

Mr. Bulletfeeder®

Patent 7497155, 7549364

PLEASE READ AND FOLLOW ALL INSTRUCTIONS

Please inspect your shipment. The standard set-up for one caliber will include:

- (a) Collator
- (b) Collator Plate – caliber specific
- (c) Bullet nose guide and attaching hardware - caliber specific
- (d) Large or Small Output Tube Assembly (output tube, output spring and spring adapter)
- (e) L-bracket stand, tube and mounting hardware.
- (f) Adjustable voltage DC Power supply (selectable input: 120vac-60hz or 220vac-50hz)
- (g) Bullet Dropper - caliber specific
- (h) powder funnel/expander (for handgun calibers only)
- (i) spare parts: 8-32 setscrews for dropper, expansion spring, 375 milliamp slow-blow fuse

WARNING: Reloading ammunition is inherently hazardous. [BE SAFETY CONSCIOUS AT ALL TIMES and ALWAYS USE EYE and EAR PROTECTION.](#) Maintain a sturdy, clean, organized re-loading bench.

DON'T LIKE TO READ INSTRUCTIONS ? Please reconsider. You'll probably save yourself a lot of time by reading these instructions first.

[Familiarize yourself with how the dropper operates.](#)

***** IMPORTANT *****
Your bullet dropper will NOT function properly with FULL WADCUTTERS



The dropper is deceptively simple. As you can see in this photo, the mechanism operates with only a slight amount of pressure. I filled this 45 cal dropper with 230 grain bullets and gently lowered it (by hand) onto a properly flared case. The weight of the dropper and bullets alone was sufficient to cause a bullet to be dropped and tamped into the case mouth. Keep this in mind when adjusting your dropper. There is absolutely no need to over-adjust the dropper depth in an attempt to obtain better tamping performance. Bullets should stay tamped into the cases when you index your press. When you try this, fill the dropper... because if you only use 3 or 4 bullets, there will be less mass and therefore less tamping force.

Dropper setup for Handgun calibers (If you're installing a rifle caliber dropper, read separate instructions.)

[Before installing the dropper](#), you'll need some properly prepared cases.

Note: I recommend using the new funnel/expander that came with your Mr. Bulletfeeder® unit, but it's always possible, that the case flare/expansion method that you are currently using will work properly. If you wish to try your existing setup...flare some cases and determine if you obtain dependable tamping performance. If the bullets tamp properly and don't fall over while indexing the press, then you can probably continue to use your existing setup. If your current flaring setup doesn't provide good tamping (as shown in photo above) the use the new funnel/expander.

NOTE: When using the new funnel/expander, you should adjust your powder measure die a few turns upward at first, since it's very likely that the new funnel is longer than the funnel you are currently using.

Initially, expand/flare your cases to the following specifications. Use the smallest amount of expansion/flare that allows consistent bullet tamping. You will find that as the funnel enters the case... at first it will provide more case mouth expansion than flare.

9mm-38cal. / .386" to .392"

10mm-40cal. / .426" to .432"

45 cal. / .474" to .480".



Cases can vary in length...sometimes quite a bit. Because of this, the amount of flare put on the cases will also vary somewhat. In general, it's a good idea to measure a sample group of the cases you'll be reloading and determine the average case length. Then use a few average length cases to set your flare.

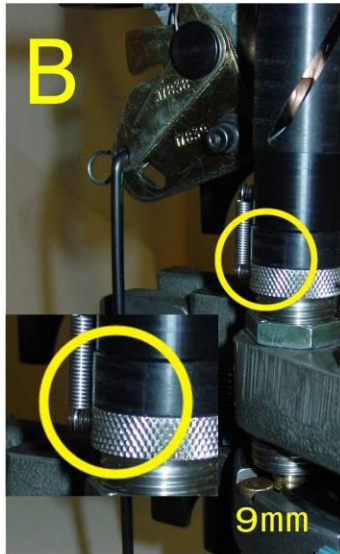
The dropper is mounted to the press in the same way a die is mounted.

- (1) Remove the powder measure. This will allow you to install the dropper more easily.
- (2) Insert a piece of properly flared brass in the shell plate underneath the position where the dropper will be installed, and fully operate the handle on your press. (i.e. 650 – shell plate fully up / 1050 tool head fully down)
- (3) Fill the dropper body with bullets all the way up to the micro-switch.
- (4) Screw the dropper into the tool head and adjust it downward toward the empty brass case. (When the cone-shaped foot of the dropper contacts the case mouth, it will begin to operate the bullet release mechanism.) Continue turning slowly and STOP when you see the column of bullets fall suddenly. Make a note of this position. Now turn the dropper another 1/2 turn or so to give a slight amount of overtravel. Hand tighten the locknut to hold this position. The dropper should now be adjusted properly, but it's a good idea to check a complete cycle, so raise the handle of your press. A bullet should now be sitting on the brass case.
- (5) Remove the bullet from the case, re-index the case underneath the bullet dropper and again slowly lower the handle. The empty case contacts the foot of the dropper and begins to operate the bullet release mechanism. Somewhere near the end of the stroke, the column of bullets will be released and fall due to gravity. The lowest bullet will be slightly tamped into the case and should now remain in place when you index the press.
Remember, the dropper does not seat the bullets, and it does not work properly with FULL wadcutter.
- (6) Now tighten the locknut a little more, **but don't overtighten it.** Use just enough force to hold the dropper in place. The die body is relatively thin walled, so over-tightening may distort its roundness and cause erratic operation. If concerned about the locknut coming loose, a few drops of low grade thread-locker will hold it in place.
- (7) Reinstall your powder measure. If you find that bullets don't drop consistently, you may need to adjust the dropper height a tiny bit lower. **Note:** Over adjustment is unnecessary. When you reach the end of each downstroke, if the dropper body is rising upward from the threaded die and stretching the expansion spring, you've adjusted it down too far. The dropper body should rise and prevent damage to the dropper foot only when an unexpectedly long case cycles through. The following photos illustrate this safety feature. As you can see, an expansion spring is connected between the threaded die and the middle dropper body section.

