



AUTOMATIC DECAPPER

Operating and Maintenance Manual

PLEASE READ THIS MANUAL BEFORE YOU USE THIS MACHINE

(OR CALL / EMAIL ASKING FOR TECHNICAL SUPPORT).

We are always happy to help if you have any questions, but it is nice to know you have read this first. Please use the same terminology that is used in the manual. It will help us to understand what the issue is.

All brass processing or reloading activities come with risks including health, environmental or personal physical risks. The owners and users of this Decapper acknowledge and accept the Rollsizer.com Pty Ltd terms and conditions of sale. A copy of the terms and conditions are available on the Rollsizer.com website.

The Automatic Decapper is designed for the small to medium personal reloader. It is not designed for commercial operations and is not warranted for commercial or unattended operation. The Decapper will process cases between 380ACP up to 308Win and only requires minor changes to the speed and using the appropriate drop tube and shuttle to change calibres.

The Decapper has been designed for use with the supplied FW Arms Universal Decapping Die and the small decapping pins. The Decapper will NOT work with large pins. You can damage the Decapper if you try.



*All products are patent pending

The FW Arms Decapping Die uses a mix of standard parts (body, cap, springs and pins), and non-standard parts (guide rod and longer pistol case shuttle). Using decapping dies other than the one provided is not likely to work.

It is expected that at some stage you WILL break pins, and occasionally guide rods for a variety of reasons (rocks, dirt, nestled cases, Berdan primed cases etc.) and with extended use (or abuse) you will break or wear out other parts on the Decapper. We have provided several spare parts as standard. Replacement parts will be available from Rollsizer.com or FW Arms shortly.

Abuse and unmonitored operation are specifically excluded from warranty claims. We will make replacement parts available for those who have managed to break parts, but these are genuinely rare occurrences (aside from the pins and guide rods).

Yes, the Decapper motor will get warm especially when new / running in. The motor and gearboxes will often get up to 75Deg C (167F), especially when new. This is normal. The plastic components have been designed for the motor / gearbox temperatures and will not be affected. At slower speeds the Decapper will have a high frequency whine, this is normal and does not affect the operation.

It is expected the gearmotor will take time to wear in, this will mean the Decapper will run slightly slower initially and stall more readily in some situations.

Operating and Maintenance Manual

Contents

Introduction.....	4
Safety First	5
Disclaimer	5
1. Why Decap cases separately?	6
2. What is the health risk from Lead?	6
3. What is supplied with the Decapper?	7
4. Decapper Operation	8
5. Decapper Location – Where to place it?	10
6. FW Arms Decapper installation	11
7. Power Supply and Motor	13
8. Switch operation.....	15
9. Casefeeder and Connecting Hose.....	15
10. Processing Rates	17
11. Calibre Conversions	17
11.1 Pistol conversions	17
11.2 Rifle conversion process	18
11.3 Calibre conversion process	18
12. Maintenance Requirements	19
13. Pre-Start Checks.....	20
14. Gearbox and Motor Maintenance	21
15. What tools do I need?	21
16. Decapper FAQ's	21

Operating and Maintenance Manual

Introduction

The Decapper you have purchased will supply years of reliable operation if the processes and safety procedures in this manual are followed.

The Decapper has been designed to remove spent / fired primers from lightly soiled or clean fired cases to allow cleaning / processing or reloading as required.

Please ensure you read this manual from start to finish BEFORE you use the Decapper. Please pay attention to the following key points.

- The Decapper is not designed for unattended operation and should be monitored at all times.
- Only fired cases with spent primers should be used in the Decapper.
- The following are considered consumables and are not covered by warranty
 - Wear on the stainless-steel base and plastic pegs / spring.
 - Wear in the spherical bearings, (these require grease).
 - Any damage to the pegs, spring, and case pusher from jammed cases.
 - Damage to the Decapper mount from repeated jamming or incorrectly adjusted decapping dies.
- Loaded ammunition or cases with live primers should never be processed or used in the Decapper under any circumstances. Serious injury or Death could result.
- Check the drop tube height is adjusted before using the Decapper, refer to the manual below.
- Fill the feed tube **BEFORE** starting the Decapper.
- The last case in the Decapper will need to be removed manually, use long nose pliers.

Operating and Maintenance Manual

Safety First

Please note that with all machinery, safety is critical. Do not allow inexperienced users to operate this machine and never allow children or minors near this Decapper whilst it is operating. Never attempt any sort of work or adjustment on the machine whilst the Decapper is energized or operating. Work should never be done on the Decapper unless the power supply is turned off and the power lead is unplugged from the power supply.

Failure to do this could result in significant injury or death.

