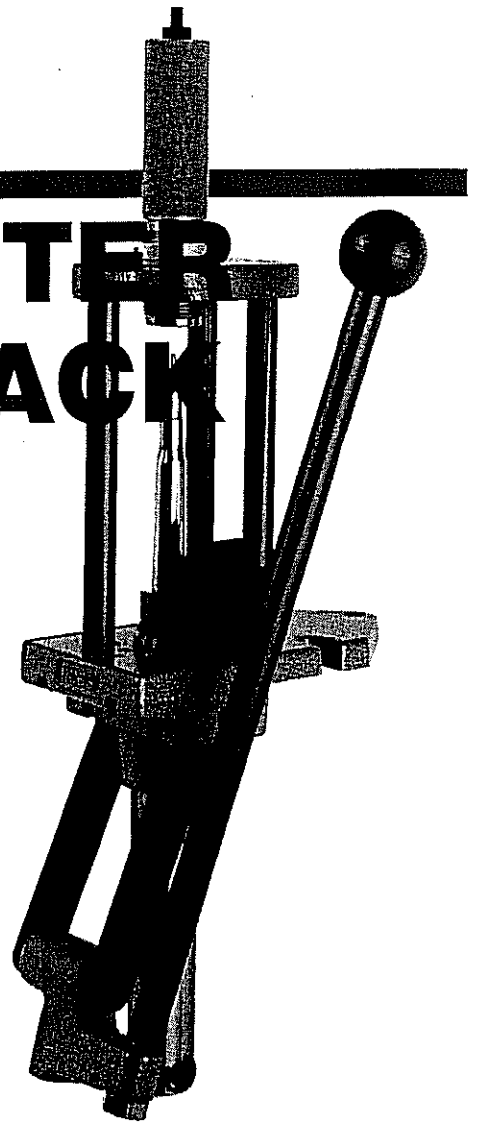


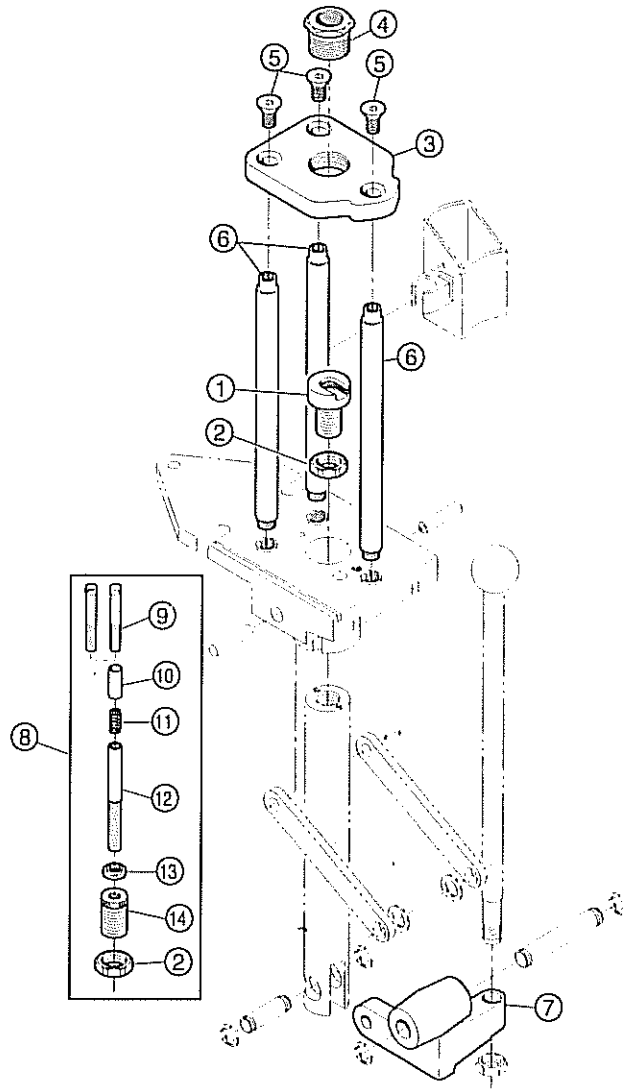
RCBS[®]

