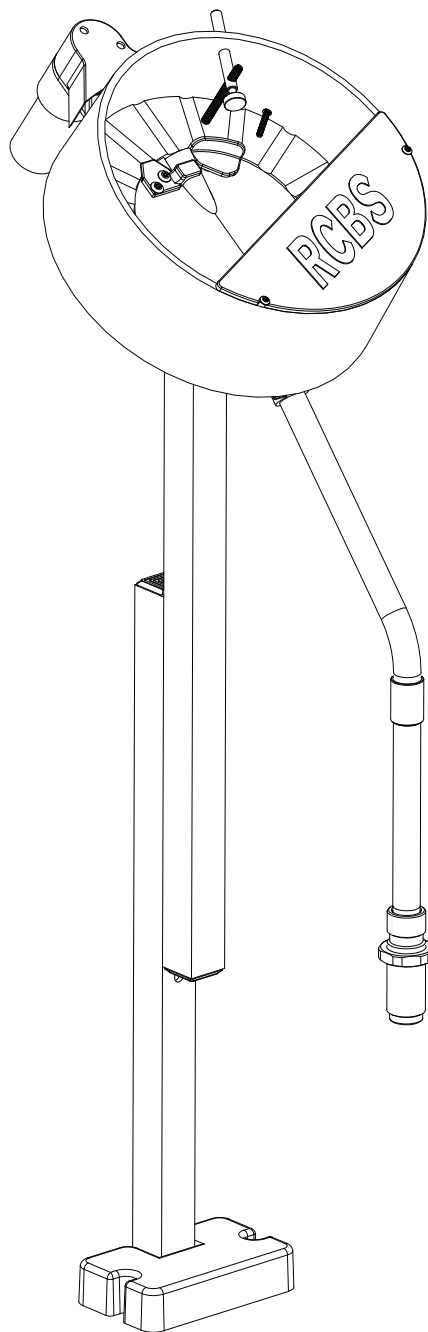


# ***RCBS***®

## **Bullet Feeder – Pistol Kit**



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PRODUCT INSTRUCTIONS

**⚠ WARNING**

Before using the RCBS Bullet Feeder – Pistol Kit, read these instructions carefully to fully learn how to safely operate the related reloading equipment. Failure to properly operate the related reloading equipment can result in severe personal injury and/or equipment damage.

**If you have any questions while assembling or operating this tool,  
Call us at 1-800-533-5000 or 1-530-533-5191  
Monday – Thursday 6:30 am – 4:00 pm Pacific Time  
(hours may vary)  
Or email us at [rcbs.tech@atk.com](mailto:rcbs.tech@atk.com)**

This instruction manual contains specific safety and operating information. It should be considered a permanent part of your reloading equipment and remain with the equipment at all times for easy reference.

**TWO YEAR LIMITED WARRANTY**

Your Bullet Feeder – Pistol Kit is warranted to be free from defects in material or workmanship for two years from the date of purchase. This warranty is extended only to the original consumer purchaser. All RCBS products are intended for non-commercial use by hobbyists. Any other use of these products will void the warranty. Should you believe that your Bullet Feeder – Pistol Kit is defective in material or workmanship, you must return it to Ammunition Accessories Inc. through its Oroville operation (hereinafter “Oroville Operations”) postage paid for evaluation. If defective, the product will be repaired or replaced at Oroville Operations’ option, at no charge.

Send a dated proof of purchase to Oroville Operations for return shipping and handling, along with the Bullet Feeder – Pistol Kit to:

Ammunition Accessories Inc.,  
Oroville Operations  
605 Oro Dam Blvd East  
Oroville, California 95965

Warranty services cannot be provided without meeting the above requirements.

THIS TWO YEAR LIMITED WARRANTY DOES NOT COVER DEFECTS OR DAMAGE RESULTING FROM: CARELESSNESS, MISUSE, COMMERCIAL USE, ABUSE, IMPROPER INSTALLATION, MODIFICATION, OR NORMAL WEAR AND TEAR. THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE LIMITED TO THE DURATION OF THIS TWO YEAR LIMITED WARRANTY. OROVILLE OPERATIONS IS NOT LIABLE FOR DAMAGES IN EXCESS OF THE PURCHASE PRICE OF THE PRODUCT AND UNDER NO CIRCUMSTANCES SHALL OROVILLE OPERATIONS BE LIABLE FOR CONSEQUENTIAL OR INCIDENTAL DAMAGES. HOWEVER, SOME STATES DO NOT ALLOW LIMITATIONS ON INCIDENTAL, OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

The above warranty provides the sole and exclusive warranty available to the customer in the event of a defect in material or workmanship in the reloading press. This warranty gives you specific legal rights, and you may also have other rights which vary from State to State.

**SAFETY**

Reloading is an enjoyable and rewarding hobby that can be conducted safely. But, as with any hobby, carelessness or negligence can make reloading hazardous. This product has been designed from the beginning with the user's safety in mind. When reloading, safety rules must be followed. By observing these rules, the chance of a hazardous occurrence causing personal injury or property damage is minimized.

