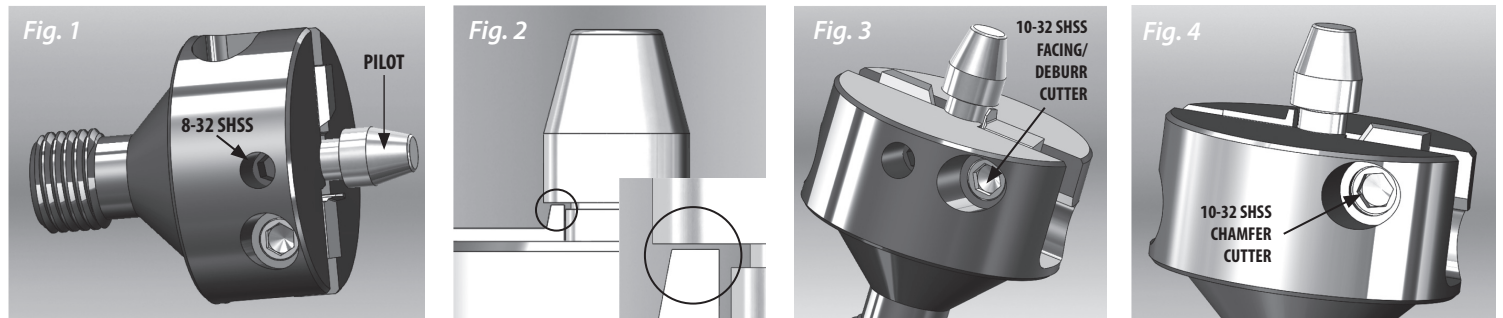


VLD 3-Way Carbide Cutter Instructions

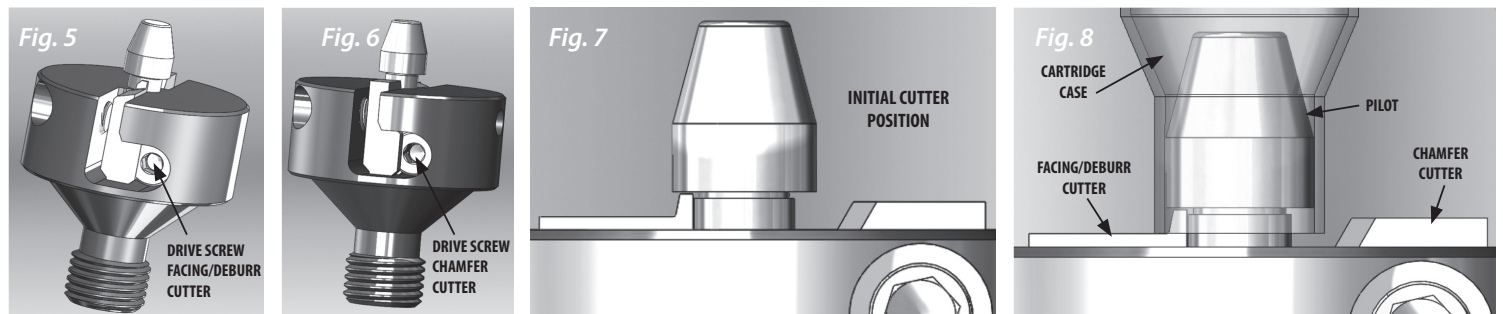
Your VLD 3-Way Carbide Cutter sets the standard in case trimming as it offers everything you need and want in a cutter. This unique one of kind cutter offers two adjustable carbide cutter inserts. The Facing & Deburr carbide insert trims the cartridge case to length as well as deburrs the inside of the case mouth to a 11 degree angle accommodating VLD style bullets. The Chamfer carbide insert removes the burr on the outside of the case mouth by cutting a 30 degree chamfer. The VLD 3-Way Carbide Cutter requires the use of standard RCBS pilots and can be adjusted to accommodate the trimming of cartridge cases ranging from .22 to .45 Cal. The VLD 3-Way Carbide Cutter attaches easily and works with Trim Pro Manual, Trim Pro Power, RCBS Universal Case Prep Center and Rotary Case Trimmers. Refer to your case trimmer instructions for important safety and operating information.

- Using a 5/64" hex wrench, loosen the 8-32 SHSS so an appropriate sized trimmer Pilot can be inserted into the Cutter Head. Insert trimmer pilot and ensure bottom of pilot does not make contact with the highest point on the Facing/Deburr cutter, (Fig. 1 & 2). The clearance will allow for adjustment of the Facing/Deburr cutter.
- Using a 3/32" hex wrench, loosen both 10-32 SHSS used to secure both the Facing/Deburr and Chamfer Cutters (see Fig. 3 & 4). Only rotate 1/4-1/2 turn max. , and do not remove.

