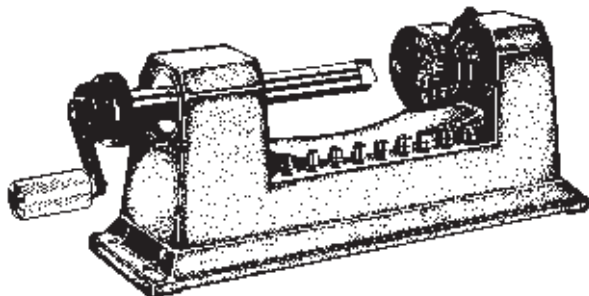


THE UNIVERSAL CASE TRIMMER

A metallic cartridge case will stretch after a number of firings and it then becomes necessary to trim it back to its proper length so it will chamber properly. The Lyman Universal Case Trimmer accepts all U.S. metallic cases. To convert to another caliber you need only change the pilot. Also included is an Allen wrench, which fits the lock screws in the adjustment rings and cutter head.



Mounting

The base casting is drilled so the trimmer may be fastened directly to the top of your reloading bench. This is the recommended method of mounting. Some reloaders prefer to clamp their trimmer in a vise when using it. If the trimmer is to be used in this manner, Lyman recommends that it be fastened to a block of wood. The wooden block can then be held firmly in the vise jaws without damaging the base casting.

Installing the Pilot

Loosen the lock screw on the case trimmer's cutter head, open the package containing the Universal Trimmer pilot and insert it all the way into the cutter head (see **Figure 13**). Now tighten the lock screw.

Preparing the Cases

Before trimming, cases must be full-length or neck-resized and deprimed. Pilots are designed to be used only with sized necks.

Measuring the Cases

You will need an accurate means of measuring case length. We recommend that a good vernier caliper be used. When your cases have lengthened to the point where they exceed the maximum case length allowable for your cartridge, they must be trimmed. For a list of "Maximum Case Lengths" and suggested "Trim-To Lengths" see your Lyman Handbook.

Locking the Case in Place

Place the chuck lever in "open" position and slip the head of your unprimed cartridge case into the chuck head as pictured in **Figure 14** (pg 38). By pressing the rim of the case against the side of the



Insert pilot into cutter head and lock in place with allen wrench.

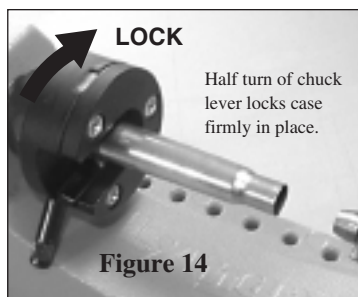
Figure 13.

Universal Case Trimmer (continued)

steel alignment ball, the case will snap into position with the cams engaged in the extractor groove. Be certain the case is straight and that both cams are engaging evenly.

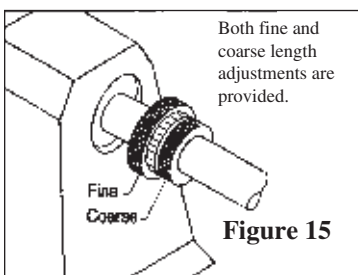
Slide the cutter shaft in so the pilot enters the neck of the case and cutter face is touching the case mouth. Then, rotate the check lever to “lock” position.

Do not use excessive force when locking the chuck. Slight thumb pressure on the lever is sufficient to hold the case firmly. Leave the pilot and cutter in this position as you proceed to adjust the trimmer.



Adjusting the Cut

Two knurled adjustment rings, located on the cutter shaft (see **Figure 15**), provide for both fine and coarse adjustments. Before making any adjustments, hold the large ring with your finger and turn the small ring counterclockwise, four full turns. This will leave about 3/32" space between the rings and allow room for fine adjustment. Make certain the cutter face is still positioned against the case mouth and slide the adjustment rings in tight against the side of the base casting. Tighten the lock screws in the small ring.



Later models have a series of indicators each representing .001 inch of travel on the shaft. Used as reference marks, they enable the user to return to an approximate setting for various cases without time consuming trial and error testing.

Adjust the cut a little at a time, checking your case length with the vernier caliper after each cut. When the correct “Trim-To Length” has been reached, tighten the lock screw in the large ring.

