ROLLSIZER.COM

Manual and DC Compact Rollsizer Operating and Maintenance Manual

Patent Pending

PLEASE READ THIS MANUAL BEFORE YOU CALL ASKING FOR TECHNICAL SUPPORT.

We at rollsizer.com are always happy to help if you have any questions, but it's nice to know you have read this first.

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Operating and Maintenance Manual

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Rollsizer Operating and Maintenance Manual

Introduction

The rollsizer you have purchased is a Manual or DC Compact Electric rollsizer that will supply years of reliable operation if the processes and safety procedures in this manual are observed.

The rollsizer has been designed to remove the bulge from the base of the cases, and when combined with a standard full-length sizing die, will result in a smooth and uniform case sidewall.

This combination will offer the best and most consistent overall shape and performance in the final loaded ammunition.

Please ensure you read this manual from start to finish <u>BEFORE</u> you use the rollsizer. Please pay attention to the following key points;

- **Only clean, dry, fired (or deprimed) cases should be used in the rollsizer, no case lubrication is required. Case lubrication will compromise the operation of the rollsizer.**
- **No live ammunition is to be processed through the rollsizer under any circumstances.**
- **Check the drop hose height is adjusted before using the rollsizer, refer to the manual below.**
- **Only use sorted brass in the rollsizer, whilst it is not likely to damage the rollsizer, but you will waste a lot of time picking the cases out.**
- **If you abuse the rollsizers but running the DC Compact for extended periods or for the Mini rollsizer by using overpowered drills, running too fast speed or drills with impact mode on you, WILL damage the rollsizers. This is not a warranty issue.**

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 rollsizer whilst it is operating. Never attempt any sort of work or adjustment on the machine whilst the rollsizer is energized or operating. Work should never be done on the rollsizer 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 as a consequence.

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

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Disclaimer

The purchaser and users of this machine expressly acknowledge and hold harmless Whitehead Specialty Engineering, Rollsizer.com, 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 rollsizer and any actions that the use that the rollsizer 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.

1. Why Rollsize?

Rollsizing is a case processing method that removes the bulges in the base of spent cases and allows the ammunition to be reloaded and reused with a much higher degree of reliability. The ammunition will be more consistent in quality and time that would be otherwise wasted in case gauging and wasting loaded ammunition and components can now be used to shoot.

The shooter / reloader can now consider the option of purchasing bulk “once fired” brass with confidence the ammunition will reliably perform.

2. Why Reload?

The reloading of ammunition is done for a variety of reasons:

- Cost, reloaded ammunition is cheaper than most factory manufactured ammunition.
- Various shooting sports require ammunition to be loaded with specific characteristics, factory ammunition is not usually loaded to suit the specific sport requirements.
- Reloaders will reload once fired or range picked brass and the origin of this brass may be from oversized or unsupported chambers and is required to be resized to meet the appropriate specifications.
- The shooter can control the size, specification and quality of reloaded ammunition to suit their requirements.
- Ammunition can be tailored more easily to suit specific applications.
- Brass can be reused saving time, cost with higher quality than often available from commercially reloaded ammunition.

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3. What are the main steps in reloading?

The steps in reloading are generally as follows; Please consult your loading manual if you are not sure of the reloading processes:

1. Carefully sort / separate your spent brass checking for damaged, cracked or unserviceable cases.
2. Clean the cases to remove dirt, stains etc. via tumbling or wet processing. We do NOT recommend you full length size before rollsizing. If you want to remove the primers before cleaning use a universal deprimer, not a full length sizer / deprimer die.
3. **Rollsize your brass**.
4. Reload normally using standard sizing dies (do not use undersized or small base circle sizing dies).

4. What is supplied with the Rollsizer?

The rollsizer will generally be supplied with the following components in addition to the calibre conversions purchased with your rollsizer;

1. Your rollsizer is supplied with a drop hose for the calibre conversion. You will need to install and adjust the drop hose height before use per the details in this manual. A small pistol drop hose is used for 9mm, 38SC, 40S&W. A large Pistol drop hose is used for 45ACP.
2. Spares supplied for the manual rollsizer include;
    a. 2 x #5 Hex key driver bits for use with a drill
    b. 2 x 10mm M6 Socket head bolts
    c. 2 x 16mm M6 socket head bolts
    d. 1 x oversize washer
    e. Length of 16mm ID PVC hose with a Dillon casefeeder adaptor on one end and a cable tie for the drop hose on the other end. This has been supplied in a length suitable for a bench top installation only.
3. Spares for the DC Compact Electric rollsizer include;
    a. 2 x 10mm M6 Socket head bolts
    b. 2 x 16mm M6 socket head bolts
    c. 1 x oversize washer
    d. Length of 16mm ID PVC hose with a Dillon casefeeder adaptor on one end and a cable tie for the drop hose on the other end. This hose has been supplied in a length sufficient for and an under-bench installation.

