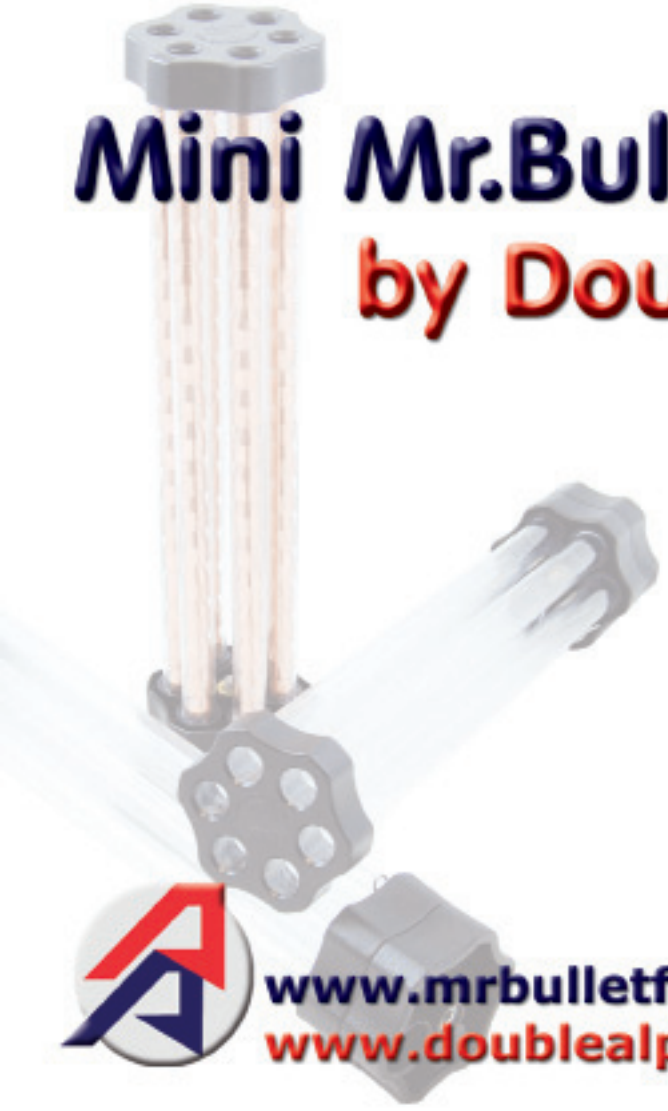
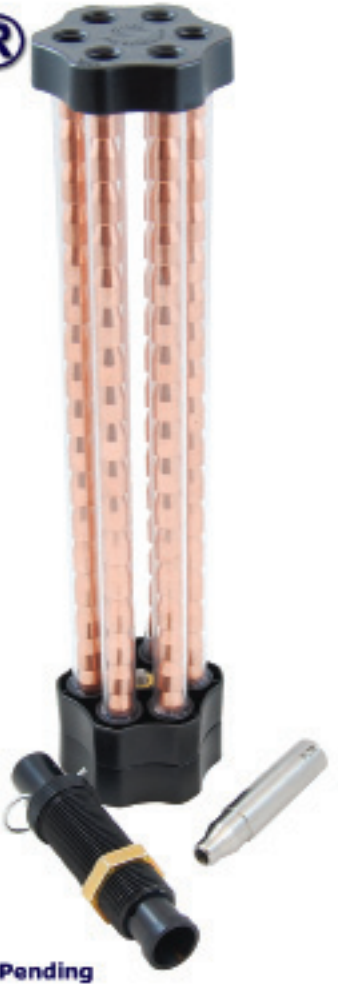
Mini Mr.Bulletfeeder®

by Double-Alpha

User Manual





www.mrbulletfeeder.com

www.doublealpha.biz

US Patents Pending

Mini Mr.Bulletfeeder® by Double-Alpha

User Manual

Thank you for choosing the Mini Mr.Bulletfeeder® by Double-Alpha!

This newly designed product will give you years of reliable service. It will make your reloading sessions easier and faster than ever before!

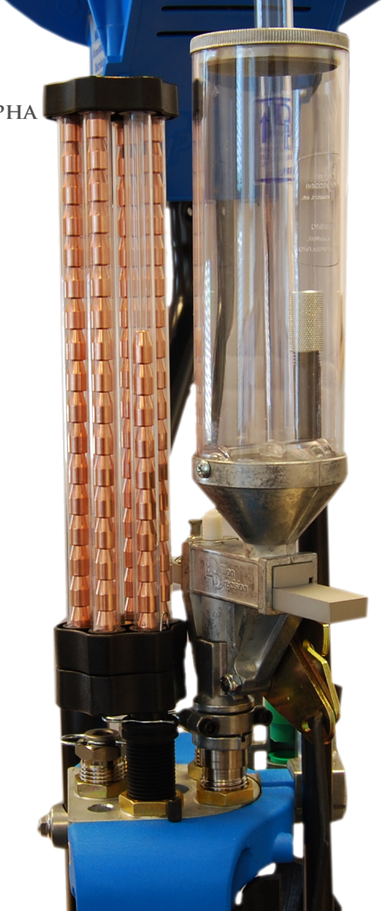
It is critically important that you set up your bullet feeder correctly, so PLEASE take the time to read through this instruction manual before starting to install and use your bullet feeder. You will save considerable time and effort by reading these instructions first.