In addition, you should never process reloaded ammunition or cases with live primers through the Decapper, if the ammunition or components are ignited, there is significant risk of injury or death as a result.

Disclaimer

The purchaser and users of this machine expressly acknowledge and hold harmless, RollSizer.com Pty Ltd, its affiliates, associates, and resellers (hereafter noted as RollSizer.com), from all liabilities including loss of income, injury, harm or death for the use of the Decapper and any actions that the use that the Decapper may have. RollSizer.com make no claims or guarantees regarding the suitability of the processed cases for reloading or any other use and it is the responsibility of the user to verify the suitability and purpose of the finished product.

All Decappers are sold subject to the Terms and Conditions on the RollSizer.com website.

- ❖ When you see this symbol, we will provide suggestions that will assist in installing / setting up / operating your Decapper.

Operating and Maintenance Manual

1. Why Decap cases separately?

Decapping cases in a separate stage allows the primer pockets to be cleaned inside and out including the primer pockets and this results in several benefits.

- Reduced maintenance on reloading presses due to the primer pocket contaminant jamming up the reloading press or sensors.
- More consistent primer seating during reloading.
- Lead exposure is reduced.
- Faster cleaning and processing without the need to clean your cases before you decap as you would normally do with traditional reloading methods.
- Soiled cases are kept separate from your expensive press and equipment.

2. What is the health risk from Lead?

The ammunition used by the majority of manufacturers and reloaders contains lead products in the bullets and primers. Lead residue is often found any time there is handling of reloading components. Traditional dry media cleaning results in air born dust and this brings lead exposure. Wet cleaning removes a lot of this risk.

“Exposure to high levels of lead may cause **anemia, weakness, and kidney and brain damage**. Very high lead exposure can cause death. Lead can cross the placental barrier, which means pregnant women who are exposed to lead also expose their unborn child. Lead can damage a developing baby's nervous system”. Ref WWW.cdc.gov website.

The RollSizer.com Decapper offers the ability to decap lightly soiled cases and wet clean the cases inside and out in one step.

- The soiled cases and primers are contained in the discharge tubes / buckets.
- The Decapper allows cases to be mixed (within limits) and minimizes the handling of soiled and contaminated cases.

Operating and Maintenance Manual

- Reduced handling and processing times.

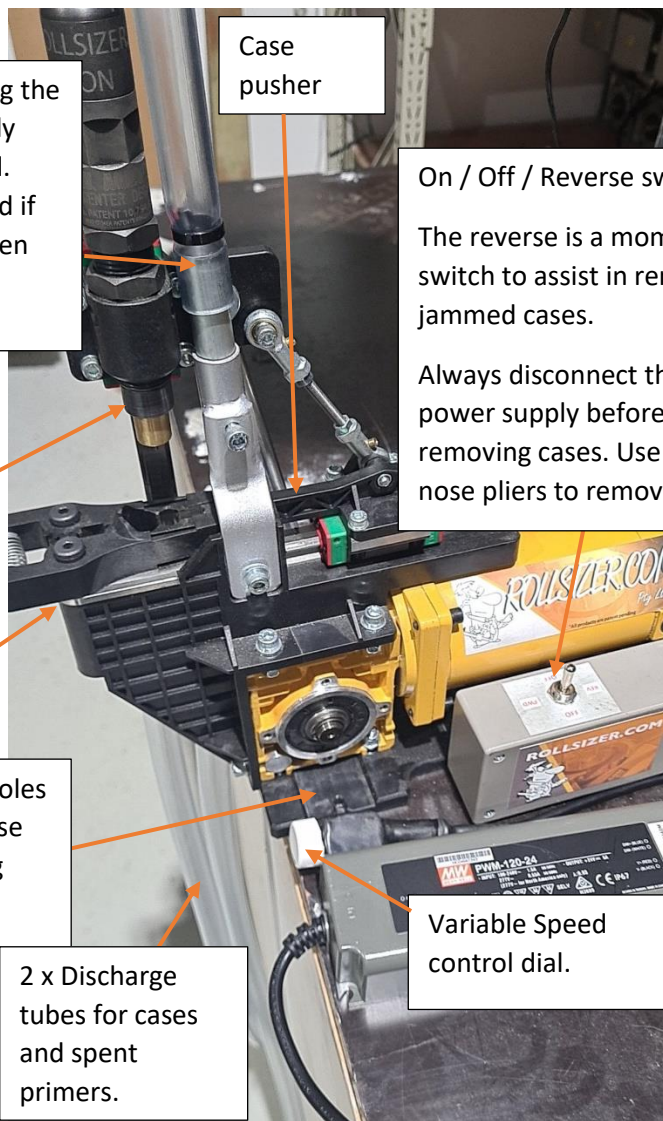
3. What is supplied with the Decapper?

