

LUBRICATION AND MAINTENANCE

Proper lubrication will insure long life and excellent performance—A few drops of oil or a small amount of grease should be applied to all bearing surfaces as needed, after one or two thousand rounds of loading normally.

The press head will require adjustment and/or cleaning if the measure drum sticks or jams. Often a slight adjustment of the nut on top of measure drum will cure the trouble. If measure drum continues to hang, clean press head thoroughly.

To Disassemble:

1. Empty shot and powder hoppers. Remove hopper locating screw and measure stud.
2. Remove nut on top of hopper. Loosen set screw in nut before attempting to unscrew.
3. Lift hoppers from machine.
4. Remove lock nut and lift out measure drum.
5. Unscrew locknut and spring stop directly above station #4.
6. Cut off plates can be lifted out.
7. Clean and lubricate.

To Assemble:

1. Be sure the cut off plate indexing pin and springs are in place.
2. Replace cut off plates.
3. Replace spring stop.
4. Place measure return spring in measure drum—compress spring past assembly rod hole—insert rod or nail in hole to keep spring compressed.
5. Place drum in head—replace measure stud and remove assembly rod.
6. Replace other parts.
7. Tighten lock nut until measure drum will not move freely—Then back nut off until measure drum is just free.
8. Tighten set screw in turret nut—Check measure drum to be sure it returns freely.

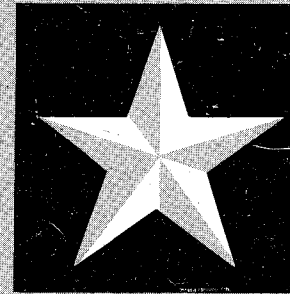
WARRANTY

The Manufacturer warrants each new Reloading Tool manufactured by it to be free from defects in material and workmanship under normal use and service, its obligation under this warranty being limited to making good at its Factory any part or parts thereof supplied by the Manufacturer.

The obligation of the Manufacturer under this warranty shall be limited to the repair or replacement of parts proved defective within Ninety (90) days from date of original purchase, it be returned to the Manufacturer with transportation charges prepaid, and which its examination shall disclose to its satisfaction to have been thus defective; this warranty being expressly in lieu of all other warranties expressed or implied, and of all other obligations or liabilities on its part, and it neither assumes nor authorizes any other person to assume for it any liability in connection with the sale of its Reloading Tool or parts thereof.

This warranty shall not apply to any Unit or part which shall have been repaired or altered outside of an authorized dealer in any way so as, in the judgment of the Manufacturer, to affect its stability or reliability, nor which has been subject to misuse, negligence or accident.

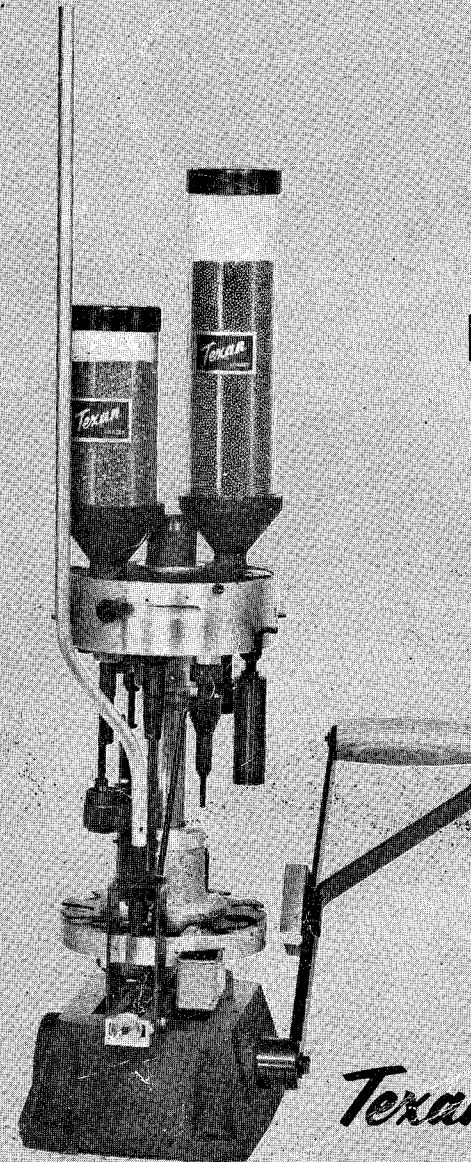
NOTE: We assume no liability in connection with the use of this tool. As we have no control over the operations of the tool, or components used, or the handling of same.



Texan[®] AUTOLOADER

MODEL *MM III*

INSTRUCTION BOOKLET



BETTER
PERFORMANCE
PRODUCTS
FROM

Texan[®] RELOADERS, INC.

P. O. BOX 5355 / DALLAS, TEXAS 75222

M IV AUTOLOADER

CONGRATULATIONS! Your selection of a Texan M IV Autoloader has placed the finest, fastest automatic reloading machine in its price range at your disposal. Precision construction, modern design and easy operation will produce quality reloads to please the most discriminating shooter.

The M IV is designated to reload all 2 $\frac{3}{4}$ " shells (2 $\frac{1}{2}$ " in 410) both paper and plastic. Loads target, field or short Magnum loads simply by changing shot and powder bushings and making minor adjustments for wad pressure and crimp. The M IV may be converted to other gauges by installing complete Gauge Conversion Kit.

NOTE: The M IV is designed to reload 2 $\frac{3}{4}$ " shells only and may not be converted to load 3".

MOUNTING INSTRUCTIONS

The M IV is shipped completely assembled except for the handle and primer feed tube. This unit has been carefully adjusted and tested by loading several shells. Enclosed with this loader you will find an inspection sheet specifying the exact components used in adjusting and testing. If you will place the loader into operation using these same components no adjustment will be required.