Look at the next photo labeled A,B,C,D and E: For example...if your dropper is set up for reloading 9mm and a LONGER case like a 38 supercomp or 9 Largo cycles through, the spring will protect the dropper foot from being damaged. (applies to any unexpectedly long case cycling through... example: shorter 40SW vs longer 10mm, etc.)

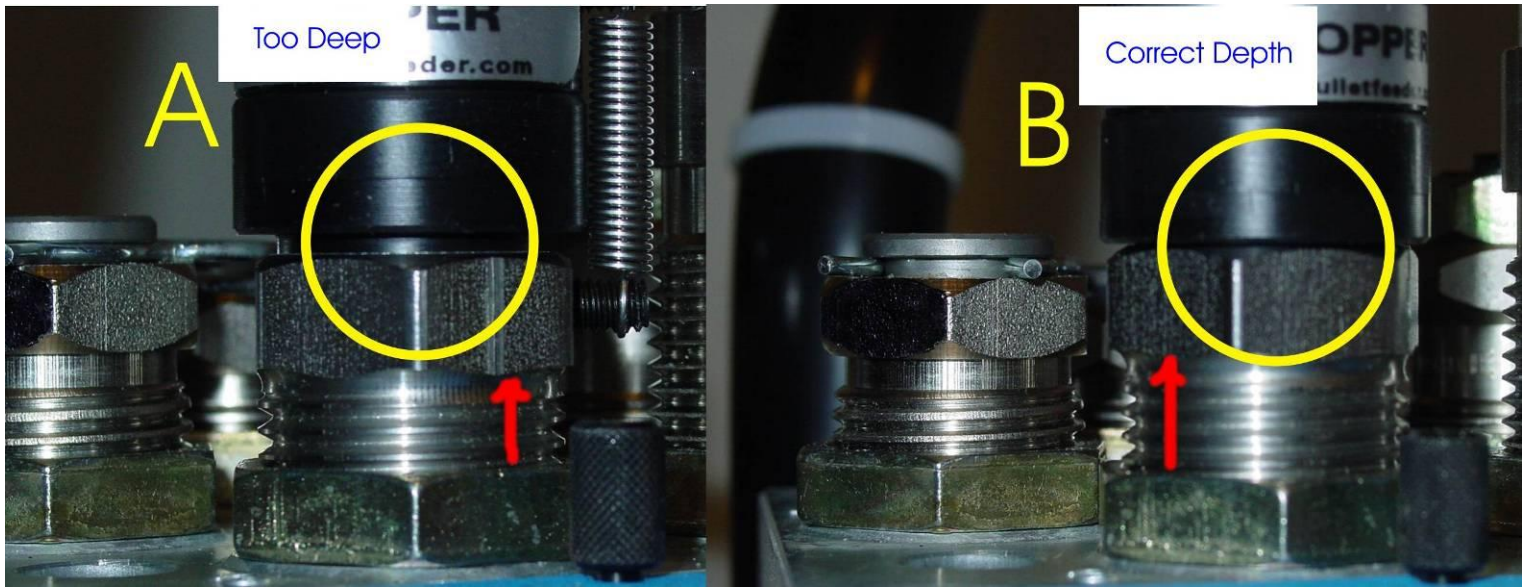
The press in the photo is properly adjusted for 9mm cases. Images A, B and C show the dropper operating normally on a 9mm case. Notice that the dropper body stays held down in position by the expansion spring that connects to the threaded die and the middle dropper body. Two 3/8" long 8-32 setscrews are used to attach the spring. The lower setscrew is only threaded into the die far enough to act as an anchor point. (DO NOT tighten the setscrew since this will prevent the lower dropper body from moving up and down and defeat the purpose of the expansion spring.) The upper setscrew is screwed into the mid dropper body just far enough to act as the other anchor point for the expansion spring.

Images D,E, and F show what happens when a longer case unexpectedly cycles through. When the press is operated, the long case will contact and push upwards on the dropper foot, and as the press handle continues downward, the limit of travel for the dropper foot will be reached...but the press handle has not finished the downward stroke. Image E shows that when the press handle continues to the end of the stroke, the expansion spring allows the dropper body to move upward to accommodate the long case. Without this new feature, the long case would likely cause damage to the dropper foot.



The next photo (labeled A “Too Deep” and B “Correct Depth”) shows how you can use this feature to determine if your dropper height is adjusted correctly for the cases you will be reloading. In reality, either adjustment will work, but Image B shows the correct adjustment. Bullets will drop, but the dropper body will stay in contact with the threaded die throughout the cycle.

Image A shows that the dropper has been adjusted down too deeply. You can see that the lower dropper body has been raised upward from the threaded die when the press handle is fully down. So...*the dropper will work* when adjusted like this, but there will be unnecessary pressure applied to the foot for every round loaded. The expansion spring should only allow the dropper body to rise when an unexpectedly long case is cycled through.



Make sure that the setscrew used as an attaching post on the dropper is not tightened into the threaded die body. As shown in the photo, the setscrew is only screwed in a few turns and used as an attaching post for one end of the expansion spring, and also to act as a guide that prevents the dropper body from twisting in the threaded die body. The purpose of the expansion spring is to allow the dropper body to rise upwards from the threaded body when an unexpectedly long brass case or other object enters the dropper foot. This will help prevent damage to the foot. The other setscrew should be tightened only enough to hold the dropper sections together.