**AMMOMASTER
.50 BMG PACK**



PRODUCT INSTRUCTIONS

AMMOMASTER .50 BMG PARTS



AMMOMASTER .50 BMG PARTS LIST

KEY	PART #	DESCRIPTION
1	88742	Shell Holder Ram Adapter
2	87505	Lock Nut
3	88731	Top Plate (1 1/2"-12)
4	88748	Bushing 1 1/2"-12 to 7/8"-14
5	88750	Flathead Setscrew 3/8-16x3/4(3)
6	88722	Support Rods (3)
7	7-88711	Toggle Block
8	55005	Ram Priming Unit
9	88745	Primer Plug Flat
9	88760	Primer Plug Round
10	88744	Primer Sleeve (50 Cal.)
11	88749	Compression Spring (50 Cal.)
12	88743	Primer Adjustment Shaft
13	80049	Adjustment Screw Lock Ring

IMPORTANT: READ THIS SECTION FIRST

Before using the RCBS Ammomaster .50 BMG Pack, read the instruction manual carefully to fully learn how to safely operate the related reloading equipment. Failure to properly operate certain reloading equipment can result in severe personal injury and/or equipment damage. If you have read these instructions and still do not understand some operation, call us at 1-800-533-5000 and a technician will assist you. This instruction manual contains specific safety and operating information. It should be considered a permanent part of your reloading equipment and remain with the equipment at all times for easy reference.

SAFETY

Reloading is an enjoyable and rewarding hobby that can be conducted safely. But, as with any hobby, carelessness or negligence can make reloading hazardous. This product has been designed from the beginning with the user's safety in mind. When reloading, safety rules must be followed. By observing these rules, the chance of a hazardous occurrence causing personal injury or property damage is minimized.

GENERAL

- Use all equipment as the manufacturer recommends. Study the instructions carefully and become thoroughly familiar with the operation of the product. If you do not have written instructions, request a copy from the equipment manufacturer.
- Don't take short cuts. Attempting to bypass established procedures is an invitation to an accident.
- Observe "good housekeeping" in the reloading area. Keep tools and components neat, clean and orderly. Promptly and completely clean up primer and powder spills.
- Reload only when you can give your undivided attention. Do not reload when fatigued or ill, or under the influence of medications or alcohol. Develop a reloading routine to avoid mistakes which may prove hazardous. Don't rush - load at a leisurely pace.
- Always wear adequate eye protection to protect your eyes from flying particles. You assume unnecessary risk when reloading without wearing safety glasses.

LOADING DATA

- Use only laboratory tested reloading data. We highly recommend the current SPEER Reloading Manual.
- OBSERVE ALL WARNINGS ABOUT THE USE OF MAXIMUM LISTED LOADS.

PRIMERS AND POWDER

- Store primers and powder beyond the reach of children and away from heat, dampness, open flames and electrical equipment. Avoid areas where static electricity is evident.
- Do not use primers of unknown identity. Scrap unknown primers in accordance with applicable regulations.
- Keep primers in the original factory container until ready to use. Return unused primers to the same factory packaging for safety and to preserve their identity. Primer packaging is designed to provide safe storage.
- DO NOT store primers in bulk. The blast of just a few hundred primers is sufficient to cause serious injury to anyone nearby.
- DO NOT force primers. Use care in handling primers.
- DO NOT have more than one can of powder on the bench at one time. Powder cans should be stored away from the bench to avoid picking up the wrong one.
- DO NOT use any powder unless its identity is positively known. The only positive identification is the manufacturer's label on the original canister. Discard all mixed powders and those of uncertain identity.
- If you use a powder measure, replace the lids on both the powder hopper and powder can after the powder hopper has been filled.
- When using a powder measure, settle the powder in the powder hopper before charging any cases. Throw and check the weight of at least ten charges. This will assure you that the correct powder charge is being thrown.
- When you finish a reloading session, pour any remaining powder back into its original factory container. This will preserve the identity and shelf life of the powder.
- DO NOT smoke while reloading.

Because RCBS has no control over the choice of components, the manner in which they are assembled, the use of this product, or the guns in which the resulting ammunition may be used, we assume no responsibility, expressed or implied, for the use of ammunition reloaded with this product.

