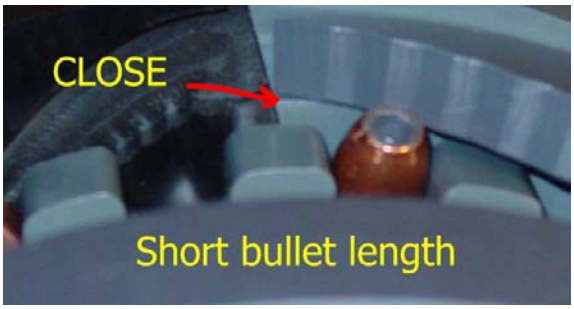
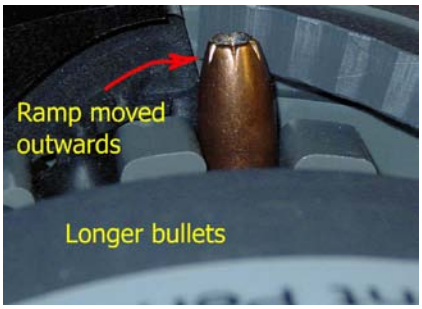
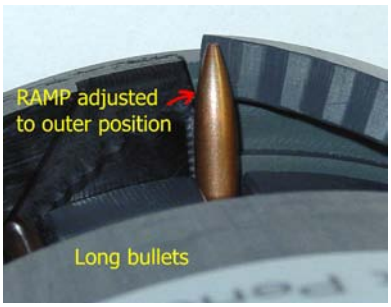
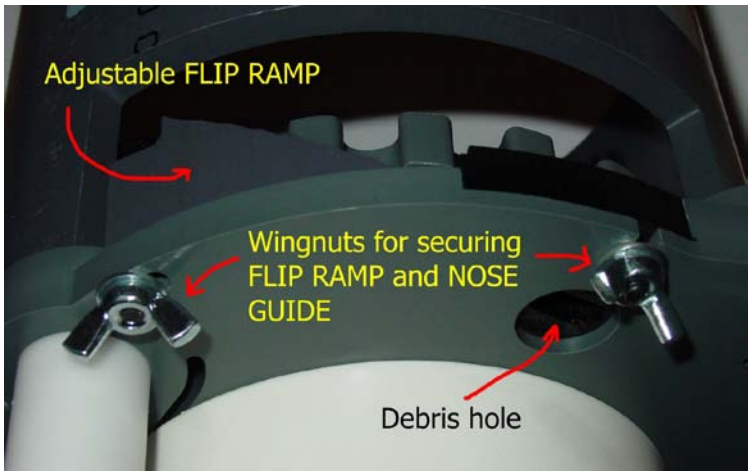
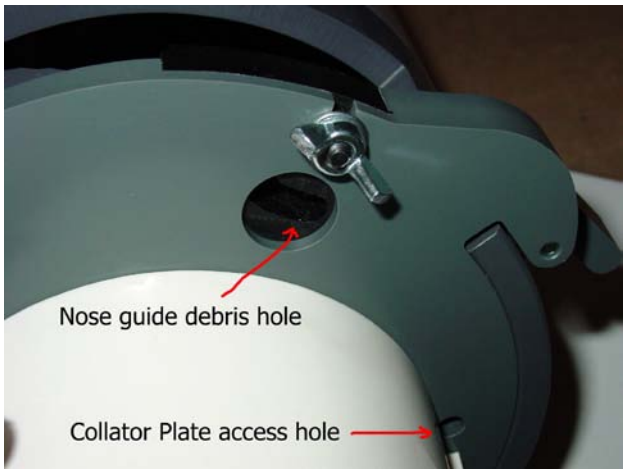
Here are some photos of **flip ramp positions** for some short, medium length and longer bullets.



