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Warranty Agreement

The Dillon Super 1050 reloader has been designed as a commercial machine. Our expectation is that its life expectancy will be in excess of two million rounds of loaded ammunition. All Super 1050 machines are warranted for life from defects in material or workmanship, plus a one-year, 100% warranty against normal wear. All electrical/electronic components in Dillon equipment are covered by a one-year warranty.

Mandatory Safety Measures

The reloading of ammunition and the handling of components (gun powder and primers) is inherently dangerous, indeed shooting firearms is inherently dangerous. Accidents can and do occur, sometimes with disastrous results including, but not limited to, loss of vision, hearing or life. These accidents are nondiscriminatory, they occur with both the novice and the experienced reloader.

Dillon Precision Products has consciously designed the Super 1050 with this in mind. We’ve shielded the primer magazine and machined clearance holes for the elimination of powder and primer residue. In short, we have done everything we know how, to make the use of our machine as safe as possible. We cannot however, guarantee your complete safety. In order to minimize your risk, use common sense when reloading and follow these basic rules:

Never operate the machine without ear and eye protection on. Call our customer service department at (800) 223-4570 for information on the wide variety of shooting/safety glasses and hearing protection that Dillon has to offer.

• PAY ATTENTION: Load only when you can give your complete attention to the loading process. Don’t watch television or try to carry on a conversation and load at the same time. Watch the automatic systems operate and make sure they are functioning properly. If you are interrupted or must leave and come back to your loading, always inspect the cases at every station to insure that the proper operations have been accomplished.

• SMOKING: Do not smoke while reloading or allow anyone else to smoke in your reloading area. Do not allow open flames in reloading area.

• SAFETY DEVICES: Do not remove any safety devices from your machine or modify your machine in any way.

• LEAD WARNING: Be sure to have proper ventilation while handling lead components or when shooting lead bullets. Lead is known to cause birth defects, other reproductive harm and cancer. Wash your hands thoroughly after handling anything made of lead.

• LOADS AND LENGTHS: Avoid maximum loads and pressures at all times. Use only recommended loads from manuals and information supplied by reliable component manufacturers and suppliers. Since Dillon Precision has no control over the components which may be used on their equipment, no responsibility is implied or assumed for results obtained through the use of any such components.

Seat bullets as close to maximum cartridge length as possible. Under some conditions, seating bullets excessively deep can raise pressures to unsafe levels. Refer to a reliable loading manual for overall length (OAL).

• QUALITY CHECKS: Every 50-100 rounds, perform periodic quality control checks on the ammunition being produced. Check the amount of powder being dropped and primer supply.

• RELOADING AREA: Keep your components safely stored. Clear your work area of loose powder, primers and other flammables before loading.

• COMPONENTS: Never have more than one type of powder in your reloading area at a time. The risk of a mix-up is too great. Keep powder containers closed.

• LEAD WARNING: Be sure to have proper ventilation when handling components containing lead. Wash your hands thoroughly after handling anything made of lead.

• PAY ATTENTION: Load only when you can give your complete attention to the loading process. Don’t watch television or try to carry on a conversation and load at the same time. Watch the automatic systems operate and make sure they are functioning properly. If you are interrupted or must leave and come back to your loading, always inspect the cases at every station to insure that the proper operations have been accomplished.

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We have done everything we know how to make your machine as safe as possible. We cannot, however, guarantee your complete safety. To minimize your risk, use common sense when reloading and follow these basic rules.

• REMEMBER: If your machine does not perform to your expectations, or if you are having technical difficulties, give us a call. Technical Support (800) 223-4570
Contents

- Super 1050 machine with caliber specific shellplate and loading dies installed and adjusted.
- Casefeeder Assembly: casefeed bowl, caliber specific casefeed plate, casefeed mounting post, casefeed tube, and post studs
- Collection bin support bracket
- Bullet bin bracket
- Collection bin
- Bullet bin
- Spent primer cup
- Powder measure assembly
- Powder bar return rod assembly
- Primer early warning system
- Operating handle
- Die box

See the schematics pages in the back of this manual for more detail.
How the Super 1050 Works

Stations 1 - 8 (counterclockwise)
toolhead and dies cut away for clarity

Station 1: Empty cases are automatically inserted into the shellplate via the electric casefeeder.

Station 2: Here the spent cartridge cases are resized and deprimed.

Station 3: Here the case mouth is expanded while a rod supports the case base for swaging.

Station 4: A new primer is installed at this station. The spring driven primer slide is extremely smooth. The steel shrouded primer magazine is capped with an electronic Early Warning Device to let you know when you’re down to approximately three primers.

Station 5: Here the case mouth is belled and powder dispensed.

Station 6: This station is open to allow for case inspection.

Station 7: The bullet is seated to its proper depth at this station.

Station 8: In this station, the bullet is crimped and then ejected out of the shellplate with the next pull of the handle.

Your dies have been adjusted at the factory. Before you change anything, try it the way it is, once you thoroughly understand the machine’s operation, make whatever adjustments to the dies you feel necessary.

Reminder: There may be some variation due to components.
Super 1050 Assembly

Your new Super 1050 has been assembled at the factory. All of the adjustments necessary to reload have already been made, in fact we’ve even adjusted the dies to reload the caliber you have chosen. However, before you can reload you must do some minor assembly.

Due to variations in components, check all stations for proper settings before loading ammunition. It is absolutely necessary that you read the following instructions.

If you get stuck on something that you don’t understand, call (800) 223-4570 for technical assistance.

Step 1: Mounting the Super 1050

Select a clear area on your reloading bench. Be certain your bench is free from vibration and is strong enough to support your Super 1050’s mass and operating force. If possible, attach your bench to the wall using screws.

Remove the Super 1050 main frame from the packaging and place it on your selected area. The crank extension (#11000) should be to your right. Bring the machine to the forward edge of your bench – be sure to allow clearance for operation of the handle. Mark the four mounting holes using the machine as a template. Remove the machine and drill four 1/4” holes through the bench. Replace the machine and bolt securely. Fig. 1

Fig. 2 - Note that there are three different positions for mounting the operating handle.

Install the handle (#12727) as indicated in the parts schematic. Secure in place with the handle set screw (#13432). Fig. 2 You will note that there are three different positions for mounting the operating handle. Choose the one that feels best for you. The longer the handle, the less force required but the stroke is longer.

The toolhead (#20420) is held down on the main frame for shipping by the use of plastic ties. Remove the ties while holding the handle.

Slowly move the handle up. This will move the toolhead approximately three inches to its “up” position. Note: If the handle is not moving freely, carefully inspect for shipping damage.

Step 2: Installing the Casefeed Assembly

Using the screw provided (#13377) install the bin bracket (#13238). Fig. 5

Install the bullet bin bracket (#12144) to the casefeed post (#20641) using the screw (#13685) as shown in the schematic on page 30.

Screw the casefeed post studs (#13271) to the main frame (place the washer provided on the bottom post only), tighten securely with an Allen wrench through the cross hole provided.

Fig. 4 - Locator button being inserted into its proper position.

Fig. 5 - See the schematic on page 30 for more details.
The casefeed mounting post assembly (#20641) is attached to the casefeed post studs (#13271) by the use of two post bolts (#13205). Attach the power cable and clamp and bin bracket (#12144) as shown in the schematic on page 30. Fig. 6

The casefeed bowl assembly needs to be placed on the casefeed post with the Dillon logo and the on/off switch facing you.

The casefeed tube (#13761) should now be inserted into the casefeed adapter (#13654*) Fig. 7 Note that the tube is marked “up” on one end. Press this end into the tube clip (#13859) attached to the casefeeder motor housing Fig. 8. This assembly is now complete.

Step 3: Installing the Powder Measure

Remove the blue cap from the powder die (#20320) and loosely clamp the powder measure in position. Fig. 9 Install the powder measure return rod (#13960) through the 3/8” eyebolt (#13089) mounted on the left rear of the main frame. Fig. 10 Now attach the rod to the powder measure bellcrank using the clip. Fig. 10 Install the spring (#14033) and wing nut (#13799) on the rod and screw the wing nut up until you feel light tension on the spring. Tighten the powder measure clamp screws (#14037).

Step 4: Installing the Spent Primer Cup and Bullet Bin

Install the spent primer cup (#13650) on the right side as shown on the schematic on page 27. Fig. 11

Install the spent primer cup (#13650) on the right side as shown on the schematic on page 27. Fig. 11
Hook the bullet bin (#13756) and the collection bin (#13484) on to their respective brackets. Fig. 12

**Step 5: Cycling the Machine**

At this point your assembly should be complete. Gently pull the operating handle towards you, make a full stroke to the bottom and up again. The shellplate should be indexing and the primer slide (#20318*) should function. The casefeed plunger (#13073*) should travel forward to the shellplate. Make sure that you repeat this several times to gain an understanding of the various functions of the machine before you start reloading. Fig. 13

Now plug in the casefeed motor and activate the switch. The casefeed plate should turn smoothly within the casefeed bowl.

Assuming that all is well, proceed with components.

**Loading Components**

Your Super 1050 is equipped with a cartridge activated powder measure that will dispense powder only when a cartridge is in Station 5.