The setscrew is simply used as a post for attaching the expansion spring. It's also threaded slightly into the rectangular slot in the dropper body to act as a guide. Don't tighten the setscrew or the dropper body won't be able to slide in and out of the threaded die body easily.



Other Tips Regarding Dropper Operation...

Use the threaded body that came with the dropper. If you have a caliber conversion, I recommend using the threaded body that came with it. Don't leave one threaded body in the tool head and simply replace the dropper components. Why? During manufacture, dropper components are matched for best fit. Due to slight variations in part dimensions, there is always a possibility that the parts of a different caliber dropper may not operate correctly due to a poor fit. That being said, if you check and find that one threaded body fits well with your different caliber dropper parts, then it's OK use.

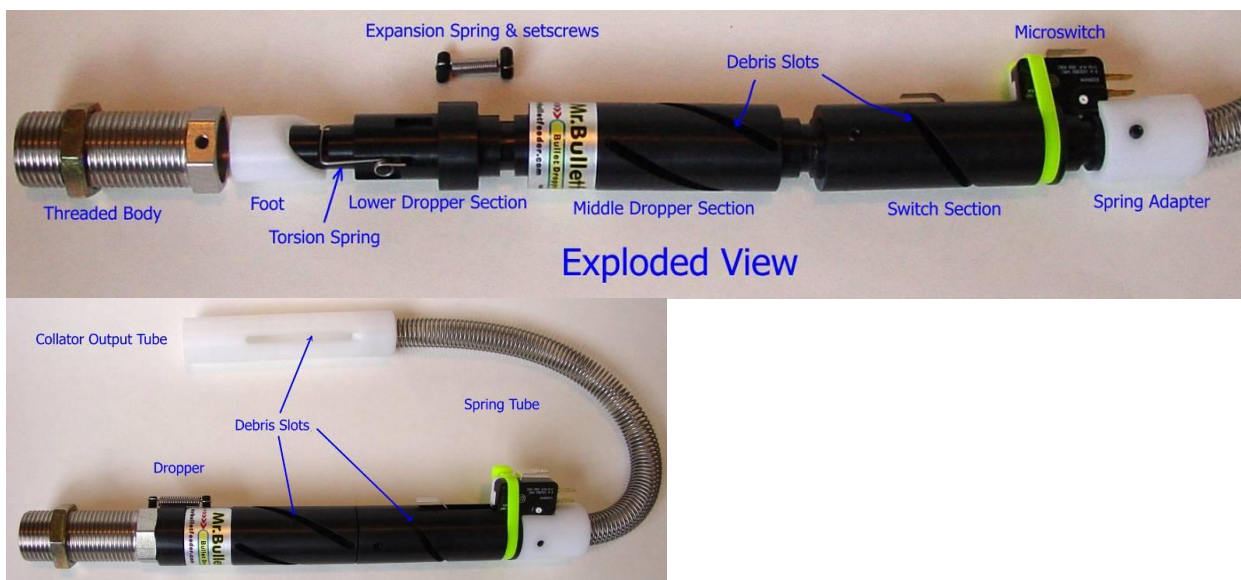
DO NOT over-adjust the dropper. Remember, the dropper does NOT seat the bullets. It simply allows gravity to act upon the column of bullets. When an empty case moves the dropper foot to the release point, the column of bullets falls and the bottom bullet gets tamped into the case. A useful analogy would be...when you squeeze a trigger far enough, the hammer falls and the gun goes BANG! Squeezing the trigger further won't do anything else. Similarly, adjusting the dropper excessively past its release point won't do anything. The column of bullets has already fallen.

DO NOT operate the dropper onto a case that already has a bullet on it. That may sound silly, but people have damaged their droppers when they double stroked their press for some reason. Damage like this is very obvious, since the bullet that is forced up into the dropper will contact the torsion spring and bend it upwards. Also, the end of the dropper tube may become cracked or broken off.

A Few Operational Notes:

The Bullet Dropper was designed to be fairly tolerant of jamming due to foreign material (i.e. tumbling media), but if you ever have a bullet stuck in the dropper body, you may be able to dislodge it via the debris slots. If you try to free the bullet by inserting a narrow rod upwards through the foot, be very careful not DO NOT BEND or DAMAGE the torsion spring. If you find that it's necessary to disassemble the dropper to free the bullet, simply remove the 8-32 x 3/16 setscrew and the dropper components will slide out. When reassembling, make sure the torsion spring rides on the angled portion of the foot. Do not over-tighten the setscrew...just snug it in 1/8 of a turn or so. When cleaning and reassembling the mechanism, lubrication is not required. If you decide to lubricate it anyway, use a dry Teflon powder type spray and use it sparingly.

The modular dropper body sections can be turned as desired for viewing the bullet column, wire alignment, etc. When you have your dropper oriented the way you like, snug up the setscrews to hold position. **Don't overtighten the setscrews**... just tighten them enough to hold position. Over-tightening the setscrews may deform the dropper body enough to cause the bullets to hang up inside the body.



When using the system on a press like the 1050 (where the toolhead moves up and down), mount the collator high enough to avoid forming a “trap” in the output tube. If there is too much slack in the output tube spring, a trap can occur when the toolhead is in the raised position. As bullets fill up the spring tube they will jam in the collator plate... eventually resulting in a blown fuse. **It's best to mount the collator just high enough to avoid forming a trap.** With the toolhead lowered, the output tube spring should be fairly relaxed or perhaps stretched only slightly.



