

Hints on easy use: You may have to adjust the blade portion until you obtain satisfactory results on the amount of deburring required.

Do not apply excessive pressure on your Chamfer/Deburr Tool as it is not required and may move the position of the blade, as well as form an unnecessarily sharp edge on the mouth of the case. You can damage your cases if improperly used. Make sure to check each case carefully for proper deburring.

When changing calibers, you must change the position of the blade.

You may also use your Chamfer/Deburr Tool on any Lyman trimmer. Always align each case carefully before trimming in this manner to ensure uniform chamfer/deburring on your case.

Your Chamfer/Deburr Tool, when used on a Lyman trimmer, can accommodate the most popular pistol calibers and will accommodate rifle calibers up to 300 Winchester length cases.

Caution: Always wear safety glasses when using any revolving cutting tool. Use caution when handling your cutting tool as the cutting edges are extremely sharp. This tool is not a toy. Do not leave children unattended when using this tool. Do not allow children to use this tool.

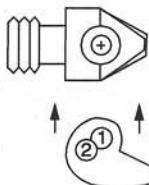
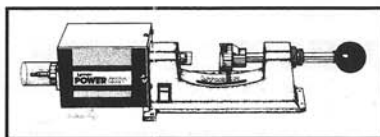
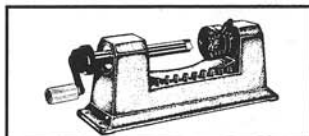


Figure 6



Lyman Power Trimmer (Shown with Primer Pocket Brush Mounted)



Lyman Universal Case Trimmer



Lyman Accutrimmer (Shown with Chamfer/Deburr Tool Mounted)

Questions regarding the use of any of these and other tools can be answered by calling our toll-free telephone number: 1-800-22-LYMAN, Monday through Friday between 9:00 a.m. and 3:30 p.m. Eastern Time. You can also order items using this phone number.

Lyman Products Corp., 475 Smith Street, Middletown, CT 06457

IBM #7968506

Lyman

Instructions

Case Care Kit
Utility Crank Tool
Ream/Clean Accessory Set
Chamfer/Deburr Tool

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Case Care Kit

Your Case Care Kit contains the following items:

1. Utility Crank Tool.
2. Ream/Clean Accessory Set.
3. Chamfer/Deburr Tool.

This brochure contains instructions for each item listed above.

Instructions for Lyman Utility Crank Tool

Your Lyman Utility Crank Tool is manufactured to rigid tolerances. An occasional drop of oil or powdered graphite on rotating parts will improve performance. Your Utility Crank is designed to be either bench-mounted via screws or bolts directly to a bench, or mounted to a board and held in a vise.

Your Utility Crank, when used in conjunction with Lyman Case Preparation tools and adapters, can easily perform the following functions;

1. Ream/Clean case primer pockets.
2. Chamfer/Deburr case mouths.
3. Brush attachments to clean inside case mouths or apply lubricants.

Hand-tighten any of the accessories to the Utility Crank as shown in Figures 1 through 4. The thread adapter is utilized with the smaller accessory items such as primer pocket reaming and cleaning tools and case neck brushes. (Case neck brushes are not included with the Case Care Kit. You can order them by calling the toll-free number listed at the end of this manual.) Ream/Clean Accessory Set instructions and Chamfer/Deburr Tool instructions are included elsewhere in this manual. Your Lyman Utility Crank, when used with other fine Lyman reloading tools such as our presses, case trimmers, Turbo Tumblers, and dies, allows you to easily produce your own reloaded rounds.

Caution: As with any revolving tool, safety glasses must be worn. Do not allow children to play unsupervised in the reloading area. This tool is not a toy and children should not be allowed unsupervised access to the tools. Keep your reloading area clean. Work your reloading into a system.



Figure 1

Lyman Utility Crank
with Case Neck Brush
Mounted



Figure 2

Lyman Utility Crank
with Chamfer/Deburr
Tool Mounted



Figure 3

Lyman Utility Crank
with Primer Pocket
Cleaning Tool Mounted



Figure 4

Lyman Utility Crank
with Primer Pocket
Reaming Tool Mounted

Instructions for Ream/Clean Accessory Set

Note: In order to use the Ream/Clean Accessory Set on the Accutrimmer, a Lyman X-2 Shellholder will be required. This shellholder will properly accept the chuck head adapter supplied with the accessory set.

Large quantities of cartridge cases (to .45 caliber) can be quickly processed, after resizing and decapping, on your Lyman Universal Trimmer to prepare the primer pocket for reloading. The Ream/Clean Accessory Set is essential to this process.

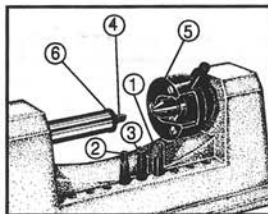


Figure 5

Key	Part Description	Part No.
1	Large Reamer	7990365
2	Small Reamer	7990366
3	Large Cleaner	7990372
4	Small Cleaner	7990373
5	Chuck Head Adapter	7990380
6	Ream/Clean Adapter	7990381

Operate as Follows:

1. Remove the trimmer's cutter head and replace it with the ream/clean adapter (6).
2. Install the chuck head adapter (5) in the trimmer's chuck head and lock it in place, just as you would an unprimed cartridge case.
3. Install the large (3) or small (4) cleaner bit into the ream/clean adapter (6) to fit the primer pockets.
4. Retract the trimmer shaft sufficiently to permit a cartridge case to fit between the cleaner (or reamer) bit and chuck head adapter (5).

5. Place the case mouth over the end of the chuck head adapter (5) and, still holding the case, slide in the cutter shaft so the cleaner bit enters the primer pocket. A turn or two of the shaft assembly removes the fouling. Now process the rest of your cartridge cases in the same manner.

Note: Removing the primer pocket crimp from once-fired military brass is a one-time operation involving the appropriate reamer bit—large (1) or small (2). The procedure is the same as for primer pocket cleaning and should be done before primer pocket cleaning.

After extended use, your ream/clean bits and brushes may wear beyond usefulness. When that happens, order the appropriate replacement set according to the following chart. You can order by referring to the toll-free number listed at the end of this manual.

Item	Part No.
Replacement Reamer/Cleaner Set (4 bits: large and small reamer/cleaner bits)	7777797
Replacement Brush Set (3 brushes: .25, .38, and .45 cal. brushes)	7777799

Instructions for Chamfer/Deburr Tool

Your Chamfer/Deburr Tool will cleanly deburr the inside and outside diameter of your case mouth with one easy setup.

Use Figure 6 as a guide to setting up your Chamfer/Deburr Tool. First, your Chamfer/Deburr Tool as received from the factory is pre-assembled. You should do the following:

1. Cases with burrs to be removed must be sized and trimmed to length to get uniform results.
2. Remove the hex screw from the Chamfer/Deburr Tool. Allow the blade to slip into the slot and position into hole number 1 (see Figure 6). This position is adequate for most calibers. Insert hex screw, but do not tighten at this time. Should you have large calibers (some .44's and .45's), you may use the second hole. Snug it up until the blade moves with some resistance in the slot. We urge you to experiment until you receive the best results.
3. Screw the Chamfer/Deburr Tool tightly into your Utility Crank or Lyman trimmer.
4. Bring the mouth of your case to rest flush on the angled portion of the Chamfer/Deburr Tool. Move the blade portion of the tool until it engages in the outside neck of the case. Tighten the hex screw until the blade is firmly locked into place.
5. Rotate your trimmer with the case pressed flush against your Chamfer/Deburr Tool. A few revolutions will remove burrs on both the inside and outside diameters.