The Decapper will generally be supplied with the following components in addition to the drop tubes and additional spares purchased with your Decapper.

1. Your Decapper is supplied with a custom FW Arms Decapping Die Assembly. You will need to install and adjust the Decapper as detailed in the supplied instructions from FW Arms AND the process described in this manual.
2. The following is supplied with the Decapper as standard
 - a. This manual. Updated manuals are available online.
 - b. 1 set of self-aligning “pegs” and spare spring.
 - c. Length of 16mm (5/8”) ID vinyl feed hose with a Dillon casefeeder adaptor fitted on one end and a cable tie for the drop tube on the other end. This is the feed hose.
 - d. Length of 16mm (5/8”) ID Vinyl hose to be used to control the cases feeding into a bucket (or similar) and for primers. The customer can cut the hose to suit.
 - e. Universal Power supply suitable for 100VAC to 277VAC supplies. The power supply brick is supplied to the market with an Australian power plug and depending on your location a plug adaptor. You may need to purchase a plug adaptor to suit your location. These are available from most electronic and travel stores.

Refer to photographs below identifying the main components of the Decappers.

Operating and Maintenance Manual



Drop tube showing the feed hose correctly positioned / fitted. Trim the **other** end if you need to shorten the hose.

Case pusher

FW Arms Decapping Die

Self-aligning pegs

Mounting holes to screw base to reloading bench. (4 places)

2 x Discharge tubes for cases and spent primers.

On / Off / Reverse switch.

The reverse is a momentary switch to assist in removal of jammed cases.

Always disconnect the power supply before removing cases. Use long nose pliers to remove cases.

Variable Speed control dial.

4. Decapper Operation

The Decapper operation is generally as follows.

Operating and Maintenance Manual

Note: Cases do not always need to be sorted perfectly. However, some case combinations can be a problem as they can nestle within the other case and jam in the drop tube. This will result in nuisance jams and potentially damage to the decapper.

1. Remove rocks, debris, and other contaminants from the fired cases (light soot and soiling on the cases is acceptable).
2. The cases are fed from a casefeeder though the supplied feed hose.
3. Cases fall into the drop tube which allows individual cases to be control fed into the case pusher.
4. The motor operation lifts the Decapper housing (moving up and down vertically) while the case pusher moves horizontally backwards and forwards.
5. As the case is pushed into position it will “snap” into the decapping position. This position is self-centering.
 - ❖ It does not matter if the case is a small 380ACP or a 44mag case. The primer position is the same.
6. As the motor turns, the case pusher arm pulls back, and the decapper lowers onto the primer to push out the primer. The primer will come out with an audible “SNAP”. This noise is normal and is useful to identify if the primer pin is broken.
 - ❖ We recommend you process cases in small batches so if you miss identifying a broken pin you will not have to redo large volumes.
7. As the primer is being removed, another case falls in front of the case pusher.
8. The motor continues to turn, the decapper body lifts, and the new case is pushed into position. As the case moves into position it will push the previous case out.
9. As the case is pushed out the pegs will “snap” and will be thrown into the drop chute.
 - ❖ In certain case types the processing speed will need adjustment (up or down) to prevent the cases bouncing around too long in the drop hole.

Operating and Maintenance Manual

10. When the case supply has run out the last case will not be pushed out. To remove this case, park the decapper so there is sufficient clearance above the case to allow the case to be removed.
 - ❖ We STRONGLY recommend you use long nose needle pliers to remove cases. DO NOT PUT YOUR FINGERS IN THE DECAPPER unit ever. Serious injury could result.

5. Decapper Location – Where to place it?

The location of the Decapper requires some thought and planning BEFORE you fit / cut the hoses. Please consider the position of the casefeeder and where the primer tube and decapped cases will be routed.

- ❖ Place the Decapper on your bench as a trial and look at the underside of the machine. You will see 2 tubes coming out. These will have tubes connected to them and need to clear the edge of the bench. Think about where the tubes will go and how easy it will be to remove the primers from the tube. The spent primer hose can be sealed with tape or plugged.

In most applications, the hoses for the deprimed cases and spent primers do not need to be clamped to the discharge tubes. Simply push them on.

The tube is supplied coiled in the box and will often want to stay that way. Running (and holding) hot water in the tube for a few minutes will allow the tube to relax and straighten out.

- ❖ It helps if you knead the hose whilst it is hot and hang it vertically whilst it cools.

The decapper machine is fitted with 4 places where hold down bolts or screws can be used. Refer to the photos in this manual.

In normal operation, these will not be required, but if you place it in a position where it can get knocked off the bench, then screw it down.

Operating and Maintenance Manual

- ❖ If the decapper falls off your bench onto concrete, you will break things. We can supply replacement parts if required (but they will cost you if you break them).