**GENERAL**

- Use all equipment as the manufacturer recommends. Study the instructions carefully and become thoroughly familiar with the operation of the product. If you do not have written instructions, request a copy from the equipment manufacturer.
- Do not take short cuts. Attempting to bypass established procedures is an invitation to an accident.
- Observe "good housekeeping" in the reloading area. Keep tools and components neat, clean and orderly. Promptly and completely clean up primer and powder spills.
- Reload only when you can give your undivided attention. Do not reload when fatigued or ill, or under the influence of medications or alcohol.
- Develop a reloading routine to avoid mistakes which may prove hazardous. Do not rush - load at a leisurely pace.
- Always wear adequate eye protection to protect your eyes from flying particles. You assume unnecessary risk when reloading without wearing safety glasses.

**LOADING DATA**

- Use only laboratory tested reloading data. We highly recommend the current SPEER Reloading Manual.
- OBSERVE ALL WARNINGS ABOUT THE USE OF MAXIMUM LISTED LOADS

**⚠ WARNING/CAUTION**

**PRIMERS AND POWDER**

- Store primers and powder beyond the reach of children and away from heat, dampness, open flames and electrical equipment. Avoid areas where static electricity is evident.
- DO NOT use primers of unknown identity.
- Dispose of unknown primers in accordance with applicable regulations.
- Keep primers in the original factory container until ready to use. Return unused primers to the same factory packaging for safety and to preserve their identity. Primer packaging is designed to provide safe storage.
- DO NOT store primers in bulk. The blast of just a few hundred primers is sufficient to cause serious injury to anyone nearby.
- DO NOT force primers. Use care in handling primers.
- DO NOT have more than one can of powder on the bench at one time. Powder cans should be stored away from the bench to avoid picking up the wrong one.
- DO NOT use any powder unless its identity is positively known. The only positive identification is the

manufacturer's label on the original canister. Discard all mixed powders and those of uncertain identity.

- If you use a powder measure, replace the lids on both the powder hopper and powder can after the powder hopper has been filled.
- When using a powder measure, settle the powder in the powder hopper before charging any cases. Throw and check the weight of at least ten charges. This will assure you that the correct powder charge is being thrown.
- When you finish a reloading session, pour any remaining powder back into its original factory container. This will preserve the identity and shelf life of the powder.
- DO NOT smoke while reloading.

**RECORD KEEPING**

- Keep complete records of reloads. Apply a descriptive label to each box showing the date produced, and the primer, powder and bullet used. Labels for this purpose are packed with SPEER bullets.
- Never attempt to guess at the identity of your ammunition.

*Because RCBS has no control over the choice of components, the manner in which they are assembled, the use of this product, or the firearms in which the resulting ammunition may be used, we assume no responsibility, expressed or implied, for the use of ammunition reloaded with this product.*

**USE**

The RCBS Bullet Feeder – Pistol Kit has been designed to increase your progressive pistol load rate by ~50% by reducing the manual operation of placing a bullet onto the case mouth. All parts and adapters are included for you to be able to feed 9mm, .38 Spl, .357 Mag, .40 S&W and .45 ACP pistol bullets.

The Bullet Feeder is designed to work with FMJ/TMJ, JACKETED or SEMI JACKETED Hollow Point, Soft Point, Round Nose, Truncated/Flat Nose and Semi Wadcutter designed bullets ONLY. Cast or swaged LEAD and Wadcutter(HB, BB, DE) bullets are NOT to be used. The lube from lead bullets deposits on the moving parts and collects dust and dirt, slowing down the function of the Bullet Feeder and eventually causing the motor to burn out and will void the Warranty. The deposited lube also does not allow the bullets to be positioned properly for feeding from the sorting Wheel to the Feed Tube. The Wadcutter design will not sort properly through the Bullet Feeder.

The Bullet Feeder is designed to be used on RCBS 5-station progressive presses such as the Pro2000, Pro2000 Auto and PiggyBack. The Bullet Feeder has also been designed to function on progressive presses manufactured by other companies. RCBS has successfully tested the Bullet Feeder on the following presses: Dillon® RL550B, XL650 and Hornady® Projector™, L-N-L™ AP™. For presses that require you to Seat and Crimp bullets in separate operations, you may need to combine bullet Seating and Crimping to accommodate the Bullet Feeder. This may require the purchase of a combination bullet Seat and Crimp die(not included).

The Collator will hold ~200 bullets depending on caliber. Less for .45, more for 9mm.

**UNPACKING**

Refer to the list below to Identify parts as you unpack your new Bullet Feeder – Pistol Kit.

