#749-101-020 Sinclair Stainless Ultimate Trimmer

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Congratulations on your purchase of another fine Sinclair reloading product. For best results, please take a few minutes to carefully read the following instructions before installing and using this product.

Sinclair Stainless Ultimate Trimmer

The Sinclair Stainless Ultimate Trimmer can be used to trim cases to the correct trim length. All you need is the correct Wilson case holder to hold the case. No pilots are needed. Additional tooling is available for reaming primer pockets to remove military crimps, inside neck reaming, and chamfering case mouths (30° and 45° cutters).

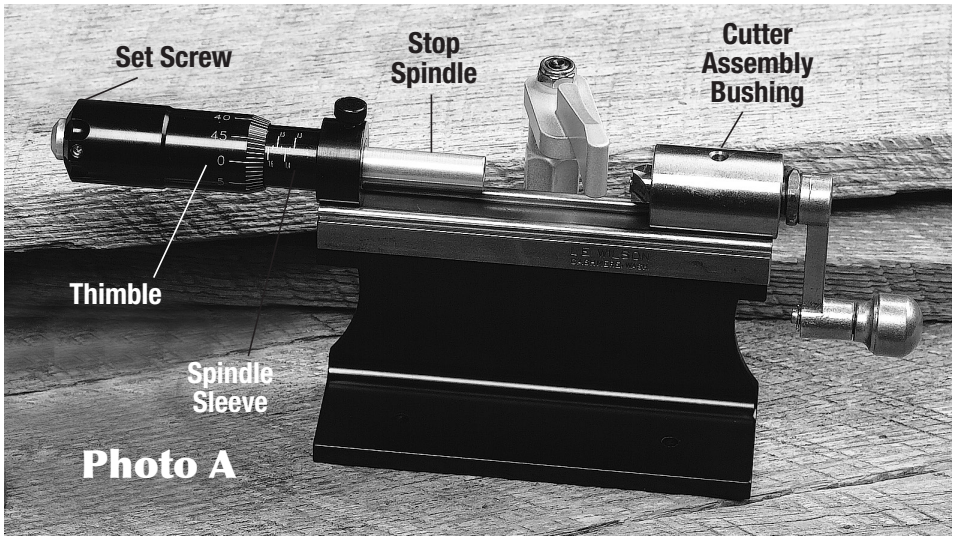

Photo A

Setup:

Your trimmer micrometer has been set up at our shop and is almost ready for use. There are only two items you need to address before starting to trim. (1) The cutter has been installed backwards in the cutter bearing for shipping and needs to be properly installed. (2) The shark-fin case holder clamp (already installed) may require some final tuning. To accomplish this final tune you will need either a 7⁄16" open end wrench, socket or a crescent wrench to tighten or loosen the lock nut on the top of the shark-fin clamp assembly. This will add or remove tension that is put on the case holder by the shark-fin arm.

Your Stainless Ultimate Trimmer can be fastened to a bench top with screws or bolts (use holes in bottom of mount) or can be c-clamped to a bench top with a single c-clamp.

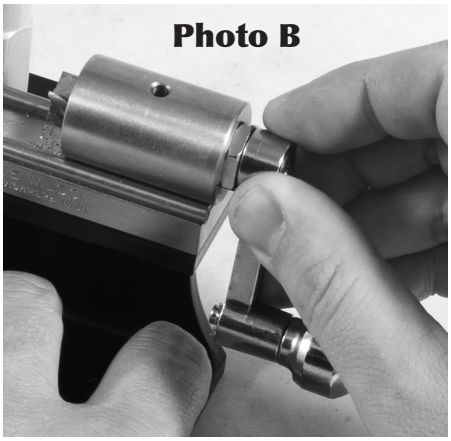
Photo B

Use Your Trimmer:

1) Unlock the micrometer by turning thumbscrew on top of micrometer.

2) Set micrometer to desired case length and re-tighten thumbscrew.

3) Cases are held in Wilson case holders by their body taper. Each rifle case holder has a groove in one end. Insert the case in that end. Drop the case in mouth first and then tap the case head on a hardwood or plastic block. With a little practice, you will find this an extremely fast way to load cases into the shellholder. The case head should always be protruding out the grooved end and the case mouth should be protruding out of the other end. Pistol cases require a mallet unless using the Q-Type holder, which we highly recommend.

4) Set the case holder (with case) on the rails of the trimmer.

5) Push the case head against the stop spindle of the micrometer assembly. To use the shark-fin case holder clamp simply swing the shark-fin arm over the case holder. This should both secure the case head against the micrometer spindle and prevent the case holder from spinning and/or moving in the trimmer. It should require some force to move the arm over the case holder. If you find that the arm is putting too much or not enough tension on the case holder you can adjust the tension by using the method described in the "Setup" section above. As you trim, all you need to do each time is swing the arm onto the top of the case holder.