For further information, please visit our website www.mrbulletfeeder.com. There you can view detailed video tutorials on how to set up and use your bullet feeder. If you have any questions, email us at daa@doublealpha.biz.

WARNING:
Reloading ammunition is inherently hazardous. BE SAFETY CONSCIOUS AT ALL TIMES and ALWAYS USE EYE and EAR PROTECTION. Maintain a sturdy, clean, organized reloading bench.

What's In the Box

Inside the box you will find:
1. Dropper Die Assembly, with extra spare ball-bearings
2. Bullet Tube Assembly
3. Stainless Steel Powder Funnel
4. Instruction manual



Installing and Adjusting the Powder Funnel

Your Mini Mr.Bulletfeeder® is supplied with a newly designed and improved powder funnel. The powder funnel is a very important component of a bullet feeder of any kind, as it prepares the brass correctly so that the bullet can be seated in the case, and not tip over as you index the shell plate. To achieve this, we have redesigned the powder funnel to allow for just the right amount of expansion, without over flaring or stressing your brass.

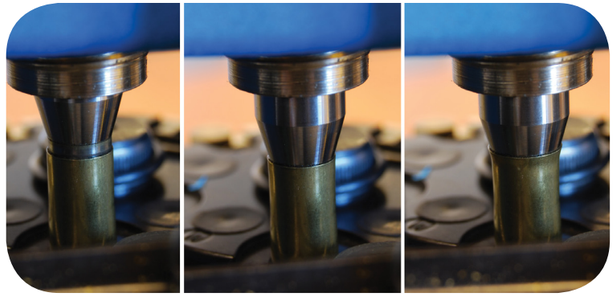
It is recommended that you adjust your powder funnel first, before assembling the dropper die, as you will need properly prepared brass when adjusting the dropper.

Note that our droppers are somewhat shorter than the standard ones provided by Dillon, so you will most likely need to adjust your powder measure die down. It is best to do this with an empty powder measure.

Place a resized brass under the powder measure, and cycle the handle of the machine down. Adjust the die of the powder measure down in small steps until it makes full contact with the brass and is operated fully (charge bar slides forward and backward).

Note how far the powder funnel tip enters into the brass before it is released. You should aim to adjust the funnel down until the top edge of the case just starts to push up onto the tapered section of the powder funnel, achieving a minimum amount of rim flare. In this position, the lower section of the powder funnel has entered into the case, expanding the top just a few millimeters, enough to allow the bullet to sit correctly in the case and not tip over as the machine indexes.

A good test is manually to place a bullet into a case you have cycled through the powder station. With a well-adjusted powder funnel, the bullet should be seated smoothly a couple of mm into the case, and should not fall out easily, even when you turn it upside down.



The picture on the left shows a powder funnel not adjusted far enough down. The funnel enters into the case, but does not go down far enough. The bullet may not be seated deeply enough, and may tip over as you index the machine. The center image shows a correctly adjusted funnel – the case enters up far enough to just reach the chamfered area of the funnel and receive a slight belling. The image on the right shows a funnel set too deep. The case is excessively belled and will fatigue quickly - it may not hold the bullet straight.

The resulting bullet seating of the three powder funnel heights. The left bullet is not seated well, as the funnel is too high – and as a result the bullet is likely to tip over as you index the machine. The middle bullet is well tapped into place, and will remain straight and true as you index. The right bullet shows the result of belling the case too much. The deformation in the case will cause rapid case fatigue, and the bullet may not remain straight as you seat it.

Dropper-Die Installation and Adjustment

Inside the square plastic box you will find the dropper die assembly, the powder funnel, and a set of spare stainless steel balls for the dropper, as per your caliber.

9/.38 uses ball-bearings of 4.5mm
10/.40 uses ball-bearings of 4.0mm
.45 uses ball-bearings of 3.5mm

Since the bullet dropper is generally installed in the station following the powder measure, place a properly prepared case in the shell plate below that station, and cycle the press handle all the way down.

Note: On a Dillon 1050, if you are using a powder check in the station following the bullet dropper, you may need to remove it. It will interfere with the Feed Tube Assembly which rests on top of the Dropper Die.