6. FW Arms Decapper installation

The FW Arms Decapping Die supplied with the decapping machine is a proprietary product that has been modified to suit the RollSizer.com automatic decapping machine. **It is not a standard FW arms decapping unit.** The installation of the decapping unit must only be done with the decapper linkage shown in the position shown in the photo below. This ensures the decapper body will not touch / crush the pegs in its lowest position.

Failure to follow this procedure will break or damage the pegs or the decapper body. This is NOT a warranty claim.

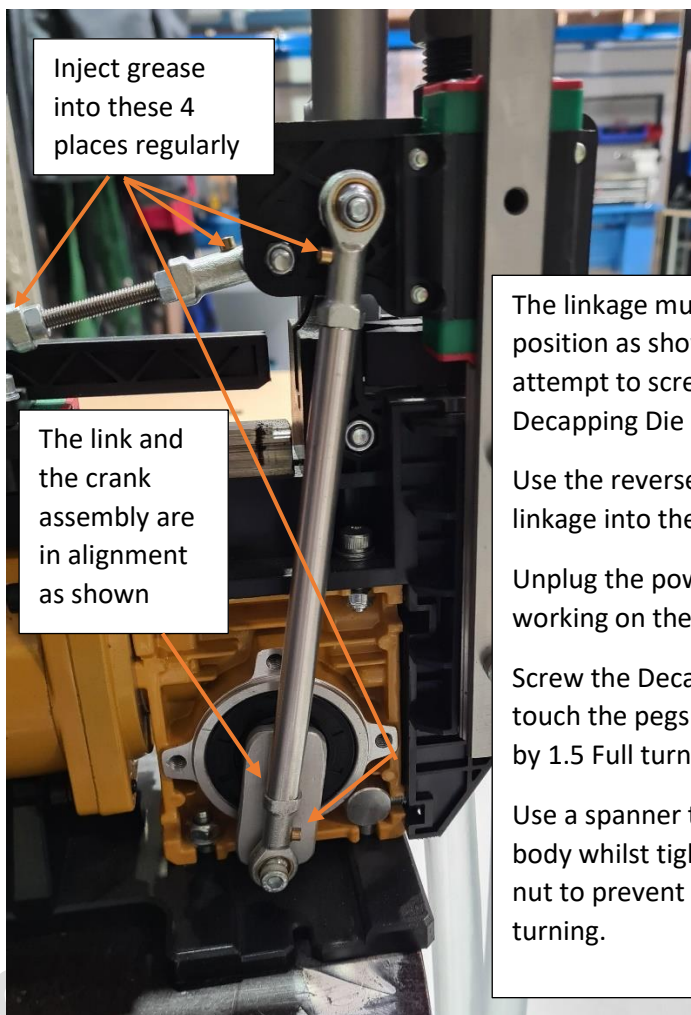
The decapper will only work with Small Pins. Using the FW Arms large pins will result in the cases jamming on the pin and being pulled up and out of the pegs.

Please read the Instruction and Installation Manual supplied with the FW Arms Decapper. The manual explains the safe pin removal / replacement procedure. The supplied decapper parts include specialized spanners to remove broken pins and a spare guide rod. Pins should be finger tight only with the locktite and left to set for a minimum of 1 hour before use.

YOU MUST USE MEDIUM STRENGTH LOCKTITE ON THE PINS. WITHOUT LOCKTITE THEY WILL UNSCREW AND BREAK OFF IN THE GUIDE ROD OR DAMAGE THE MACHINE.

Some cases such are made with very small / undersized flash holes. These cases may pull up on the decapping pin. Some minor adjustments are possible in raising or lowering the decapping body BUT some cases are known to be a problem such as NORMA and some cases using lead free primers. **This is not a fault of the machine.**

Operating and Maintenance Manual



Inject grease into these 4 places regularly

The link and the crank assembly are in alignment as shown

The linkage must be placed in the position as shown BEFORE you attempt to screw the FW Arms Decapping Die down.

Use the reverse switch to bump the linkage into the lowest position.

Unplug the power supply before working on the Decapper.

Screw the Decapping Die down to touch the pegs and then back out by 1.5 Full turns.

Use a spanner to hold the Decapper body whilst tightening the locking nut to prevent the body from turning.

- ❖ Before you install the FW Arms Decapping Die, we recommend you get familiar with the decapper operation with the adjustment of the drop tube and how the cases move and behave when the move through the machine. This will save damaging the machine and save you a lot of time.

Operating and Maintenance Manual

Greasing the bearings is best done with a cheap bicycle grease pump similar to the one in the phot below. A single pump per grease point with generic bearing grease is sufficient. These are about \$15 - \$50 from a variety of online stores. The internet is great to find these cheaply.



