

## Three-Way Cutter Instructions

This is case trimming at its finest. The unique three cutter configuration trims a case like our standard cutting tool, but in addition to trimming to length, an inside cutter levels the case mouth while an outside cutter deburrs it. The three-way cutter attaches easily and works with Trim Pro Manual, Trim Pro Power and Rotary Case Trimmers. Use the following instructions to install the cutter and to make any necessary adjustments. The Three-Way Cutter is factory-set for the inside bevel. **Refer to your case trimmer instructions for important safety and operating information.**

Step 1: Remove the standard cutter from the cutter shaft on the case trimmer by turning the cutter counter-clockwise while holding the shaft stationary. Be careful not to burr the cutter shaft.

Step 2: Install the Three-Way Cutter assembly onto the cutter shaft by turning the cutter assembly clockwise.

Step 3: Adjust the case trimmer for proper trim length. Refer to your case trimmer instructions. Then, trim case.

Step 4: Remove the case from the case trimmer. Check the overall length and make any necessary overall length adjustments. Following the overall length adjustment, check the amount of bevel on the inside of the case mouth. Adjusting the overall length of the case does not affect the case mouth bevel. The inside bevel was set at the factory. If adjustment is necessary, proceed as follows:

- Remove the cutter assembly from the cutter shaft.
- Apply tension to the pilot. Hold your finger against the nose of the pilot to limit any movement of the pilot.
- Loosen the setscrew in the side of the cutter head.
- Turn the adjustment screw clockwise to increase the bevel and counter-clockwise to decrease the bevel. NOTE: A 1/8<sup>th</sup> turn of the adjustment screw equals .004" change in bevel.
- Tighten the setscrew in the side of the cutter head.

Step 5: Re-install the three-way cutter onto the cutter shaft and trim a case. Check the inside bevel. Repeat step 4 until you are satisfied with the amount of inside bevel.

The following adjustment is for the outside deburring tool. This can be done with the three-way cutter installed on the case trimmer.

Step 6: Insert the same case in the case trimmer. Move the cutter assembly to the case mouth as if trimming the case. Be sure the cutter head is in contact with the case mouth but do not rotate the cutter. If you are using the power trimmer, be sure the power is switched off.

Step 7: Loosen the outside deburring setscrew in the front of the cutter assembly.

Step 8: Move the outside deburring tool towards the case by turning the thumb screw clockwise. Adjust the outside deburring tool GENTLY until it just makes contact with the case. NOTE: The outside deburring tool should just make contact with the case. Do not drive the outside deburring tool into the case. This could cause damage to the cutter.

Step 9: Back the cutter assembly away from the case. Turn the adjustment screw clockwise to set an amount of outside bevel. A 1/8<sup>th</sup> turn of the screw equals a .002" change in outside bevel. Remember when you debur a case, all you want to do is remove any burrs from the case mouth.

Step 10: Tighten the setscrew in the front of the three-way cutter. Repeat steps 6-9 until you are satisfied with the amount of outside bevel.

If the trim length of the cases begins to vary or the cutter stops trimming and deburring, remove the cutter assembly from the cutter shaft and clean the cutter by removing any brass shavings that may have built-up on the cutter. The cutting edges should be positioned as show in the drawing.