1. Bowl assembly
2. Upper Support Tube
3. Lower Support Tube
4. Support Foot
5. Power Supply and Plug adapters
6. Bullet Die body
7. Continuous Spring Tubes
8. Plastic Lower Clear Tubes



**BF – Pistol Kit Parts Bag #1**

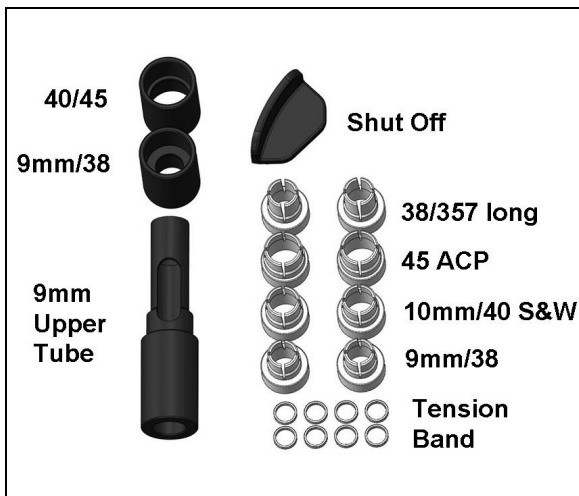
- Upper Tube 9mm
- Tube Adapter 38/357
- Tube Adapter 40/45
- Shutoff
- Bullet Fingers(2) 9mm/38
- Bullet Fingers(2) 40
- Bullet Fingers(2) 45
- Bullet Fingers(2) 38/357 Long
- Tension Bands (8)

**BF – Pistol Kit Parts Bag #2**

- Bullet Guide 9mm/38
- Bullet Guide 40
- Bullet Guide 45
- Bullet Guide 38/357 Long
- Bracket Pin

**BF – Pistol Kit Parts Bag #3**

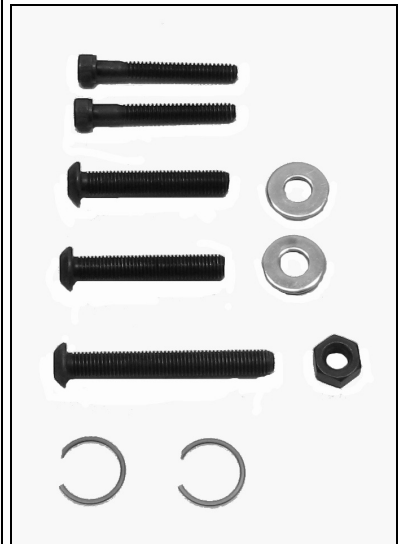
- 10-24x 1 1/2 SHCS(2)
- 1/4-28x 1 1/2 BHCS(2)
- 1/4-28x2 BHCS
- 1/4" Flat Washer(2)
- VH-62 Retaining Ring(2)



**Bag 1**



**Bag 2**



**Bag 3**

## ASSEMBLY

Attach the Lower Support Tube to the Support Foot using two 10-24x1 ½ SHCS (A)(see photo 1).

Attach the Upper Support Tube to the Lower Support Tube using two ¼-28x 1 ½ BHCS and ¼ Flat Washers(B)(see photo 1). The Support height is adjustable depending on the type of press that you will be using the Bullet Feeder with.

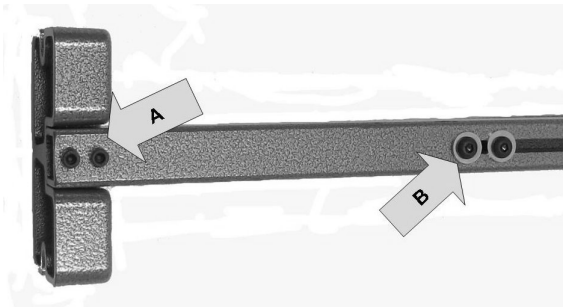


Photo 1

Attach the collator Bowl assembly to the top of the Support assembly with the ¼-28x2” BHCS and a ¼-28 Hex Nut (A)(see photo 2). Tighten this just enough so that the Bowl assembly will still pivot. Install the lower “angle” Bracket Pin into the middle 35° adjustment position (B)(see photo 2). This position works for most types of bullets, however, you may need to change the angle of the Bowl assembly to reliably sort the bullets that you are using.

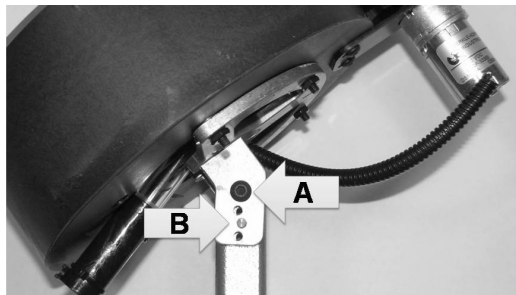


Photo 2

Four changeable plugs are provided: US, UK, AUS and EU. The power transformer is an automatic switching 120-240 VAC design. Select the proper plug adapter and install onto the power transformer. Plug in the Power Supply and connect to the power jack on the underside of the Bowl assembly (A)(see photo 3).

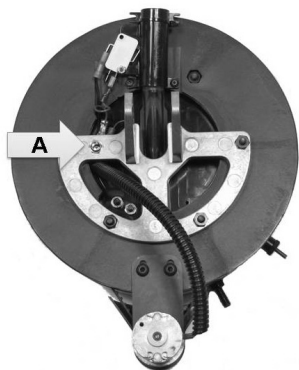


Photo 3

## INSTALLATION

Bolt the Bullet Feeder – Pistol Kit to the reloading bench or table using the slots provided in the Support Foot casting. Temporarily install the Continuous Spring tube and plastic Lower Clear Tube to help position the assembly in relation to your press. Insure that the placement of the Bullet Feeder does not interfere with the operation of your press.