Make sure the thread in your tool head is clean and lightly oiled. Screw the dropper's threaded body into the tool head for 2 or 3 turns and then fill the dropper tube with bullets, all base down. You can fit 5 or 6 bullets into the dropper die.

Continue to screw the threaded body down until you see that the inner section stops moving down – it has made contact with the rim of the case beneath it. Very slowly continue to screw the threaded body down until you hear and see the column of bullets inside the tube drop down. Turn the threaded body another quarter turn, and tighten the nut by hand. This is the correct height position.

Raise the tool head.

You should see one bullet sitting firmly in the case. Note that the dropper does not seat the bullet to length and only lightly taps the bullet in, so that it does not fall when the machine is indexed.

Do not over-tighten the locking nut! It is not necessary and you may damage the threaded body, which is made of aluminum. Tighten by hand or lightly using a spanner/wrench. There is no force applied to the dropper body during function, so there is no risk of it moving. If desired, a drop or two of low strength Loctite may be applied.

Do a final check by cycling the press a few times. Use your prepared case and 5 or 6 bullets in the tube for each cycle. Confirm that each time one bullet is dropped and tapped into place on the case. Your dropper is now correctly adjusted.

Note that different brass may have slightly different lengths, even within the same caliber. Should you change your brass, you may find you need to adjust both the powder funnel and the height of the dropper for best results.

Dismantling the Dropper Die Body

Should you need to dismantle the dropper die body, do so above a bowl as the small steel ball-bearings inside fall out and are easily lost!

To dismantle the die section, first remove the retention spring. Then the inner tube can slide down and out of the threaded die body. As you slide it down, the three steel ball-bearings will fall out – be sure you are over a bowl to catch them!

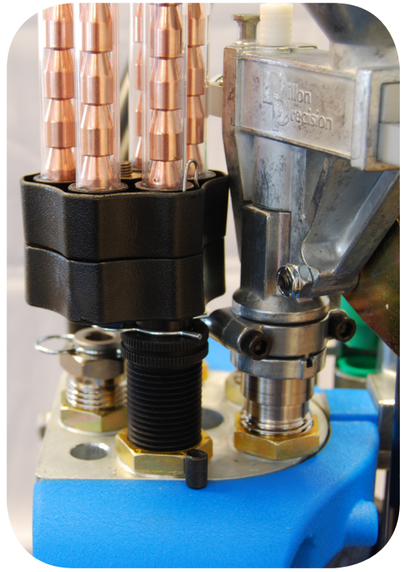
Three extra steel ball-bearings are included as spares. You should not need to dismantle the dropper often.

In the inner tube you will notice two rows of three holes. The lower level is normally only used for very short bullets (perhaps 90 gr 9 mm or very short .40s). It is better to use the upper row of holes as it will allow the column of bullets to drop a little further, thereby better tapping the lower bullet into place. (Rifle caliber tubes may have three rows of holes).

To reassemble, slide the inner tube into the threaded body from below until the row of holes is just visible. Position the three steel balls on the same level of holes (each separated by 120 degrees) and slide it further up until the threaded body retains the balls. Then slip the retention spring back into place. Use the upper groove when using the upper row of steel-ball pockets (normal setup) and the lower groove when the steel balls are positioned lower for very short bullets.

Loading and Installing your Bullet Tube Assembly

Your Mini Mr.Bulletfeeder by DAA is supplied with one fully assembled and ready to use Bullet Tube Assembly. This assembly consists of 6 tubes, and will hold approximately 100 bullets. The precise number will vary depending on the bullet length you are using.



One of the tubes has a steel retention pin close to its base. Align this tube with the hole through the base of the unit. The retention pin will prevent the bullets from dropping out of this tube while you load it up.

Load your bullets manually into the top of the tubes. Make sure you insert all of the bullets base down. It takes only 2-3 minutes to load up this assembly with 100 plus bullets.

If you have purchased additional Bullet Tube Assemblies, you can prepare and preload multiple tube assemblies before starting your reloading session. Much in the same way you would preload primer tubes.
Keep the Bullet Tube Assemblies standing upright, to prevent bullets from tipping out the top holes.
When ready to reload, simply place the Bullet Tube Assembly on top of your pre-adjusted Dropper Die, and seat it into place, then remove the retention pin from the first tube. You will notice the bullets in this first tube drop down into the Dropper Die. You are ready to load!
Rotate the Bullet Tube Assembly way from the powder dropper, so that they do not interfere with one another.

While you reload, keep an eye on the tube. When you see the bullets vanish beneath the level of the base of the Bullet Tube Assembly, reload 2 more rounds to ensure the top bullet has gone lower then the base (you still have 5-6 bullets more in the Die section). Then, simple use your thumb and forefinger to rotate the tube assembly and click the next tube into place.

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