The handle is attached by removing the hex head screw from the end of the rocker arm shaft, sliding handle into the slot, replacing the hex screw and tightening securely. Your M IV is now ready to be mounted on a sturdy bench or table. Set loader in place allowing clear space of 12 to 14 inches on each side of the loader. Mark the hole location of the three mounting bolt holes. Drill appropriate size holes and attach the loader securely to the bench or table using $\frac{1}{4}$ " bolts or lag screws. Before discarding the shipping carton, make sure that all accessory items and literature have been removed. Included are extra shot and powder bushings, primer catcher, extra crimp starter (except in 28 and 410), Texan wrench, hex socket wrench, primer feed tube and literature.

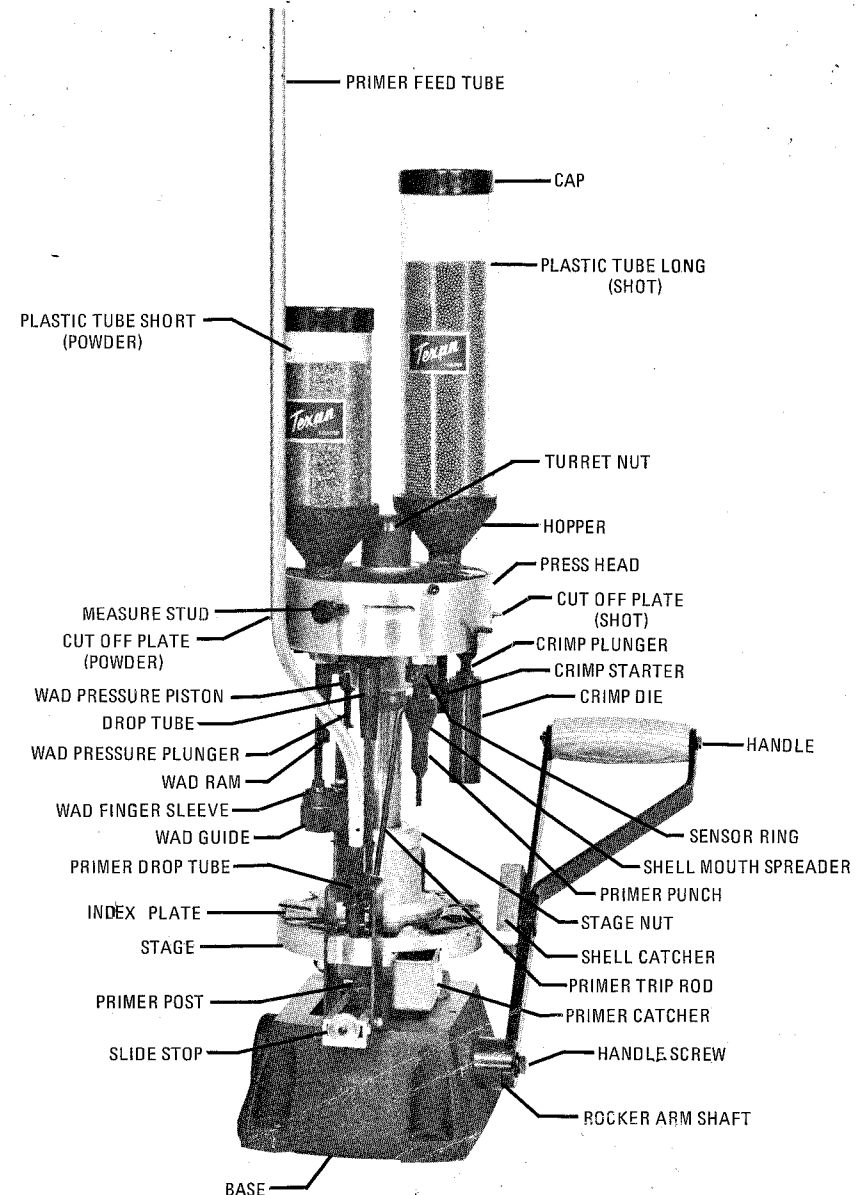
PREPARING TO LOAD

The first step in preparing to load is to become familiar with your loader. Study the illustration on the following page to become familiar with names for various parts that will be referred to later in this manual. Locate each item on your machine so that they may be readily identified.

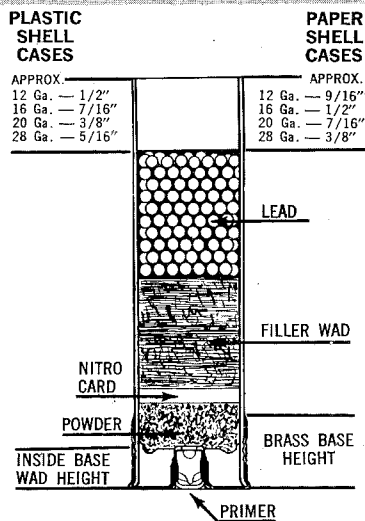
Move shot and powder cut off plates to the off position. Carefully move the handle through a complete cycle. **NOTE** automatic rotation of the index plate during the final portion of the downward travel of the stage. **NOTE** the amount of pressure that is required to cycle the handle. Only a very little more effort will be required when you are actually reloading shells. **NOTE** how the wad guide lowers at the beginning of the return travel. By observing the measure stud **NOTE**

how the measure drum rotates to position to drop powder and shot. Drop will only be completed if shot or powder cut off plates are in the ON position. **NOTE** that the primer feed is actuated by the shell.

This means that a primer is dropped into the primer post assembly only if there is a case being deprimed. **NOTE** the location of the shell guide springs that maintain alignment of the case and dies during the loading operations. You will find that a few minutes spent in becoming familiar with the name and functions of these items will be of a great deal of assistance later.



SHELL CASES



It is always important to remember that the quality of the reloaded shell can not surpass the quality of the empty shell that it is loaded into. Sort cases carefully by brand and type and at the same time check each case for defects. Cases that have cracked case mouths, loose primer pockets, loose base wads, cracks or pin holes through the body or badly deformed or cracked case heads should be discarded.