Install the Tension Band down to the first “step” on the desired caliber plastic Bullet Fingers and insert into the bottom of the Bullet Die. Secure with the Retaining Ring.



Photo 4

Bullet Fingers are coded on the bottom with a series of marks(lines):

One = 45 ACP

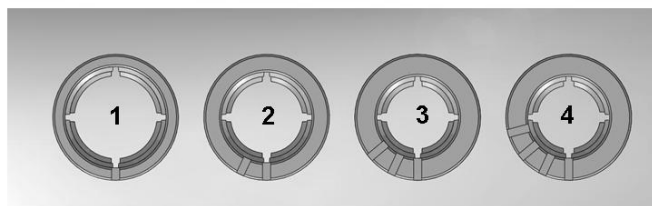
Two = 10mm/40 S&W

Three = 9mm/38

Four = 38/357 Long, 170 gr and heavier

(2)10mm/40 S&W

(4)38/357 Long



(1)45 ACP

(3)9mm/38

Install the Bullet Die assembly into your press (See **ADJUSTMENT** section for proper setup). Where you choose to install the Bullet Die depends on the press that you are using. For RCBS five station presses, station four (4) is the most common position.



Photo 5

Install the Bullet Guide into the die body, the tapered inner portion is the “top” of the guide. Bullet guides are stamped on the side for identification.



Photo 6

Place the proper plastic Lower Clear Tube(A) into the top of the Bullet Die and place the Tube Adapter(B) on the top.

Install the Continuous Spring tube into the top of the Tube Adapter and into the Bowl assembly(C).

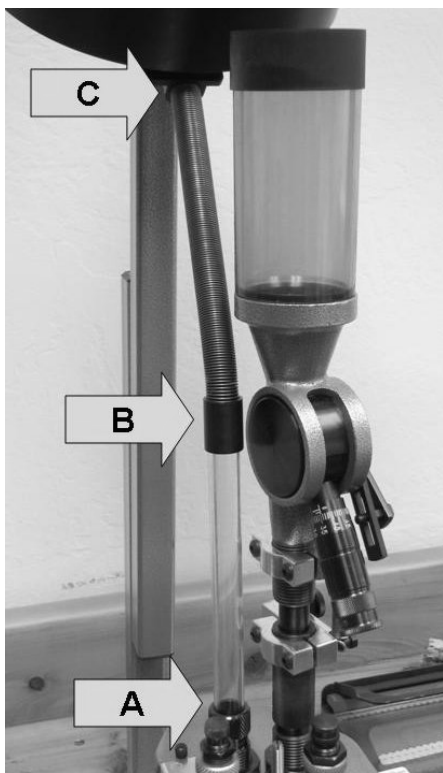


Photo 7

For short 9mm and .38 bullets, the Upper Tube 9mm needs to be installed. **⚠ CAUTION** Move the micro switch out of the way to install the 9mm Upper Tube adapter. Failure to do so will cause the switch to break, the motor will then not shut off and continually feed bullets potentially burning out the motor or breaking parts in the Bowl.

When you are ready to load, fill the Bowl with ~100 bullets and connect the Power Supply. The Bowl will run until the feed Tubes fill up with bullets. Add another ~100 bullets to bowl.

You are now ready to begin your loading session.

### OPERATION

With the Bowl filled with bullets and power applied, the Bullet Wheel will orient the bullets and fill the feed Tubes.

The Bullet Guide in the top of the Bullet Die aligns the bullet for feeding through the Bullet Fingers.

The case will expand the Bullet Fingers and allow one bullet to be placed on the case mouth. As the case is retracted, the Bullet Fingers close, preventing the next bullet from passing through the Bullet Die.

As the press handle is operated and a case is brought up into the Bullet Die, a bullet will be placed on the case mouth. The weight of the bullet stack puts enough pressure on the placed bullet to prevent it from falling off the case as it moves to the next station to be seated and crimped.

Add more bullets to the Bowl as needed. NOTE: The sorting plate may not feed the last 10-20 bullets

### ADJUSTMENT

#### Bullet Die

The position of the Bullet Die must be adjusted to properly place the bullet on the case mouth at the top of the press stroke. This is a trial and error adjustment.

Case mouths should be belled/flared .030” over the bullet diameter. For example:

9mm	.385”
.38/.357	.387”
.40 S&W	.430”
.45 ACP	.481”

With the Bullet Die partially threaded into the press and the plastic Lower Clear Tube filled with bullets, run a properly flared case up into the Bullet Die. Thread the Bullet Die into the press until you hear a bullet drop or see the bullet stack move down. Thread the Bullet Die down a further ½ turn and temporarily lock the Bullet Die lock ring. Run another properly expanded and flared case up into the Bullet Die to check the setting. If a bullet is placed on the case and no other bullets fall through the die, the setting is correct. Lock the Bullet Die lock ring. If a bullet is not fed, loosen the Bullet Die lock ring and thread the die down in ½ turn increments until the proper setting is achieved.

Depending on how level your reloading bench is or the type of bullet that you are using, you may need to change the angle position from the middle 35° to 40° or 45°. A steeper or shallower angle is achieved by moving the Bracket Pin to one of the other positions.

