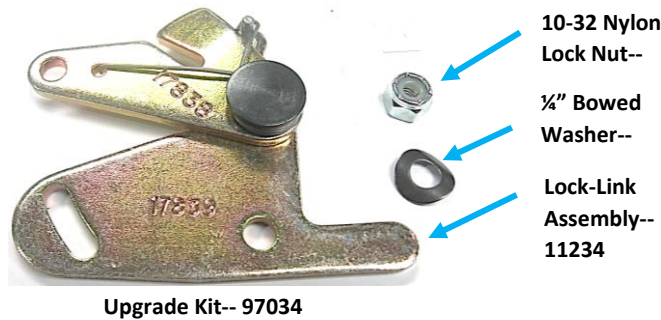


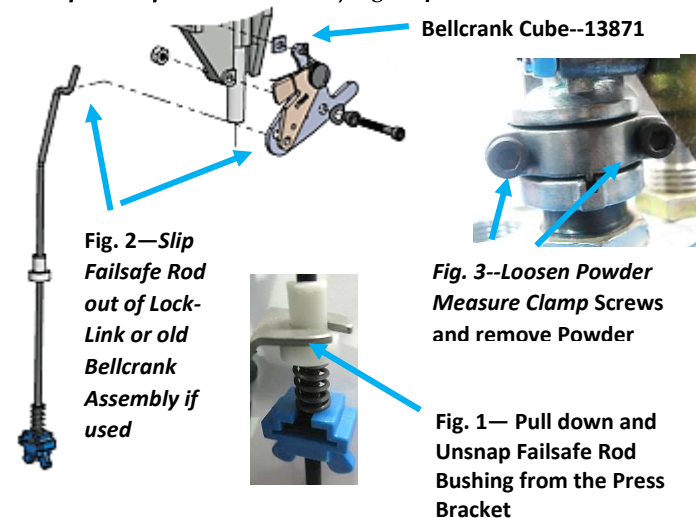
# Dillon Powder Measure Bellcrank Upgrade Kit PN97034 Instructions

This Kit upgrades the older Dillon Powder Measure Bellcrank Lock-Link Assembly that uses a Spring Return and the older Lock-Link Assembly using the "toothed" Kep Nut and Flat washer to the current production Lock-Link Assembly. The new Lock Nut and Bowed Washer allow Powder Bars to be replaced by pulling/disengaging the White Bellcrank Cube (13871) from the slot in Powder Bars and then sliding different Powder Bars in and out of the Powder Measure.

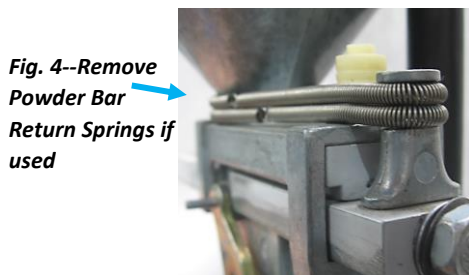


## Installation Procedure:

1. Disconnect the bottom end of the Failsafe Rod and slide the top hook out of the Lock-Link Assembly in **Fig. 1 & 2**. Loosen the two Socket Head Cap Screws that clamp the Powder Measure to the Powder Die. **Fig. 3**, using a 5/32" Allen Wrench and remove the Powder Measure Assembly from the Powder Die. Empty any powder in the Powder Measure into its original container. **Cycle the Powder Measure right-side-up and upside-down verifying all powder is removed.**

