

Dillon Powder Measure Failsafe Rod Installation Instructions

This instruction is for installing the Failsafe Rod Assemblies (See Fig. 8 page 2) used with the Lock Link Assembly PN11234 on the Dillon Powder Measures on each of the Dillon Reloading Systems. This Assembly returns the Powder Bar to its closed position when the Operating Handle of the Reloader is returned to its "Home" position.

1. **FOR ALL DILLON SYSTEMS**, install the Powder Measure on the Powder Die and lightly tighten the Clamping Screws—See Fig. 1 below.



Fig. 1 Install Powder Measure

2. **FOR ALL DILLON SYSTEMS** the proper adjustment of the Failsafe Rod, Bushing and Blue Wingnut is shown in Fig. 2 below.

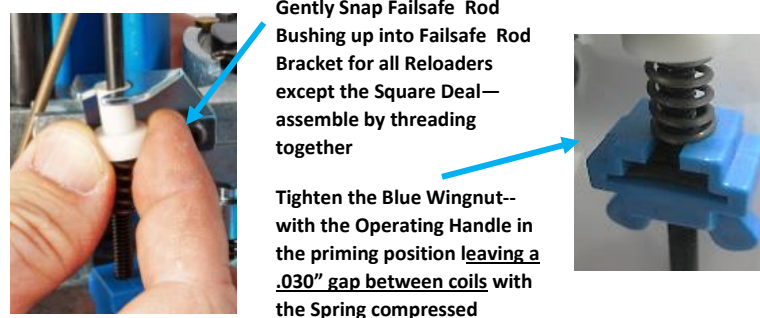


Fig. 2 General Failsafe Adjustment

SPECIFIC RELOADER FAILSAFE ROD PROCEDURES ARE AS FOLLOWS:

3. **Square Deal B**—Remove the Blue Wingnut, Spring and Failsafe Rod Bushing from the Failsafe Rod. Insert the threaded bottom end of the Rod down through the hole in the Square Deal Return Bracket, see Fig. 3. Use your hand to pull the Lock Link Assembly on the Powder Measure down aligning the hole with the slot and insert the Rod through the slot and the hole and install the Failsafe Rod Clip, see Fig. 1 below. Install the Spring, and thread the Blue Wingnut back on the Rod. Push and hold the Square Deal Operating Handle to the full aft priming position and thread the Blue Wingnut up until there is ~.030" gap between the Spring Coils—the approximate thickness of two business cards. You can also gently use the Operating Handle to pull the Bushing into place. Cycle the Operating Handle a couple of times and verify the proper clearance between the Spring Coils and that everything moves freely.

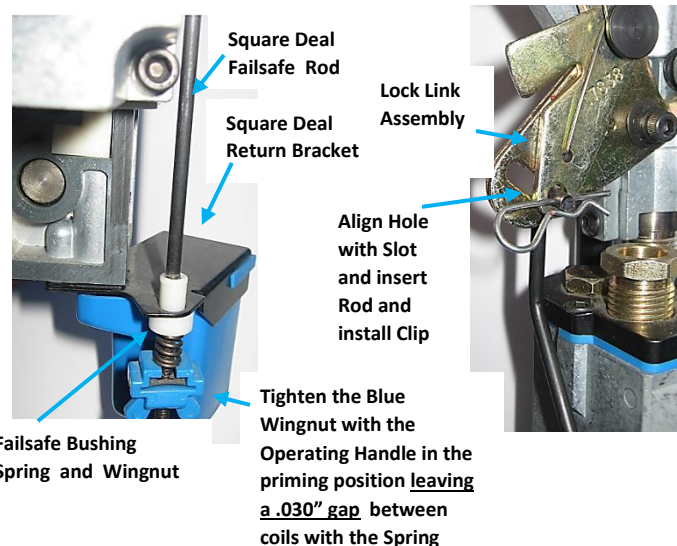


Fig. 3 Square Deal B

4. **RL 550B**-- Use your hand to pull the Lock Link Assembly on the Powder Measure down aligning the Slot with the Hole in the two parts and insert the Rod through the Slot and the Hole. See Fig. 4 below. Snap Failsafe Rod Bushing up into Failsafe Rod Bracket Fig. 4 below. Push and hold the RL550 Operating Handle to the full aft priming position and thread the Blue Wingnut up until there is ~.030" gap between the Spring Coils—the approximate thickness of two business cards with the Spring compressed. You can also gently use the Operating Handle to pull the Bushing into place. Cycle the Operating Handle a couple of times and verify the proper clearance between the Spring Coils and that everything moves freely.