## Bowl Assembly

There are two “wipes” in the bowl assembly. These are designed to prevent a double stack of bullets.

With the power disconnected, rotate the Sorting Plate until one of the grooves is in line with the first “wipe”. Place a bullet into the groove, loosen the lock nut and adjust the “wipe” in or out until it clears the bullet by 1/8”-1/4”, tighten the locknut.

Move the bullet up one groove and adjust the “spring wipe” by loosening the two locknuts and positioning the spring to clear the bullet nose by ~1/8”.

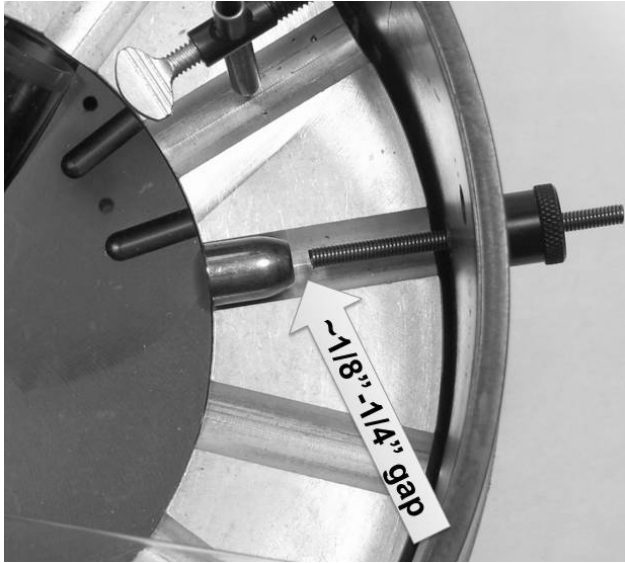


Photo 8

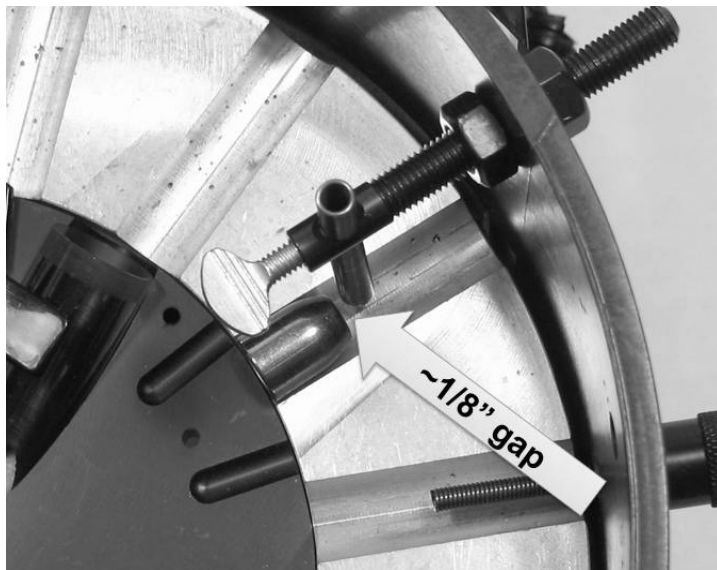


Photo 9

## Shut Off

RCBS has found that certain round nose bullet designs for 9mm and 38/357 require the Shut Off to be installed.

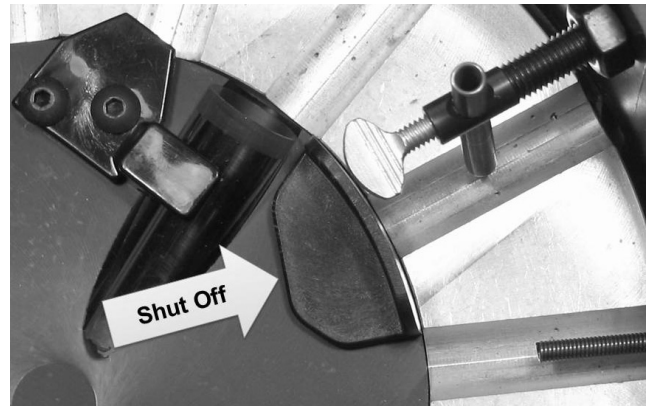


Photo 10

## CALIBER CHANGE

When changing calibers, the Bullet Fingers and Bullet Guide must be changed. The Continuous Spring tube and plastic Lower Clear Tube may also need to be changed.

There are two diameters of Continuous Spring Tubes and Lower Clear Tubes.

The smaller diameter tubes are for 9mm and 38/357. The 9mm Upper Tube may need to be added to the “out” feed of the Bullet Feeder to load “short” light (90 gr) 9mm bullets. The micro-switch will align in the cutout in the side of the 9mm Upper Tube (A).

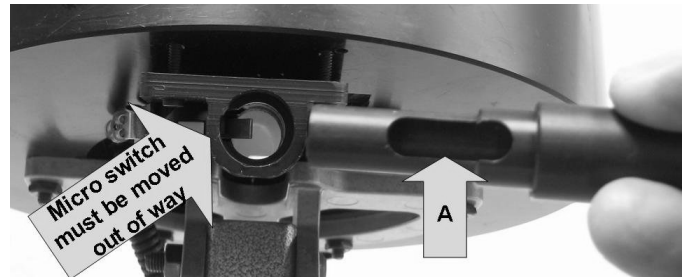


Photo 11

The larger diameter tubes are for .40 cal and .45 ACP. Unplug the Power Supply from the Bullet Feeder. Disconnect the Lower Clear Tube from the Bullet Die and remove any bullets still in the tubes.