POWDER

Many types of powder are available in each brand. When purchasing powder make sure that type suitable for the load desired is obtained. Always refer to reliable loading data for proper powder quantities and types for each load. Powder types that are suitable in target or other light loads are seldom suitable for heavy hunting loads. Do not attempt to make substitutions on powder type or quantity or shot quantity as dangerous loads may result.

PRIMERS

The primer performs the important function of igniting the powder. Most of the current cases use a primer designated as 97, 109, 209, 220 or 4BP all of which are of the same diameter, the designation depending on the manufacturer. Intended for use in the 410 gauge case are primers designated as 69, 97-4 or 410. Again the designation depends on the manufacturer. Another size (smaller than the above) carries the designation of 57, 157 or G57F and is used in Remington and Peters paper and high velocity field load plastic cases. Most currently produced primers have the flash hole covered by either a small paper disc or a drop of special sealer. This does not impair efficiency and is necessary to prevent the entry of the extremely small flakes of ball type powders into the primer battery cup.

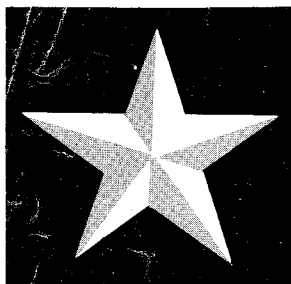
WADS AND WAD PRESSURE

Modern smokeless powder is progressive in its burning. Proper confinement is necessary to produce uniform ignition. The wad serves to provide this confinement as well as a cushion to prevent distortion of the shot. Prior to the introduction of plastic wads proper confinement was obtained by applying varying amounts of pressure to the card and fibre wads. Pressure applied to the wad column varied according to the burning rate of the powder and requirements were quite exacting. With the advent of plastic wads, wad pressure became far less critical. This improvement is the result of the superior obturation (sealing) properties of the plastic wad. Pressure for the plastic wads is generally considered proper at approximately 20 pounds. Reloading data will generally include the proper wad pressure to be used with the recommended wads. Wad column length is easily determined by placing powder, wad and shot into case and measuring from the level of the shot to the mouth of the uncrimped case. The accompanying drawing indicates the amount of space that should remain after wad pressure has been applied and shot has been dropped into the case.

SHOT

The quantity of shot used in any given load is equally important as the quantity of powder. Loading data lists the amount of shot in ounces to be used with a given quantity of powder. To increase shot quantity without corresponding change of powder quantity or type will produce loads that develop increased chamber pressures. This is a dangerous practice and may result in damage to the gun they are fired in and possible injury to the shooter or bystanders. A decrease in shot quantity for the same given quantity of powder will produce loads with lowered pressures. Lowered pressures result in shells of low velocity and poor patterns. This shell often will not produce adequate pressure or recoil to function a semi-automatic gun. Always be sure that both the quantity of shot and powder are in accordance with the loading data.

The size of the shot is left to your choice. Small sizes of shot are used for small game birds, trap and skeet. Larger shot sizes are used for larger game and game birds. Larger shot provides greater killing power per pellet at longer range due to better retention of velocity but of course has fewer pellets in the shot pattern.



Texan®

SHOT BUSHING TABLE

NO. 88660
All Sizes \$1.00 Each

This table gives the approximate ounces of shot dropped by Texan shot bushings under normal loading operations.

No.	Ounces
1 X	3/4
2 X	7/8
3	1
4 X	1-1/8
5	1-3/16
6	1 1/4
7	1-3/8
8	1 1/2
9	1-5/8
10	1 3/4
11	3/8
12	1/2
13	5/8

This table gives the approximate number of grains of powder dropped by Texan Powder Bushings under normal loading operations in Texan machines.

The "M" Column applies to Texan models "M", "M-II-A", "M-IV"

HERCULES 2400 Powder Bushing	M
K	15.0
X	14.0

POWDER CHARGE BUSHING TABLE BUSHINGS \$1.00 EACH

THIS IS NOT A LOADING TABLE: Refer to powder manufacturers recommended loads.

Bushing	HERCULES					DUPONT				
	Green Dot M	Red Dot M	Blue Dot M	Herco M	Unique M	Hi-Skor 700 X M	PB M	4756 M	4227 M	7625 M
A	15.1	15.1	25.1	19.5	20.5	16.5	17.6	20.9	29.8	21.0
B	17.1	17.3	28.5	22.3	23.3	18.6	19.9	23.5	33.8	23.6
C	19.5	20.0	32.5	25.8	26.7	21.3	22.7	26.9	38.4	26.9
D	21.0	21.7	35.2	27.8	28.7	23.0	24.5	28.8	41.1	29.0
E	24.5	25.4	41.1	32.6	33.6	26.8	28.4	33.6	47.6	33.8
F	27.8	29.2	47.0	37.5	38.4	30.6	32.5	38.4	54.0	38.5
G	17.6	17.8	29.3	23.0	23.9	19.2	20.5	24.4	34.6	24.5
H	23.2	24.0	38.8	30.8	31.8	25.3	27.0	31.8	45.1	32.0
J	16.2	16.3	27.0	21.1	22.2	17.7	18.8	22.3	32.1	22.4
K	8.1	7.5	13.4	9.9	10.8	8.6	9.4	11.3	15.4	11.4
L	9.7	9.4	16.1	12.1	13.1	10.4	11.3	13.4	18.8	13.5
M	11.8	11.8	19.7	15.1	16.1	12.9	13.8	16.5	23.1	16.5
N	13.0	13.0	21.7	16.7	17.7	14.1	15.1	18.0	25.5	18.1
P	14.1	14.2	23.5	18.2	19.2	15.4	16.4	19.5	27.8	19.5
Q	18.1	18.5	30.3	23.9	24.8	19.8	21.1	25.0	35.9	25.1

CAUSES OF VARIATION IN CHARGES DROPPED

1. Moisture content of powder.
2. Density of powder and shot.
3. Size of shot.
4. Inconsistent operation or agitation.
5. Dirty or oily bushings or drop tube.