GENERAL INFORMATION

The single-stage version of AmmoMaster is a big, strong press that provides the experienced or beginning handloader with all the clearance, strength, and leverage to reload all rifle and pistol calibers. With the RCBS legendary compound leverage system and massive 1 1/2" ram, AmmoMaster will form cases or swage bullets. The 7/8-14 top thread allows the use of standard reloading dies and many RCBS accessories. With 7 inches between the top plate and the main press frame, AmmoMaster will easily handle the longest standard cartridge.

WARNING:

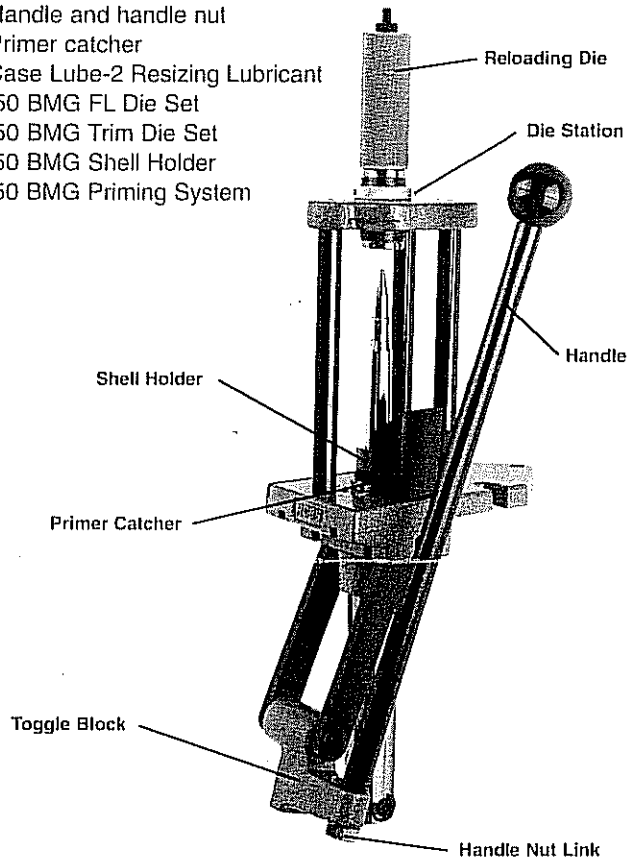
TO AVOID INJURY, READ AND FOLLOW THESE SAFE PRIMING PRACTICES:

- DO NOT attempt to prime military cartridge cases with crimped primer pockets until the crimp has been removed with a counter sink, a special reamer or by swaging. Primers seated into crimped pockets are subject to deformation which can cause misfires and even detonation during seating which can cause serious personal injury.
- DO NOT attempt to seat primers against excessive resistance which may cause detonation and possible serious personal injury. Check to be certain that the case was not previously primed, that the fired primer was removed, that a portion of the primer cup wall might still be in the primer pocket and that you are using the correct size primer.
- DO NOT modify the priming system in any manner or attempt to use similar parts or priming systems from other manufacturers. To do so could result in primer detonations resulting in serious personal injury.
- NEVER seat a primer into a powder charged case.

UNPACKING

Unpack the press carefully and look for the items listed below. Refer to the parts list for identification. The kit should contain the following items:

- Press
- Handle and handle nut
- Primer catcher
- Case Lube-2 Resizing Lubricant
- .50 BMG FL Die Set
- .50 BMG Trim Die Set
- .50 BMG Shell Holder
- .50 BMG Priming System



INSTALLATION

Before starting, make sure the press is securely bolted to a sturdy bench using the three mounting holes in the base of the press.

Mount the AmmoMaster Press to a sturdy workbench or table with three bolts of sufficient length to penetrate the press base and bench. Install the threaded portion of the handle through the toggle block. Attach the handle nut and tighten firmly. The handle nut must remain tight at all times to avoid damage to the handle and toggle. To correctly position the primer catcher, snap it onto the rear post as shown. Spent primers drop through the partially hollow ram and into the primer catcher.





-sizing the case

1. Remove the black bushing from the top plate. Thread the .50 cal sizer die into the top of the reloading press. *See photo 1.*
2. Adjust the die as you would any standard reloading die. Lightly lubricate the outside of the cases with RCBS Case Lube-2 Resizing Lubricant and slide a case into the shell holder. *See photo 2.*

3. Gently but firmly, lower the press handle and run the case all the way into the die. This operation will resize the case, expand the case mouth and knock the fired primer out of the bottom of the case.