Remove the Bullet Die from the press. It is easiest to change the Bullet Fingers in the Bullet Die when the Bullet Die is removed from the press.

Remove the Retaining Ring from the bottom of the Bullet Die and set aside, remove the Bullet Fingers, replace with the desired Bullet Fingers, reinstall the Retaining Ring.

Reinstall Bullet Die into press, insert proper Bullet Guide and adjust per the **ADJUSTMENT** section.

Remove and replace the tubes with the appropriate ones if required.

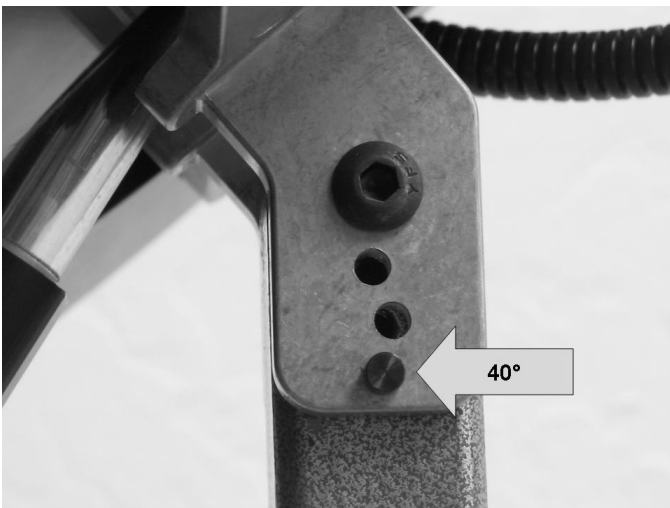
**NOTE:** If you are loading 170 grain or heavier .38/.357 bullets, the Bullet Finger with four marks and the .38 Bullet Guide marked “38L” with the stepped inner base must be used together.

## TROUBLESHOOTING

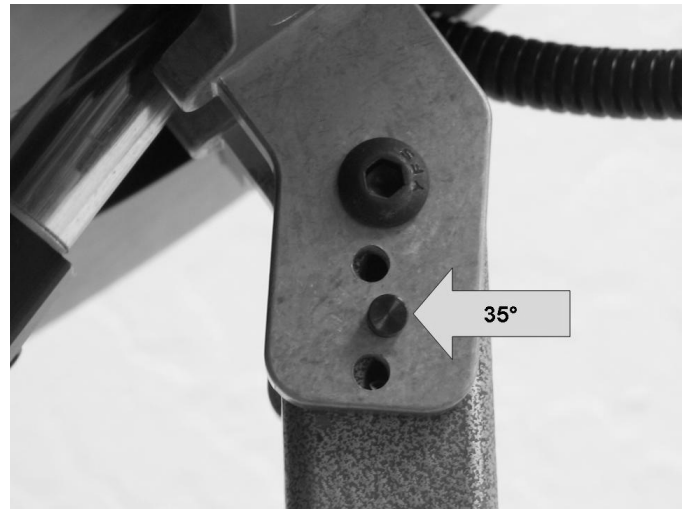
If correctly oriented bullets fall off of the sorting plate too early, change to a shallower Bowl angle adjustment. Move the Bracket Pin from the 45 or 40 degree position to the 40 or 35 degree position.



*45° position-top*



*40° position-bottom*



*35° position-middle*

If changing the angle does not correct the problem, install the Shut Off into the bowl.