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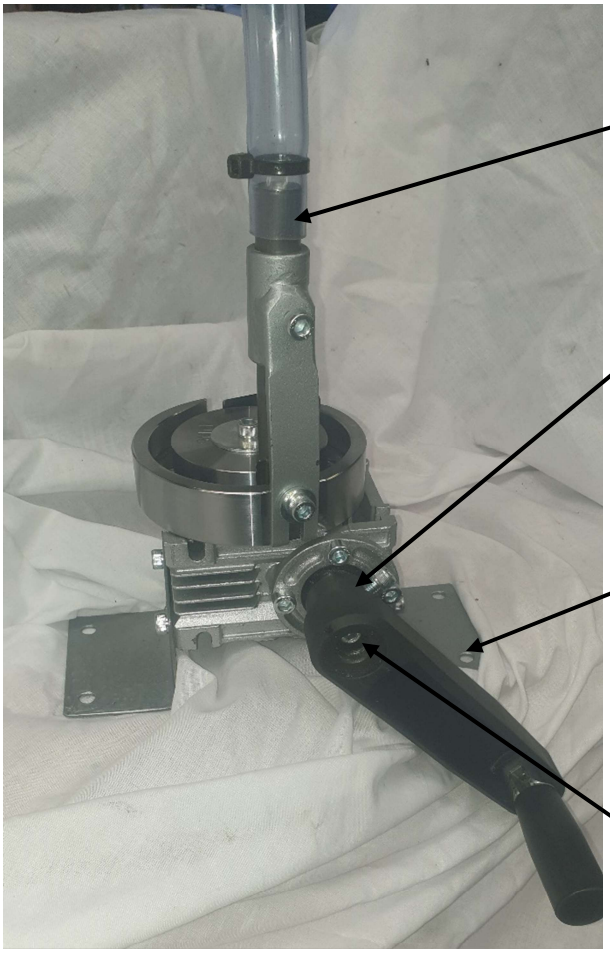
e. Universal Power supply suitable for 90VAC to 300VAC supplies. The power supply brick is supplied with an Australian power plug only. Depending on your location you may need to purchase a plug adaptor to suit your location. These are available from most electronic and travel stores.

Refer to photographs below identifying the main components of the rollsizers. The base and conversions are the same for the Mini and DC Compact.



Drop hose showing PVC hose correctly positioned. Trim the **other** end if you need to shorten the hose.

Removable Crank handle. The handle can be folded away if not in use.

Mounting holes to screw base to reloading bench.

Socket head bolt in the end of the crank shaft.

Before using a drill to operate the rollsizer remove the handle.

Use a #5 Hex driver bit inserted in your drill to power the rollsizer.

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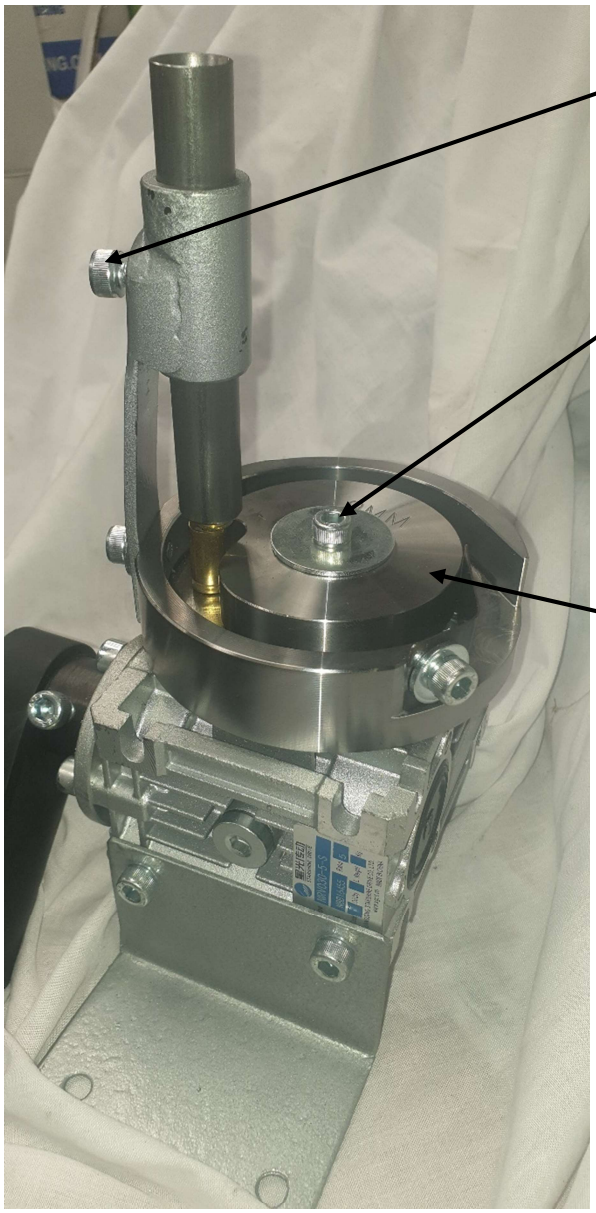