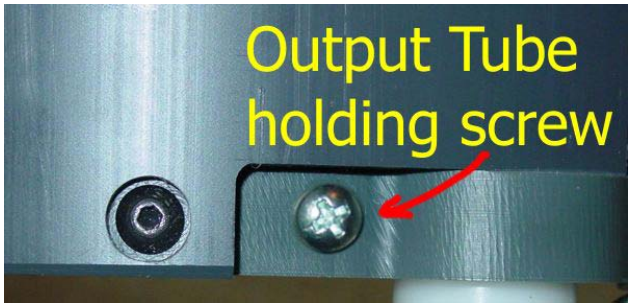


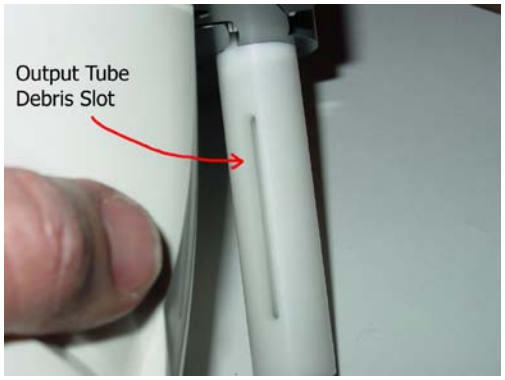




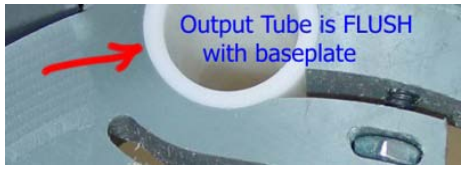


The **output guide tube** is held in place by a screw that squeezes the baseplate slightly to hold the tube in place.





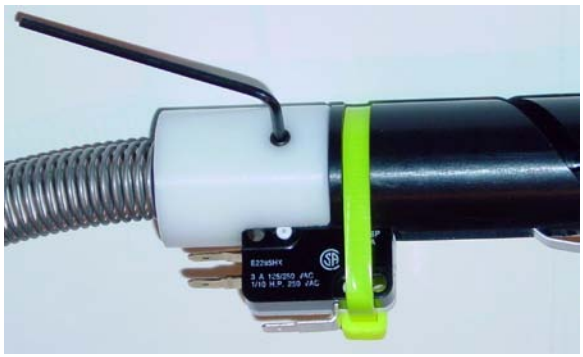
Only a small amount of tightening is required…tighten only enough to firmly maintain position and not fall loose from the collator. Over-tightening is unnecessary. The **output guide tube must be adjusted flush with the inside surface of the baseplate.** This allows bullets to freely slide down into the tube and into the output spring tube. There is a debris slot on the tube. It should be positioned to allow debris to fall out of the bottom of the tube. The output tube should be correctly mounted and adjusted when shipped, but check it anyway, just in case it was moved during shipment.



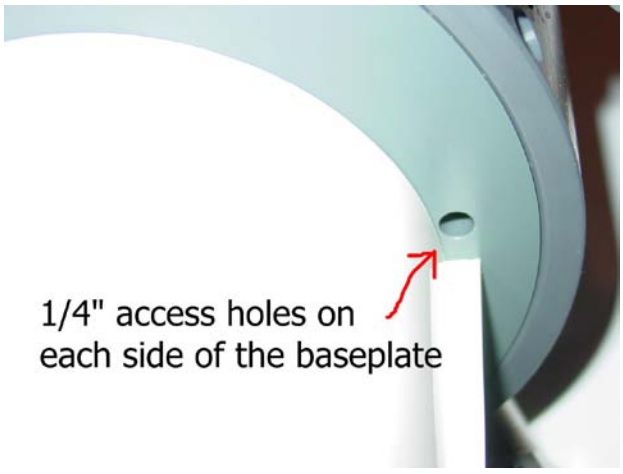
One end of the output spring tube screws into the output guide tube and the other end screws into the spring adapter. Inserting the guide tube spring into the output tube and spring adapter is very easy.

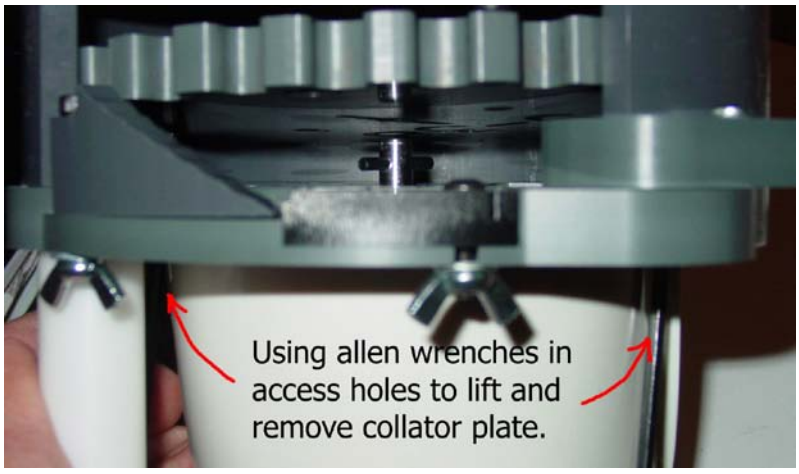
Simply **twist the spring clockwise** while applying a little force into the hole. The spring will give slightly while twisting and compress enough to fit into the hole. Continue twisting and pushing the spring as necessary until it bottoms at the ridge inside the hole. The spring can be easily removed by again **twisting clockwise** while pulling it out of the hole. The **large** spring adapter assembly is used for all calibers **except for .223 cal and a few types of short 90-100 grain 9mm bullets**…which use the **small** spring adapter assembly.