Also, on the 1050, bullet tamping will be improved somewhat by using the swage back-up rod/expander in the swage station. (see photo, above right) You don't need to actually swage the primer pockets if you don't want to... simply remove or disable the lower swage rod. There should be instructions for properly adjusting the swage back-up rod/expander in your Dillon manual. Another alternative: many owners report excellent results by using a Lyman “M” Die for neck expansion instead of the swage back-up rod.

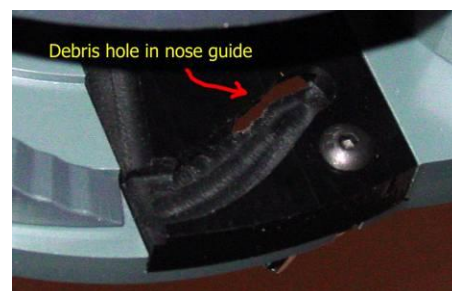
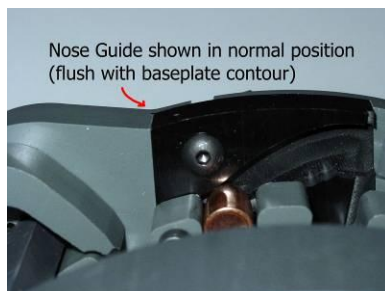
Normal collator operation is as follows: Bullets enter the collator plate slots, either nose up, nose down or partially inserted. As the collator plate turns, partially inserted bullets are knocked back into the pile by the spring-loaded bullet dislodging arm. Nose up bullets simply slide over the exposed ledge of the nose guide and continue to the output tube. When a nose down bullet moves over the guide, the nose falls into the slot and the bullet begins to rotate. Then it rides up the flip ramp into the nose up position and continues to the output tube. With the exception of cast lead/wax-lubed bullets, DO NOT use any lubricants in the collator or on the bullets. (see page 14 for more info)

Adjustments:

The nose guide can be easily adjusted to accommodate various bullet profiles. Adjusting the guide inward will make it easier for nose down bullets to fall into the slot. Adjusting it outward will expose more of a ledge for nose up bullets to slide across. Your collator has been adjusted to operate correctly with most bullet profiles of the caliber you selected, but it's a good idea to check its position in case it was moved during shipment.

For best results, do not overload the drum. Overloading will generally make it more difficult for bullets to fall into the collator plate slots. Filling the drum with no more than approximately 250 bullets at any one time will result in very dependable operation.

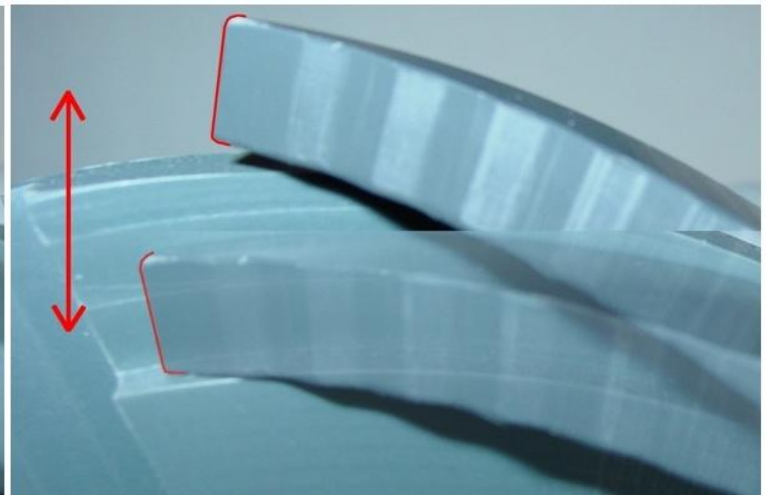
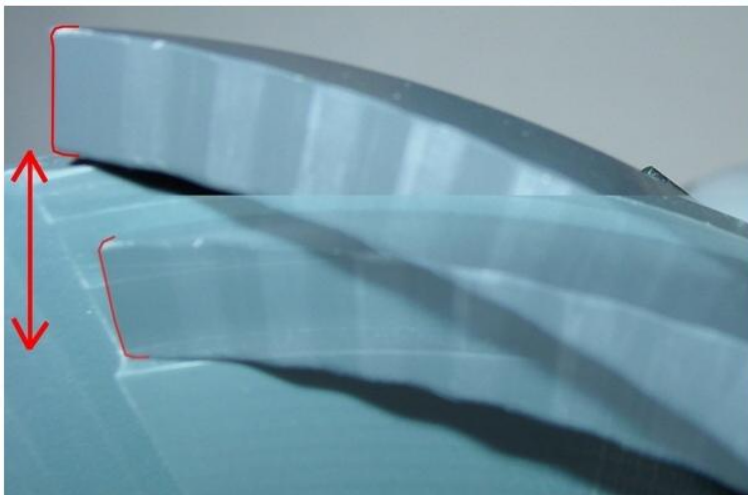
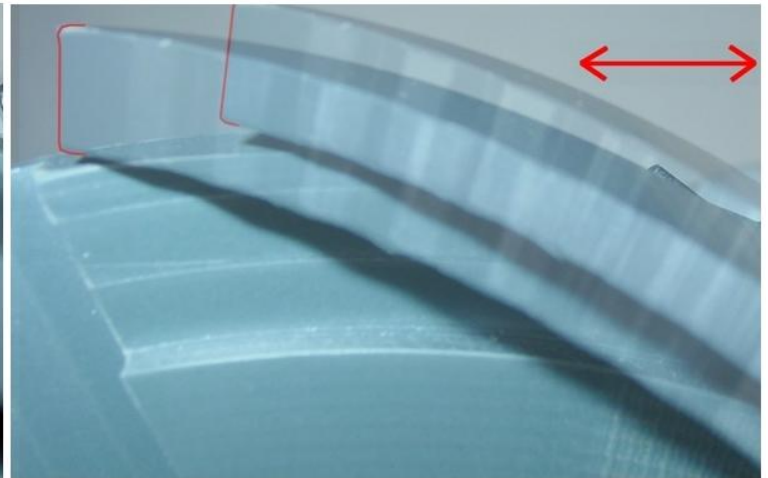
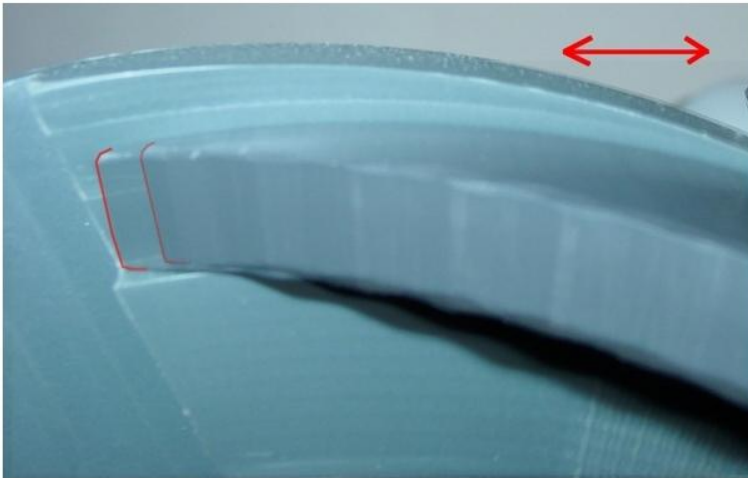
The purpose of the spring-loaded bullet dislodging arm is to knock partially inserted bullets out of the plate and back into the collator. If you wish, the arm can be disabled by inserting a bullet between the arm and the collator tub.