Socket head bolt to adjust drop hose height and to allow calibre conversions to be changed.

Bolt holding calibre conversion disc.

Calibre Conversion disc. The conversion disc must be placed with the label facing upwards.

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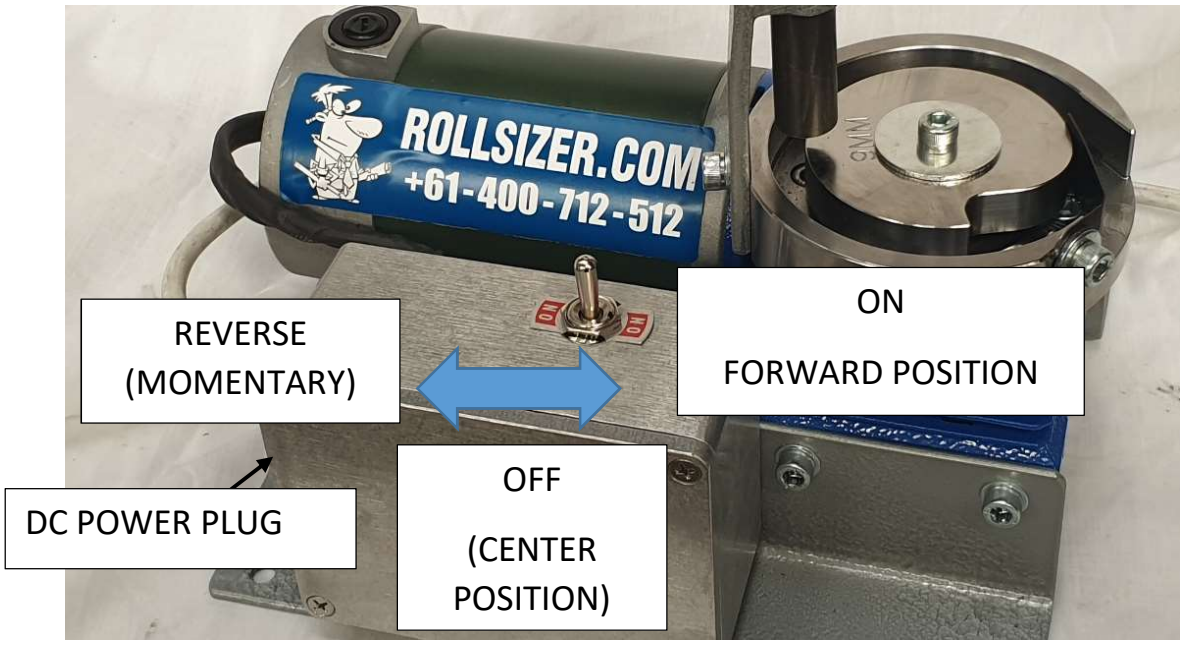
5. DC Compact On / Off / Reverse Switch

Please note, do not plug in the rollsizer to the power supply until all the positioning and adjustments of the rollsizer, connecting hoses and all the ancillary checks have been done. Please ensure all hands, clothing and other equipment are clear of the rollsizer before plugging the power brick in.

The DC Compact Rollsizer is fitted with a 3-position switch. The positions are On / Off / Reverse (Momentary). The On switch allows normal rollsizing, the Reverse switch is a momentary operation which returns to the off position when released and is designed to allow the rollsizer to be reversed in the case of a jam or malfunction.

Once the rollsizer is set up, plug in the power supply to the back of the Terminal box and plug in to the wall socket using a plug adaptor if required. Please note the power brick is a universal power supply and can accept power supply from 90VAC to 300VAC as well as 50-60hz. The power supply is fitted with an Australian plug, international customers will require an adaptor to suit their local requirements.

