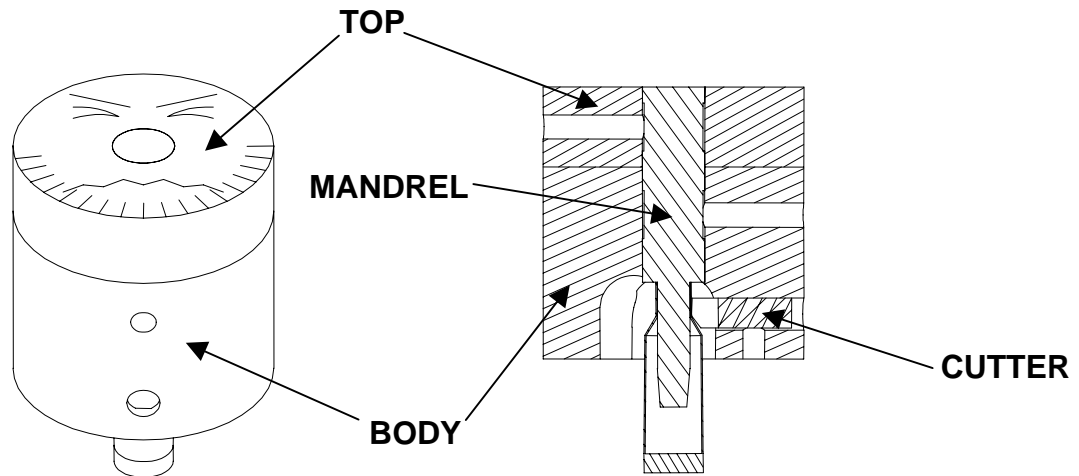


# INSTRUCTIONS FOR USING THE SPF NECKTURNER



Make sure you have the correct mandrel for the neckturner and expander that you are using. Sinclair and most K & M expanders should work. The mandrel on the turner is 0.002 below bullet size. The expander should be 0.001 below.

The mandrel has an eccentric ground between the top part and the part that fits into the case. There is approx 0.002 travel in 180 degrees. Below are the steps in setting up the turner:

1. Loosen the screw that is in the body holding the mandrel. Rotate the mandrel using the top part to align the two holes in the body at the center of the tick marks on the top below the face. The two holes will act as the index mark. You can mark on the body with a marker if you prefer a line.
2. Loosen the cutter retaining screw and loosen the screw that holds the mandrel to the top. Move the mandrel up and down until the case is in the correct position axially. (DON'T move the top compared to the mandrel in a rotary motion. If you accidentally move it, there is an alignment mark on the mandrel inside that should line up with the tick mark on the right side of the face. That should be the position in which the mandrel is closest to the mark and will give the largest neck thickness.) If you have an expanded case this is easy if you put the case on the mandrel and move it until the cutter is in the correct position on the neck. Tighten the screw in the top to hold the mandrel and the one in the body to the mandrel.
3. Use a piece of shim or a case that has already been turned to the correct size to set the cutter to a nominal position. Push the cutter in until it touches the shim/case and tighten the screw.
4. Remove the shim/case. At this point you can turn the top compared to the bottom and move the mandrel slightly closer and farther from the cutter. This should be a good position for the turner to be fine adjusted from.
5. USE A GOOD PROCEDURE TO TURN THE NECKS. I am not going to go into how to turn necks here. Get someone who knows how to show you or find a FAQ on benchrest.com. For any questions call us.

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