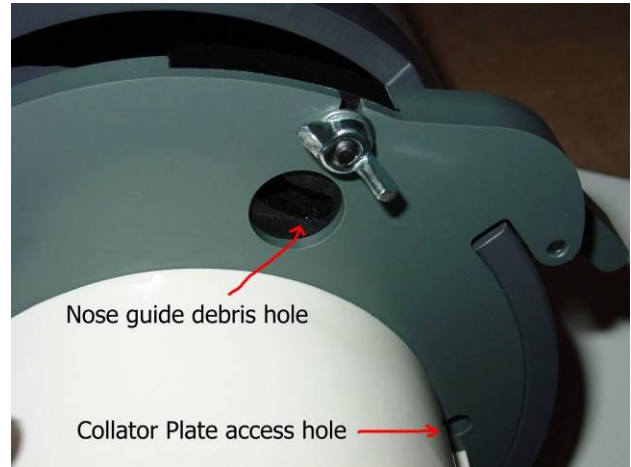
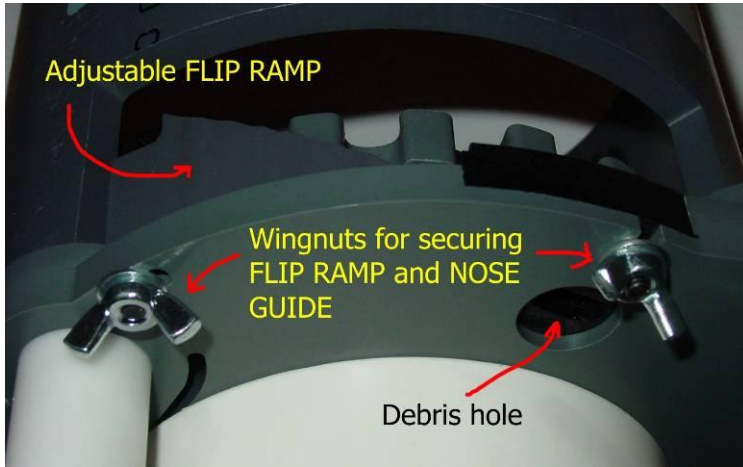
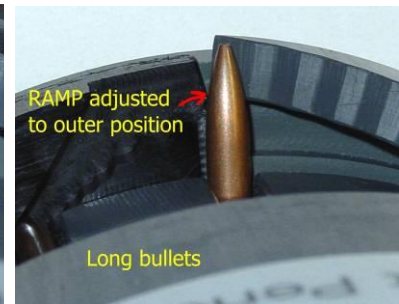
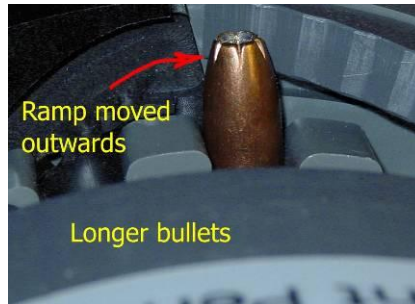
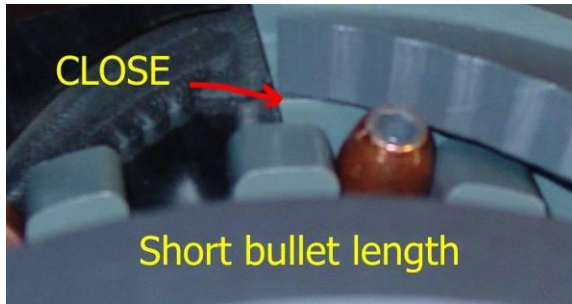
The bullet nose guide is held in place by a wingnut and is easily adjustable. The normal position for the bullet nose guide is flush with the front edge of the baseplate. Most bullet profiles will collate properly with the guide set in this position. The nose of an inverted bullet will drop down into the slot of the nose guide and then be flipped over into the correct position as the collator plate rotates. There is a debris slot in the nose guide which will allow small debris to fall clear of the nose guide slot.