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



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6. Installation

Before you commit to the location of the rollsizer, please consider the following key issues.

- Casefeeder location when the rollsizer is in use.
- Does the hand crank of the rollsizer allow full range of operation and your hand does not hit any parts for the press or bench?
- What is the route of the flexible hose between the casefeeder and the rollsizer? The hose route needs to be smooth without kinking the hose.
- Can you access the center bolt holding the caliber conversion disc in this position to allow you to do caliber conversions without moving the rollsizer?
- Can you see the cases under the drop hose to check the drop hose is adjusted to the correct height?
- It is recommended the manual rollsizer is bolted or screwed down to a benchtop before use using the pre-drilled holes in the base angles. The DC Compact rollsizer does not require mounting on the bench, but has been supplied with pre-drilled holes in the base angles if required.

6.1 Casefeeder and Connecting Hose

The rollsizer has been supplied with a brass adaptor and hose to connect to the standard Dillon™ casefeeder. Refer to photo below.

The brass adaptor will clip into the casefeeder where the normal plastic drop hose connects the Dillon™ casefeeder to the Dillon™ reloading press. The flexible PVC hose supplied will connect the brass adaptor clip to your rollsizer drop hose.

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

Install the hose end with the cable tie on it on the drop hose. Run the hose from the rollsizer to the casefeeder. Insert the adaptor clip into the casefeeder and mark out where to cut the hose. The hose route should be smooth and clear of equipment, allow some extra length in the hose, mark the hose. Measure and check again before you cut the hose.

To mount the hose onto the brass 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 must 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 hose end is required to prevent cases in the hose catching on the end of the drop hose.

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

7. Processing rates

The manual rollsizer operating speed will be limited by either the crank speed you can supply (typically 1,000 to 1,200 cases per hour). Typical case feed rates from Dillon casefeeders are around 1,500 to 2,500 cases per hour depending on their condition and fill amount.

For the Manual rollsizer, we only quote a 400-500 cases per 1/2hr as we doubt you will want to spend more than 1/2hr each time to roll your brass. The effort required to roll cases is minimal but it is repetitive. The crank handle is fitted with a foldaway provision to prevent it catching on clothing when reloading of walking past the rollsizer.

The alternative to the crank handle is to use an electric drill with the supplied #5 hex bit.

The manual rollsizer is fitted with a socket head bolt screwed into the end of the crank handle shaft. The bolt is an M6 metric bolt and has a #5 socket head. We have supplied 2 x #5 driver bits in the spares kit.

If you wish to use an electric drill to operate the rollsizer you need to do the following;

1. Remove the crank handle by removing the caps crew holding the handle onto the crank shaft.
2. Check the drill is set to screw mode only with the clutch set as low as possible. Do not use IMPACT MODE. The use of impact mode in a drill will break the bolt and possibly damage the

gearbox. This is NOT a warranty claim, you have been warned. Any damage to the gearbox will require the gearbox to be returned to a reseller or rollsizer.com for inspection.

3. Run the electric drill in low speed mode, if your drill does have a low speed setting, go buy one. If you run the electric drill too fast and a jam occurs the bolt in the crank handle bolt is likely to break, this is to protect the gearbox. Removal of the bolt may require specialist help

It is critical that you do not try to process cases through the rollsizer 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 wish to process cases at rates above the capacity of your existing casefeeder, please contact us at info@rollsizer.com or call us on +61-400-712-512.