Information shown in this Powder Charge Table was compiled from tests held under perfectly controlled conditions. Individual charges shown are average charges metered by each specific bushing using specific lots of powder. It is the operators responsibility to assure a specific bushing will meter the powder charge desired from each container of powder. No other liability is assumed or implied.

Loading information shown has been revised and supercedes all information printed before 1-1-71. Destroy all old loading information.

Minimum Parts Order
\$2.00 Each Order

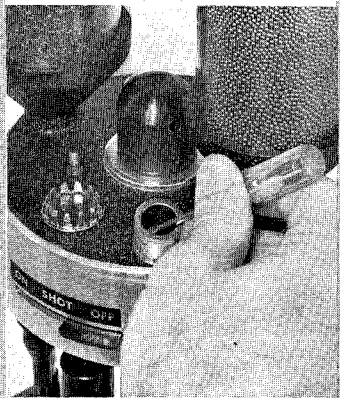
When Ordering Parts
From the Factory, Add \$1.00
for Postage and Handling

All Prices Subject to
Change Without Notice

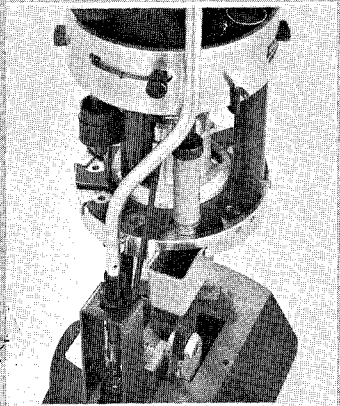
R	22.3	23.0	37.2	29.5	30.05	24.3	26.0	30.6	43.3	30.8
S	32.7	34.5		44.1			38.2	44.9		44.7
T	11.3	11.2	18.9	14.4	15.4	12.3	13.2	15.8	22.1	15.8
U	12.5	12.4	20.7	16.1	16.9	13.5	14.5	17.3	24.4	17.3
V	10.0	9.7	16.7	12.6	13.6	10.8	11.7	14.0	19.4	14.0
W	8.5	8.0	14.2	10.6	11.5	9.2	10.0	12.0	16.4	12.0
X	7.4	6.9	12.4	9.1	10.0	8.0	8.8	10.5	14.2	10.5
Y	10.5	10.2	17.5	13.3	14.3	11.4	12.3	14.6	20.4	14.7
Z	9.3	9.0	15.5	11.6	12.6	10.1	10.9	13.0	18.0	13.0

Bushing	ALCAN				WINCHESTER				
	AL-5 M	AL-7 M	AL-8 M	AL-120 M	AA 12 M	AA-20 M	450 SL M	500 HS M	540 MS M
A	24.4	24.9	19.9	16.8	18.6	20.4	28.7	35.4	32.3
B	27.6	28.2	22.8	19.0	21.0	23.0	32.6	39.9	36.4
C	31.6	32.2	26.3	21.7	24.0	26.3	37.4	45.6	41.6
D	34.0	34.6	28.5	23.3	25.9	28.3	40.0	48.8	45.1
E	39.7	40.2	33.6	27.1	30.3	33.0	47.4	57.0	52.3
F	45.7	45.8	38.6	30.9	34.6	37.7	54.3	65.0	59.6
G	28.4	29.0	23.5	19.5	21.8	23.9	33.8	41.0	37.5
H	37.6	38.2	31.7	25.7	28.6	31.2	44.8	54.0	49.5
J	26.2	26.7	21.4	18.0	19.9	21.8	30.8	37.9	34.5
K	12.6	13.6	10.7	9.0	9.8	11.0	15.0	19.0	17.3
L	15.5	16.3	12.1	10.9	11.7	13.1	18.1	22.8	20.8
M	19.0	19.7	15.2	13.2	14.5	16.0	22.2	27.8	25.1
N	20.9	21.5	16.9	14.5	16.0	17.6	24.6	30.5	27.8
P	22.7	23.2	18.5	15.7	17.3	19.0	26.8	33.1	30.1
Q	29.4	30.0	24.4	20.2	22.3	24.5	34.6	42.4	38.7
R	36.0	36.6	30.4	24.6	27.6	30.1	43.0	51.9	47.5
S	51.3	53.7	45.4	36.3	41.1	44.2	63.8		
J	18.2	18.9	14.5	12.7	13.9	15.4	21.5	26.7	24.3
U	20.0	20.6	16.1	13.9	15.3	16.9	23.5	29.2	26.6
V	16.0	16.8	12.5	11.2	12.3	13.7	18.8	23.6	21.4
W	13.5	14.4	10.4	9.6	10.4	11.6	16.0	20.2	18.3
X	11.6	12.7	9.0	8.4	9.0	10.2	14.0	17.7	16.1
Y	16.8	17.6	13.3	11.8	12.8	14.3	19.8	24.8	22.4
Z	14.8	15.7	11.6	10.4	11.4	12.7	17.5	21.9	19.9

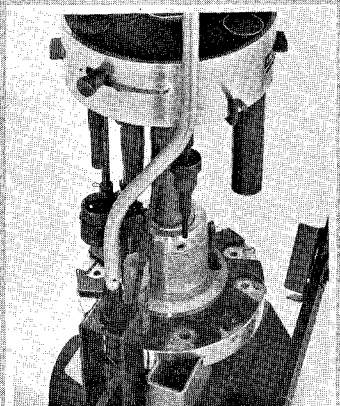
OPERATING INSTRUCTIONS



1



2



3

1. Move cut off plates to the off position. Use a small screw driver to remove snap buttons. Operate handle to move stage to full up position. Remove hopper locating screw and rotate hopper until snap button hole is located over bushings. Place empty shell or other container under drop tube and move cut off plate to "on" position; this will empty bushing. Remove bushing with screw driver or small wire hook. Place desired bushing in place, replace snap button and repeat procedure for other bushing. When both bushings have been checked and replaced, return hopper to normal operating position and replace and tighten hopper locating screw. (Note: Two locations for the hopper locating screw are provided. One locates the hopper over drop tubes for draining the other for normal operation. If hopper is in drain position and handle is operated shot and powder will flow directly through the bushing without being measured. Overcharges and spilling of powder and shot will occur.)