It is important to understand that the adjustable powder bar should reach the end of its travel at the same time that the handle reaches the bottom of its stroke against the frame stop. Fig. 14 To achieve this adjustment, the die body must be screwed up or down as needed.

The powder die has already been adjusted at the factory. An empty case must be placed in the shellplate at Station 5 in order to check this adjustment. Note that the case used to adjust the powder measure die must already be sized.

**NOTE:** If you are adjusting for a straight wall case, start your powder die adjustment with the die obviously too high and work down. This will avoid over belling the case.

If you are adjusting a case with a shoulder, such as a .223, do not turn the die down too far or the shoulder will buckle.

Use a reloading manual to determine how much powder you need for a particular load and an accurate powder scale to determine the weight. Caution: While you do not have to use a Dillon Precision powder scale, you should use a scale of equal quality. Do not use scales with plastic frames or “razor blade” pivots. Quality scales have jeweled pivot points. Razor blade pivots can dig into the frame of the scale and give dangerously inaccurate readings.

**Powder Measure Adjustments**

In Station 5 we adjust the powder measure. It works like this: screw the powder die into the toolhead and insert the pistol powder funnel expander or a rifle powder funnel with the grooved end toward the top of the powder die.

Fig. 14 The funnel should move freely in the die, leaving a loose fit between the top of the die and the powder measure collar. This will enable you to adjust the die to give you a bell on the mouth of your pistol cases making it easier to start the bullet.

On rifle cases, the die should be adjusted so that the powder funnel will contact the mouth of the case and then fully actuate the powder bar. These adjustments are accomplished with a sized case in the shellplate and alternately raising and lowering the operating handle while adjusting the powder die.

When properly adjusted, the powder bar will be moved to the end of its travel by the cartridge case Fig. 14.
When you have determined that your adjustments are correct, tighten the lock ring (#14067). Fig. 16

**Powder Bar Return Rod Assembly**

The purpose of the powder bar return rod is to return the powder bar to its closed position.

Remove the blue cap from the powder die (#20320) and loosely clamp the powder measure in position.

To install the powder bar return rod (#13960) remove the blue wing nut (#13799) and rod spring (#14033) from the rod, then insert the bottom end through the 3/8” eyebolt (#13089) that is mounted on the left rear of the main frame.

Next, using your thumb and index finger of your left hand, move the lock-link down and align the hole with the slot on the bellcrank. Then, insert the rod through the two holes and insert the return rod clip (#13929). Fig. 17

When the correct powder charge had been set, cycle several cases through the machine and check the load with a scale.

**Primer Magazine**

Select the proper size primer pick-up tube and fill it by placing the plastic tip over loose primers and pressing down.

You will notice that the primer magazines and primer pick-up tubes have different colored tips. They have been color coded to help you identify size more easily.

The color code is as follows:

- Blue  Small Primer Magazine Orifice
- Red    Large Primer Magazine Orifice
- Yellow Small Primer Pick-up Tube
- Green  Large Primer Pick-up Tube

The shiny side of the primers should be facing up. This is most easily accomplished by use of a primer flip tray. Fig. 21 This quality cast metal flip tray is available from Dillon Precision and is a better choice than the smaller plastic trays which are difficult to use and have a tendency to warp.
caliber cartridges that may be hidden in larger caliber cartridges. **Fig 23**

**Warning:** Be sure that no loaded rounds are mixed with your empty cases. It is possible to feed a blunt nosed cartridge like a .38 Sp. WC into the shellplate upside down and explode it when it is hit by the decap pin.

---

**The Electric Casefeeder**

Once you’ve filled the pick-up tube, make sure the little retaining clip is in place at the top of the tube. **Fig. 22** Pivot the switch lever (#13864) away from the Early Warning System housing and invert the pick-up tube over the primer shield cap (#13957). You will notice the cap has a bevel to help you funnel the primers in. Hold the tube in place as shown in **Fig. 22**, pull the retaining pin and allow the primers to drop into the magazine. Pivot the switch lever back over the Early Warning System housing. Gently slide the follower rod down through the switch lever and into the primer magazine tube. When you are nearly out of primers, approximately three remaining, the follower will activate the buzzer.

---

**The Electric Casefeeder**

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---

**The Electric Casefeeder**

Now fill the casefeed bowl with approximately 500 pistol cases or about 350 rifle cases. **Fig 24**

Your Super 1050 is now charged with components and ready to go, but before you start reloading, read the following explanation of the sequence of the eight reloading stations and the processes that are done at each station.

**Review: How the Super 1050 Works**

**Stations 1 - 8 (counterclockwise)**

**Station 1:** Empty cases are automatically inserted into the shellplate via the electric casefeeder.

**Station 2:** Here the spent cartridge cases are resized and deprimed.

**Station 3:** This station is totally unique. The case is supported from the inside and slightly expanded (not belled) while simultaneously a swager is driven into the primer pocket to remove any crimp.

**Station 4:** A new primer is installed at this station. The spring driven primer slide is extremely smooth. The steel shrouded primer magazine is capped with an electronic Early Warning Device to let you know when you’re down to approximately three primers.

**Station 5:** Here the case is belled and powder is dropped by the case-activated powder measure. It is extremely accurate and will not drop powder unless a case is present. Dillon Precision offers an optional accessory to be utilized with the automatic powder measure at this station – Dillon’s Low Powder Sensor provides an audible and visual reminder when it’s time to refill the powder reservoir.

**Station 6:** This station is open to allow for case inspection.

**Station 7:** The bullet is seated to its proper depth at this station.

**Station 8:** In this station, the bullet is crimped into place. The cartridge is then automatically ejected into a collection bin.

As stated earlier, your dies have been adjusted at the factory. Before you change anything, try it the way it is, once you thoroughly understand the machine’s operation, make whatever adjustments to the dies you feel necessary.

Reminder: There may be some variation due to components.

**To Begin Reloading**

Turn on the switch on the front of the casefeeder motor housing. The casefeeder plate should begin to turn. Cases will begin to dispense, base down, into the clear plastic casefeed tube. The motor
will continue to run until the tube is full, at which point a micro-switch will temporarily stop the case flow.

From this point the casefeeder will automatically fill the tube as you reload. If the casefeeder does not function properly or the cases do not fall base down, refer to the Trouble Shooting section of this manual.

Pull the operating handle smoothly to the bottom stop, then raise the handle, a case has been fed to Station 1. Cycle the handle again, strive to be smooth in your operation.

The first case should be indexed to Station 2. Cycle the handle again. It is not necessary to apply any force on the upstroke of the handle. All you are doing on the upstroke is indexing the shellplate. Remember that priming is done on the down stroke. A slow measured upstroke gives you lots of time to pick up the next bullet and ready it for seating. If you count one second down, and one second up, you’ll have a good pace.

5. Remove the locator button (#20637*), extract the round and check the primer. If everything looks okay, replace the case and button and proceed. However, if the primer is not seated properly (too high or too deep) you will need to adjust the primer push rod (#12819). Clockwise turns of the primer push rod will cause the primer to be seated deeper while counterclockwise turns will seat the primer higher.

Cycle the handle again, the automatic powder measure will drop the charge you’ve selected. Pistol casemouts will be belled at this time. Look through the inspection hole in Station 6 – you should be able to see your powder charge in the case.

The first case should now be in Station 3 with a case in Stations 1 & 2 as well. Cycle the handle again. The case is swaged and expanded at Station 3. Observe the swage operating part (#20314*), if the swage is proper, proceed – if not see items 3 and 4 in the Trouble Shooting section of this manual. Cycle the handle again and the case gets primed at Station 4.

If the primer is not seated properly (too high or too deep) you will need to adjust the primer push rod (#12819). Clockwise turns of the primer push rod will cause the primer to be seated deeper while counterclockwise turns will seat the primer higher.

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Cycle the handle again, the automatic powder measure will drop the charge you’ve selected. Pistol casemout will be belled at this time. Look through the inspection hole in Station 6 – you should be able to see your powder charge in the case.
ple height adjustment to the seating stem may be necessary. Refer to a loading manual for proper loaded length (OAL). Cycle the handle again and check for crimp at Station 8. Refer to Trouble Shooting item 8 for adjustments if necessary. Add a bullet, cycle again. Your first loaded round should now be ejected into the collection bin.

If all has gone well to this point you’ve got it made. Just keep adding bullets, watch your fingers so they don’t get caught and don’t hurry. Just try to be smooth in your operation. The speed will come naturally and you’ll be doing a thousand rounds per hour before you even realize it.

The following are some adjustment suggestions as well as Trouble Shooting hints.

**Adjustments**

**Casefeeder**

It may be necessary to readjust the micro-switch for different calibers. Cases may become lodged between the micro-switch and the tube wall. The other extreme is the case failing to put enough pressure on the micro-switch to shut off the system causing it to continue running and over flow the tube. Fig. 26

The casefeed spacer (#13703) supplied in the accessory package, is to be used when you are reloading .41 Mag, .44 Mag, .357 Mag, .30 Carbine, or .45 Colt.

**Handle**

The operating handle is adjustable to three different length settings. Choose the one most comfortable for your operation. Loosen the set screw (#13432) then retighten when the handle is in the most comfortable position.

**Swager**

Swaging on the Super 1050 is a simple process and is necessary on all cartridge cases as a means of uniforming the entrance of the primer pocket. Fig. 29 The swage rod (#20314 large or #20313 - small) is fully adjustable.