8. Calibre conversions

8.1 Pistol conversions

The calibre conversion for a pistol calibre comprises of 2 basic components

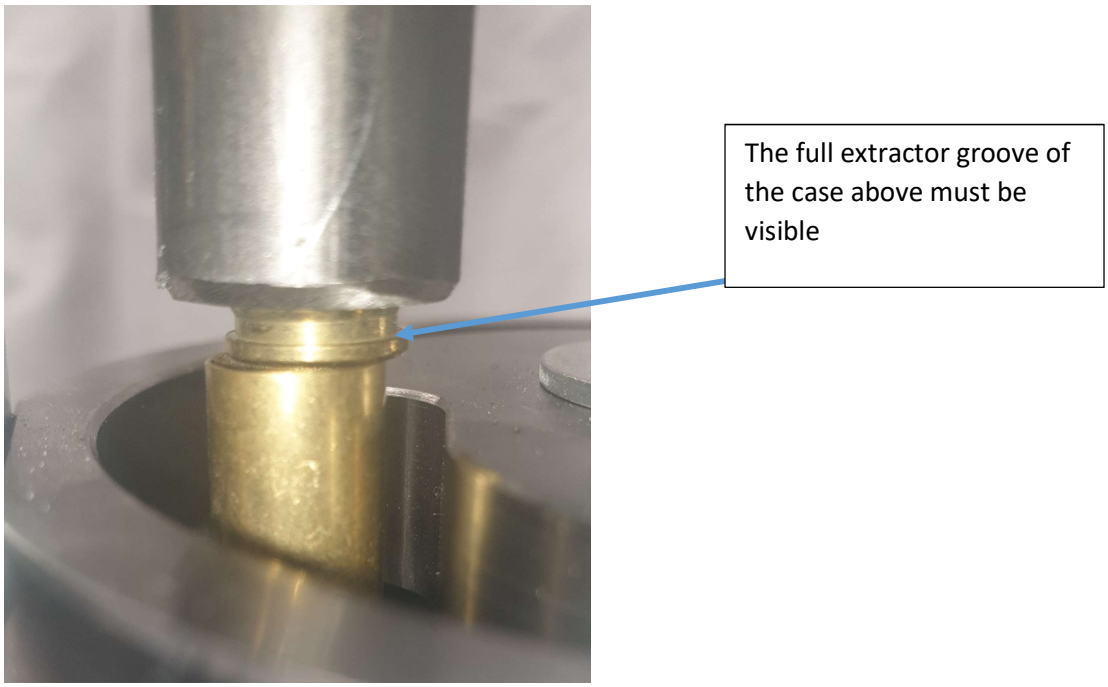
- Calibre specific conversion disc (with the calibre engraved on the disc)
- Drop hose, there are 2 different hoses
    - Small pistol drop hose covering 9mm, 38S/SC, 40S&W
    - Large Pistol drop hose covering 45ACP
    - Additional pistol calibres will be released when they become available
- Neither the Mini or DC Compact will be released with rifle conversions due to technical reasons. If you require a rifle conversion you must purchase the commercial rollsizer.

8.2 Calibre conversion process

To change calibre you need to;

1. Remove any residual cases from the case feeder, 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 rollsizer and unplug the Rollsizer power brick from the wall socket if applicable.
3. Using a #5 Allen key (not supplied) and loosen the bolt holding the drop hose. Lift the drop hose approximately 25mm (1”) up and lightly tighten the bolt.
4. Using a #5 Allen key (not supplied) and remove the bolt and oversize washer in the center disc. Lift out the disc and store in a dry place. (If the work area is subject to high humidity, wipe the disc down with an oily rag to prevent surface rust or place in an airtight bag).

5. With the disc removed wipe down the base assembly with a dry rag to remove any dust or residual dirt or tumbling media etc.
6. Replace it with the new disc ensuring the disc is clean with no traces of oil or rust preventative. Reinstall the center bolt and oversize washer, install the bolt finger tight only.
7. If the conversion requires the drop hose to be replaced remove the drop hose by unscrewing the bolt securing the drop hose and replacing it with the required hose.
8. Check and adjust the drop hose height. Drop 2 cases into the drop hose and check the extractor groove of the second case is visible, adjust the height of the drop hose as required. Check the clearance of the case containment spring as the rifle conversion drop hoses can interfere with the containment spring. Refer to attached photograph.



9. When the drop hose is correctly positioned for height, fill the casefeeder and feed hose.

9. Rollsizer operation

The rollsizer operation is as follows

- The rollsizer is setup and installed per the above processes.

- Check the drop hose size is correct for the case type and the height is adjusted correctly.
- A caliber conversion disc is installed.
- Only clean and carefully sorted cases matching the calibre conversion are placed in the casefeeder and the casefeeder will then drop the cases base first into the hose connecting the casefeeder to the rollsizer.
- Once the rollsizer feed hose is full, turn on the rollsizer, manually crank or use drill as appropriate. (Refer to rifle specific operations previously).
- As the disc rotates, the case pusher will drop and rotate sideways pushing the case out from under the drop hose.
- The next case will drop down and sit on the top of the center disc.
- When the center disc rotates around, the next case will drop and push out sideways again.

9.1 OK, I have rollsized my cases, now what?

Once your cases have been rollsized, your normal reloading process can occur. It is important to note your reloading press may need adjustment.

In most cases, the only adjustment is that the seating and crimp stations may need adjusting.

For rifle cases the full reloading process will need to be rechecked again, in some cases the overall length may have increased and cases may require trimming.

It is strongly recommended the reloading process and reloaded ammunition checked carefully before reloading quantities of ammunition.

