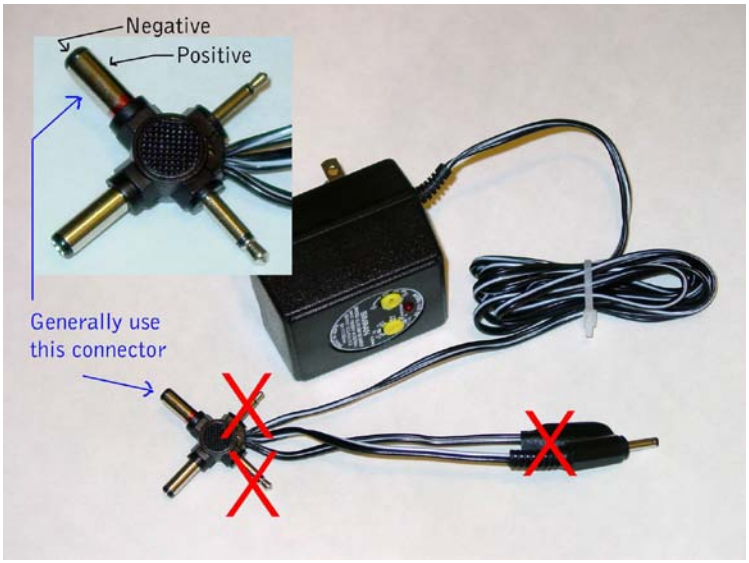


The connector can be inserted into the power jack more easily if you use a slight twisting motion. The collator plate should rotate clockwise when viewed from above. A jam will occur if the plate rotates counter-clockwise, and the bullet dislodging arm enters a collator plate slot. Changing the polarity switch (Fig B) will reverse rotation. The motor is quite powerful so turn off the power switch or unplug if you have to clear a jam.
The motor is protected by a fuse. If the collator plate is jammed and the motor is stalled for more than 30 to 45 seconds, the fuse is likely to blow. It's easily replaced from underneath the elbow. (**375 ma – slow blow fuse**). If you suspect a fuse is blown, check it with a continuity meter. **Fuses that appear to be OK visually, may actually be burned out.**

If your fuse is good and the collator still does not run, check the position of the **voltage output selector switch**. Perhaps the internal contacts of the switch have moved slightly and rest in-between 2 voltage settings; example: if positioned between 12v and 9v no power will be available to operate the collator. Turning the voltage selector a bit should restore power. If the collator still doesn't operate, make sure that the power switch of the collator is **ON** and also check to see that the **micro-switch feeler arm** (on the dropper) moves freely. You should hear switch click when moving the feeler arm in and out of the slot in the dropper body.

Foreign objects or material caught in the collator may cause a jam, but generally speaking, there are only a few ways a jam will occur. As previously mentioned, if you don't adjust the nose ramp properly, you will most likely get a jam. Another way is when the output spring tube becomes blocked (example: trapped bullets shown in photo on Page 7). Bullets will fill the tube until the jam occurs. To prevent this from happening, make sure the output tube spring is positioned correctly. The tube will also fill up if the microswitch feeler arm has become bent incorrectly (or broken) and no longer senses the bullet level in the dropper body.

When you connect the wires to the microswitch, use the **two terminals that are farthest apart** (the center terminal is not used, and may have been removed from the switch). Polarity for this connection is not important. Also, the system operates at a relatively low voltage and current, so there is no dangerous shock hazard. Just use common sense…don't reload while standing in ankle deep water ;-)

Use the mount that comes with your system. If you choose to use a different method to mount your collator, just make sure that the base of the collator is level and that it's mounted securely enough to prevent excessive shaking. If your unit shakes excessively, bullets may occasionally collate upside down. A properly installed and adjusted collator will seldom deliver a bullet upside down.

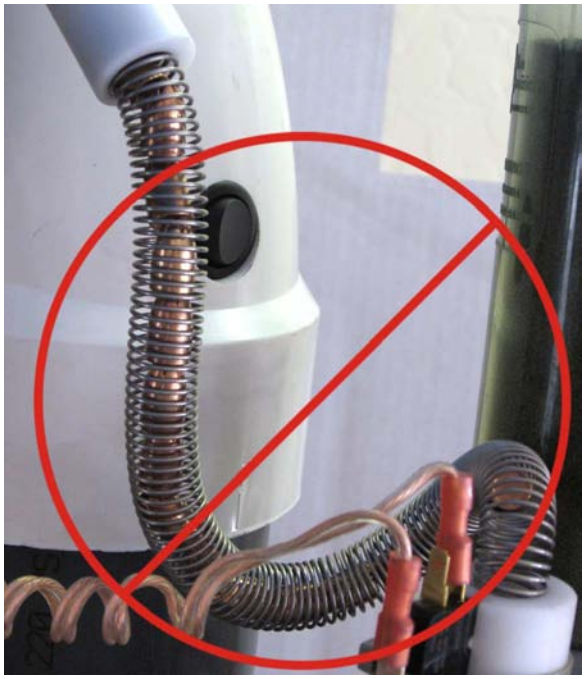
XL-650 Mounting Method: On the latest model XL650, the case feeder support tube is positioned more towards the right of the press than on the earlier 650's. This allows the Mr. Bulletfeeder ® collator to be mounted by using an L-Bracket. Because the earlier model XL650 case feeder is mounted more to the left of the press, you will most likely have to use a tube stand for the bullet collator so as not to interfere with the case feeder bowl (see inset at bottom of photo).

