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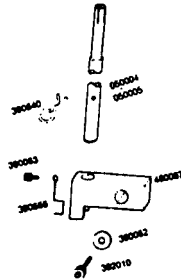
## AUTOMATIC PRIMER FEED For Use With The Positive Priming System

The Hornady Automatic Primer Feed is designed to work in conjunction with the Positive Priming System™ on your press, and will simplify your priming operation by eliminating the need for handling individual primers. Use of the automatic primer feed will also speed the priming operation.

### INSTALLATION INSTRUCTIONS NOTE: DO NOT ATTEMPT INSTALLATION WITH PRIMERS IN THE PRIMER TUBE OR AUTOMATIC PRIMER FEED BODY

1. Remove the contents of the automatic primer feed box and check to be sure that the following parts are present (see illustration #1): 1 ea - 480087 - APF Body - This item will be assembled to include:

- 1 ea - 390062 - Flat washer
- 1 ea - 390063 - APF spring screw
- 1 ea - 390666 - Body spring
- 1 ea - 050004 - Large primer tube
- 1 ea - 050005 - Small primer tube
- 2 ea - 390640 - Hairpin clip
- 1 ea - 392010 - APF adjusting screw



Illus. # 1

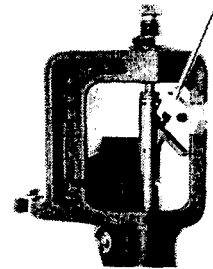
Examine the APF body to be sure that the body spring is located in the body spring slot at the front of the body, and the body spring screw is tight. Check the spring to make sure it moves freely within the slot.

2. Place the APF body in position against the frame of the press as pictured and install the flat washer and adjusting screw. The mounting hole in the APF body is larger than the adjusting screw. This allows adjustment of the APF body to assure proper fit with the primer arm. Tighten adjusting screw lightly to allow movement for final adjustment.

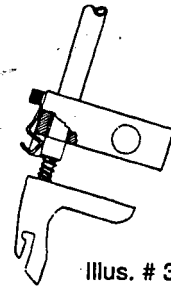


Illus. # 2

3. With APF body in position, move the press ram to its uppermost, extended position, allowing the primer arm to pivot away from the ram and into position to receive a primer (see picture.)



4. Loosen the APF body adjusting screw only enough to allow positioning of the APF body over the primer. The position of the APF body is important to insure optimum results. Be sure that the base of the APF body and the upper flat surface of the primer arm, as seen in illustration #3, are parallel. At this point the APF body should rest firmly enough against the primer cup to move the APF body spring out of its slot, which releases a primer. However, do not adjust the APF body in such a manner that the primer cup is depressed; it will not accept a primer in this position. To check adjustment, look through the primer tube hole (without the primer tube installed) to see that ample deflection of the body spring has occurred to release a primer. When the preceding adjustments have been made, secure the adjusting screw.

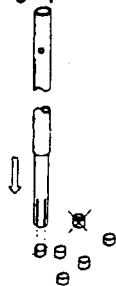


Illus. # 3

Do not try to overtighten the adjusting screw. It should be tight enough to hold the unit in place, but still allow the body to move to prevent a primer from being caught or crushed. **Remember - Primers Are Explosives** - do not try to force a primer into the primer pocket. If, for some reason, the positive priming system or automatic primer feed does not work properly, stop to see why. Never try to force the operation.

5. By examining the primer tubes, you will notice that two tube sizes have been included. Check your reloading manual to find out the proper size (large or small) primer needed for the cartridge you will be loading and select the primer tube. Examination of the tube will reveal that one end is slotted and the other end has a hole drilled through both sides to allow insertion of the hairpin clip before loading the primer tube.

6. Place primers on a flat surface, such as the Hornady Primer Turning Plate, and make sure that all of the primers have the cup, or smooth, surface facing upward (see illustration #4). Press the slotted end of the tube firmly down over each primer, as shown in the illustration, until the column of primers reaches the hairpin clip. You are now ready to install the filled primer tube in the APF body.



Illus. # 4

7. Place the tube, clip end downward, in the primer tube hold of the APF body, seating the tube firmly against the shoulder in the hole. Remove the hairpin clip and the primers will move downward into the feed position, resting on the APF body spring. You are now ready to begin priming.

### PRIMING INSTRUCTIONS

8. Place a deprimed case in the shellholder of the ram and raise the ram to its uppermost, extended position. The primer arm will pivot out of the ram and engage the APF

body spring, which will deflect to allow a primer to drop into the priming cup. Withdraw the ram and return it to its original position in the base of the press. As the ram travels downward, the primer arm will pivot into the ram and position the primer directly in line with the primer pocket of the cartridge case.

9. As the primer makes contact with the primer pocket, you will feel a slight resistance. Continue exerting moderate, even pressure on the press handle until you meet with increased resistance indicating that the primer is completely seated. From the time you make initial contact with the primer pocket until seating is completed, you should experience a maximum of 1/8" of ram travel. If the primer does not move after initial contact is made, or excessive pressure is required to cause travel, stop and examine the primer and case. **NEVER USE EXCESSIVE FORCE TO SEAT THE PRIMER. PRIMERS ARE EXPLOSIVE AND MAY BE DETONATED BY CRUSHING.**

### TROUBLESHOOTING

A. If primers do not seat easily, check to be sure you are using the proper size primer for the case you are loading.

B. When loading once - fired military cases, it may be necessary to remove a small crimping ring which was rolled into the primer pocket when the ammunition was loaded for the military. This may be accomplished by use of a primer pocket reamer, which will cut away the crimping ring and return the primer pocket to its original size. Primers will then load normally.

C. If primers do not feed, remove the tube and all primers. Re-examine the adjustment of the APF body. It is possible the body does not line up correctly or may have shifted out of position (see illustration #2). If this has happened, readjust the APF body.

C. If more than one primer is released when the primer arm contacts the APF body, remove the tube and all primers and examine the feed spring. It should move freely within the spring slot and return to position when the primer arm moves away. If this does not occur, check for a loose spring screw or bent spring and correct.