9.2 My cases do not gauge after rollsizing

The rollsizing process works on the lower 10-15mm (1/2”) of the case. This is the section of the case that is unable to be sized in the full-length sizing process. To complete the case gauging process, the rollsizing process will often require the reloading press to be adjusted to ensure case gauge correctly.

When the cases are rollsized, the cases will stretch / extend slightly. In the majority of situations this is of no significance as pistol cases usually shrink with repeated reloading, but it is common for the seating and crimping dies to require adjustment for pistol cases.

Bottleneck pistol cases such as the 357SIG and rifle cases **will** require adjustment of the seating dies and crimp.

The following procedure is a process that will assist in establishing the adjustment required in your reloading press for rollsized cases.

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1. Clean and rollsize your cases per the details outlined above using the correct conversion kit.
2. Insert the base of a rollsized case (prior to full length sizing) into the case gauge. (The case depth will vary, but it the base should extend into the case gauge approximately 10-20mm (1/2" – ¾"). This confirms the base dimensions are within specification. This process only works with rimless cases unfortunately).
3. Full-length size the case in your reloading press. Remove the case and check again in the case gauge. The case should seat full depth.
4. If the case still does not fully seat, then it is likely the full-length sizing die needs to be adjusted down. Repeat this step and until the empty case gauges correctly.
5. Reload the case (without primers or powder) and repeat the process with a single case. Once this is correctly adjusted repeat with as a continual process reload 10 or so dummy cases continuously. This often shows up movement / flexing in the shell plate holder of some progressive presses.
6. If the dummy cases do not insert fully into the case gauge, the reloading press dies may need further adjustment, this is normal.
7. To verify where the adjustment is required, remove the dummy case and place permanent marker lines around the entire round and let dry.
8. Once dry, place the case inside the case gauge (or chamber check in your firearm) and twist slightly to make a witness mark on the case. The witness marks will be visible by scuff marks on the case. These scuff marks will identify the areas where the cases need adjustment. Consult your press manual for these adjustments. Please do not do this with a fully loaded round (I.E. powder and primers inserted into the round)

Please note that all reloading presses flex to a degree (even high-end commercial presses). The settings of the reloading press should only be considered final once the shell plate assembly is filled with cases and the press is fully loaded. It is often necessary to adjust the dies further once the shell plate is full of cases. Rollsizing your cases will reduce the load on your reloading press to a significant degree.

It is important to note that different manufacturers of case gauges use different tolerances. There are many case gauges in the market that have very tight tolerances. The rollsizer.com machine has been designed to roll cases to meet the mid-range SAAMI specifications with normal sizing dies. This dimension reflects the typical factory ammunition dimension.

Rollsizer.com cannot guarantee all cases will case gauge as the cases, gauges and sizing dies and the cases themselves all vary and are not within our control.
These gauges will require consistent monitoring and adjustment of the dies and in high volume commercial applications, the sizing dies require replacement on a regular basis.
Rollsizer.com is able to provide special order undersized calibre conversion discs if required.
Please contact us at info@rollsizer.com with your requirements.

For firearms subject to minimum power factor limitations or requirements, the point of impact be checked as this may have changed due to rollsizing process.
Based on feedback from buyers, (in general) the power factor in reloaded pistol ammunition used in IPSC / USPSA matches, rollsized ammunition will usually increase in factor by approximately 1-2 points and the velocity spread will reduce considerably resulting in significantly better accuracy. Overall, we have found the ammunition will nestle in magazines better and high capacity magazines will allow extra room with rollsized ammunition.

If you have any questions on the case gauging or final sizing processes, please contact us at info@rollsizer.com

10. Why do cases stretch?

When ammunition is fired, the cases are stretched to match the shape of the chamber of the firearm used. The chamber sizes are usually manufactured to established standards and tolerances (SAAMI or CIP) but the final chamber dimensions are often quite different between the manufacturers and their market application.

In some situations, loose / oversized or unsupported chambers are required for a particular firearm design, other applications may result in chamber tolerances that are very tight or undersized (for example high end target firearms).

In many Military or Law Enforcement, Concealed Carry / Self Defense (MilSpec) applications, reliability under difficult and less than optimum conditions are seen as more important than sub 1" groups at 100m.

In these (MilSpec) applications, the chambers are often looser to ensure reliability across a wide variety of ammunition and to operate under adverse conditions.

Stretching also occurs when running high pressure ammunition in Competition firearms particularly with light recoil and / or main springs, the quicker unlocking and reduced energy in the slide often leads to a case that is partly unlocked before the pressures have reduced. A common example is seen in the use of 9mm major ammunition in IPSC / USPSA competitions as well as blowback actions used in PCC competitions.