If you haven't overloaded the collator drum and some bullets are being collated upside down, you may need to adjust the bullet nose guide slightly inward or outward, depending upon the profile of the bullet you are collating. If nose-down bullets **don't flip over consistently**, you may have to adjust the bullet nose guide slightly inward. This will allow the nose of the bullet to enter the guide slot more easily. Conversely, if nose-up bullets are flipping to be upside down, you may need to adjust the guide slightly outward. This increases the exposed ledge area of the guide that the flat bottom of the bullet slides over. Find what position works best for the bullet you're using.

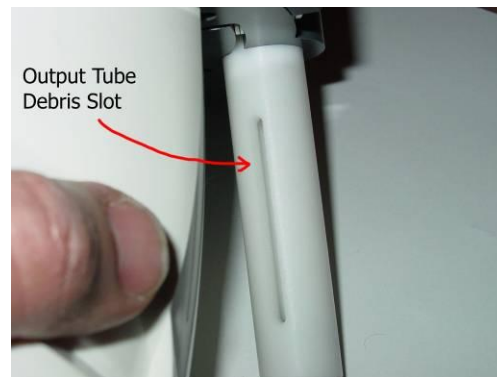
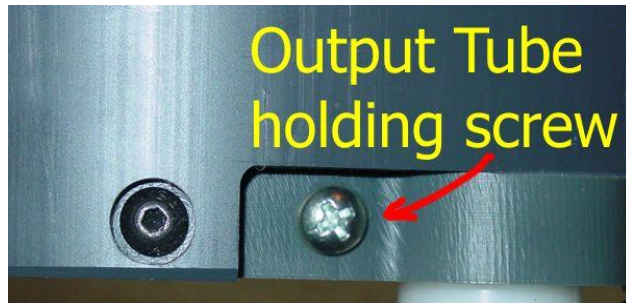
The flip ramp may be adjusted by rotating both inwards /outwards or sliding left / right, as shown in the photos below. The oblong flip ramp slot allows for the left to right adjustment. This offers a range of adjustment that will facilitate flipping bullets of various lengths.



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.

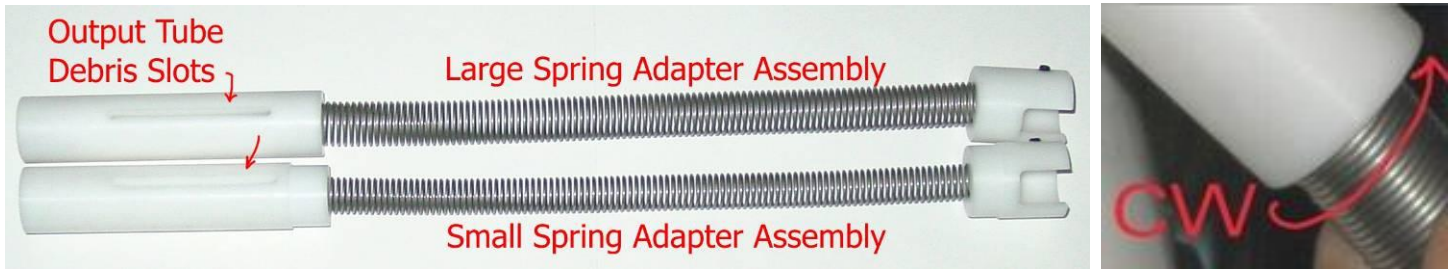


Only a small amount of tightening is required...tighten only enough to firmly maintain position and not fall loose from the collator. Over-tightening is unnecessary. The output guide tube must be adjusted flush with the inside surface of the baseplate. This allows bullets to freely slide down into the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



It is important that both the inside of the collator tub and the collator plate be clean and dry. Also, use only clean and dry bullets in the collator. DO NOT use any lubricants in the collator or on the bullets. The only exception to this concerns cast lead/wax-lubed bullets which require a release agent to prevent wax buildup problems. (see page 14 for more information about this)

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.



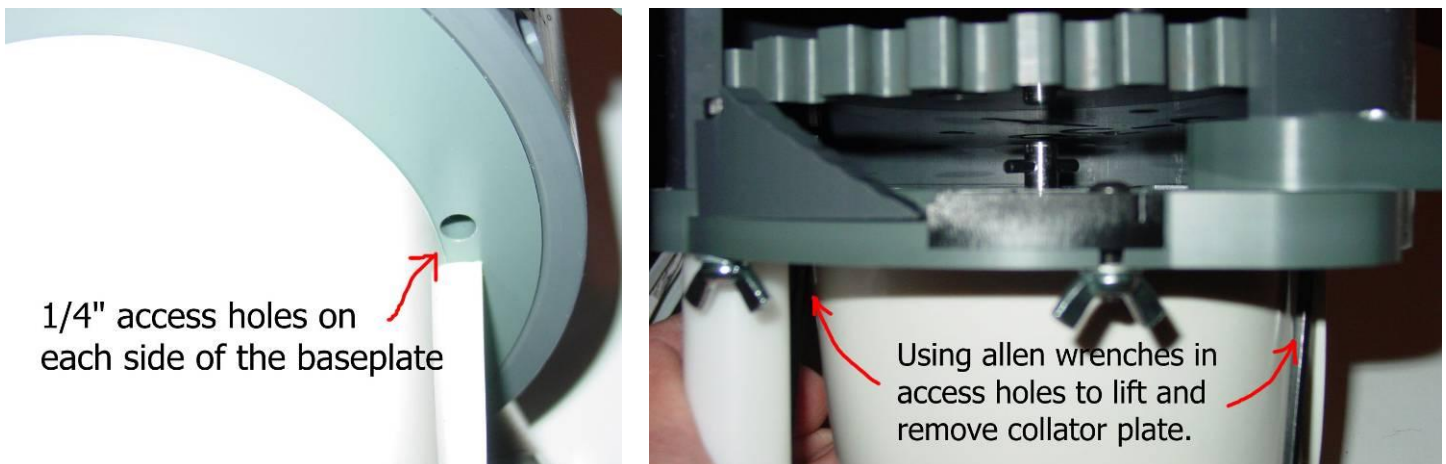
Simply twist the spring clockwise while applying a little force into the hole. The spring will give slightly while twisting and compress enough to fit into the hole. Continue twisting and pushing the spring as necessary until it bottoms at the ridge inside the hole. The spring can be easily removed by 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 can fall sideways into the tube and cause a jam.