**Swage Conversion and Adjustment Conversion – Fig. 30**

Begin by removing the swage cover (#13064). Next remove the hitch pin (#13840) and slide out the clevis pin (#13522). Remove the operating handle. Rotate the swage connecting rod a half turn and remove it. This will allow you access to the swager. Pull the swager down and out of the machine. Fig. 30

Insert the new swager and reassemble.
Swage Adjustments
Use ONLY an unswaged military case for these adjustments.

With the handle in the down position, screw the swage back-up expander down until it makes contact with the case bottom and holds it in place. Fig. 31

With the handle still in the down position, turn the swage rod up until it makes contact with the case bottom.

Raise the handle half-way and rotate the swage rod a quarter turn. Now, cycle the handle. Inspect the case and when you achieve a completed swage of the primer pocket, tighten the swage lock nut (#14067).

A properly swaged pocket will show a rounded edge around the rim. Some military cases (.223 & .308) start out with three small dents around the base of the pocket, once properly swaged, the dents will no longer be visible. Fig. 32

Primer System Change Over Instructions
The Super 1050 has been shipped to you with either the large or small primer system installed. To change the system from large to small or vise versa, follow these instructions:

Be sure all primers have been removed from the primer system. Then remove the Early Warning System and the knurled cap. Then remove the primer magazine (#22031 - large or #22030 - small) and replace it with the new size magazine. Be sure the key on the tip (#14003 - large or #14024 - small) is in the slot and the magazine is all the way down in place. Fig. 33

Pull the operating handle to its down position.

Loosen the lever arm bracket screw (#14037) and slide the bracket assembly up four inches and lock it in place. Fig. 34

Remove the powder bar return rod (#13960) from the powder measure bellcrank (#17839) by releasing the return rod clip (#13929). Fig. 35

Remove the casefeed tube (#13761) and place it on your bench. Remove the toolhead. Fig. 36 For more information see the following section – TOOLHEAD REMOVAL.
Now remove the shellplate lock nut (#13425) by loosening the four locator tab screws (#13895) about four full turns. **Fig. 37**

Loosen the ejector tab screw (#13896) and swing the ejector tab (#13189) out of the way. **Fig. 38** Next, slide the casefeed plunger (#13073*) back and remove the shellplate. **Fig. 39**

Next, remove the bushing (#13031 - large or #13222 - small); spring (#13858) and punch (#12849 - large or #13307 - small) and replace them with the parts for your new primer size. Note that there is a specially designed screwdriver supplied for the bushing (included in the accessory bag). **Fig. 40**

You should clean your machine at this time. **Fig. 41** Prior to installation, lube the base of the primer punch. Now adjust your new punch (#12849 - large or #13307 - small) so that it is flush with the bushing (#13031 - large or #13222 - small) by turning set screw (#13226) up or down. If the primer punch is too low, dirt will collect on top of it leaving imprints on your primers. If it is too high it will bind the slide. Note: You can use the slide for a guide. Slide it back and forth over the bushing to check your adjustments. See the schematic on page 29 or the trouble shooting section for additional information.

**Toolhead Removal**

Disconnect the powder bar return rod (#13960) from the bellcrank (#17839) by releasing the return rod clip (#13929). **Fig. 42**

Remove the Primer Early Warning device.

Raise the primer slide lever assembly (#20488) and lock in place - see Fig. 34.

Now remove the toolhead bolt (#13342) turn it in only finger tight then cycle the handle up and down to make
sure everything is properly located. With the handle in the down position, tighten the toolhead bolt with the above mentioned wrench.

Shellplate Removal
Loosen the ejector tab screw (#13896) and swing the ejector tab (#13189) out of the way. Fig. 38
Loosen the four locator tab screws (#13895) about four full turns. Fig. 37
Use a toothbrush to remove any powder that may be in the threads before removing the lock ring.

Next remove the lock ring (#20311). Now push the casefeed plunger back (#13073*) and lift the shellplate off. Be sure to lightly grease the bore of the shellplate when reinstalling it. Fig. 44
Rule of thumb: turn the lock ring down until tight then back off one-eighth of a turn. Then tighten the four locator tab screws (#13895).

Casefeed Plunger Conversion
When changing calibers it may be necessary to replace the casefeed plunger (#13073*).
To do this, remove the clear casefeed tube (#13761) and pull out the colored casefeed adapter (#13654*). The adapter is taped for shipping purposes.
Remove the two housing screws (#13815) and the casefeed adapter housing (#11006).

Die Adjustments
Station 2 - To install the size/decap die
Warning: Never attempt to deprime live primers, an explosion may result.
Move the toolhead down, by lowering the handle all the way down.

Fig. 44 - Your machine will work its best when properly cleaned and lubricated.

Fig. 45 - The casefeed plunger and spring are under tension. Hold them in place while removing the roller bolt.
Place your hand on the plunger while removing the roller bolt (#13333). This will prevent the casefeed plunger and spring from jumping out of the machine. Fig. 45

Fig. 46 - Be sure to lightly grease the sides of the casefeed plunger track, casefeed plunger and roller after cleaning.
Thoroughly clean the track and casefeed parts with a solvent. Now very lightly apply grease to the sides and install the proper size casefeed plunger (#13073*). Fig. 46 Remember to grease the roller (#13498) and the roller track (Fig. 46) and Loctite the threads on the roller bolt (#13333).
Install the casefeed housing and insert the proper size adapter (#13654*). The casefeed tube (#13761) should now be inserted into the casefeed adapter (#13654*). Note that the tube is marked “up” on one end. Press this end into the tube clip (#13859). See the Trouble Shooting section for any adjustments.

Fig. 47 - Screw the size/decap die down until it just touches the shellplate.

Screw the sizing die into Station 2. Continue to screw the die down until it just touches the shellplate. Fig. 47
Tighten the die lock ring finger tight. Now move the toolhead up by raising the handle to its upright position.
Note: When loading .270 or .30-06 you need to raise the decap assembly so that the hitch pin clip is a minimum of 1/8” above the silver lock ring as shown in Fig. 47.
Place a case in the casefeed funnel. Here, the case drops to the casefeed plunger.
Cycle the handle. The casefeed cam pushes the roller bushing back, dropping the case into the slot of the plunger.
Cycle the handle. The case is inserted into the shellplate.
Note: After raising the handle, insure that you push the handle against its full aft stop. This will insure that the shellplate fully advanced to the next station.
Note: When priming, pushing the handle against its stop, will insure that the primer is fully seated.

Fig. 47 - The casefeed plunger and spring are under tension. Hold them in place while removing the roller bolt.
Again, move the toolhead down.
The case is now sized. If the case has a
spent primer, it will be deprimed.
Leave the toolhead in this position
with the case fully inserted in the die.

**Fig. 48** This will ensure that the die
remains in alignment when tightening
the lock ring.

Using a 1-1/8” wrench to turn the
lock ring and a 7/8” wrench to hold the
die body, tighten the lock ring.

**Station 3 - Adjustment of the
Expander Die**

Install the expander die (caliber
specific) at Station 3. Place a case in
Station 2 and cycle the operating han-
dle once (sending the case to Station
3). Turn the expander die down until
you feel it make contact with the case
and cycle the operating handle. Make
adjustments in one-quarter turn
increments until the desired expan-
sion of the case mouth is achieved.
Tighten the die lock ring.

**Fig. 49** - You don’t need any more expansion
than what you see in this photograph.

A properly expanded case should
show a slight flare at the case mouth.

**Fig. 49**

**Fig. 50** - When properly adjusted, the
case mouth will go past the expanding
line and the stem will contact the bottom
of the case.

**Station 5 - Adjustment of the Powder
Die/Powder Funnel**

Note: Adjusting the powder die for
a straight wall case is not the same as
adjusting a powder die for a bottle-
necked case. This is because straight
wall cases are given a bell and bottle-
necked cases are not given a bell.

For the powder bar to properly dis-
pense a measured powder charge, the
powder bar must travel its full dis-
tance. To travel its full distance, the
white cube must contact the powder
measure body (see arrow **Fig. 51**).

**Fig. 51** - This photo shows the powder bar at
the end of its travel.

Also the belling process does not
begin until after the powder bar has
traveled its full distance. The angled
portion on the bottom of the powder
funnel (**Fig. 52**) is what bells the car-
tridge. Once the white cube has con-
tacted the powder measure body the
case is forced upward against the
tapered portion of the powder funnel
producing a bell. The more the powder
die is adjusted down (clockwise) the
more the case will be belled.

Note: If the powder die is not adjust-
ed down far enough to cause the pow-
der bar to travel its full distance the
powder charge will be erratic and the
case will not receive enough bell.
Station 5 - Adjustment of the Powder Die/Powder Funnel Cont...

Drop a case into the casefeed funnel and cycle the handle twice. The case should now be in the shellplate at Station 2.

Move the handle down. Notice the resistance at the end of the down stroke. This is the resistance of the case in the sizing die. Raise the handle. The case will index to Station 3.

Cycle the handle to advance the case to Station 4. Again, cycle the handle to prime the case and index it to Station 5.

Cycle the handle.