The normal processes used in reloading cannot remove the case bulge as the shell plate holding the case prevents the sizing dies reaching the location of the bulge on the case. A number of alternative methods of removing the bulge include push though die systems, undersized dies (small base circle dies) as well as a number of alternative case rolling designs. These low volume / low processing rate systems can work to a degree. Many of these systems are limited to specific case types (such as

rimless cases) or are limited in the extent in which the cases can be rolled or reshaped due to the equipment design.

The rollsizer.com process is designed to remove the bulge at the base across the calibre conversion ranges offered AND to ensure the cases are concentric to the rim to ensure the reloaded ammunition case will gauge and perform reliably.

11. Why don't you rim roll your cases?

Good question, the simple answer is that we at rollsizer.com do not believe it is required in over 99.9% of situations.

In the extensive testing processes undertaken over many years, we identified that in the majority of occasions, rim deformation was not the root cause of why ammunition was not reliably feeding.

The investigations by the designer (and mechanical engineer of 30+ years' experience), identified the root cause of the ammunition failure was in fact due to the location and shape of the case bulge. In some situations, the case stretch was eccentric, and the resizing process did not always reform the case body concentric to the case rim. When the reloaded case was chambered in the firearm, it jammed as the rim locked up on the breech face. This is not a reflection of the firearms manufacturers themselves, but a recognition that these manufacturers make their firearms with tighter tolerances than others.

The rollsizing process adopted in the rollsizer.com machine has recognized this, and the sizing / arrangement and tolerances adopted in the rollsizer.com machine has been designed to minimize this problem.

In the very rare situations where the rollsizer.com machine does not resolve this problem, we see the most likely scenario is that the case is unserviceable. In most cases the cases were excessively worn with little or no headstamp markings visible. We recommend the user check their cases carefully as unserviceable cases can lead to injury to the user and their firearms.

Rollsizer.com cannot guarantee every case will case gauge reliably as there are too many factors outside our control including the ammunition cases, the load data and projectiles used for the ammunition, the reloading processes used after rollsizing as well as the condition and type of firearm used all can have a significant effect on the ammunition quality and performance.

Should you need to discuss this in detail, please contact at info@rollsizer.com or by using the contact details below.

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12. Maintenance

The short answer is, very little.

The equipment is industrial rated and requires very little maintenance. A small spares kit has been supplied with the rollsizer and generally most of these components should never have to be replaced. Should you require replacement components please contact us using the contact details below.

Should the motor trip, stop working, or trip out and electrical circuit breakers or safety fuses 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.

Contact us at Rollsizer.com using the contact details below.

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.
- Check the base and rollsizer discs are free of dirt and oils or other debris. If the base area requires cleaning isolate the power supply and remove the power lead before attempting any work.
- The rollsizer has the correct calibre conversion installed, the drop hose is adjusted correctly and the casefeeder, connecting hose and rollsizer 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 rollsizer on / off as required.
- The drop hose 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.

The rollsizer plates are machined steel and can oxidize / rust if left in a wet or humid environment. It is recommended the calibre conversion plates and all unused metal components are wiped with an oily rage and packed in the supplied calibre conversion boxes supplied with the rollsizer.

Any surface rust can be removed with steel wool and retreated with a light coating of oil.
Prior to use the discs and all components should be wiped clean and all traces of oil / grease removed using degreaser and a clean, lint free cloth.

For rollsizer discs in constant use, the ongoing heat generated from the motor and gearbox will keep away any moisture and as such they are unlikely to require any treatment. If minor surface rust occurs use steel wool to remove this.

If any brass residue is on the base or rolling surfaces of the rollsizer, this can be removed using fine steel wool, do not use sandpaper or any other abrasive method as this will damage the rolling faces and lead to marks on the cases during the rolling process.

If the operator processes uncleaned or dirty brass through the rollsizer it will damage the contact faces of the base and calibre conversion discs. The faces will wear, and the finished size and surface finish of the case will be compromised.
No warranty claims will be considered if unclean brass is processed through the rollsizer.

14. Gearbox and Motor Maintenance

In domestic use applications the gearbox or motor is unlikely to 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 300,000 cases, replacement brushes will be available from rollsizer.com shortly.

The Mini and DC Compact rollsizers are only suitable for the low to medium volume shooter. Running the DC Compact rollsizer for extended periods will result in the motor and gearbox getting warm. This is expected and we do not recommend running the rollsizer for more than 2 hours at any one time. The heat generated will not affect the cases as the clearances between the base and the disc will not change if they are the same temperature. If you do a calibre change after running the DC unit for an extended period, turn off the motor and let the replacement conversion disc warm up for a period by heat sink to ensure the cases are rolled to the correct size.