7. Power Supply and Motor

The Decapper is operated with a Pulse Width Modulated (PWM) variable speed controller with built in overload protection. It's a very high quality unit.

The motor speed is controlled using a dial controller attached to the power supply. Rotating the dial will increase or decrease the speed. The power supply operates with a soft start operation. At some speeds the motor may exhibit a high frequency Whine.

- ❖ Aside from the whine being annoying, it does not affect the operation and is normal.

The power brick is a universal power supply and can accept all power supplies between 100VAC to 277VAC as well as 50-60hz. The power supply is fitted with an Australian plug as standard. Adaptor plugs will be provided for USA (3 pin) or European (2 pin) customers. Other customers may require an adaptor plug. These are commonly sold at electronics or travel stores.

Operating and Maintenance Manual

If the power supply is on and connected to the Decapper and the switch does not operate the Decapper, please check the connections and the plug is fully inserted first. If this does not work, then do not use the Decapper and consult with your reseller in the first instance or RollSizer.com via info@RollSizer.com.

The power supply brick is designed to switch to a safety mode called “Hiccup” in the case of a jam. The hiccup mode is essentially a rapid start / stop operation. If this occurs move the switch to the off position, clear the jam and then restart normally.

If your decapper goes into “hiccup” mode on startup, a quick adjustment of the speed controller will stop this. The hiccups will go away once the gearmotor is bedded / run in. This is normal.

The decapper DC motor uses carbon brushes. These brushes occasionally need bedding in to ensure a good contact between the brushes and the motor armature to develop correct torque in the motor.

If your Decapper trips out or stalls repeatedly it may need to be run overnight unloaded to bed in the brushes / gearbox. This is a result of us supplying an oversized gearbox and motor. It will last a long time, but they do occasionally need time to run in.

If the decapper needs running in for a long period, then put an elastic band over the pegs to keep them separated from the case pusher and run the decapper for a few hours. The running in period may need to be up to 12 hours (very rare).

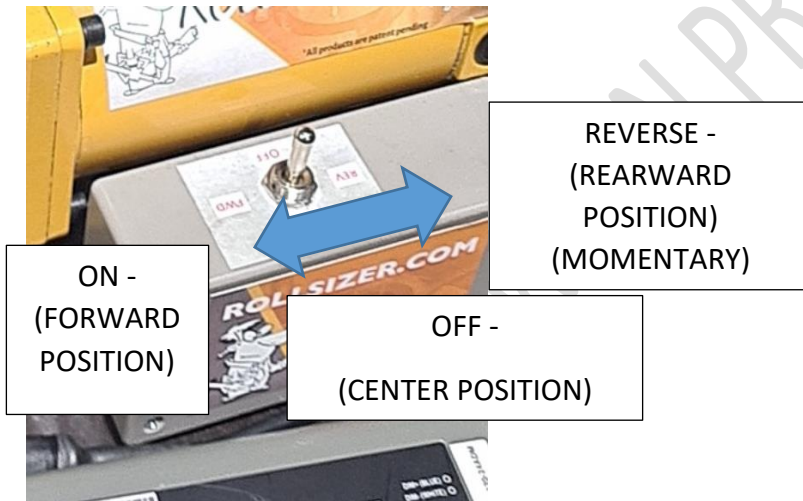
Yes, the DC motors will run warm, especially when new. This is normal and the Decapper can get up to 75 Deg C (167F) when new. The Decapper will cool down significantly after about 30 hours of operation. This is normal.

Operating and Maintenance Manual

8. Switch operation

In the forward position the switch will stay on, the reverse switch will return to off when released.

- ❖ The switch is a heavy-duty unit and should last a very long time. If you allow the switch to “arc” it will burn out the contacts and ultimately fail. Use the variable speed controller to control the motor speed rather than trying to use the switch.



9. Casefeeder and Connecting Hose

The Decapper has been supplied with an adaptor and hose to connect to the standard Dillon™ casefeeder. Refer to photo below.

Operating and Maintenance Manual



The adaptor will clip into the casefeeder where the normal plastic drop tube connects the Dillon™ casefeeder to the Dillon™ reloading press. The flexible Vinyl hose supplied will connect the adaptor clip to your Decapper drop tube.

When the casefeeder and Decapper locations are confirmed, check the route for the flexible hose.

Install the hose end with the cable tie on it on the drop tube end. Run the hose from the Decapper to the casefeeder. Insert the adaptor clip into the casefeeder and mark out where to cut the hose. The hose route should be as vertical as possible, smooth, and clear of equipment, allow some extra length in the hose, mark the hose.

❖ Measure twice before you cut the hose.