If the white cube has not traveled its full distance, raise the toolhead just enough to pull the case off of the powder funnel (this will prevent the shellplate from indexing while you adjust the powder die). While holding the powder measure, turn the die down 1/8 of a turn. Again lower the toolhead and observe the travel of the powder bar.

Repeat as needed until the powder bar travels its full distance, Fig. 51.

Once the powder bar travels fully across you should continue to adjust the powder die for the desired amount of bell (turn the powder die 1/8 of a turn at a time). The desired amount bell is just enough to allow the bullet to sit on the case mouth without falling off and to keep the case from shaving lead during the seating process - see the illustration (right) example “B”.

Note: If you screw the die down too far, the case will look like example “C” in the illustration (right). You must then discard this case, back the powder die off, by turning it counter-clockwise, and continue with a new sized case.

You’ll soon learn to judge the correct amount of bell by simply looking at it. In the meantime, you might want to use your dial calipers to check it. Twenty thousandths of an inch greater (at the mouth of the case) than its original diameter, should about do it.

Once you’ve achieved the desired amount of bell – with the case in Station 5, raise the toolhead. Run the lock ring down hand tight.

While holding the powder measure in place, snug the lock ring using a 1-1/8" wrench.

Station 7 - General Information on Bullet Seating

The purpose of the seating die is to insert the bullet into the case and to push it down into the case the proper amount.

How far the bullet is pushed into the case will determine the overall length (OAL). Several factors go into determining the proper OAL – such as, the maximum recommended OAL, listed in the reloading manual, and the type of bullet being loaded. The type of bullet can determine the OAL in one of two ways.

If the bullet has what is called a cannelure, or crimping groove Fig. 54 & 55, this will determine the proper OAL. If the bullet you’re using doesn’t have a cannelure or a crimping groove, then you’ll need to refer to your reloading manual for the suggested OAL. The purpose of the cannelure and crimping groove is to secure the bullet by giving the mouth of the case a place to go (without deforming the bullet) when being crimped. When the bullet is properly seated, the mouth of the cartridge case should be near the top of the cannelure/crimping groove. Refer to your reloading manual. Under the section specified for the caliber you’re loading, you’ll find a

Fig. 53 - Make sure the bellcrank and return rod bolt are aligned.

Insure the bellcrank and the return rod bolt (in the frame) FIG 53 are aligned. Using a 5/32" Allen wrench, snug the collar clamp screws.
schematic of the cartridge. For example,.38 Special lists a maximum OAL of 1.55" (Lyman Reloading Handbook). If you’re seating the bullet to the cannelure/crimping groove, the OAL should be well within the maximum OAL listed, however, use a set of dial calipers to check it. (Dial calipers are available from Dillon Precision). If the bullet you’re using doesn’t have a cannelure/crimping groove, refer to the specific type of bullet you’re using in the reloading manual. For example – if you’re loading a 158 gr. .38 Sp. JHP and it doesn’t have a cannelure/crimping groove, use the suggested OAL of 1.480 (Lyman Reloading Handbook).

Station 7 - Installation and Adjustment of the Seating Die

Take the seating die from the die box and screw it into Station 7. Screw the die down until the bottom of the die is flush with the bottom of the toolhead. Note: At this point the die will not be screwed down far enough to begin seating the bullet, but it will give you a place to start.

Please note that every die set includes seating stems to fit most common bullet types. Select the appropriate seating stem for the bullet type you are loading.

Station 8 - Installation and Adjustment of the Crimp Die

Screw the crimp die into Station 8. Screw it down until it is flush with the bottom of the toolhead. This is a good starting point for the crimp adjustment.

Place a cartridge with a properly seated bullet into Station 8.

Fig. 56 - Place the bullet on the case mouth at Station 7.

Place a case (with a belled case mouth) into Station 7. Fig. 56

Place a bullet on the belled case mouth and lower the toolhead. Then, raise the toolhead just enough to inspect the bullet without indexing the shellplate. If the bullet is not seated deep enough, screw the seating die down 1/2 turn at a time. As a guide, one full turn moves the die down about 70 thousandths of an inch, about the thickness of a nickel. Again, cycle the machine and inspect the seating depth. Repeat these steps as necessary until the correct overall length is achieved. Use a dial caliper or equivalent to measure the overall length of the cartridge. Check the overall length of the round against the information in your reloading manual.

Once you have obtained the proper OAL, replace the cartridge into Station 7 and lower the toolhead. Using a 1-1/8" wrench to turn the lock ring and a 7/8" wrench to hold the die body, snug the lock ring.

Note: If you ever load a cartridge that you are unhappy with, you can use a Dillon bullet puller to reclaim your components.

Station 8 - Installation and adjustment of the Crimp Die

Screw the crimp die into Station 8. Screw it down until it is flush with the bottom of the toolhead. This is a good starting point for the crimp adjustment.

Place a cartridge with a properly seated bullet into Station 8.

Fig. 57 - Cut away crimp die shows the area being crimped while the case is being fully supported by the die body.

Lower the toolhead and continue to screw the die down until it touches the cartridge. Fig. 57

Raise the toolhead and screw the die down 1/8 of a turn, lower the toolhead.

Raise the toolhead half-way and inspect the cartridge. If the bell is still present, or the desired amount of crimp has not been achieved, give the die a 1/8 turn down and try again. Continue making small adjustments to your crimp die until the desired amount of crimp has been achieved.

Once the adjustment is complete, place the case back into Station 8 and lower the toolhead. Using a 1-1/8" wrench to turn the lock ring and a 7/8" wrench to hold the die body, snug the lock ring.

Note: When adjusting the crimp die it is important to know what to look for. Check that the crimp: Looks OK, allows your firearm to function consistently and the bullet feels tight in the case.

The drawing of case #3 (above) is a depiction of a case that has been over cramped by adjusting the crimp die down (clockwise) too far. Note the
defined line below the mouth of the case and the bulge below the line. This is not a proper crimp. This line is the direct result of the cartridge being over crimped. A line like this will only appear if the crimp die is adjusted down too far. Warning: Over crimping .45ACP, .38 Super, 9mm, etc., can actually cause the bullet to be loose in the case.

Adjustments for calibers 9mm, .38 Sp., .45 ACP and for hot loads that have been fired many times

Configuration 1

To begin, place a military case (sized, decapped and unswaged) into Station 3. Screw the back-up rod (#12749*) down two turns into the toolhead (#20420). Pull the handle.

Using a wrench turn the back-up rod (#12749*) down until it hits the inside bottom of the case. Note: Do not force the expander as this will damage the case and the shellplate. Now secure the lock ring (#20006*). Raise the handle.

Screw the eyebolt (#13245) all the way into the swager. Grease the clevis pin (#13522) heavily.

Put the swager into position. Push the clevis pin through the connecting rod and eyebolt and secure with the hitch pin (#13840). Replace the swage cover (#13064).

With the military case still in Station 3, pull the operating handle down with your left hand. Now turn the swager upward with your right hand until it meets resistance. With your left hand raise the operating handle about 10 inches. With your right hand turn the swager up a 1/4 turn. Cycle the handle down.

Turn the swager in, using 1/4 turn increments until you achieve the proper swage. Secure the jam nut (#13682). Note: Do not over swage. This condition will cause damage to the shellplate (#12600*).

When your swager is properly adjusted you will feel resistance during the final 1/2" to 1" of the downward stroke of the handle.

Adjustments for rifle calibers

Configuration 2

To begin, place a military case (sized, decapped and unswaged) into Station 3.

Remove the back-up rod (#12749*) from the back-up die (#12184).

With the operating handle in the down position, screw the back-up die into Station 3 until the die comes into contact with the shellplate. Now back the die out one full turn and secure it in place with the lock ring (#14067).

Leave the handle in the down position. With a wrench, screw the back-up rod into the back-up die. Turn the back-up rod down until it touches the inside bottom of the case. Note: Do not force the expander as this will damage the case and the shellplate. Now secure the lock ring (#20006*). Raise the handle.

Screw the eyebolt (#13245) all the way into the swager. Grease the clevis pin (#13522) heavily.

Put the swager into position. Push the clevis pin through the connecting rod and eyebolt and secure with the hitch pin (#13840). Replace the swage cover (#13064).

With the military case still in Station 3, pull the operating handle down with your left hand. Now turn the swager upward with your right hand until it meets resistance. With your left hand raise the operating handle about 10 inches. With your right hand turn the swager up a 1/4 turn. Cycle the handle down.

Raise the handle just enough to remove the case and inspect the primer pocket to see the amount of swaging being done. The swager should leave a radiused entrance on the primer pocket. Fig. 58

When your swager is properly adjusted you will feel resistance during the final 1/2" to 1" of the downward stroke of the handle.

RL1050 vs. Super 1050

Not all parts are the same but some are still interchangeable. We have made changes to several parts used on the Super 1050 that are not interchangeable with the RL1050 machine.

• The Super 1050 primer lever assembly (#) has a longer arm to accommodate the higher toolhead travel. This is not available for RL 1050 machines. Primer feed body (#20773) will fit both machines but again the primer lever assembly will not.

• The Super 1050 assembly does not include the ratchet cam, ratchet restriction tab and related parts.

• The Super 1050 index lever has been shortened considerably and will not index properly on RL 1050 machines.

• The Super 1050 index roller has changed in diameter and is much too large for the RL 1050.