2. Place a supply of empty cases in a container on the right hand side of the loader. Place a supply of the proper size wads in a container on the left hand side of the loader. Place a container to receive the loaded shells to the right rear of the loader. Make sure stage is in full down position. Move both shot and powder cut off plates to the off position. Fill shot (long hopper tube) and powder (short hopper tube) tubes with the selected components. Remove primer tube, place cotter pin into hole in lower end and fill tube with proper size primers (place primers into tube with flange side down). Primer feed will hold 100 primers. Return primer tube to the primer feed and remove cotter pin. Place case into station #1 and operate handle fully. Case will be deprimed and case mouth will contact sensor ring to activate primer feed and drop primer into primer post.

3. As stage is returned to the full down position, index plate will rotate to move the case deprimed in station #1 to station #2 and seat the primer. Check the positioning of the shell guide spring. The screw that controls its travel must be adjusted so that spring touches rim of case but is not allowed to protrude under the case when primer is pressed into the

OPERATING INSTRUCTIONS

primer pocket. Move powder cut off plate to the "on" position and insert empty case into station #1.

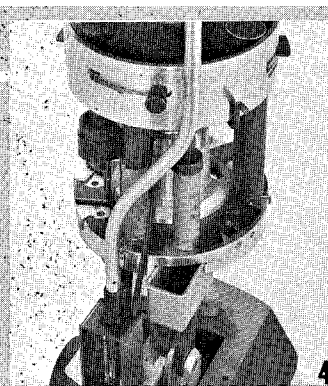
4. Operate handle to move stage to full up position. Powder is dropped into case in station #2 and previous operations repeated at station #1. Return stage to full down position. This advances the index plate and moves shells ahead one station.

5. Insert empty case in station #1 and a wad, (that is correct for the case and load being used) into the wad guide. Operate handle to move stage to full up position. Wad guide will lower onto case, then wad is pressed down into the case. All previous operations at stations #1 and #2 will automatically be repeated. Return stage to full down position.

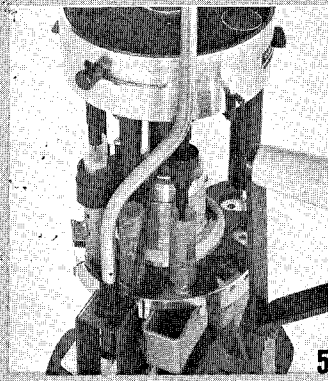
Repeat twice the operations of inserting case into station #1 and wad into self lowering wad guide and operating handle and note that as the first shell placed into the loader advances through the next two stations (#4 and #5) that no operations are performed.

6. Repeat operations of placing empty case into station #1 and wad into self lowering wad guide and operate handle to move stage to the full up position. Wad pressure is applied to the top of the wad column at station #6 and direct wad pressure is read on the wad pressure gauge. Each line on the gauge equals 10 pounds (i.e.: 5 = 50 pounds of pressure; 8 = 80 pounds of pressure). Check powder manufacturers information for proper wad pressure recommendations. As a rule, with plastic 1 piece wads, 20 pounds of pressure is adequate.

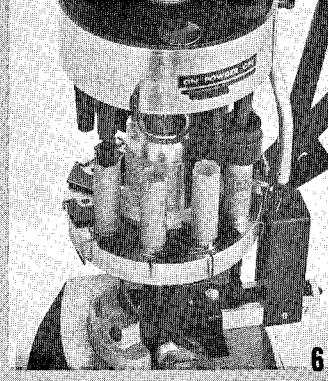
7. Move shot cut off plate to the "on" position. Repeat operations of placing empty case into station #1 and wad into self lowering wad guide. Operate handle to move stage to the full up position. All previous operations will automatically be repeated plus shot will be dropped into the case in station #7. Return stage to full down position.



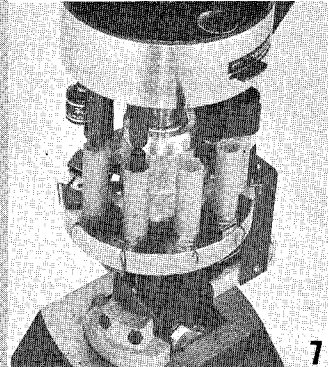
4



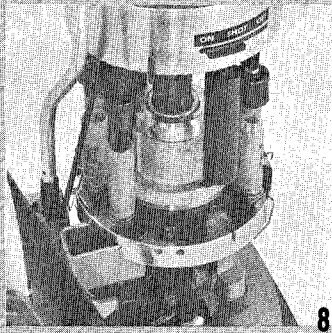
5



6



7



8

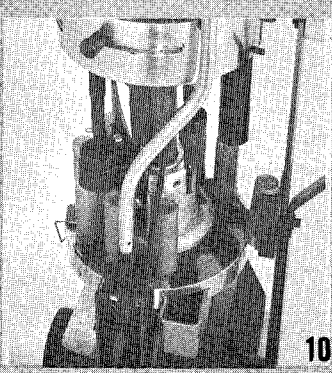
8. Repeat operations of placing empty case into station #1 and wad into self lowering wad guide. Operate handle to move stage to full up position. All previous operations will automatically be repeated plus crimp start will be placed on case by the self aligning crimp starter in station #8. (Make sure that the crimp starter being used matches the number of points formed in the original crimp.)

Return stage to the full down position.