To mount the hose onto the adaptor clip, you place the end of the hose in some hot water for approximately 2 minutes and push onto the hose tail barbs whilst still hot. Leave to cool whilst holding the hose straight.

In some situations, the hose will have kinked when it is coiled in the box. The hose can be re-shaped by plugging one end of the hose and filling the hose with hot water and kneading the hose to re-shape the hose as required. After the hose is straight and kinks removed drain the water and hang vertically to cool for 1/2hr.

When not in use, the hose should be hung vertically from one end or left in a flat position to prevent kinks or bends in the hose. If this occurs repeat the process above.

The placement of the cable tie on the drop tube end is required to prevent cases in the hose catching on the end of the drop tube.

Operating and Maintenance Manual

In most cases, the end of the hose where it mounts on the drop tube is not required to be secured, but can be secured if required, using cable ties or hose clamps (not supplied).

10. Processing Rates

The Decapper operating speed will be limited by either the Decapper (typically 2,000 up to 3600 cases per hour) or by the casefeeder performance.

Typical case feed rates from Dillon case feeders are from 1,500 to 4,500 cases per hour depending on their condition and fill amount. Modified / upgraded case feeders will perform significantly better and are recommended for all RollSizer.com machines.

- ❖ **It is critical that you do not try to process cases through the Decapper faster than the casefeeder can supply reliably and consistently. This will result in jams. 99% of the problems can be directly related to this.**

If you are getting jams due to cases not stabilizing in the decapper or not clearing the drop chute, then slow the machine processing speed down.

If you wish to process cases at rates above the capacity of your existing casefeeder, please contact us at info@rollsizer.com.

11. Calibre Conversions

11.1 Pistol conversions

The calibre conversion for a pistol calibre comprises of 3 basic steps.

1. Pistol Shuttle and spring (this is the long one installed in the decapper body as supplied). The shuttle is longer than the rifle and has a specific spring. This is used for all pistol cases.
2. Drop tubes. These are the same as used in the RollSizer.com range of rollsizers. There are different types, (small pistol, large pistol, and rifle conversions)

Operating and Maintenance Manual

- Small pistol drop tube covers 9mm, 38S/SC, 357SIG, 10mm 357Magnum and 40S&W.
 - Large Pistol drop tube covers 44Magnum and 45ACP.
 - Small Rifle covers 300BLK and 223.
 - Large rifle covers 22-250, 243, 308 etc.
3. Drop tube height. The drop tube needs to be adjusted per the photograph below.

If you have mixed cases (say 380ACP in with 9mm) then adjust the drop tube position for the taller of the cases.

- ❖ Some cases will fall / nestle inside others and cannot be decapped together, sorry, we didn't make the case designs so don't blame us. Examples of this include 380ACP, 9mm and 38SC inside 40S&W.

11.2 Rifle conversion process

1. The 223 and 308 cases require a calibre specific rifle drop tubes.
 - ❖ Rifle drop tubes have slots cut in them.
2. The rifle drop tubes need to be aligned so the cases can be pushed out through the slots in the tube.
3. The shuttle and spring inside the Decapping Die need to be changed to the shorter shuttle to allow clearance for the taller rifle cases. (These are in a bag marked as "Rifle Spring").
 - ❖ The pistol shuttle will work for 300BLK and 223 cases but will have a short spring life. It will NOT work for 308 cases.

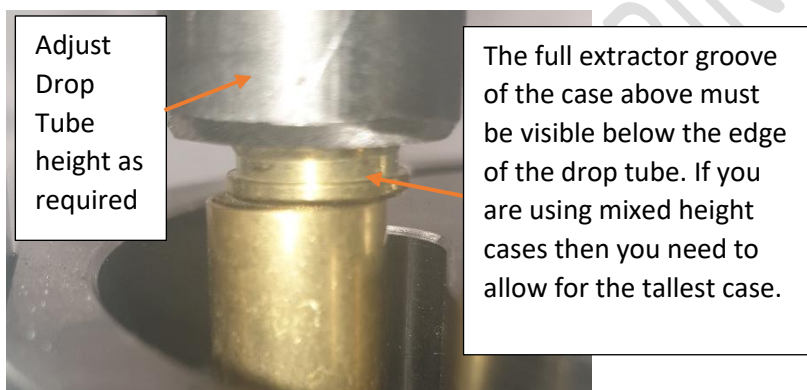
11.3 Calibre conversion process

To change calibres, you need to.

1. Remove any residual cases from the case feeder and from the pegs. Check the casefeeder is empty by running for a short time and listening and checking for any cases in the case feeder or feed hose.
2. Turn off the Decapper and unplug the Decapper power brick from the wall socket.