## MAINTENANCE

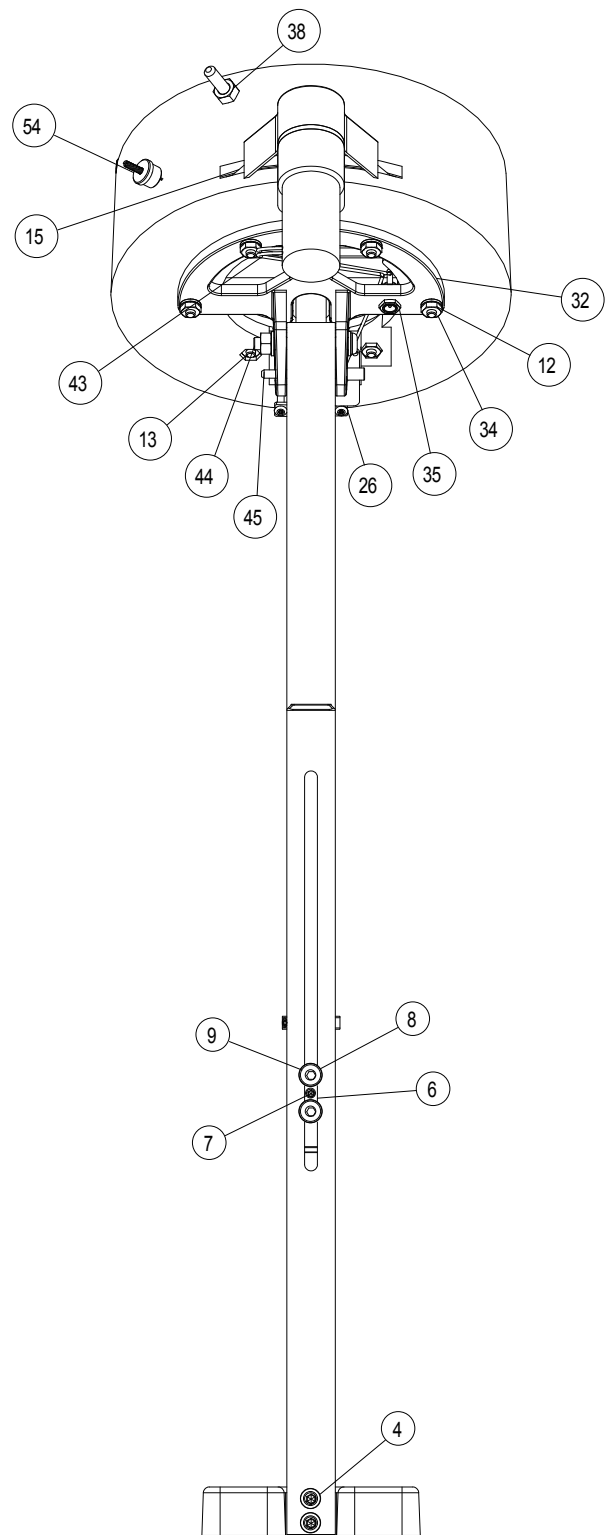
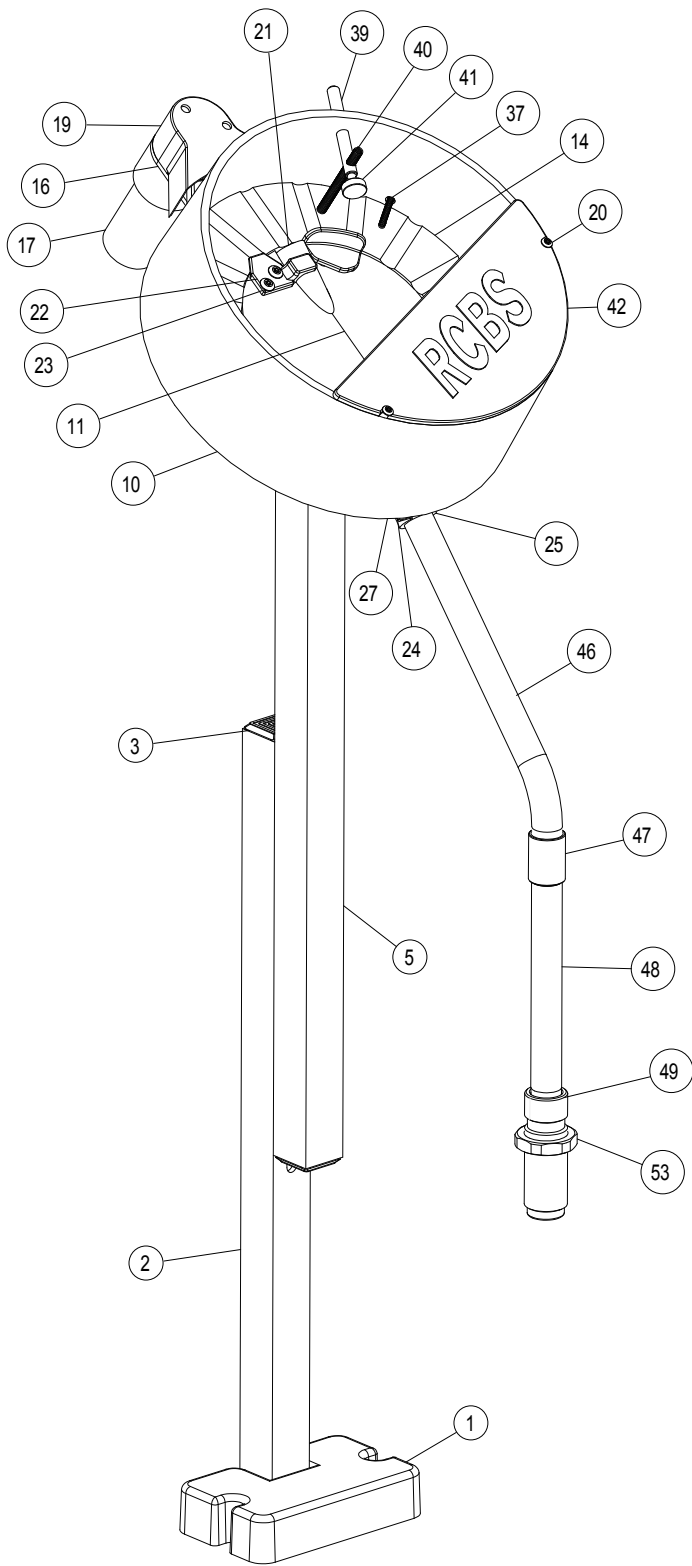
Periodically wipe down the inner part of the Bowl and Bullet Wheel to remove dust and debris.