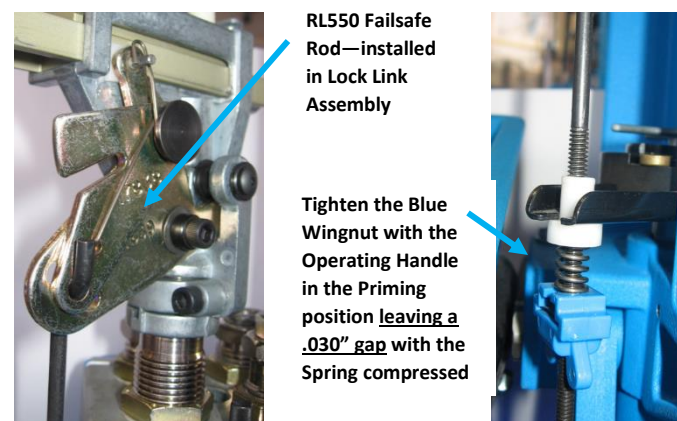
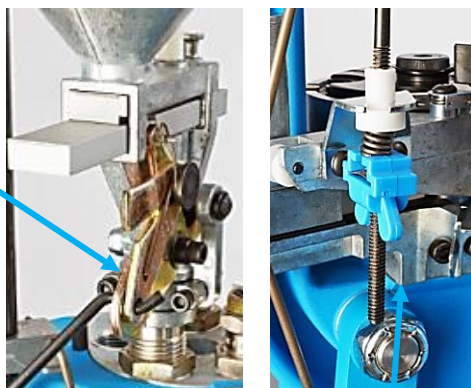


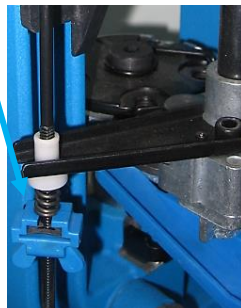
Fig. 4 RL550B/C

5. **XL 650/XL 750**-- Use your hand to pull the Lock Link Assembly on the Powder Measure down aligning the hole with the slot in the two parts and insert the Rod through the Slot and the Hole. See Fig. 5 below. Gently Snap the Failsafe Rod Bushing up into Failsafe Rod Bracket Fig. 5 below. Push and hold the RL550 Operating Handle to the full aft priming position and thread the Blue Wingnut up until there is ~.030" gap between the Spring Coils—the approximate thickness of two business cards with the Spring compressed. You can also gently use the Operating Handle to pull the Bushing into place. Cycle the Operating Handle a couple of times and verify the proper clearance between the Spring Coils and that everything moves freely.

XL650 and XL750 Failsafe Rod—installed in Lock Link Assembly through Slot and Hole



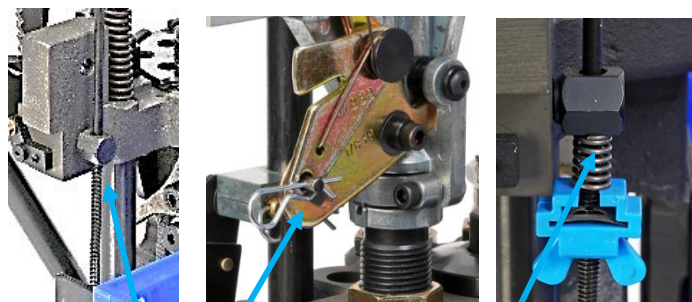
On the XL650, tighten the Blue Wingnut with the Operating Handle in the Priming position with the Spring compressed leaving a .030" gap



On the XL750 tighten the Blue Wingnut with the Operating Handle in the priming position leaving a .030" gap with the Spring compressed