Operating and Maintenance Manual

3. If the conversion requires the drop tube to be changed remove the drop tube by unscrewing the winged bolt securing the drop tube and replacing it with the required tube.
4. Check and adjust the drop tube height. Drop 2 cases into the drop tube and check the extractor groove of the second case is visible, adjust the height of the drop tube as required. Refer to the photograph below.



5. When the drop tube is correctly positioned for height tighten the wing bolt securing the drop tube and fill the feed hose.

12. Maintenance Requirements

The only regular maintenance required is removing excess dirt and soot and regular lubrication of the linkages and guide bearings. The linkages are spherical bearings with bronze liners. Whilst they have some self-lubrication properties, the bearings will last a lot longer with grease or oil injected into the greasing points on the joints.

The guide bearings should be kept clean from dust and grit and occasionally a drop of oil placed on the rails.

Operating and Maintenance Manual

The Decapper WILL break pins and occasionally guide rods. We recommend you keep a good supply of pins on hand. (Small pins only).

With repeated use and especially with soiled cases being processed, parts will eventually wear. Replacements will be available on the rollsizer.com website.

Should the DC motor trip/ stop working, turn the machine off and let the power block reset (it only takes a few seconds). If the electrical circuit breakers or safety fuses supplying the decapper trip out, please do not use the machine, remove the power lead from the wall socket and ensure the machine is not used, place an "Out of Service" tag on the machine if available and contact your reseller or Rollsizer.com if purchased directly.

Prior to use, all components should be wiped clean, and all traces of oil / grease removed using degreaser and a clean, lint free cloth.

13. Pre-Start Checks

Prior to use, the following checks should be done.

- Visual inspection, check the power lead is in good condition and is clear of any rotating equipment, check the connecting hose is straight with no kinks.
- The Decapper has the correct calibre conversion installed, the drop tube is adjusted correctly and the casefeeder, connecting hose and Decapper are clear of any cases.
- Check the power supply is safe and circuit breakers are functioning correctly.
- The gearbox does not have any oil leaks.
- The switch turns the Decapper on / off / reverse as required.
- The drop tube and flexible hose is clear of rubbish, tumbling media or stuck cases.
- The case feeder has the correct cases for the conversion and is operating in accordance with the manufacturer's manual.

Operating and Maintenance Manual

- Put a few drops of light machine oil on the spherical bearings and guide rails

14. Gearbox and Motor Maintenance

In normal domestic use applications, the gearbox or motor is unlikely to ever require any maintenance. The gearbox is sealed for life and in non-commercial applications is not expected to require oil changes for many years.

The DC motor is fitted with brushes, and these are a normal wear item and are expected to require replacement at after processing around 1,000,000 cases (give or take a few.... lol), replacement brushes are available from RollSizer.com. With normal domestic use the brushes should last for years if not decades.

15. What tools do I need?

Normal operation and adjustment are limited to the drop tube using the wing nut installed on the drop tube holder.

Most bolts on the decapper are M6 or M5 metric socket head bolts and these need a #5 or #4 Allen key respectively (not supplied).

The spanners required for adjusting short linkage is an 8mm and 10mm open ended spanner (not supplied).

16. Decapper FAQ's

1. Can the decapper process dirty cases?
 - A. Yes, lightly soiled cases can be processed through the Decapper, but you need to remove the rocks and debris from inside the cases to prevent damage to the Decapper.
2. Does the Decapper remove crimped / sealed primers?