Also, disassemble the Bullet Die body and clean the Bullet Guide and Bullet Fingers to ensure smooth function.

The drive belt may need adjustment as the belt wears. Loosen the two FHCS and apply more tension on the belt. Re-tighten the two FHCS.

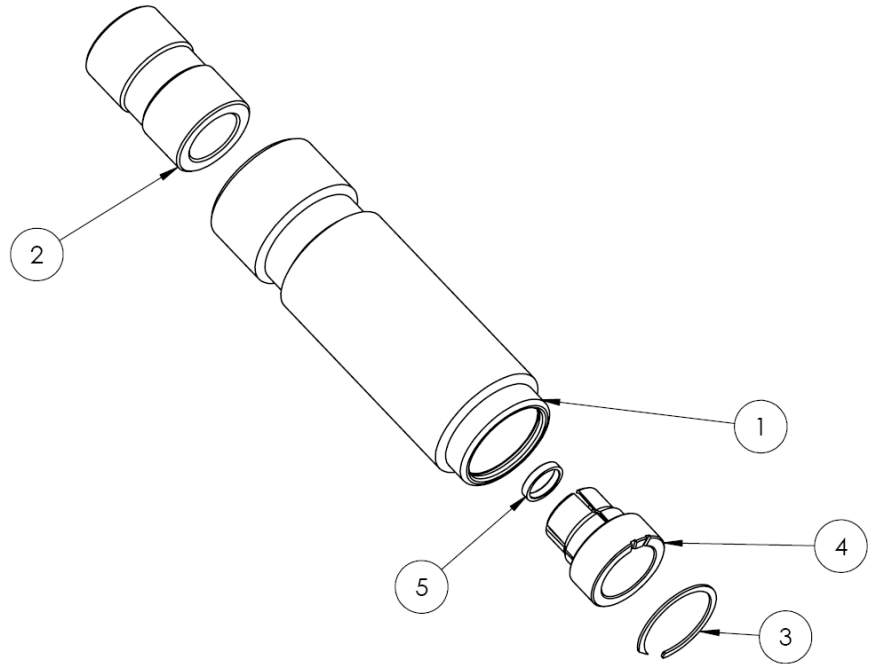






82350 Bullet Feeder - Pistol Kit			
Part Number	Description	Item No	Qty
781205	Support Foot	1	1
781208	Support Tube Lower	2	1
181219	Tube Cap	3	2
181233	10-24 x 1-1/2 BHCS	4	2
781207	Support Tube Upper	5	1
181218	Support Block	6	1
186214	6-32 x 1/2 SHCS	7	1
180072	1/4" Flat Washer	8	2
181234	1/4-28 x 1-1/2 BHCS	9	2
781200	Bowl	10	1
781204	Pistol Hub	11	1
187211	10-32 x 1 BHCS	12	4
181231	10-32 x 1/2 BHCS	13	3
781201	Pistol Bullet Wheel	14	1
181222	Drive Belt	15	1
181217	Motor Mount	16	1
181215	Motor	17	1
181221	Drive Pulley	18	1
181203	Pulley Cover	19	1
181237	5-40 x 3/8 BHCS	20	4
781221	Bowl Drop Tube	21	1
181206	Tube Retainer	22	1
187217	8-32 x 3/8 BHCS	23	2
781203	Switch Block Left	24	1
181204	Switch Block Right	25	1
181230	6-32 x 3/8 BHCS	26	2
181223	Case Switch	27	1
181239	.110 Female Disconnect	28	2
181238	3/16 Female Disconnect	29	2
181228	4-40 x 5/8 SHCS	30	1
181227	4-40 Hex Nut	31	1
781206	Bowl Bracket	32	1
781225	Jumper Wire	33	1
109603	10-32 Hex Nut	34	5
181220	Power Jack	35	1
181229	6-32 Nyloc Nut	36	2
181224	Continuous Spring	37	1
109604	1/4-28 Hex Nut	38	3
781210	Deflector Rod	39	1
181240	Deflector Spring	40	1
181236	8-32 x 3/8 Thumbscrew	41	1
181207	Bowl Cover	42	1
781226	Split Wire Loom	43	1
181235	1/4-28 x 2 BHCS	44	1
781224	Bracket Pin	45	1
181242	Continuous Spring	46	1
781215	Tube Adapter	47	1
781223	Bullet Drop Tube	48	1
781219	Bullet Die	49	1
187546	Retaining Ring	50	1
181211	Bullet Fingers	51	1
781217	Bullet Guide	52	1
787500	7/8-14 Lock Ring	53	1
781227	Wiper Bushing	54	1

Item No.	Part Number	Description	Qty.
1	781219	Bullet Die	1
2	781216, 17, 18, 20	Bullet Guide .38, .40, .45, .38 Long	1
3	187546	Retaining Ring	1
4	181210, 11, 12, 13	Bullet Fingers .38, .40, .45, .38 Long	1
5	181226	Tension Band	1





**PRECISIONEERED RELOADING EQUIPMENT**

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Customer Service

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