The .50 Pack is supplied with a ram priming unit. The installation and operation procedure to seat primers is as follows:



Remove the sizer die from the top plate. Install in its place the bushing. *See photo 3.*

priming the case

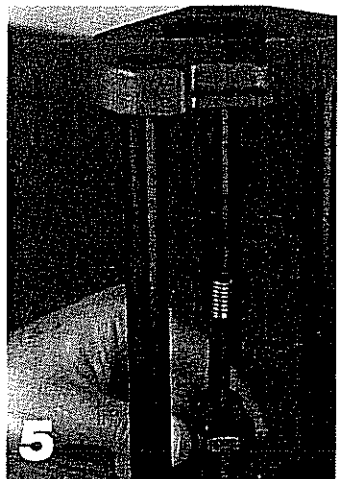
4. Remove the .50 cal. shell holder from the press ram and thread it into the bushing in the top plate. *See photo 4.*

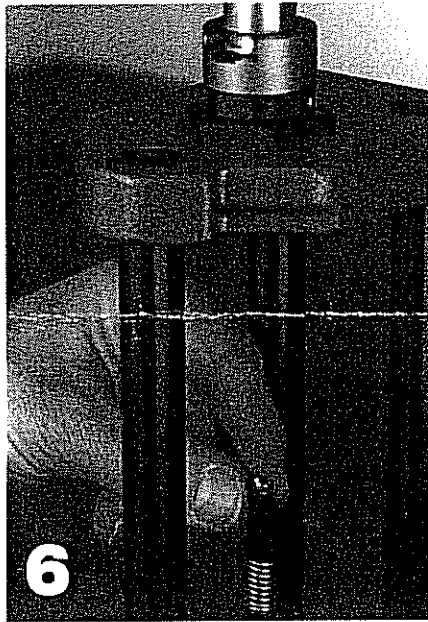
5. Position it so the shell holder slot is facing the front. Secure it by

tightening the hex lock nut. Install the ram priming adapter into the press ram. *See photo 5.*

6. To prime, simply place the primer, anvil side up, into the extended primer rod assembly. *See photo 6.*

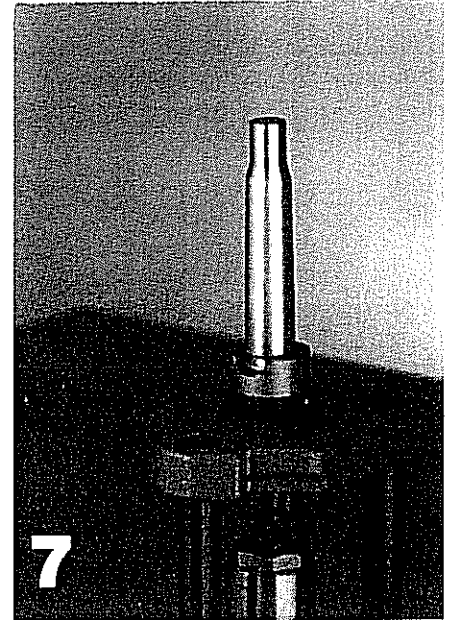
7. Insert a deprimed case into the shell holder in the top plate and lower the operating handle until the primer is seated. *See photo 7.* Proper primer seating requires that the primer be seated between .002 and .004 inch below the case head.





Please Note: Insufficient or excessive primer seating depth will greatly decrease primer sensitivity and can result in misfires. Due to the mechanical advantage of this press, it is possible to over-seat or crush primers during this operation. Care must be exercised until you learn the proper "feel".

After you have accurately weighed the powder charge, it can be poured into the primed case. You are now ready for the final step of reloading the case—seating the bullet.



SEATING THE BULLET

8. Remove the ram priming unit and bushing from the press and install the seater die in the top plate. Adjust the .50 cal seater die as you would any regular seater die. Insert a primed and powder charged case into the shell holder, hold a bullet over the mouth of the case with one hand and lower the press handle with the other. Run the bullet and case into the seater die. *See photo 8.*

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