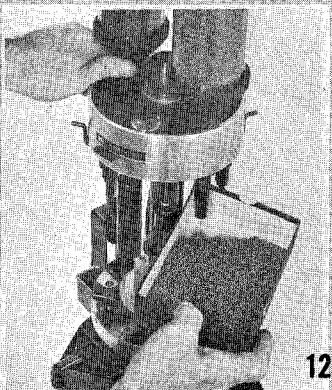
9

9. Repeat operations of placing empty case in station #1 and wad in self lowering wad guide. Operate handle to move stage to full up position. All previous operations will automatically be repeated plus the final crimp is formed on the case in station #9.



10

10. Operate handle to return the stage to the full down position. As index plate advances the completed shell will be ejected from the index plate, caught by the shell catcher and dumped into the finished shell container previously placed at the rear of the loader.



11

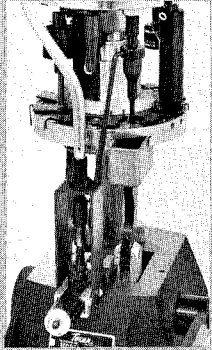
11. Your Texan Model MIV is now in normal full turret operation. Continued operation consists simply of placing an empty case in station #1 and a wad in self lowering wad guide and operating the handle to provide full up and down movement of the stage. Each cycle of the stage will complete and eject a reloaded shell.

12. Move both shot and powder cut off plates to the "off" position. Remove hopper locating screw. Rotate hopper so that hoppers are located over drop tube. Replace hopper locating screw. To remove shot, move shot cut off plate to the on position. Place container beneath shot drop tube. Move measure stud to the right (against the spring pressure) and hold as shot drains from drop tube. Flow may be shut off at any time by allowing measure stud to return to normal position. Removal of powder is accomplished in the same manner, turning the powder cut off plate to "on" position and placing container under powder drop tube. After draining shot and powder, remove hopper locating screw and return hopper to normal operating position. Replace and tighten hopper locating screw.

The Texan model M IV has been inspected and tested by loading ammunition with the components listed on the inspection sheet. If the loader is placed in initial operation using these exact components, no adjustment will be required. This will enable the operator to become familiar with the loading operations without making adjustments to compensate for other components or loads.

Adjustments are sometime made when the problem is actually due to an improper combination of components. Always make sure that primer, wad, powder and shot quantities are correct for the case being loaded before making adjustments. This may prevent a loss of time from adjusting, then re-adjusting, as well as ruined cases and wasted components.

Most adjustments, to compensate for changes in components, will be small and should be made in half turn or less increments.



PRIMER FEED ADJUSTMENT

The primer feed on the Texan model M IV is designed so that a minimum of adjustment is required. The primer feed is actuated by the shell mouth contacting the sensor ring. This means that a primer is dropped only if a case is in position and being deprimed.

The following instructions for primer feed adjustment cover complete adjustment. It is quite probable that complete adjustment will seldom be required. However when making any adjustment start at the very beginning of these instructions and verify that adjustment is correct for each step until the required adjustment is located. After an adjustment is made continue through the balance of the adjustment procedure as one adjustment may create the need for additional compensating adjustments.

1. **PRIMER POST:** This is the initial adjustment that must be made and/or checked. With deprimed case in place in station #2, primer of the proper size in primer post, adjust primer post assembly up or down to seat primer to proper depth at full down position of the stage. When retightening the 3/8 jam nut the primer post should be in the hole in the stage to insure proper alignment. **NOTE:** If primer post is adjusted too high case head will be concaved and index plate may be bent. If primer post is adjusted too low primer will not be completely seated and will cause loader to "lock up" when indexing is attempted.

2. **SLIDE STOP:** Adjust slide stop until it hits the base of the automatic primer feed, while the primer post is centered in the hole in the stage. (Stage in down position). Lock in the slide stop in place with the 1/4-20 hex jam nut.

3. **PRIMER DROP TUBE:** The primer drop tube assembly is adjusted for height, to just provide clearance over the primer post. The primer drop tube is adjusted forward or backward to provide alignment with the primer post. The primer post should, at its rearmost position (handle full down, stage up) have traveled just slightly past the primer drop tube.

4. PRIMER TRIP ROD: The primer feed is actuated by the case mouth contacting and lifting the sensor ring. This in turn causes upward movement of the primer trip rod. With a case in position, being deprimed and the stage in the full up position, trip rod nuts are adjusted to just allow primer to be released. Adjusting the trip rod nuts too high will drop primer too soon and may place unnecessary strain on the primer feed. If trip rod nuts are adjusted too low the primer will not drop. (A primer accidentally inserted into the primer tube upside down will lock up primer feed slide preventing its return. To clear jam, move stage to full up position. Use finger and thumb of left hand to depress primer post cup and slowly return stage to lowered position).

WAD PRESSURE ADJUSTMENT

With plastic 1 piece wad columns precise wad pressure is not a critical factor in reloading. It is however recommended with most plastic wads and most powders, that approximately 20 pounds of pressure be applied to assure that wad is fully seated against the powder. The wad pressure is adjustable over a wide range of pressures and for all types of wads.

To adjust for proper pressure for different loads, loosen lock nut and adjust wad pressure plunger up or down until correct reading is obtained on the scale on the wad pressure piston. Retighten lock nut.

CRIMP STARTER ADJUSTMENT

In order to form proper crimps a crimp start must be placed on each case. The number of folds may be either 6 or 8. Prior to reloading a group of cases, determine how many folds were used in the original loading. For best results reload cases using a crimp starter that will produce the same number of folds. Adjust the crimp starter stud up or down as required to provide proper crimp start. The points on the case, after crimp starting should be closed to a diameter of approximately one third the diameter of the case or less. Too much crimp start will cause the crimp to be off center or have a swirl pattern. Too little crimp start will leave a hole in the center of the crimp that may allow shot to escape.