Connection to the Bullet Dropper is also very simple, as you can see in the photos. The setscrew only needs to be screwed in far enough to enter the groove on the end of the dropper. This will hold the spring adapter in place.



Changing calibers on the collator is very simple. First, you need to remove the existing collator plate and nose guide. There are (2) 1/4“ access holes on the bottom of the baseplate through which you can push up on the collator plate. A couple of Allen wrenches work nicely for this purpose.

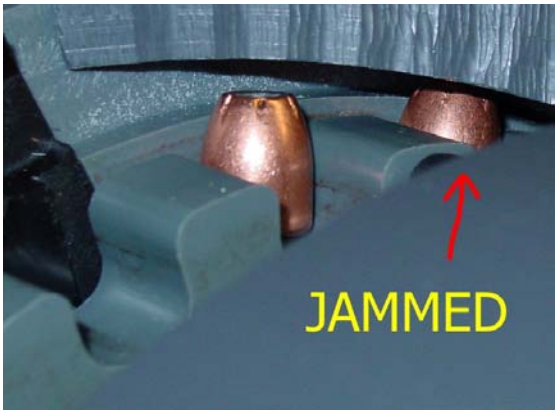




Nose guides are marked for easy identification (smallest caliber = 1 mark / largest caliber = 5 marks).

The collator plate **MUST** rotate clockwise as viewed from above. Counter clockwise operation will result in a jam and possibly break the dislodging arm. To be safe, disable the arm before checking rotation.

ALWAYS make sure that the **FLIP RAMP IS ADJUSTED PROPERLY** for the particular bullet length you're using. Adjust the ramp to allow approximately the outer 1/3 of the bullet to ride up the ramp and then flip over. The photo below shows the ramp adjusted for long bullets and how a short bullet will slide behind the ramp and jam.



Also: Collating bullets that are shorter than their own diameter will eventually cause a jam in the collator. Example: a 45 cal bullet that is only .430" long can fall sideways into a collator plate slot and jam.

Examine the power supply. The standard setup is for 110 VAC (Fig A). If you are using 220 VAC, simply adjust the 110-220 switch. There are two other adjustments…one for DC output voltage and one for polarity (Fig B). The 12V setting will yield the highest rotation speed, but sometimes a slower speed is more appropriate. As an example: if you're reloading very <u>long</u> bullets…the 9V setting will rotate the collator plate a little more slowly and allow a tiny bit more time for the bullet to fall out of the collator plate slot and into the output tube. **Experiment to find out what voltage works best for your bullet type.** Adjust the power supply settings with a small bladed screwdriver.

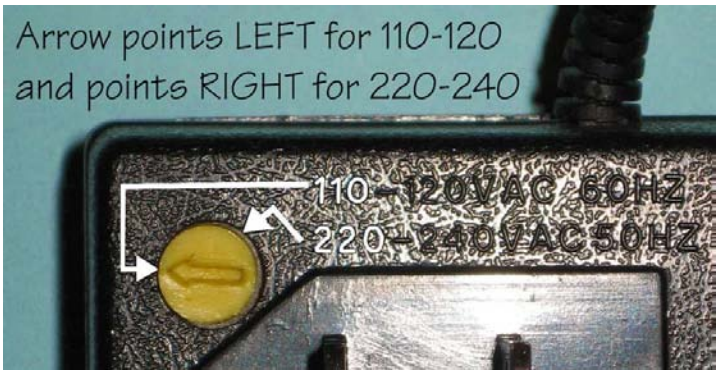


Fig A

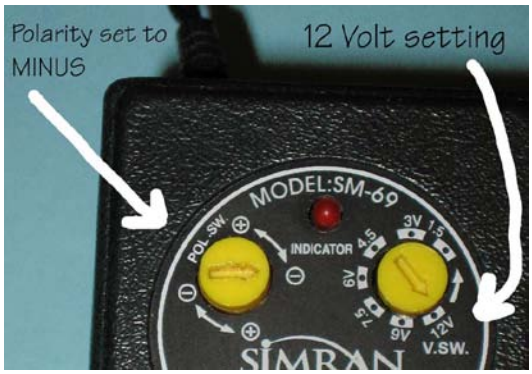


Fig B