• The Super 1050 mainshaft, mainshaft pivot pin, crankshaft assembly, and bearings are completely different.

• The casefeed body has been modified to allow long cases to feed through but is interchangeable between the Super 1050 and RL 1050 machines.

• Any RL 1050 toolhead assembly will fit the Super 1050 machine. You will need to remove the ratchet cam from the toolhead and install a 1/8” thick washer or spacer in its place. Then reinstall the cam guide bolt.

• The toolhead spring and sleeve, as a set, are longer to accommodate the increased toolhead travel on the Super 1050 but they will work on the RL 1050.

• Any RL 1050 shellplate will fit on the Super 1050 with one exception. The #1 shellplate for .45 ACP has tight fitting pockets and may or may not allow .308 Winchester cases to feed into the shellplate freely. All new #1 shellplates have a star next to the number one to indicate the revised version.

• The Super 1050 indexer return spring...
has an additional bend in it but can be used on both the Super 1050 and RL 1050 machines. NOTE: If you are using an indexer return spring from an RL 1050 spare parts kit, you will need to make an additional bend in the spring before installing it on the Super 1050.

• The RL 1050 spent primer cup has been replaced with a larger, plastic spent primer cup and bracket. It is not interchangeable.

Using RL 1050 toolheads and dies on the Super 1050...

If you want to interchange an RL 1050 toolhead already set for a caliber you want to load onto the Super 1050 you will need to check for the following clearances.

1. Remove the toolhead assembly from the Super 1050.
2. Replace the shellplate with the shellplate for the caliber you intend to load with.
3. Remove the toolhead spring and set the toolhead onto the mainshaft while holding the handle at about mid-travel for proper alignment into the frame. Next, install the washer and toolhead bolt.
4. Slowly lower the handle and look to see if any die comes in contact with the shellplate. Readjust dies as needed.
5. Place one unprimed case in the swage station and again slowly lower the handle. Readjust the expander and swage rod as needed.
6. Once you have reset the dies to the machine, remove the toolhead and reinstall the toolhead spring and complete the rest of the conversion and set up to reload. Reinstall the toolhead.

Trouble Shooting

.308 Winchester and related calibers with similar case length (.243 and/or .22-250) also lend themselves to reloading on this new machine. No special changes are necessary to the die set.

Hard or Incomplete Indexing
1.) Wrong size locator buttons (#20637*).
2.) Index pawl bent or worn (#13705).
3.) Shellplate lock ring adjusted too tightly (#20311).
4.) Dirt under the shellplate (#12600*).

5.) Bent or broken shellplate (#12600*).

When reinstalling the ejector tab (#13189) it is vital that it is not set too low or it will interfere with the shellplate.

6.) Ejector tab (#13189) interfering with the shellplate - see above photo.

Station 1: Case Insertion Problems
1.) Wrong size case insert plunger (#13073*).
2.) Wrong case insert adapter (#13654*).
3.) Shellplate lock ring not adjusted tight enough.
4.) Dirt in the shellplate (#12600*) pockets or damaged shellplate.
5.) Handle being moved too rapidly on upstroke.
6.) Bent or broken roller bolt (#13333).
7.) Dirt or media in casefeed track.

Station 2: Resizing and Decapping Problems

With .30-06 and .270 calibers it is important to note that the seater and crimp dies must be shortened for clearance reasons. They are available and are included with the respective conversion kits.

1.) Crushed cases:
   a.) Shellplate lock ring too loose or too tight.
   b.) Not enough radius on the die. Use Dillon dies whenever possible.
   c.) Wrong size or missing locator buttons.
2.) Bending or breaking decapping pins:
   a.) Wrong shellplate (#12600*).
   b.) Slightly bent decapping assembly or pin.
   c.) Berdan primed cases.
   d.) Dirt in shellplate pockets.
   e.) Handle being moved too rapidly on the down stroke.
   f.) Rocks or other foreign objects in cases.

Station 3: Primer Pocket Swaging Problems

1.) Primers smearing or crushing:
   a.) Swage back-up rod not down far enough (#13332 or #13348).
   b.) Swage rod not adjusted high enough (#20314 - large or #20313 - small).

Station 4: Priming Problems

The above photo shows the rocker arm set screw (#13226) being adjusted. The Super 1050 comes from the factory with this set screw properly adjusted, but over time it can move. When the rocker arm set screw is out of adjustment, it can dent primers and/or cause the primer slide to stick. When properly adjusted, the primer punch (#12849 large - #13307 small) will be flush with the platform surface – see arrow above.

1.) Crushed primers:
   a.) Swage rod (#20314 - large or #20313 - small) not adjusted correctly, dirty or worn out.
   b.) Dirt in the shellplate (#12600*).
   c.) Ringed primer. When a spent primer has been pierced by the decapping pin leaving a ring of metal from the primer in the pocket.
   d.) Primer station locator button (#20637*) not adjusted correctly.
   e.) Worn primer punch (#12849).
   f.) The bench that the machine is mounted on is not rigid enough. This can be corrected by affixing a board to both the wall and your bench.
   g.) Hot-loaded ammo that has been fired several times and the base of the
case has been flattened out.

2.) High primers:
   a.) Adjust the primer push rod (#12819).
   b.) On .223 cases the swage back-up rod (#13332) is down too far, slightly collapsing the primer pocket and not allowing the primer to seat fully.
   c.) Loose shellplate (#12600*).
   d.) Erratic handle motion.
   e.) Do not remove the rubber piece on the primer slide.

3.) Smeared primers - see Station 3: Primer Pocket Swaging - item 1

4.) Locator tab:
   a.) When adjusting the priming station locator tab, it should be set as close to the case as possible without touching it. Be sure the cases in the shellplate rotate freely past the tab. Change primer magazine tips every 20,000 rounds. Note: Move the handle down, bringing the toolhead down. Move the locator tab in to the case in the priming station.

   Station 5. Powder and Case Mouth Belling Problems

1.) Crushing cases:
   a.) Wrong size or missing locator buttons.

2.) Spilling powder:
   a.) Slamming or going too fast with the operating handle (#12727).
   b.) Stick or pencil-lead type powders bridging on the case mouth in the powder funnel (#13005). See conversion chart.
   c.) Check powder bar adjustment.

3.) Erratic belling:
   a.) Variation in case length. Divide cases by brand.
   b.) Handle not moving all the way down on each stroke. Note: Try setting a bullet on the case mouth in Station 6.

4.) Erratic powder charges:
   a.) Powder bar not moving full length of its travel. Turn the powder die down until it does.

   Station 7: Bullet Seating Problems

1.) Erratic seating depth of the bullet:
   a.) Build up of lead shaving and/or lube in the seater or crimp dies.
   b.) Bullets having erratic dimension (length and/or the ogive).
   c.) Use the proper seating stem for the type of bullet being used.
   d.) Variations in case types and/or lots – sort brass.
   e.) Refer to a loading manual for proper loaded length (OAL) and additional information.

   Station 8: Crimping Problems

1.) Erratic crimping:
   a.) Length of cartridge cases erratic, probably due to mixed brands of brass.
   b.) Worn out or improperly made die, use Dillon dies whenever possible.

2.) Loose bullet:
   a.) Too much taper crimp. Note, this condition also ruins accuracy.
   b.) Wrong expander (#12749*).
   c.) Thin cases.

   Maintenance

   Loctite

Loctite should be used following adjustments to or replacement of all threaded screws. Please note that Loctite should be applied to threaded portions only and should be of a non-permanent type. Blue Loctite #242 is recommended.

   Swage

Clean the swage by pulling the operating handle down and use a small brush to clean the tip. Every 10,000 rounds, remove the swage rod (#20314 - large or #20313 - small). and clean, lightly grease and replace. Note: Do not grease the tip of the swage where it contacts the primer pocket.
**Lubrication**

Operating circumstances will dictate the frequency of required lubrication. It is highly recommended that the Super 1050 be cleaned and lubed after every 10,000 rounds of operation.

Use a high-grade, conventional wheel bearing grease – *do not use oil*.

**Lubrication Points:**

- Casefeed Plunger (#13073*), lube the sides and bottom.
- Casefeed Plunger Roller (#13498) and Bolt (#13333)
- Tappet (#12995)
- Rocker Arm (#13058), cam surfaces and hole.
- Pivot Bolt (#13296)
- Primer Punch Base (#12849 - large or #13307 - small)
- Alignment Pins (#12972 & #13515 located under the toolhead)
- Cam Guide Bolt (#12486) and its mated slot
- Toolhead Bore (#20420 - lightly to avoid rusting and/or freezing up)
- Mainshaft Lubrication – Use only 30 weight motor oil. DO NOT use a penetrating lubricant such as WD-40, Breakfree, etc...

- Swage Connecting Rod (#13417) and Clevis Pin (#13522)
- Shellplate lock ring (#20311), bottom surface to shellplate face.
- Shellplate center hole. It’s easiest to lubricate the shellplate center hole when changing from one caliber to another.

We recommend that you use a droplet of Blue Loctite on the threads of the following bolts prior to reinstalling: #13333, #13296, and #13276 (see photos and schematics).
Lube Points for the Super 1050
Crank Assembly

With the handle in the rest position, on the left side of the machine, use a grease syringe to lube the bearing pin (#11009) located in the link arm (#11002). Then, cycle the handle down to the bottom stop.

