

550 Primer Track Bearing (Item # T1571)

Installation Instructions



Here is the procedure to install the 550 Primer Track Bearing. It looks complicated when it is written out like this but is actually pretty simple and straight forward. Refer to your Dillon Instruction Manual for part descriptions and where they are located on your press.

CAUTION: Make sure all primers have been removed from the Automatic Primer System before proceeding.

1. Remove the Spent Primer Cup (#13650) and set aside. This will give you more room to work during later steps.
2. Disconnect the Primer Slide Return Spring (#13928) from the Primer Slide Return Spring Post (#13924) that sticks out the bottom of the Primer Slide (#13920). Leave the other end of the spring attached to the press and just let the spring dangle.
3. Raise the press ram all the way to the top, then lower completely. This will kick out the Primer Slide and, without the spring attached, it will stay on the out position. This will also take tension off the Operating Rod (#13869) so you can easily remove it without risk of bending it.
4. Detach the Operating Rod. It simply pulls straight out of the Operating Rod Bracket (#13887). Set it aside where it won't get bent.
5. Raise the press ram, push the Primer Slide all the way in, then lower the press ram. This will ensure the Primer Slide will not fall out during the next step.
6. Remove the two Primer Housing Screws (#14014) and lift the entire Automatic Primer System off the press frame and set aside. Then lift the Primer Slide off and set it aside.
7. Remove the Primer Track Bearing (#14015).
8. Clean the press frame where the Primer Track Bearing was removed.
9. Install the UniqueTek Primer Track Bearing on the press frame. Take care not to disturb the moly coating on the top face.
10. Position the Primer Slide on top of the Primer Track Bearing and then set the Automatic Primer System in place. Install the Primer Housing Screws but do not tighten the screws.
11. Raise the ram and slide the Primer Slide back and forth several times to make sure it is properly positioned and moving freely, then tighten the Primer Housing Screws. After tightening the screws, raise the ram again and confirm that the Primer Slide still moves freely. When finished, leave the Primer Slide in the fully out position and lower the ram.
12. Install the Operating Rod into the Operating Rod Bracket and let it hang so that it is aligned with and engages the groove in the Roller (#13765) on the Roller Bracket Assembly (#14280).
13. Raise the press ram about half way and gently push the Primer Slide in. Ensure that the groove in the Large Roller (#13889) in the Primer Slide engages the Operating Rod. The Large Roller is free to slide back and forth on the Roller Pin (#13919) and you may need to slide it to get it aligned with the Operating Rod.
14. While pressing inward on the end of the Primer Slide, lower the ram fully. The Primer Slide should now be fully into position under the shellplate.
15. Attach the Primer Slide Return Spring.
16. Attach the Spent Primer Cup.
17. Before adding any primers, cycle the press multiple times to ensure the Primer Slide is moving freely and completely.

If you have any questions do not hesitate to call.