Processing Your Cases

Once the trimmer is in adjustment, your entire lot of cases may be processed to bring them all to the correct length. As you turn the crank handle, keep an inward pressure on the cutter so that it is always bearing against the case mouth, but do not force it. Variations in finished case length would likely be caused by inconsistent pressure applied against the cutter head during the trimming process. If the case mouth sticks against the cutter head after trimming either too much pressure is being used or the pilot is not installed firmly against the cutter head. After trimming, small burrs will be present on the case mouth. These can be easily removed from both inside and outside the case mouth with your Lyman Deburring Tool.

Keep a Master Case

When a reloader is working with several different calibers, it is wise to retain a master case of the correct length for each cartridge.

This reduces adjustment time since the master case can be snapped into the chuck and the cutter quickly brought into adjustment against its mouth.

Universal Case Trimmer (continued)

Maintaining the Trimmer

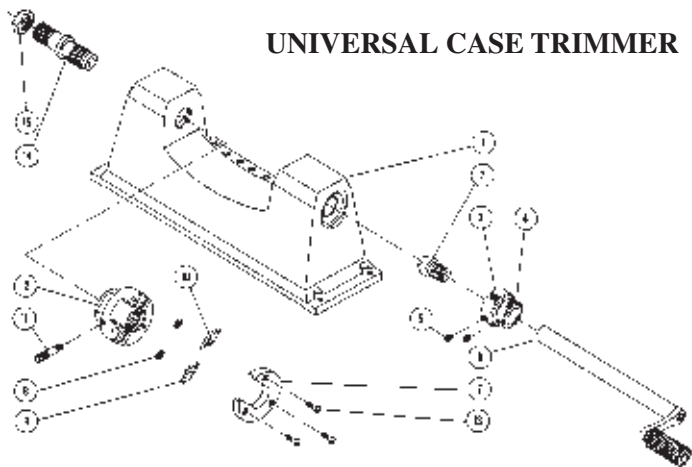
Powdered graphite or light oil on the cutting shaft will provide proper lubrication for smooth operation. A light film of oil or grease will protect steel parts against rust.

Power Adapter Instructions

An optional adapter is available to quickly and simply convert your Universal Case Trimmer to a power trimmer (Item #7862001). To install, first securely mount the case trimmer on a bench or table. Unscrew the cutter head from the Universal Trimmer shaft and slide it out of the trimmer body. Next, remove the cutter head from the Power Adapter and slide the Power Adapter shaft into the trimmer body. Reattach the cutter head to the Power Adapter shaft. Insert the hex shaft into the chuck of a hand drill or power screwdriver and tighten securely. Make sure your power source is in line with the trimmer shaft. Install the proper pilot and adjust the stop collars to the desired lengths.

Caution

- 1. Always wear proper eye protection during reloading.
- 2. Only use the trimmer adapter with electric hand drills or power screwdrivers operating between 140 and 1000 RPM. Do not use with a drill press.
- 3. The power source should be supported during use so that the trimmer shaft is not bearing the full weight.
- 4. Power use will cause more wear to the trimmer shaft and bearing than hand operation. Occasionally lubricate the trimmer shaft with light machine oil.
- 5. Read and follow all safety and operating instructions supplied with your electric drill and Lyman Universal Case Trimmer.



Key	Part Description	Part #
1	Trimmer Body	7994433
2	Cutter Head Assembly**	7822011
3	Stop Collar, Fine	7994416
4	Stop Collar, Coarse	7994417
5	Set Screw 8-32 x 1/8" (2)	7994418
6	Shaft Assembly	7994432
7	Chuck Head Cap*	7994404
8	Compression Spring*(2)	7994410
9	Retaining Cam, RH*	7994409
10	Retaining Cam, LH*	7994408

Key	Part Description	Part #
11	Chuck Head Knob*	7994421
12	Chuck Head Base Only*	7994403
13	Pan Head Screw#6-32*(3)	7994428
14	Head Shaft Assembly	7994430
15	Hex Nut 9/16"-18	7125559

*These items may be ordered from Lyman as a complete Chuck Head Assembly, 7994434.
** Replacements available in a two-pack, 7822203