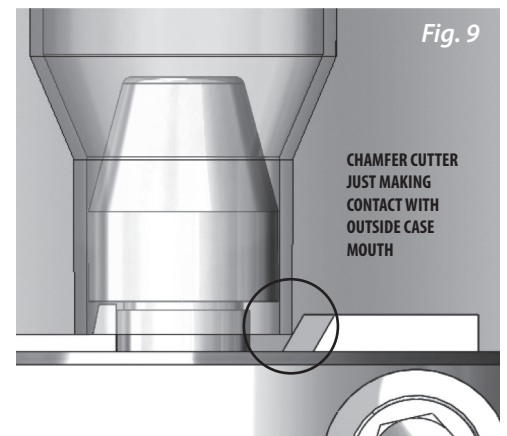


ENSURE THERE IS CLEARANCE BETWEEN CUTTING EDGE AND BOTTOM OF PILOT

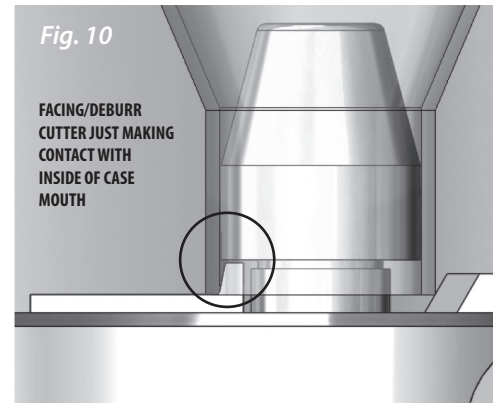
- Using a 3/32" hex wrench, rotate the two Drive Screws to position the cutters as shown, in Fig. 5-7. Clockwise rotation advances cutter towards pilot and counterclockwise rotation advances cutter away from pilot. This initial adjustment is to move the cutters into a position that will allow for the cutter to be set for the desired case to be trimmed.
- Using a sized and expanded cartridge case**, place over the pilot and onto the Facing/Deburr Cutter as shown in Fig. 8. This case will be used to adjust cutters.



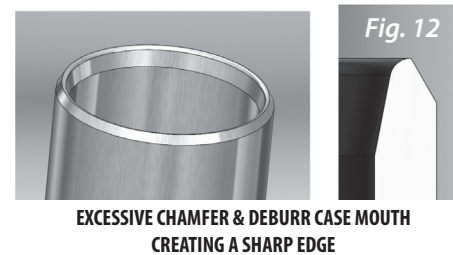
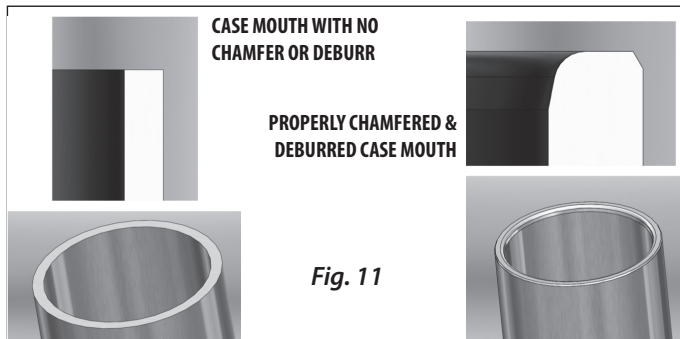
- Using a 3/32" hex wrench rotate Drive Screw to **position Chamfer cutter to where it is just making contact with the outside of the cartridge case**, this will aid in supporting the case. Once cutter is positioned properly secure cutter in place with the 10-32 SHSS (see Fig. 9).



6. Using a 3/32" hex wrench rotate Drive Screw moving the Facing/Deburr Cutter outboard to where the cutter just makes contact with the inside of the case mouth, **DO NOT EXCEED**. Once cutter is positioned properly secure cutter in place with the 10-32 SHSS (*see Fig. 10*).

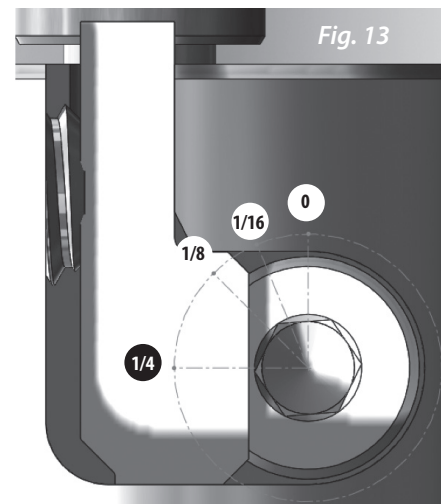


7. Test cutter on case to ensure all cutting edges are making contact and brass is being removed on the face and on the inside and outside of case mouth, to the desired amount. **DO THIS BY HAND TO ENSURE THE CUTTERS ARE SET PROPERLY AND TO PREVENT DAMAGING BRASS IF CUTTERS WERE SET INCORRECTLY**. Excessive chamfer and deburr will produce an undesirable sharp edge, if this happens readjustment of cutter is required (*see Fig. 11 & 12*).