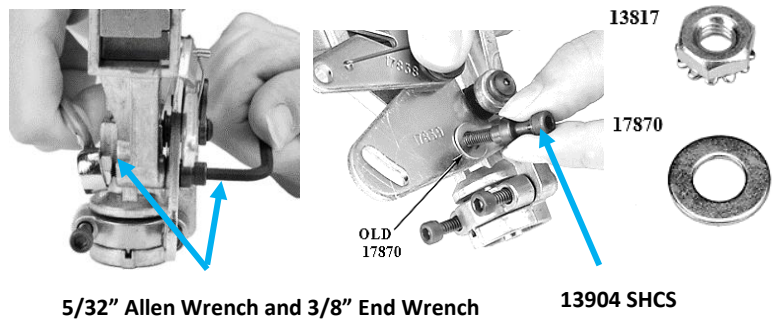


2. Remove the Powder Bar Return Springs if they are being used in **Fig. 4**.



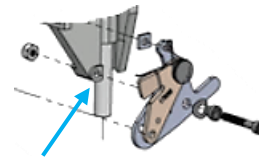
3. Using a 5/32" Allen Wrench and a 3/8" End Wrench in **Fig. 5**, remove the 10-32 Socket head Cap Screw (SHCS) 13904, from the **old** Kep Nut 13817 including the Bushing 13848, the

**old** Flat Washer 17870, the Bellcrank Cube and the Lock-Link Assembly. The Bellcrank Bushing 13848 and the 10-32 SHCS 13904 will be reused.



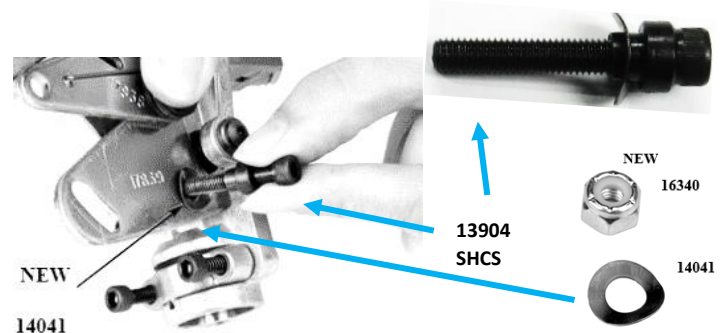
**Fig. 5--Remove the old Kep Nut 13817, the old Flat Washer 17870, Bushing 13848 and SHCS 13904 using a 3/8" End Wrench and a 5/32" Allen Wrench**

4. Clean any residue where the Bellcrank Assembly and Powder Measure Body meet. Apply a small amount of grease--**Fig. 6**.



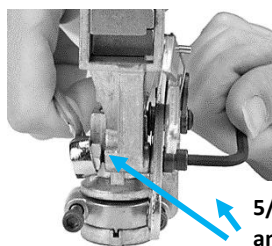
**Fig. 6 Clean and lightly grease**

5. Assemble the new Lock-link assembly 11234, with the New Bowed Washer 14941, the existing Bushing 13848 and SHCS 13904, the New Bellcrank Cube into the Powder Measure Body in **Fig. 7**. Note the small end of the Bushing 13848 goes against the Bowed Washer and the Bowed Washer 14041 must be installed with the concave side down ( ) against the Lock-link Assembly 11234.



**Fig. 7-- Install the new Bowed Washer 14041 and the new Lock Nut 16340 using the existing Bushing 13848 and SHCS 13904. Note the correct orientation of the Bushing and Washer.**

6. Tighten the 10-32 SHCS 13904 with the 5/32" Allen Wrench while holding the 10-32 Lock Nut 16340 with a 3/8" Wrench in **Fig. 8**, until the 10-32 SHCS and the Nut stop, then back the Nut up 1/16 of a turn. This step might require some final tightening or loosening. Check that the Powder Bar moves freely back and forth. If it is too loose, the White Bellcrank Cube will fall out or the Bellcrank. If it is too tight it will drag against the Powder Measure Body.