Fig. 5 XL650 and XL750

6. **RL 1050 Super 1050, and RL1100**-- Remove the Blue Wingnut, and Spring from the Rod. Insert the bottom end of the threaded Rod down through the 3/8" Eyebolt in the backside of the Frame. See Fig. 5. Use your hand to pull the Lock Link Assembly on the Powder Measure down and align the Slot with the Hole in the two parts of the Lock Link Assembly. Insert the Hook Rod End through the Slot and the Hole and install the Failsafe Rod Clip. See Fig. 5. Re-install the Spring, and thread the Blue Wingnut back on the Rod end. Make sure the Operating Handle is back in its "Home" position. Thread the Blue Wingnut up until there is ~.030" gap between the Spring Coils—the approximate thickness of two business cards with the Spring compressed. Cycle the Operating Handle a couple of times and verify the proper clearance between the Spring Coils and that everything moves freely.

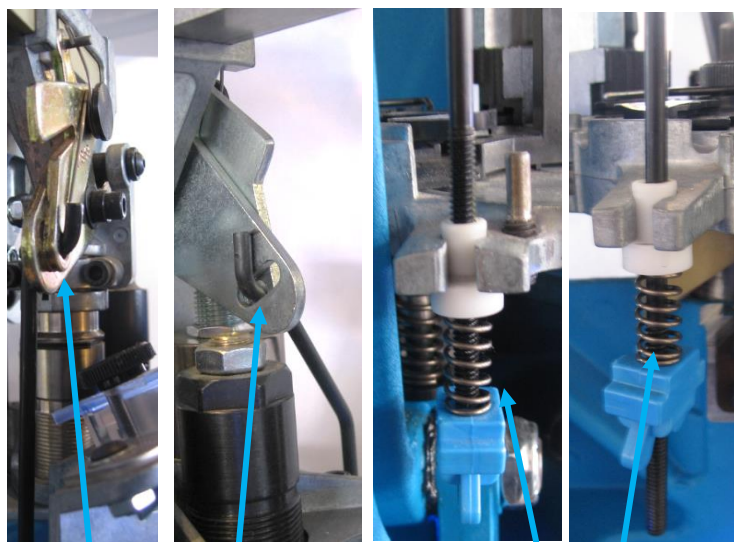


Install Rod down through eye bolt and insert hook through Slot and Hole in the Lock Link Assembly and secure the Rod with the Spring Clip

With the Operating Handle in the Home position, tighten the Blue Wingnut leaving a .030" gap with the Spring compressed

Fig. 6 RL 1050, Super 1050 and RL1100

7. **SL 900** The SL900 is unique in that it has two Failsafe Return Assemblies. One for the Powder Measure and one for the Shot Dispenser. Align the Slot and the Hole in the Shot Dispenser Lock Link Assembly and insert the hook end of the Failsafe Rod through the Lock Link Assembly. See Fig. 7. Align the Slot and the Hole in the Powder Measure Lock Link Assembly and insert the hook end of the Failsafe Rod through the Lock Link Assembly. Gently snap the Shot Dispenser Failsafe Bushings up into the Shot Dispenser return Bracket and the same for the Powder Measure. Push and hold the Operating Handle to the full aft position and thread both Blue Wingnuts up until there is ~.030" gap between the Spring Coils—the approximate thickness of two business cards with the Spring compressed. Cycle the Operating Handle a couple of times and verify the proper clearance between the Spring Coils and that everything moves freely.



Insert Hook End of Rod through the Lock Link Assembly of the Powder and Shot Dispenser

With the Operating Handle in the up position, tighten the Blue Wingnut leaving a .030" gap between coils with the Spring compressed for both the Shot and Powder Dispenser

Fig. 7 SL900

Reloader	Lock Link Assy	Return Rod Assy
Square Deal	11234	16814
RL550	11234	16813
SL650/750	11234	22172
RL/Super1050/RL1100	11234	16811
SL900 Shot Dispenser	11234	17822
SL900 Pwdr Dispenser	11234	17821

Fig. 8 Return Rod Assemblies

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