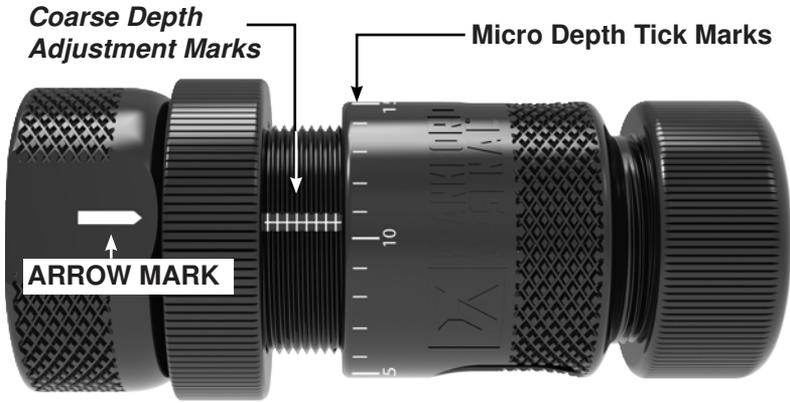
CORRECT LENGTH: 1.76"



$$\begin{array}{r} 1.96'' \\ - 1.76'' \\ \hline .20'' \end{array}$$

TO CUT LENGTH: 1.96"

SETTING UP THE TRIMMER



Coarse Depth Adjustment Marks: This scale is included for a visual reference only. Markers (sharpie dots, etc) can be placed on this scale allowing for quicker caliber coarse adjustment when switching calibers.

11. Once you have your measurement, locate the ARROW mark on the Flat side of the Cutter housing
12. Using that ARROW mark, look at the Micro Depth Tick Marks. Each tick mark represents .001" of adjustment. Calculate how many Tick marks you need to move the Case housing to get your cutting depth.
13. Loosen the Jam nut while maintaining the same alignment of the ARROW mark and the Case housing.
14. Rotate Case Housing COUNTER Clock Wise until you reach the correct tick mark you want to cut to.
15. Re-tighten the jam nut

Your cutter should now be set for cutting depth.

SETTING UP THE TRIMMER

16. Insert cutter shaft into drill or drill press. Match chuck jaws with flats on cutter shaft to insure radial stability and a secure hold.

NOTE: Make sure the drill or drill press is set to “drill” and not “extract”. Holding the drill or looking at the drill press the chuck should turn **CLOCK** wise.

17. Turn on the drill or press and press the brass case into the trimmer using firm steady pressure.

18. While using steady pressure, once the cutter no longer cuts the case mouth, remove the case from the trimmer.

19. Turn drill or press off.

20. Measure the cut brass for correct overall length.

IF the length is too short or too long repeat steps 12 - 15 to retract or advance the case housing to the correct depth. Then, using another piece of brass, repeat steps 16 - 20.

Repeat the above adjustments until you reach the correct cutting depth.



WARNING:

Do not insert anything into cutter windows.

The cutter is extremely sharp and can cause injury

The cutter housing and case holder are designed to “float” on bearings. Inserting anything into cutter windows can couple the cutter shaft to the housing and holder causing them to spin at high RPM and high torque which could result in injury.

Problem

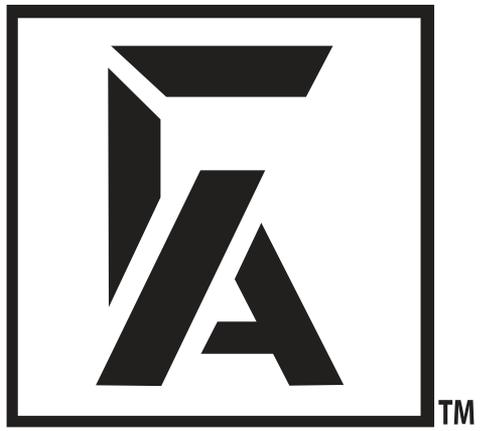
Remedy

Cut quality is not good

1. Use less force on Case when trimming. Aggressive cuts can cause the cutter to dig into and gouge the case mouth.
 2. Use more force on Case when trimming. Too light of force on the case may allow the case to “chatter” on the cutter.
 3. Cutter may need to be replaced.
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Trim length varies more than desired

1. Ensure all cases are properly cleaned and sized
2. Always chamfer and deburr cases before measuring. Burrs from cut can cause inaccurate measurements
3. Check that proper Bushing and Collet are being used
4. Ensure that cases are stopping fully against bushing during trimming
5. Rotate case 1/2-turn clockwise while trimming. This helps ensure a square cut on the case mouth



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