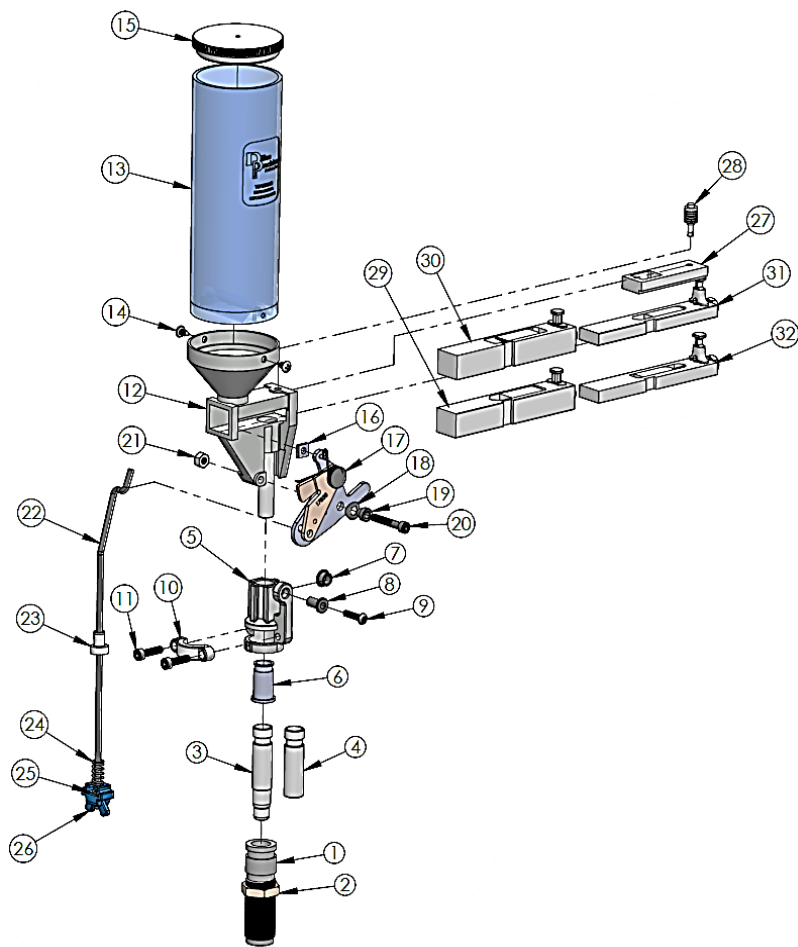


**Fig. 8—Tighten the 10-32 SHCS 13904 with the 5/32" Allen Wrench for free Bellcrank movement**

7. Reinstall the Powder measure Assembly on the Powder Die. Tighten the two SHCS on the Powder Measure Clamp Fig. 9 and reconnect the Failsafe Rod through the Lock Link Assembly and the Snap the White Fail-Safe Rod Bushing back into the Bracket on the Press in **Fig. 1 and 2.**
- 8.



**Fig. 9—Reinstall Powder Measure and retighten Clamp Screws**



**Fig. 10—Powder Measure Assembly and Parts List**

NUM	DESCRIPTION
1	13990_POWDER DIE
2	14067_DIE LOCK RING
3	PISTOL STYLE POWDER DIE
4	RIFLE STYLE POWDER DIE
5	13940_BODYCOLLAR HOUSING
6	13845_BODY COLLAR SLEEVE
7	13793_BODY COLLAR ROLLER
8	14808_BODY COLLAR BUSHING
9	14023_8-32x750 BHCS
10	13939_BODY COLLAR CLAMP
11	14037_10-24x750 SHCS
12	13780_POWDER MEASURE BODY
13	13691_HOPPER TUBE
14	14202_8x375 HOPPER TUBE SCREW
15	13822_POWDER HOPPER LID
16	13871_BELLCRANK CUBE
17	11234_LOCK LINK ASSEM
18	14041_250 BOWED WASHER
19	13848_BELLCRANK BUSHING
20	13904_10-32x1250 SHCS
21	16340_10-32 LOCKNUT ZINC
22	13629_FAILSAFE RETURN ROD (650/750) 97000_FAILSAFE RETURN ROD (550)
23	18086_FAILSAFE ROD BUSHING
24	14033_PRIMER CUP SPRING
25	13801_TINNERMAN NUT
26	13799_FAILSAFE WINGNUT
27	13644_POWDER BAR SPACER
28	13921_POWDER BAR SPACER PLUG
29	20063-LARGE POWDER BAR ASSEM
30	21353_EXTRA LARGE POWDER BAR ASSEM
31	20062_SMALL POWDER BAR ASSEM
32	20780_EXTRA SMALL POWDER BAR ASSEM