CRIMP DIE ADJUSTMENT: The crimper body and crimp plunger are independently adjustable. To deepen crimp loosen lock nut and adjust crimp plunger down. This may also necessitate a compensating adjustment on the crimper body. To increase taper at case mouth adjust crimper body down. Make sure that crimper body is not adjusted so that it hits index plate and prevents stage from traveling to full up position.

INDEX PLATE TIMING: If the index plate does not move far enough, or too far, to seat a primer the timing is off. To adjust the timing push the handle all the way back. The cam follower roller against the index cam, rolls on an eccentric bushing. Loosen the hex head bolt. Rotate the eccentric bushing until the roller is against the index cam. If the adjustment is too loose the index plate will not index far enough. If it is too tight it will index too far. Tighten the hex bolt. The eccentric can be set at two different points for correct timing to seat a primer. However, if set with the eccentric hanging below the hex bolt, may cause the index to start too soon not allowing the shells to clear the primer ejection punch or the crimper body. When setting rotate the eccentric over the top of the hex bolt letting the roller fall against the index cam. Hold the eccentric in place while tightening the hex bolt.

CONVERTING THE M IV TO OTHER GAUGES

Conversion of the M IV is not difficult. The first time that conversion is made, DO NOT RUSH. Pay close attention to the approximate adjustment of parts before removing them to replace with those for another gauge. A few minutes spent in noting the details of parts location and adjustment will be repaid many times over during later conversions.

1. To change the index plate, loosen two set screws in the stage nut and unscrew the nut. Loosen two set screws in the measure cam holder. Raise the nut and measure cam holder as high as possible. Lift on one half of the index plate at the same time tap lightly on the other half. They will come apart and can be removed. Lubricate both sides of the index plates with a light grease where contact is made. Place one half of the index plate on the stage with the index cam in one of the rectangular slots. Make sure the index ball and spring are in the hole in the stage. Place the other half of the index plate over the ball, locking the two halves together. Pull the measure cam holder down. Be sure the index cam goes through the slot in the flange of the measure cam holder. Tighten the stage lock nut hand tight. Make certain the thread protector plugs are in the set screw holes of the lock nut. Rotate the measure cam holder until the back side of the measure cam touches the back up roller on the press head. Stage must be raised. Tighten the two set screws in the measure cam holder. (But not too tight). These prevent the measure cam holder from turning. If tightened too tight the stage will bind on the center post.

2. Remove shell mouth spreader by inserting hex wrench through hole in side of spreader and loosening the socket head set screw.

Replace with shell mouth spreader from conversion kit and retighten in place. (410 gauge does not require shell mouth spreader).

3. Remove powder and shot drop tubes by loosening 7/8-14 lock nut and threading out of press head. Install drop tubes from conversion kits. Thread into press head until touching cut off plates then back off 1/4 turn and lock securely in place with 7/8-14 lock nut.

4. Replace wad finger sleeve in wad guide body by holding wad guide body securely and pressing wad finger sleeve up out of body. Place wad finger sleeve from conversion kit in wad guide and press firmly into place.

5. If converting to 28 or 410 gauge. Wad pressure plunger must be changed. Loosen wad plunger lock nut, remove wad plunger and install wad plunger from conversion kit. Lock in place with lock nut.

6. Remove crimp starter by loosening lock nut and threading crimp starter stud out of press head. Replace with crimp starter from conversion kit and lock in place with lock nut. The conversion kit includes both 6 and 8 point crimp starters (except 28 and 410, 6 point only). Make sure that crimp starter being installed has the appropriate number of points for cases to be reloaded.

7. Remove crimp die and crimp plunger assembly by loosening crimp plunger lock nut and threading entire assembly out of press head. Make sure that crimp plunger and body are assembled and two lock nuts installed on the threaded shaft of the crimp plunger. Thread crimp plunger into press head and lock in place.