The small spring adapter assembly is used with .223 and also can be used with any length 9mm/38cal bullets.

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 long 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.

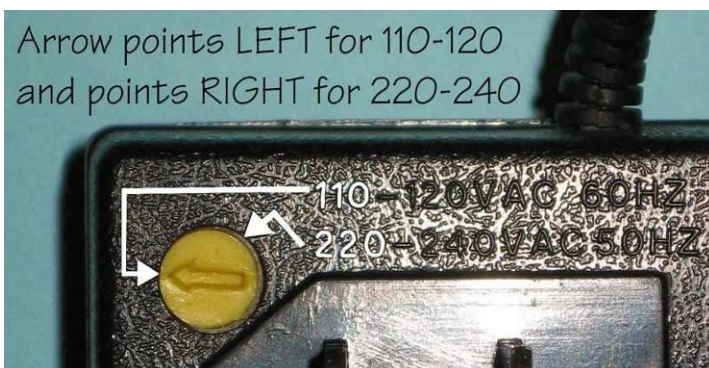
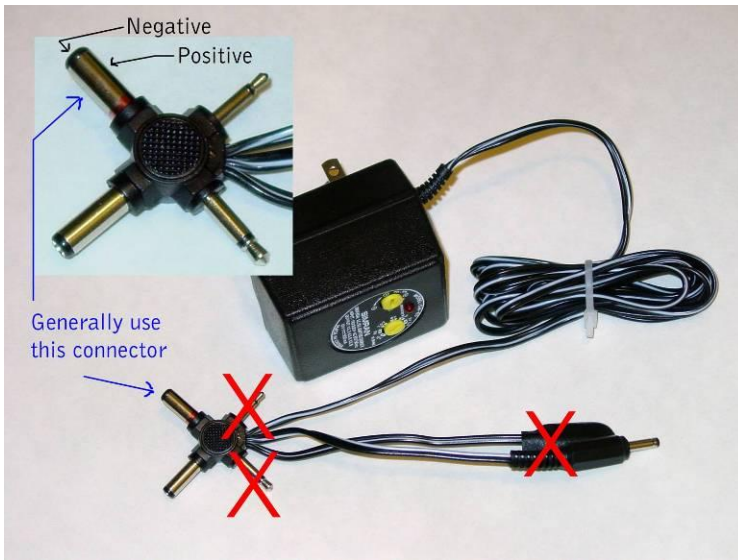


Fig A



Fig B



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 version XL650, the case feeder support tube is angled back and to the right of the press. This allows the Mr. Bulletfeeder® collator to be mounted by using an L- Bracket. The earlier model XL650 case feeder support tube is angled back and to the left of the press (see photos below). In order to obtain adequate clearance to mount the collator you will have to install a pair of 2 ¾” wide spacers between the L-Bracket and the press frame. This will provide the additional clearance needed to properly mount the bullet collator.

On a fixed toolhead press like the 650, the output tube spring simply functions as a guide for the bullets to move from the collator to the dropper. There should be a little bit of slack in the spring tube. Bullets will slide through the spring tube to the dropper easily. If, for some reason, your output tube spring is too short, simply stretch it out a little to create a small amount of slack. On the other hand...if your spring tube is too long and there is excessive slack, the bullets may not slide all the way to the dropper and begin forming a “trap” in the sagging tube. If that happens, you should trim the spring tube a little shorter. After trimming, file the inner end of the spring tube to remove any burrs. Bullets sliding down the tube can “catch” on a burr and cause bullets to fill the tube, resulting in a collator jam.

Note: the .223 caliber dropper is one section taller than the handgun and .308/30-06 droppers so your output tube spring will have to be a little shorter to account for the extra height of the dropper.

The L-Bracket mounts directly to the frame of the newer version 650. Since the casefeeder support tube on the early version 650 angles back and to the left, spacers are required between the L-Bracket and the frame.



Also notice that when setup for reloading 223, a shorter output tube spring will be needed. This is due to the fact that the 223 dropper is one section taller than the handgun caliber droppers.

Mount the L-Bracket and stand to the newer version XL650 press by using the 3” x ¼” bolts. Use the 6” x ¼” bolts and spacers to mount the L-Bracket to an early version XL650.