Again, using the grease syringe, lube the mainshaft pivot pin (#10994) on the left side of the machine via the access hole located 1.2" above the carrier cap (#11010).

Use 30 weight motor oil on the mainshaft (#10999).

Towards the back of the machine, lube the indexing lever cam surface (#20312) and index lever shoulder bolt (#13276).

When it is time to lube the roller bearings (#11008) in the frame and crankshaft, first remove the swage rod assembly, swage connecting rod, and operating handle. On the left side of the machine, use a 5/32" Allen wrench to remove the screw (#13685). Slide the carrier cap (#11010) out of its bore and lube the left-hand side roller bearing (#11008) and carrier cap. Next, slide the crankshaft (#11000) out of the frame from the right side of the machine BUT NO MORE THAN 3/4". Using a grease syringe, dispense some grease onto the right-hand side roller bearing (#11008). Next, lube the crankshaft surface (#11000). Then, reinsert the crankshaft fully into the frame. Reinstall the carrier cap (#11010). Blue Loctite must be used on the threads before installation, tighten. Finally, reassemble the swage component and operating handle back onto the frame. Lube the swage connecting rod (#13417) and clevis pin (#13522).
<table>
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<th>Conversion</th>
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<tbody>
<tr>
<td>20478 – .41 Mag Conversion</td>
<td>11856 #6 Shellplate, 13930 #1 Locator Buttons (6), 12882 .41 cal. Expander – H, 13654 Adapter – Yellow, 13073 Casefeed Plunger – Large, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring, 13005 Powder Activator – Pistol</td>
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<tr>
<td>20479 – .44 Spl/Mag Conversion</td>
<td>12600 #4 Shellplate, 14047 #4 Locator Buttons (6), 12628 .44 cal. Expander – G, 13654 Adapter – Yellow, 13073 Casefeed Plunger – Large, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring, 13005 Powder Activator – Pistol</td>
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<tr>
<td>20480 – .45 ACP Conversion</td>
<td>12999 #1 Shellplate, 13930 #1 Locator Buttons (6), 12749 .45 cal. Expander – E, 13872 Adapter – Red, 13073 Casefeed Plunger – Large, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring, 13005 Powder Activator – Pistol</td>
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<tr>
<td>20481 – .45 LC Conversion</td>
<td>11235 #C Shellplate, 14047 #4 Locator Buttons (6), 12749 .45 cal. Expander – E, 13654 Adapter – Yellow, 13073 Casefeed Plunger – Large, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring, 13005 Powder Activator – Pistol</td>
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<tr>
<td>20482 – 9mm Conversion</td>
<td>12938 #5 Shellplate, 14060 #3 Locator Buttons (6), 12833 9mm cal. Expander – F, 13878 Adapter – Green, 13306 Casefeed Plunger – Small, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring, 13005 Powder Activator – Pistol</td>
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<tr>
<td>20484 – .38 Super Conversion</td>
<td>12938 #5 Shellplate, 14060 #3 Locator Buttons (6), 12833 9mm cal. Expander – F, 13878 Adapter – Green, 13306 Casefeed Plunger – Small, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring, 13005 Powder Activator – Pistol</td>
</tr>
<tr>
<td>20788 – 10mm Auto Conversion</td>
<td>12940 #W Shellplate, 14062 #2 Locator Buttons (6), 12912 10mm cal. Expander – W, 13872 Adapter – Red, 13098 Casefeed Plunger – Medium, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring, 13005 Powder Activator – Pistol</td>
</tr>
<tr>
<td>20789 – 10mm Conversion</td>
<td>12940 #W Shellplate, 14062 #2 Locator Buttons (6), 12912 10mm cal. Expander – W, 13872 Adapter – Red, 13098 Casefeed Plunger – Medium, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring, 13005 Powder Activator – Pistol</td>
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<tr>
<td>20955 – .223 Conversion</td>
<td>12441 #3 Shellplate, 14060 #3 Locator Buttons (6), 13332 Back-up/Expander .223, 13426 Powder Funnel – A, 12146 Adapter (pinned) – White, Long, 13098 Casefeed Plunger – Medium, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring, 13005 Powder Activator – Pistol</td>
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<tr>
<td>20956 – .30 Carbine Conversion</td>
<td>12655 #8 Shellplate, 14048 #8 Locator Buttons (6), 12749 .30M1 cal. Expander – C, 13564 Powder Funnel C, 12641 Adapter – White, Slotted, 13006 Casefeed Plunger – Small, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring</td>
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<tr>
<td>20958 – .32 S&amp;W Long/H&amp;R Magnum Conversion</td>
<td>12107 #D Shellplate, 14060 #3 Locator Buttons (6), 12780 .32 cal. Expander – S, 12845 Powder Funnel – S, 13878 Adapter – Green, 13306 Casefeed Plunger – Small, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring</td>
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<tr>
<td>21525 – 9x25 Dillon Conversion</td>
<td>12940 #W Shellplate, 14062 #2 Locator Buttons (6), 12912 10mm cal. Expander – W, 13872 Adapter – Red, 13098 Casefeed Plunger – Medium, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring, 13005 Powder Activator – Pistol</td>
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<tr>
<td>21525 – 9x25 Dillon Conversion</td>
<td>12940 #W Shellplate, 14062 #2 Locator Buttons (6), 12912 10mm cal. Expander – W, 13872 Adapter – Red, 13098 Casefeed Plunger – Medium, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring, 13005 Powder Activator – Pistol</td>
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<td>21525 – 9x25 Dillon Conversion</td>
<td>12940 #W Shellplate, 14062 #2 Locator Buttons (6), 12912 10mm cal. Expander – W, 13872 Adapter – Red, 13098 Casefeed Plunger – Medium, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring, 13005 Powder Activator – Pistol</td>
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<td>21525 – 9x25 Dillon Conversion</td>
<td>12940 #W Shellplate, 14062 #2 Locator Buttons (6), 12912 10mm cal. Expander – W, 13872 Adapter – Red, 13098 Casefeed Plunger – Medium, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring, 13005 Powder Activator – Pistol</td>
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<td>21525 – 9x25 Dillon Conversion</td>
<td>12940 #W Shellplate, 14062 #2 Locator Buttons (6), 12912 10mm cal. Expander – W, 13872 Adapter – Red, 13098 Casefeed Plunger – Medium, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring, 13005 Powder Activator – Pistol</td>
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<td>21525 – 9x25 Dillon Conversion</td>
<td>12940 #W Shellplate, 14062 #2 Locator Buttons (6), 12912 10mm cal. Expander – W, 13872 Adapter – Red, 13098 Casefeed Plunger – Medium, 17384 Blue Locator Tab – Short (1), 13569 Blue Locator Tab (5), 14067 Die Lock Ring, 13005 Powder Activator – Pistol</td>
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</table>
# Super 1050 - Caliber Conversion Chart

The Super 1050 loads all of the calibers listed for the RL 1050 as well as the calibers listed below.

<table>
<thead>
<tr>
<th>Conversion</th>
<th>Item Code</th>
<th>Item Description</th>
</tr>
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<tbody>
<tr>
<td><strong>#21049 – .308 Conversion</strong></td>
<td>11005</td>
<td>Super 1050 Adapter - .308 Win</td>
</tr>
<tr>
<td></td>
<td>12074</td>
<td>Back-up Expander - .308</td>
</tr>
<tr>
<td></td>
<td>12184</td>
<td>Swage Die Body - part</td>
</tr>
<tr>
<td></td>
<td>12999</td>
<td>#1 Shellplate</td>
</tr>
<tr>
<td></td>
<td>13073</td>
<td>Casefeed Plunger - large</td>
</tr>
<tr>
<td></td>
<td>13483</td>
<td>Old Style Jam Nut 9/16x18</td>
</tr>
<tr>
<td></td>
<td>13569</td>
<td>Blue Locator Tab (5)</td>
</tr>
<tr>
<td></td>
<td>13587</td>
<td>Powder Funnel - B, rifle</td>
</tr>
<tr>
<td></td>
<td>13930</td>
<td>Locator Pin - #1 (6)</td>
</tr>
<tr>
<td></td>
<td>14067</td>
<td>Die Lock Ring</td>
</tr>
<tr>
<td></td>
<td>17384</td>
<td>Blue Locator Tab, Short</td>
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<table>
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<tr>
<th><strong>#21050 – .30-06 Conversion</strong></th>
<th>(only conversion kit that includes dies)</th>
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<tbody>
<tr>
<td>10840</td>
<td>.30-06 Die Set</td>
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<tr>
<td>11004</td>
<td>Super 1050 Adapter - .30-06 Win</td>
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<tr>
<td>12073</td>
<td>Back-up Expander - .30-06</td>
</tr>
<tr>
<td>12184</td>
<td>Swage Die Body - part</td>
</tr>
<tr>
<td>12999</td>
<td>#1 Shellplate</td>
</tr>
<tr>
<td>13073</td>
<td>Casefeed Plunger - large</td>
</tr>
<tr>
<td>13483</td>
<td>Old Style Jam Nut 9/16x18</td>
</tr>
<tr>
<td>13569</td>
<td>Blue Locator Tab (5)</td>
</tr>
<tr>
<td>13587</td>
<td>Powder Funnel - B, rifle</td>
</tr>
<tr>
<td>13930</td>
<td>Locator Pin - #1 (6)</td>
</tr>
<tr>
<td>14067</td>
<td>Die Lock Ring</td>
</tr>
<tr>
<td>17384</td>
<td>Blue Locator Tab, Short</td>
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| **#21051 – .303 Conversion** | 12184 | Swage Die Body - part |
|                             | 13073 | Casefeed Plunger - large |
|                             | 13348 | Back-up Expander - 762x39 |
|                             | 13483 | Old Style Jam Nut 9/16x18 |
|                             | 13569 | Blue Locator Tab (5) |
|                             | 13587 | Powder Funnel - B, rifle |
|                             | 14047 | Super 1050 Adapter - .41 Mag., .44, .45 LC |
|                             | 14067 | Locator Pin - #4 (6) |
|                             | 16153 | #N Shellplate |
|                             | 17384 | Blue Locator Tab, Short |