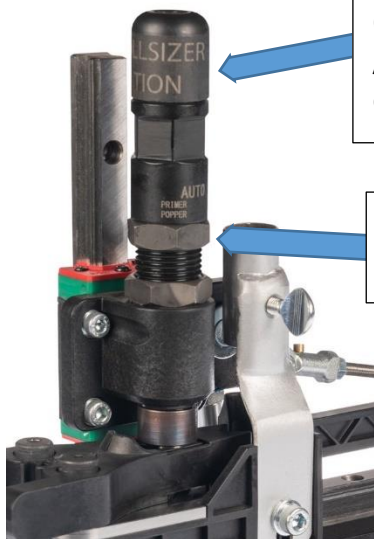
Operating and Maintenance Manual

- A. Yes, the Decapper will remove the majority of crimped primers, in some situation's primers may not be fully pushed out as they stretch. This is not a fault of the decapper. Repeated failure may indicate the decapper body needs to be reset / adjusted but this is very rare. The FW Arms decapper uses a spring to flick off the primers and primer drawback is rare.
3. My cases fall over after decapping and jam the discharge chute.
- A. This usually means the short link between decapper housing and the case pusher needs adjustment. The link is a simple threaded rod. Shortening the link by 1 or 2 turns will push the case into the correct position. The way to adjust the correct position is as follows;
- i. Clear the drop tube of cases and set the decapper to a slow / crawl speed.
 - ii. Place a 9mm case in the drop tube and watch the decapper push the case into the peg.
 - iii. The correct position is when the case does not move forward or backwards when the pegs close. Adjust the short linkage accordingly.
- ❖ Do not overtighten the locknuts on the link and only tighten the pivot bolts hand tight as over tightening may damage the case pusher.
4. How long will the pegs last?
- A. Very hard to say, it will depend upon the degree of soiling / dirt on the cases. The plastic material is a high end engineered material and is VERY hard wearing (it's used as a chute liner for abrasive materials) it will eventually wear out as expected, but we have supplied a spare. Replacements are available online.
5. Why do my Decapper pins keep breaking?

Operating and Maintenance Manual

- A. The Decapper pins will break for a variety of reasons. These are usually from rocks, smaller cases (0.22 cases are common) inside your cases, Berdan primer cases and a few case manufacturers make cases with primer flash holes that are off centre. The decapper machine is accommodating, but there are limits. If you are likely to see Berdan primer cases running the decapper at ½ speed will usually result in the decapper stalling BEFORE it breaks the pins.
 - B. If the primers are not pushed out fully, they WILL tip over and jam the exit chute. In most situation this can be fixed by screwing down the FW Arms decapper by ½ turn. The common causes from this are wet cleaned cases with primers in and not dried correctly, soft pistol primers in crimped cases, 9mm major cases or lead-free primers.
6. How do I replace the guide rod?
- A. The guide rod can be replaced by removing the cap assembly on the top of the decapper body. Please pay attention to the position of the springs etc. Refer to picture below.
7. How do I replace the pistol shuttle for the rifle shuttle and spring?
- A. The shuttles can be removed by unscrewing the middle cap assembly from the threaded body. The shuttle and spring is replaced as a single unit.

Operating and Maintenance Manual



6A. Remove this cap to remove / replace the Guide Rod / decapping pin

7A. Unscrew / separate this section to remove the shuttle

8. The Decapper machine cannot use the heavier / larger diameter pins. The larger pins will jam on the flash hole and pull the cases up with the decapping body.
9. How long will it last?
 - A. Your Decapper is expected to run for years. The limitation will be on how clean your cases are. Extremely Dirty or dusty cases will abrade the Decapper pegs and base and this is NOT a warranty item. Spares will be available from RollSizer.com.
10. My Decapper is stalling on some cases / on startup.
 - A. The PWM power supply uses a “Hiccup” mode as a safety measure. Adjusting the speed controller slightly will prevent this. Most of the hiccups will occur when the gearmotor is new and not run in. This is normal. Once the gearmotor is run in it will stop.
 - B. The DC motor uses carbon brushes. The brushes (and the motor / gearbox) are oversized, this gives a longer life, but means the carbon brushes can take longer to bed in (like running in a new

Operating and Maintenance Manual

car motor), if the stalling / hiccupping is a problem, we recommend running the decapper a minimum of 2 hours unloaded. After this you can decap normally.

- C. In very rare situations additional running in may be required. In this situation, run the Decapper overnight unloaded, (it's a by-product of using an oversized motor and gearbox). We recommend you put an elastic band on the back of the pegs to keep them open whilst running. This prevents wear on the pegs.

11. The DC motor is hot when running.

- A. DC motors run hot normally, especially when new, after running in they will start to cool down (after about 30 hours of operation) at which point they can be considered "run in". The gearmotors will initially run about 65-75 degrees Celsius (167F). They will run cooler (55Deg C -65Deg C) after running in. **This is normal. They are designed for this.**

12. Where can the Decapper be placed?

- A. The Decapper can be placed next to your press OR on the shelf under it. The Decapper is supplied with a generous length of vinyl hose and can be cut to your requirement. The straighter the hose the better.

13. How fast does it operate?

- A. The DC Decapper will process up to 3,600 cases per hour. The upper limit of 3,600 cases per hour rate may only be achieved after running in. We recommend running rifle cases at about ½ speed.

14. I want to size pistol and rifle cases, can you do it.

- A. Yes, the decapper can process multiple calibres but requires the correct drop tube to make it work.

15. How do I know if the primer pin is broken?

Operating and Maintenance Manual

- A. The primer removal will be very audible with a clear snap sound. If you fail to hear this sound, the primer pin should be checked.
 - ❖ We recommend processing in small batches and regularly emptying the cases into another bucket as they are deprimed.

16. I want to be a reseller, can I become one? (Or any other Questions)

- A. Contact us at info@Rollsizer.com.
- B. Please read the manual AND use the same terminology when asking questions. It will help us understand the question better.
- C. Stay safe, keep noisy end down range.