RL-1050 / Super 1050 Mounting Method:

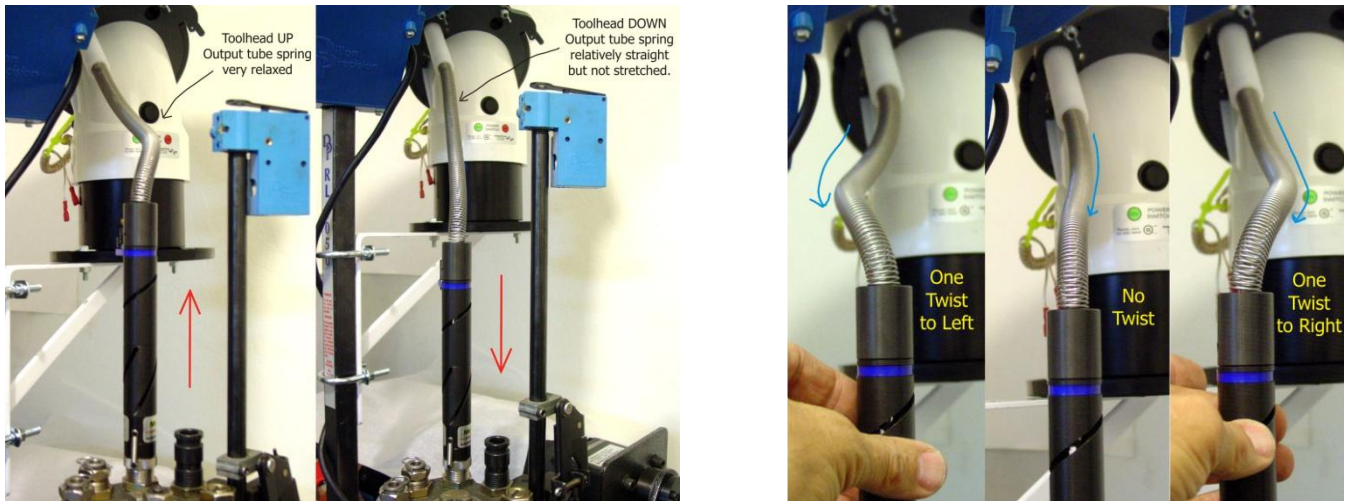
Mount the L-bracket to the case feeder support by using the supplied U-bolts, as shown in the photo.

Adjust the collator L-bracket height with the toolhead fully DOWN, bullet dropper mounted in the toolhead, and the output tube spring connected to the bullet dropper.

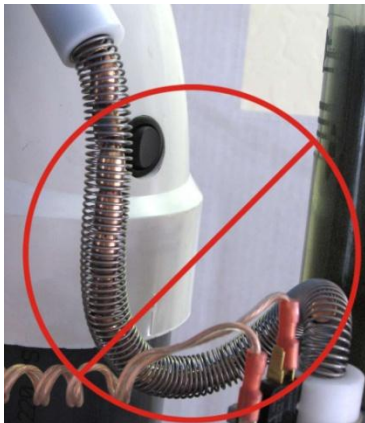
During operation, as the toolhead moves up and down, the output tube spring serves as a flexible conduit to deliver bullets to the dropper. When the toolhead is fully DOWN, the output tube spring should become relatively straight, but NOT stretched tightly. Too much tension will overcome the bullet dropper expansion spring and pull the dropper body upwards from the threaded body...resulting in erratic dropper operation.

When the toolhead is moved fully UP, the output tube spring will become somewhat slack and curved. This is normal... but if the output tube spring is excessively slack (forming a “trap” shown in the photo below, you may have to raise the collator mount slightly to minimize some of the slack. Another method that may work would be to twist the switch section one turn. This will cause the make the output tube spring to form into a slight curved shape and minimize some of the slack.

You should be able to find a “sweet spot” where the output tube spring is not too tight with the toolhead down and not too loose when the toolhead is up.



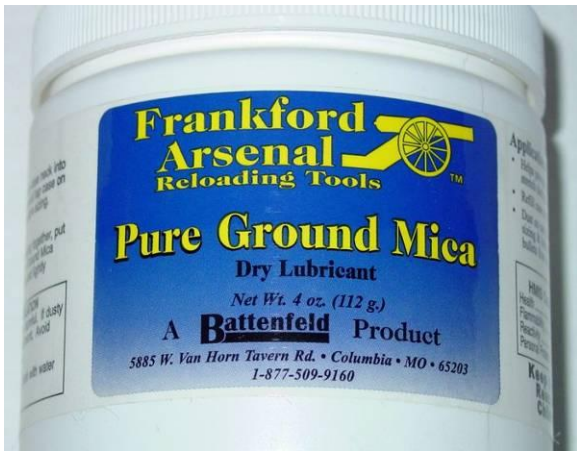
NOTE: Whenever using the .223 dropper on a 1050, you'll need to raise the collator mount approximately 3 ½ to 4" since the .223 dropper is one section taller than a standard height dropper.



< This photo shows a collator mounted too low and illustrates how bullets can become trapped in the output tube spring with the toolhead UP.

The spring will fill up and eventually cause the collator plate to jam. If this happens, turn off the power switch and clear the jam. If the collator is jammed for too long, the fuse is likely to burn out and need replacement.

Cast Lead / Wax-Lubed 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. The wax build-up can possibly cause erratic operation, and will require more frequent cleaning. Many 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. (I've even heard that some users spray non-petroleum based "tire shine" type products or Armor-All on the bullets to act as a lubricating agent.)

< By using a short piece of plastic or copper tube you can empty 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 bit 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.

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.

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

Do not make any modifications to the collator or dropper. This may void your warranty.

Comments or testimonials about your new Mr. Bulletfeeder ® system are welcomed.

Sincerely yours,

Rick Koskela

SALES AND SERVICE CONTACT INFORMATION

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