| **#21052 – .30-30 Conversion** | 11005 | Super 1050 Adapter - .308 Win |
|                               | 12068 | 1000/1050 .30-30 Expander |
|                               | 12075 | #7 Shellplate |
|                               | 12184 | Swage Die Body - part |
|                               | 13073 | Casefeed Plunger - large |
|                               | 13483 | Old Style Jam Nut 9/16x18 |
|                               | 13569 | Blue Locator Tab (5) |
|                               | 13587 | Powder Funnel - B, rifle |
|                               | 14047 | Locator Pin - #4 (6) |
|                               | 14067 | Die Lock Ring |
|                               | 17384 | Blue Locator Tab, Short |

| **#21053 – .270 Conversion** | 11004 | Super 1050 Adapter - .30-06 Win |
|                             | 12069 | 1000/1050 .270 Expander |
|                             | 12184 | Swage Die Body - part |
|                             | 12999 | #1 Shellplate |
|                             | 13073 | Casefeed Plunger - large |
|                             | 13456 | Powder Funnel - J, rifle |
|                             | 13483 | Old Style Jam Nut 9/16x18 |
|                             | 13569 | Blue Locator Tab (5) |
|                             | 13930 | Locator Pin - #1 (6) |
|                             | 14067 | Die Lock Ring |
|                             | 17384 | Blue Locator Tab, Short |

| **#21054 – .243 Conversion** | 11005 | Super 1050 Adapter - .308 Win |
|                             | 12070 | 1000/1050 .243 Expander |
|                             | 12184 | Swage Die Body - part |
|                             | 12999 | #1 Shellplate |
|                             | 13073 | Casefeed Plunger - large |
|                             | 13305 | Powder Funnel - I, rifle |
|                             | 13483 | Old Style Jam Nut 9/16x18 |
|                             | 13569 | Blue Locator Tab (5) |
|                             | 13930 | Locator Pin - #1 (6) |
|                             | 14067 | Die Lock Ring |
|                             | 17384 | Blue Locator Tab, Short |

| **#21055 – .22-250 Conversion** | 11005 | Super 1050 Adapter - .308 Win |
|                                | 12071 | 1000/1050 .22-250 Expander |
|                                | 12184 | Swage Die Body - part |
|                                | 12999 | #1 Shellplate |
|                                | 13073 | Casefeed Plunger - large |
|                                | 13426 | Powder Funnel - A, rifle |
|                                | 13483 | Old Style Jam Nut 9/16x18 |
|                                | 13569 | Blue Locator Tab (5) |
|                                | 13930 | Locator Pin - #1 (6) |
|                                | 14067 | Die Lock Ring |
|                                | 17384 | Blue Locator Tab, Short |

<p>| <strong>#21056 – .45-70 Conversion</strong> | 11007 | Super 1050 Adapter - .45-70 |
|                                | 12072 | 1000/1050 .45-70 Expander |
|                                | 12184 | Swage Die Body - part |
|                                | 12705 | 1050 Custom Shellplate, #G |
|                                | 13072 | Casefeed Plunger - .45-70 |
|                                | 13407 | Powder Funnel - T, pistol |
|                                | 13436 | Locator Pin - #7 (6) |
|                                | 13483 | Old Style Jam Nut 9/16x18 |
|                                | 13569 | Blue Locator Tab (5) |
|                                | 14067 | Die Lock Ring |
|                                | 17384 | Blue Locator Tab, Short |</p>
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<tr>
<th>Part #</th>
<th>Description</th>
<th>Part #</th>
<th>Description</th>
<th>Part #</th>
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<tr>
<td>10991</td>
<td>Bin Support Bracket</td>
<td>13449</td>
<td>Toolhead Washer</td>
<td>13939</td>
<td>Body Collar Clamp – Part</td>
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<td>10992</td>
<td>Inside Frame Stop</td>
<td>13475</td>
<td>Journal Key 1050</td>
<td>13943</td>
<td>Powder Bar Adjustment Screw</td>
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<tr>
<td>10993</td>
<td>Spent Primer Cup Bracket</td>
<td>13483</td>
<td>Old Style Jam Nut 9/16x18</td>
<td>13944</td>
<td>Indexer Return Spring</td>
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<tr>
<td>10994</td>
<td>.560 dia. Mainshaft Pin</td>
<td>13484</td>
<td>1050 Cartridge Bin</td>
<td>13951</td>
<td>Powder Bar Post – Small</td>
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<tr>
<td>10995</td>
<td>Index Lever</td>
<td>13495</td>
<td>Lower Cord Clamp</td>
<td>13955</td>
<td>Lower Plate Screw</td>
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<td>10996</td>
<td>Index Roller</td>
<td>13498</td>
<td>Plunger Roller 1050</td>
<td>13957</td>
<td>Magazine Shield Cap 1050</td>
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<td>Super 1050 Frame</td>
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<td>Clamp Retaining Screw</td>
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<td>Powder Bar Bolt Washer</td>
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<td>Index Bell 1050</td>
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<td>Powder Bar Return Rod – Part</td>
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<td>Slide Alignment Pin</td>
<td>13964</td>
<td>10-24x1/4 BHCS for Index Roller</td>
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<td>11001</td>
<td>Crank Arm</td>
<td>13522</td>
<td>Clevis Pin</td>
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<td>3/16 Roll Pin</td>
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<td>11002</td>
<td>Link Arm</td>
<td>13525</td>
<td>Index Ball Spring 1050</td>
<td>14003</td>
<td>Magazine Orifice – Large – Red</td>
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<td>Casefeed Adapter Housing</td>
<td>14023</td>
<td>10-24 5/8 Buttonhead Screw</td>
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<td>Lock Ring Insert</td>
<td>14024</td>
<td>Magazine Orifice – Small – Blue</td>
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<td>13537</td>
<td>#10 Washer for Roller</td>
<td>14033</td>
<td>Return Rod Spring</td>
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<td>11008</td>
<td>BH-1610 Roller Bearing</td>
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<td>Grease Zerts</td>
<td>14036</td>
<td>Old Powder Bar Return Spring</td>
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<td>5/32” Hex Wrench</td>
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<td>10-24x3/4 SHCS –</td>
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<td>Actuating Lever Cotter Pin</td>
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<td>Die Lock ring</td>
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<td>1050 Bullet Bin</td>
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<td>Powder Measure Tube Screw</td>
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<td>Swage Die Body – Part</td>
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<td>Small Powder Bar Spacer</td>
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<td>Collar Roller Bushing</td>
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<td>1050 Box For Shipping</td>
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<td>Spent Primer Cup</td>
<td>14990</td>
<td>Slide Roll Pin Sleeve</td>
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<td>Cam Guide Bolt 1/4x20</td>
<td>13566</td>
<td>5/16/18 Nut</td>
<td>16699</td>
<td>Spent Primer Cup</td>
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<td>13573</td>
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<td>13574</td>
<td>Swage Lock Nut 1050</td>
<td>17141</td>
<td>1/4” Hardened Washer</td>
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<td>13575</td>
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<td>Bracket Pivot Pin</td>
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<td>1050 Index Pawl 3/8</td>
<td>20063</td>
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<td>Index Ball 1050</td>
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<td>1050 Lock Ring Assembly</td>
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<td>Casefeed Plunger – Medium</td>
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<td>Actuating Lever Cotter Pin</td>
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<td>1050 Index Lever Assembly</td>
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<td>1050 Ejector Tab</td>
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<td>Strip Nut</td>
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<td>1050 Primer Slide – Small</td>
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<td>Clutch Spring Washer</td>
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<td>Bin Bracket</td>
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<td>3/16” Hex Wrench</td>
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<td>1050 Bushing Driver</td>
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<td>Hair Pin Cotter</td>
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<td>1050 Primer System – Small</td>
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<td>Short Lever Spring</td>
<td>20420</td>
<td>1050 Toolhead Assembly</td>
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<td>Index Lever Shoulder Bolt</td>
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<td>Body Collar Sleeve</td>
<td>20421</td>
<td>Auto Powder System</td>
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<td>Bellcrank Bushing</td>
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<td>1050 Primer Arm/Cam – Assembly</td>
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<td>Primer Punch Spring 1050</td>
<td>20635</td>
<td>Ratchet Detent Assembly</td>
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<td>13335</td>
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<td>Casefeed Tube Clip</td>
<td>20641</td>
<td>Casefeed Mounting Post – Assembly</td>
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<td>Bellcrank Tube</td>
<td>20773</td>
<td>Primer Feed Body/Shield</td>
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<td>Powder Measure Lid</td>
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<td>Powder Measure Body</td>
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<td>13600</td>
<td>E-Clip</td>
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<td>Casefeed Plate – Large Pistol</td>
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<td>Swage Connecting Rod</td>
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<td>Powder Bar Post – Large</td>
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<td>Casefeed Plate – Small Pistol</td>
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<td>Swage Rod Lock Nut</td>
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<td>10-24 x 3/8” BH Screw (6)</td>
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<td>Powder Funnel A – Rifle</td>
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<td>1/4-20 3/8 BH – Ejector Tab Screw</td>
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<td>Crank Handle Lock Screw</td>
<td>13604</td>
<td>Bellcrank Bolt</td>
<td>21275</td>
<td>Body Collar – Complete</td>
</tr>
<tr>
<td>13435</td>
<td>1/4” Hex Wrench</td>
<td>13605</td>
<td>Powder Bar Spacer Plug</td>
<td>21530</td>
<td>Floating Decap Assembly</td>
</tr>
</tbody>
</table>
Super 1050 Upper Machine Assembly