Mount the L bracket and stand to the press by using the 3" long ¼" bolts that came with your unit. These bolts will replace the ones that secure the brass feeder tube to the frame of the press.

Because the 650 has a fixed toolhead, notice that the collator sits at the same height for all calibers. When loading .223, a shorter output tube spring is used since the dropper is one section taller than the other caliber droppers.

RL-1050 / Super 1050 Mounting Method:

Mount L-bracket to the case feeder support by using the supplied U-bolts, as shown in the photo. Adjust the final height of the collator to allow proper routing the output tube spring. Don't allow the output tube spring to form a "trap" when the tool head is in the raised position. **When setting up for 223 cal, remember to raise the collator a few inches because the 223 dropper is one section taller than the other caliber droppers.**



Normal Sequence of Operation: Bullets are loaded into the collator hopper where they are properly oriented. Collated bullets slide down through the output tube and stainless steel output spring tube to the Bullet Dropper body. When the bullet level in the dropper body rises enough to operate the microswitch feeler arm, the switch contacts OPEN and the collator stops running. When the bullet level falls, the switch contacts CLOSE causing the collator to run and deliver bullets. Operating the reloading press brings the dropper foot into contact with a flared case, which operates the bullet release mechanism. This allows the column of bullets to drop and, by gravity, tamp the lowest bullet into the case. Tamping action is enhanced when the new, modified-profile powder funnel is used (handgun calibers only). Please note that when you are near the end of your reloading session and only a few bullets remain inside the dropper body, they may not tamp as well, so slow down to prevent those bullets falling off the brass while indexing. It's also possible that the very last bullet may be retained by the torsion spring inside the dropper body. Release the bullet by manually pressing up on the dropper foot. A short piece of plastic tubing of the proper diameter will work nicely for this purpose. The bullet will simply fall out of the dropper, down through the tubing and into your hand. Finally, if you're not using a good **case lube** (an example: Hornady One-Shot) when reloading, try some! It makes pulling that lever a whole lot smoother and easier! Have fun with your new **Mr. Bulletfeeder ®** system.

If you have any questions not answered in these instructions, or ANY problems whatsoever, please contact me for assistance. Mr. Bulletfeeder ® is guaranteed to operate correctly if properly installed.

Sincerely yours,

Rick Koskela / RAK Systems, LLC

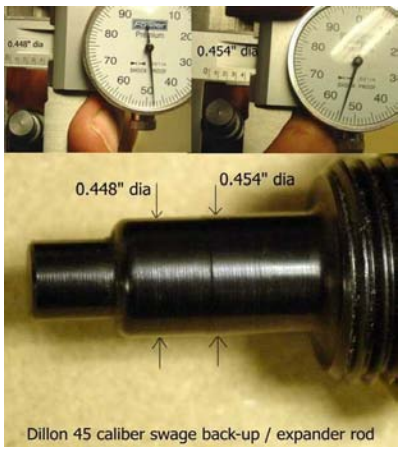
Do not make any modifications to the collator or dropper. You may void the warranty.
Comments or testimonials about your new Mr. Bulletfeeder ® system are welcomed.
E-mail: rick@mrbulletfeeder.com or phone: 480-235-8864

Other Helpful Hints:

NOTE: Wax-lubed cast lead bullets: This system was initially designed for jacketed / plated bullets and works best with those bullets. Cast lead bullets with moly lube also work well. However, if you wish to use wax lubed cast bullets in the system, be advised that wax will tend to build up on the collator plate slots and inside the dropper body… possibly causing erratic operation and requiring frequent cleaning. Users have found that system performance will be greatly improved by (1) reloading in a cool ambient temperature to keep the wax as hard as possible and (2) using a light coating of powdered mica on your wax lubed bullets. For example: one method would be to put a teaspoon or so of powdered mica into a coffee can along with the bullets and then rotate the can to lightly coat the bullets with the powdered mica. Another might be to use a salt shaker or something similar to sprinkle the mica on the bullets. Wax build up on the collator and dropper is significantly reduced when preparing your bullets in this manner. Powdered mica is available from sources such as Midway USA. Other users have reported successfully using a light spray coating of silicone on the collator plate slots in order to reduce sticking due to the wax lube.

Use a short piece of plastic or copper tube to empty out the dropper quickly and easily. Push upward lightly and all the bullets in the dropper will fall through the tube and into your hand.

If you're using a 1050, you can improve tamping even more by grinding off some material from the end of the swage back-up rod (photo at right). This will allow the larger diameter step to enter the case mouth a bit more. (0.010" – 0.020" should help) If you do this, take off only a little at a time.
Like that old carpenter's saying goes…
"I cut it 5 times **and it's still too short**!"



The Lyman (neck sizing) M-die won't work as a swage back up rod, but if you're not swaging the primer pockets, it doesn't matter. Try one in the swage station. It's easily adjustable and really helps bullet tamping. In the photo of the 45 cal M-Die, you can see the .454" expander step on the die. It can be adjusted down into the neck as much as 1/16".

You'll find that it's very easy to load ammo with your Mr. Bulletfeeder ® system. Your "rounds per hour" rate is likely to increase significantly… so pay attention to the job at hand and avoid distractions in your reloading area.

If you're not using a powder check device, be sure to look into the cases and visually verify the powder charges. Powder check devices can be used along with your bullet dropper… but in order to do so you must mount the dropper where the seating die is normally located and then use a combination seating & crimping die in the final position.