The power brick supplied with the DC Compact rollsizer is a very high-quality unit and has been sized to accommodate an overload condition and turn off. The power unit is not serviceable and must be returned to rollsizer.com in the unlikely event of a warranty issue arise.

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15. What tools do I need for the calibre conversions?

You need a single #5 Allen key (not supplied) to adjust the dropper hose height, remove or install bolts in the center discs and remove the bolt holding the conversion disc.

All bolts and fasteners used in the rollsizer are standard metric bolts,

16. How to contact us at Rollsizer.com

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• Rollsizer FAQ's

1. What does the Rollsizer do?

    A. The rollsizer machines removes the bulge by rolling the base of a fired case to bring the case back into specification to allow reloading. Removing the bulge brings the base of the case back into specification, when combined with the normal sizing dies the case will be very close to the SAAMI specifications.

2. Why do cases need rollsizing?

    A. Not every case needs rollsizing, but this depends on the case condition, load and the chamber in which the case was fired, the powder type and recoil spring used in combination. The cases after rollsizing will be easier to full length size and will be much more uniform and consistent in performance. When cases have been fired in firearms with unsupported or loose chambers. The brass from these guns can often be heavily stretched or bulged and will not case or chamber gauge reliably after reloading.

3. How long will brass last with rollsizing?

    A. Very hard to say, generally much longer than without rollsizing, but too many issues contribute so it is too hard to state exactly. The owner of rollsizer.com normally gets 50+ reloads from good quality brass before the cases start cracking and have to be thrown out.

4. Do I have to resize the cases after rollsizing?

    A. Yes, all rollsizing processes require cases to be full length resized afterwards. The resizing process is usually part of the reloading process so no additional effort is required.

5. Why is full length sizing required if the base has been sized?

    A. The base is shaped to the specific calibre requirement but unless the full-length sizing die is adjusted correctly, the rest of the case will not be shaped correctly and may not case gauge.

6. I have never used one before, why should I get one now?

    A. Rollsizing brass allows ammunition to be used in different firearms and will bring the cases back to a consistent, reliable shape for reloading. No more separation of your cases between different firearms. Ammunition feeding, and reliability issues will improve

significantly, your accuracy and grouping will also improve. With rollsizing the case shape will be more consistent and it will remove the majority of the "coke bottle effect" noticeable in the 9mm and 40S&W cases.

7. How long will it last?

    A. The rollsizer was designed by a qualified mechanical engineer and early examples of the commercial grade rollsizer have now processed well in excess of 4,500,000 cases with no overheating or wear issues.

8. What does it weigh and how loud is it?

    A. The Mini only weighs around 5kg shipped, the DC Compact rollsizer is around 10kg shipped.
    B. The rollsizers are very quiet, the case feeder will be much louder.

9. Where can it be placed?

    A. The Mini rollsizer will need to be placed on the bench next to your press. The DC Compact rollsizer can be placed next to your press or on the shelf under it. The rollsizer is supplied with a length of PVC hose and is cut by the buyer to suit their installation. The hose will allow you to feed cases from your casefeeder to the rollsizer and the rollsizer has a discharge hose to direct cases into a drum or other container.

10. How fast does it operate?

    A. The mini rollsizer is recommended for 400-500 cases in a ½ sitting.
    B. The DC Compact rollsizer will process 1,200 cases per hour.

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

    A. The Mini and DC Compact will only process pistol cases. At the time of printing only 9mm, 38Super / Supercomp, 357SIG, 40S&W, 10mm and 45ACP conversions are available. In the future additional pistol conversions will be added to this list, please look up the rollsizer.com for available conversions. No rifle conversions will be offered with the Mini or DC Compact rollsizers due to technical reasons.

12. Why don't you offer rim rolling in your Rollsizer?
    A. Simply put, rollsizer.com does not believe rim rolling is required in 99.9% of applications. The vast majority of issues identified by reloaders as "Rim Bulge" related were in fact due to

the cases being formed incorrectly. The rollsizer.com machine was developed to address this issue and has been a significant success.

13. How do I buy one?

    A. You can order online via Rollsizer.com.

14. How do I pay for one?

    A. Payments can be made online using the Rollsizer.com ecommerce portal.

15. I want to be a reseller, how do I become one

    A. Reseller enquiries can be made via contacting Rollsizer.com via the contact details on the website.