#20420 – Toolhead Assembly
- Crimp Die
- Seating Die
- Sizing Die
- Expander

13005 - 13015 refer to the caliber conversion chart

See page 29 for more detail.

Shellplate – caliber specific, refer to the caliber conversion chart

20317 – small
20318 – large

#17071 – Handle Assembly

Refer to the caliber conversion chart
Super 1050 Lower Machine Assembly

**Lower Machine Assembly**

<table>
<thead>
<tr>
<th>Part #</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>10994</td>
<td>Mainshaft Pivot Pin - .560” dia.</td>
</tr>
<tr>
<td>10996</td>
<td>Index Roller</td>
</tr>
<tr>
<td>10999</td>
<td>Super 1050 Mainshaft</td>
</tr>
<tr>
<td>11000</td>
<td>Crankshaft</td>
</tr>
<tr>
<td>11001</td>
<td>Crankarm</td>
</tr>
<tr>
<td>11002</td>
<td>Link Arm</td>
</tr>
<tr>
<td>11008</td>
<td>BH-1610 Roller Bearing (3)</td>
</tr>
<tr>
<td>11009</td>
<td>Pin - 1” dia.</td>
</tr>
<tr>
<td>11010</td>
<td>Carrier Cap</td>
</tr>
<tr>
<td>13244</td>
<td>Crank Retaining Ring (2)</td>
</tr>
<tr>
<td>13475</td>
<td>Journal Key</td>
</tr>
<tr>
<td>13685</td>
<td>1/4-20x5/8 BHCS</td>
</tr>
<tr>
<td>13738</td>
<td>#10 Washer</td>
</tr>
<tr>
<td>13895</td>
<td>10-24x3/8 BHCS</td>
</tr>
</tbody>
</table>

**Item A – Swage Rod Assembly**

<table>
<thead>
<tr>
<th>Part #</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>13064</td>
<td>Swage Cover 1050</td>
</tr>
<tr>
<td>13417</td>
<td>Swage Connecting Rod</td>
</tr>
<tr>
<td>13522</td>
<td>Clevis Pin</td>
</tr>
<tr>
<td>13581</td>
<td>Grease Zerts</td>
</tr>
<tr>
<td>13840</td>
<td>Hair Pin Cotter</td>
</tr>
<tr>
<td>13896</td>
<td>1/4-20 3/8 BH Ejector Tab Screw</td>
</tr>
<tr>
<td>14517</td>
<td>Swage Station Bushing</td>
</tr>
</tbody>
</table>

**See page 31 – Casefeed Frame Assembly**

- 13064 Swage Cover 1050
- 13417 Swage Connecting Rod
- 13522 Clevis Pin
- 13581 Grease Zerts
- 13840 Hair Pin Cotter
- 13896 1/4-20 3/8 BH Ejector Tab Screw
- 14517 Swage Station Bushing

20313 Swage Rod Assembly – Small:
- 13127 Swage Rod (1050) – Small
- 13245 Primer Swage Adjustment Bolt
- 13682 Swage Lock Nut 1050

20314 Swage Rod Assembly – Large:
- 13245 Primer Swage Adjustment Bolt
- 13364 Swage Rod (1050) – Large
- 13682 Swage Lock Nut 1050
**Upper Assembly**

**Stock** | **Description**
--- | ---
13957 | Magazine Shield Cap
20773 | Primer Feed Body/Shield
22030 | Primer Magazine Tube – Small
22031 | Primer Magazine Tube – Large
20488 | Primer Arm/Cam Assembly
  11003 | Slide Actuating Lever
  13001 | New Lever Arm Bracket
  13746 | Actuating Lever Cotter Pin
  13840 | Hair Pin Cotter
  13844 | Short Lever Spring
  13936 | Tab/Spring Arm Spring
  14037 | Clutch/Motor Bolt
  17604 | Bracket Pivot Pin

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**Lower Assembly**

**Stock** | **Description**
--- | ---
12849 | 1050 Primer Punch – Large
12995 | Primer System Tappet
13058 | Primer System Rocker Arm
13130 | Primer Punch Bushing – Large
13222 | Primer Punch Bushing – Small
13296 | Primer System Rocker Bolt
13307 | 1050 Primer Punch – Small
13363 | Primer Magazine Socket Bolt
13607 | Rocker Bolt Lock Washer
13858 | Primer Punch Spring 1050
20317 | Primer Slide Assembly – Small
  13423 | Roll Pin – 1/8x5/8
  14990 | Slide Roll Pin Sleeve
20318 | Primer Slide Assembly – Large
  13423 | Roll Pin – 1/8x5/8
  14990 | Slide Roll Pin Sleeve
Super 1050 Casefeeder Assembly

Stock # Description
12144 Bullet Bin Bracket
13205 Post Bolts
13238 Bin Bracket
13271 Post Stud
13377 Bin Bracket Mount Screw
13400 Casefeed Bowl 1050
13473 Casefeed Motor – 4 RPM (Not Shown)
13484 1050 Cartridge Bin
13494 Casefeed Funnel
13495 Lower Cord Clamp
13502 Clamp Retaining Screw
13539 Casefeed Cord Set
13540 Casefeed Motor Cover
13655 5/16 Washer
13688 Casefeed Funnel Baffle (9mm/.380/.38 Sup. Not Shown)
13756 Bullet Bin
13761 Casefeed Tube 1050
13779 Micro-Switch (Not Shown)
13812 Lighted Power Switch
13859 Casefeed Tube Clip
13895 10-24 BH Screw (Not Shown)
13954 Micro-Switch Mount Screw (Not Shown)
14022 Casefeed Motor Roll Pin (Not Shown)
14023 10-24 5/8 Buttonhead Screw (Not Shown)
14026 8-32x1/2 Bowl/Motor Screw (Not Shown)
17808 Casefeed Bowl Insert
20322 Casefeed Assembly 1050 (Large Pistol)
20324 Casefeed Assembly 1050 (Small Rifle)
20641 Casefeed Mounting Post Assembly
21079 Casefeed Assembly 1050 (Small Pistol)
### Casefeeder Clutch Assembly

**Stock #**
- 13632 Upper Clutch
- 13655 5/16 Washer
- 13703 Spacer (.41, .44, .45LC, .357, .30 Carbine)
- 13732 Clutch/Motor Bolt
- 13736 Lower Clutch
- 13813 Clutch Spring Washer
- 21072 Casefeed Plate (Large Pistol)
- 21073 Casefeed Plate (Small Pistol)
- 21074 Casefeed Plate (Small Rifle)

*Indicates a caliber specific part – see the caliber conversion charts on pages 24 & 25 for the caliber you are loading for.*

### Powder Measure Assembly - #22221

**Stock #**
- 13882 Powder Activator, Pistol
- 13089 Return Rod Eye Bolt
- 13426 Powder Funnel "A", Rifle
- 13644 Small Powder Bar Spacer
- 13799 Collar Roller
- 13793 Collar Roller Bushing
- 13939 Powder Bar Insert, Large
- 13848 Bellcrank Bushing
- 13845 Collar Sleeve
- 13842 Powder Bar Insert, Small
- 13882 Powder Measure Lid
- 13893 Powder Bar Post, Large
- 13904 Bellcrank Bolt
- 13921 Powder Measure Plug
- 13929 Return Rod Clip
- 13939 Collar Clamp
- 13940 Body Collar Housing – Part

*Indicates a caliber specific part – see the caliber conversion charts on pages 24 & 25 for the caliber you are loading for.*
On the cover…

The Super 1050 is pictured with optional accessories:
Powder Check System #21044
Low Powder Sensor #16306
Bullet Tray #22215

Other accessories available for the Super 1050 include:
Machine Cover #13239
Maintenance Kit & Spare Parts Kit #97018

The Blue Press, Dillon’s monthly catalog, has a complete listing of accessories available for all machines.

For a free issue of the Blue Press, call our customer service department at: 1-800-223-4570