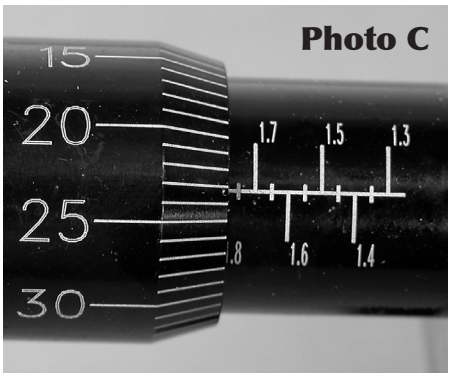

Photo C

6) When the case head is against the stop spindle, you can begin turning the crank on your cutter assembly. Keep turning until the cutter assembly is as far as it can go against the cutter assembly bushing. Check the case length on your first trimmed case with calipers to verify your micrometer zero is still good. It's a good idea to periodically check your trimmed cases for the correct length.
7) Once trimming is complete, remove the case holder with case from the trimmer and lightly tap the case mouth on your hardwood or plastic block. Tap straight down on the case mouth for best results to remove the case from the holder.

8) Chamfer and debur the case mouth with your case mouth deburring tool. We recommend completing all of your trimming and then debur all of your case mouths in one step.

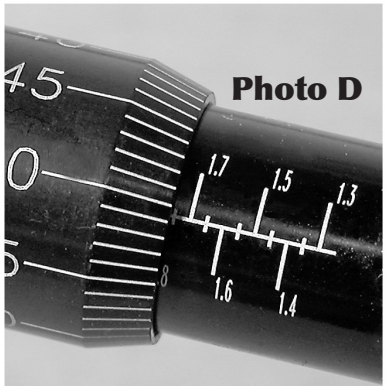

Photo D

Maintenance of Your Trimmer:

Not much is required to keep your trimmer in great shape. The cutter should last for thousands and thousands of cuts. If you ever get to the point where it begins tearing the case mouths, you may wish to order a new replacement cutter from Sinclair International.

Occasionally, put a few light drops of oil in the hole on top of the cutter assembly bushing. This will keep your cutter shaft lubricated and prevent unnecessary wear on the bushing. You may also wipe your trimmer down with an oil or rust preventative.

Instructions on Reading the Sinclair Micrometer:

Each full revolution of the Micrometer's thimble equals .050" of movement. Each minor graduation on the thimble is equal to .001". A numerical value is on every fifth graduation and represents .005" of movement.

The vernier scale on the spindle sleeve is graduated in increments of .050". Thus, one rotation of the thimble represents one increment on the spindle sleeve. The graduations on the spindle sleeve are labeled every .100". For example, the reading halfway between 1.3 and 1.4 on the scale would be 1.350".

To read the thimble and spindle scales together, look at the spindle scale first. The graduation on the spindle closest to the edge of the thimble is the first number in your reading. In Photo "C", the small (un-marked) graduation after 1.7 is clearly showing. That makes the first half of your reading equal to 1.750". Now look at the thimble scale and see what mark is in line with the vernier scale on the spindle. This is a number between 0 and 49. In Photo "C" the graduation "23" on the thimble is lined up with the scale on the spindle. Put this with your first reading of 1.750" and you end up with a measurement of 1.773".

When setting up your micrometer during the "Zero" phase, it is preferred to have the graduation on the spindle just emerging from under the thimble as the thimble graduation turns to "0". See Photo "D".

Zeroing Instructions:

Your Ultimate Trimmer comes pre-zeroed; if you need to re-zero the micrometer follow the directions below.

You will need a 5/64" allen wrench, an empty brass case that you have measured with calipers, and the appropriate Wilson case holder. If you do not know how to read a micrometer, please read the "Instructions on Reading the Sinclair Micrometer" before continuing. Setup is much easier if the brass chosen measures close to an even .100", for example a case that measures 1.500" would be ideal.

1) Back the micrometer off to at least .500" longer than the case being used.

2) Push the cutter assembly up fully against the cutter assembly bushing. Hold the cutter assembly in this position thru Step 5. See Photo "B".

3) Insert the pre-measured brass case into the case holder and set it on the trimmer rails in the normal use position with the case mouth up against the cutter.

4) Now, turn the micrometer until the stop spindle contacts the rear of the case. The case mouth should still be contacting the cutter and the cutter assembly should still be against the cutter housing.

5) Lightly tighten the small thumbscrew on top of the mounting collar. Do not over tighten this thumbscrew; you just need to lightly tighten it to prevent the stop spindle from moving. Now you can stop holding the cutter in position.

6) Loosen the small setscrew located at the rear of the thimble. See Photo "B" for location. You will now be able to slide and rotate the thimble freely on the spindle/sleeve.

7) Rotate and slide the thimble into the correct measurement position for the pre-measured case used in Steps 1 thru 4. Example: If it measured 1.500", set the thimble into that position. See "Instructions on Reading the Sinclair Micrometer".

8) Now tighten the small setscrew located at the rear of the thimble. ***DO NOT OVER TIGHTEN THIS SCREW, JUST SNUG IT DOWN!***

9) Using a culled case or an older case, trim to length and measure the trimmed case with calipers to verify your zero.

NOTE: If you ever change cutters or have the cutter re-sharpened, you will need to re-zero your micrometer.