REPLACEMENT PARTS

KEY NO.	PART NO.	DESCRIPTION	QUAN. REQ.	PRICE EACH	KEY NO.	PART NO.	DESCRIPTION	QUAN. REQ.	PRICE EACH
1.	192350	Turret Nut	1	3.00	75.	158170	9/16-18 Hex Jam Nut	2	.75
2.		#2 Lead Shot	2		76.	315550	Drop Pin	1	.50
3.	32510	10-32 x 3/16 Set Screw	3	.20	77.	317480	Deprieme Punch	1	2.50
4.	192170	Turret Nut Washer	1	.75	78.	317150	Sensor Ring	1	1.50
5.	317570	Cap 2 1/4"	2	1.00	79.	148530	Primer Catcher Tray	1	.50
6.	192460	Shot Tube	1	3.00	80.	148250	Post	1	12.00
7.	192450	Powder Tube	1	2.00	81.	148190	Link	2	1.50
8.	148740	Snap Button #1715-AC	2	.25	82.	148580	Retaining Ring #5100-118	2	.20
9.	317270	Hopper 2 3/4"	1	15.00	83.	148220	Index Plate Cam	1	4.00
10.	192240	Lock Nut	1	1.25	84.	47260	1/2-20 x 1 Hex Hd. Cap Screw	3	.20
11.	88980	Bronze Washer	4	.50	85.	148340	Index Cam Holder	1	6.00
12.	88670	Powder Bushing (See Chart)	1	1.00	86.	101130	Dowel Pin 3/8 x 7/8	2	.20
13.	88660	Shot Bushing (See Chart)	1	1.00	87.	101180	Rocker Arm Yoke	2	2.50
14.	148640	Roller Cam Follower Holder	1	2.50	88.	148490	Index Cam Return Spring	1	.75
15.	148650	Pin 1/4" x 1/2"	1	.20	89.	148840	Dowel Pin 1/4 x 1/2	1	.20
16.	148630	Cam Follower Roller	1	.75	90.	192470	Shell Catcher	1	1.95
17.	148860	Set Screw 5/16-18 x 3/8	7	.20	91.	317550	Trip Rod Retaining Pin	1	.20
18.	317260	Measure Drum	1	12.50	92.	192110	Base	1	20.00
19.	317490	Spring Plug	2	.75	93.	192120	Rocker Arm Shaft	1	7.50
20.	317550	Measure Drum Return Spring	1	1.50	94.	37550	Washer 5/16" L.D.	3	.20
21.	148180	Cut Off Plate	2	3.00	95.	88460	5/16-18 x 3/4" Hex Hd. Cap Screw	2	.20
22.	148590	Measure Spring Stop Stud	1	.50	96.	101660	Handle Frame Assy.	1	3.50
23.	192370	Cut Off Pin	2	.50	97.	148420	Wood Handle Grip	1	1.50
24.	192390	Cut Off Spring	2	.25	98.	148430	Handle Grip Bushing	1	1.00
25.	192150	Press Head	1	20.00	99.	134230	1/2-20 x 5" Hex Hd. Bolt	1	.40
26.	148810	Powder Decal	1	.20	100.	148890	5/16-18 x 1" Hex Hd. Bolt	1	.20
27.	148820	Shot Decal	1	.20	101.	101510	5/8" Flat Washer	1	.20
28.	192360	7/8-14 Lock Nut	2	1.00	102.	101680	5/8-11 x 3" Hex Hd. Bolt	1	1.00
29.	192230	Drop Tubes (Specify Gauge)	2	3.00	103.	101450	Hex Wrench 5/32"	1	.40
30.	MCS	Crimp Starter (Specify Gauge & Points)	2	5.50	104.	33590	Hex Wrench 3/32"	1	.40
31.	192380	Cut Off Handle	2	.50	105.	315880	Primer Tube	1	4.50
32.	317250	Actuating Rod Assy.	1	3.50	106.	121210	Cotter Pin 3/32 x 3/4	1	.20
33.	317410	Wad Guide Body	1	3.50	107.	37580	1/2" L.D. Flat Washer	1	.20
34.	192730	Wad Guide Finger Sleeve (Specify Ga.)	1	1.00	108.	35630	#10 Washer	1	.20
35.	317530	Hair Pin Clip WW-SX	2	.20	109.	192410	Texan Wrench	1	2.00
36.	157280	1/2-20 Jam Nut	2	.20	110.	172490	Hex Wrench 7/32"	1	.40
37.	192260	Wad Ram (Specify Gauge)	1	2.00	111.	172340	3/8-24 x 3/4 F. L. Hd. SK. Cap	1	1.00
38.	148620	Stripper Bolt	1	.75	112.	172160	Return Spring	2	.75
39.	148610	Cam Backup Roller	1	.75	113.	317230	Primer Post Assembly	1	4.00
40.	45140	1/2-20 Hex Jam Nut	5	.20	114.	226220	1/2-20 x 3/8 Hex Hd. Cap Screw	1	.20
41.	148950	Measure Stud	1	1.25	115.	317310	Slide Cam	1	4.00
42.	148520	Stage Nut	1	3.00	116.	226120	Slide Assembly	1	5.00
43.	88270	3/8-24 Hex Jam Nut	3	.20	117.	191170	3/16 Dia. x 1" Pin	1	.75
44.	221410	10-32 x 3/8 Soc. Hd. Screw	2	.20	118.	226140	Slide Stop	1	1.00
45.	317130	Wad Pressure Plug	1	2.00	119.	226250	6-32 x 5/16 RD. HD. Screw	2	.20
46.	192670	Wad Pressure Spring	1	1.00	120.	317430	Slide Base Assembly	1	8.50
47.	317120	Wad Pressure Piston	1	2.50	121.	192420	Index Cam Eccentric	1	1.00
48.	317110	Wad Pressure Body	1	2.50	122.	192430	Index Cam Roller	1	1.00
49.	177260	1/4-28 Jam Nut	1	.20	123.	317980	Instruction Manual M IV	1	1.00
50.	317140	Wad Pressure Plunger (Specify Ga.)	1	1.50					
51.	148280	Wad Guide Stop Rod	1	.75					
52.	46420	8-32 x 1/4 Truss Hd. Screw	1	.20					
53.	317360	Crimper Body (Specify Gauge)	1	5.00					
54.	317460	Crimper Plunger (Specify Gauge)	1	1.50					
55.	148830	Texan Decals	2	.25					
56.	148230	Measure Cam	1	4.00					
57.	317290	Measure Cam Button (Specify Ga.)	1	1.50					
58.	134310	1/4-20 x 1/2 Hex Hd. Cap Screw	2	.20					
59.	148350	Measure Cam Holder	1	7.50					
60.	121160	Roll Pin 3/32 x 7/16	1	.20					
61.	192140	Index Plate (Specify Gauge)	1	5.00					
62.	317180	Detent Plunger	1	1.00					
63.	163140	Detent Spring	1	.20					
64.	317240	Ejection Cam (Specify Gauge)	1	2.95					
65.	317280	Stage	1	20.00					
66.	148850	3/8-24 Hex Elastic Stop Nut	2	.25					
67.	148270	Rocker Arm Cross Stud	1	1.00					
68.	317420	Shell Retainer Spring	4	.75					
69.	317560	6-32 x 3/8 Round Hd. Screw	1	.20					
70.	317190	Primer Drop Tube Assy.	1	4.00					
71.	317540	Primer Drop Sleeve Assy.	1	1.50					
72.	317190	Primer Trip Rod	1	2.50					
73.	317440	Shell Mouth Spreader (Specify Ga.)	1	2.50					
74.	317450	6-32 Flex Lock Nut	1	.20					

Specify Gauge Size
and Part Number
When Ordering

Minimum Parts Order
\$2.00 Each Order

When Ordering Parts
From the Factory, Add \$1.00
for Postage and Handling

All Prices Subject to
Change Without Notice