8. Slight adjustments may be necessary to increase/decrease chamfer on outside of case mouth or increase/decrease deburr on inside of case mouth. To do this simply break loose the 10-32 SHSS securing cutter and rotate drive screw in or out using small increments (1/16-1/8 of a turn) to reposition cutter, using the 3/32" hex wrench. The drive screw has a thread pitch of 48, meaning one complete revolution will advance the cutter in or out by .020", thus a quarter turn of the drive screw will yield .005" of inch of travel inboard or outboard (*see Fig. 13*).

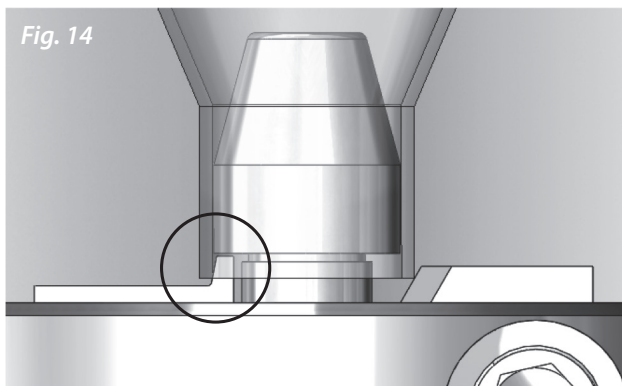
Note: before the 10-32 SHSS screw is loosened, remove the backlash in the thread by leaving the 10-32 setscrew tightened against cutter and rotate the drive screw in desired direction. *Example: If there is still a burr on the inside of the case mouth the cutter would need to moved outward to remove more material from inside case mouth.* Leaving the 10-32 setscrew secured in place, rotate the drive screw counterclockwise taking up any backlash in thread. **DO NOT FORCE** as soon as you feel resistance stop, all backlash is removed. Loosen the 10-32 SHSS screw and rotate drive screw 1/16 of a complete rotation. Secure the 10-32 SHSS and repeat step 7 above.



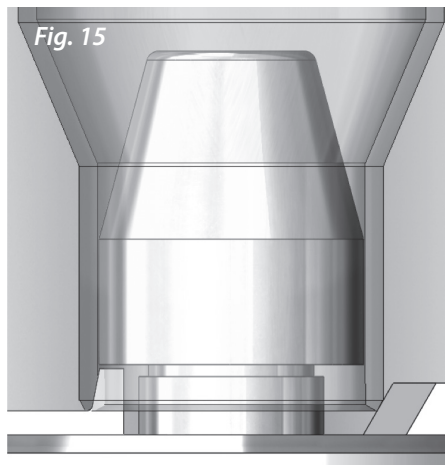
ADJUST CUTTERS BY ROTATING DRIVE SCREW, 1/16-1/8 OF A TURN



9. After test cut has been completed and desired results are achieved, ensure both 10-32 SHSS are secured in place.
10. It is important to note to not remove too much material, i.e., **do not force the cutters into the cartridge case as this will generate an excessive amount of material being removed and will damage the cartridge case**. Use small adjustments and when slight resistance is felt, i.e., cutter is in contact with case, secure cutter and conduct a test cut.

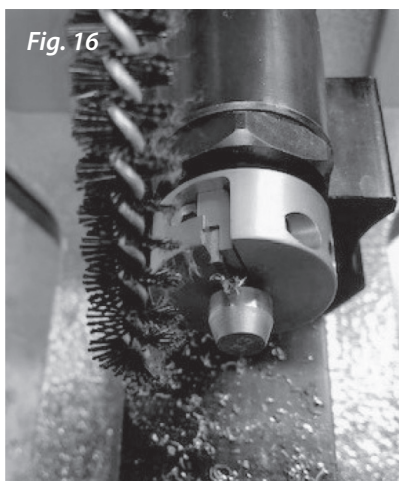
11. If the desired results are not being achieved using this process, and more of deburr or chamfer is desired, this can be done by simply lifting the case off of the cutting face slightly before advancing the cutters, then advance cutter until cutting edge is in contact with case (*see Fig. 14 & 15*). This will allow the cutter to be positioned to remove more material. If using this method perform a test cut by hand, if unable to rotate cutter and produce cut, then too much material is trying to be removed so the cutters will need to be repositioned to take less material. Remember small rotational adjustments are all that is required; 1/16-1/8 of a turn.



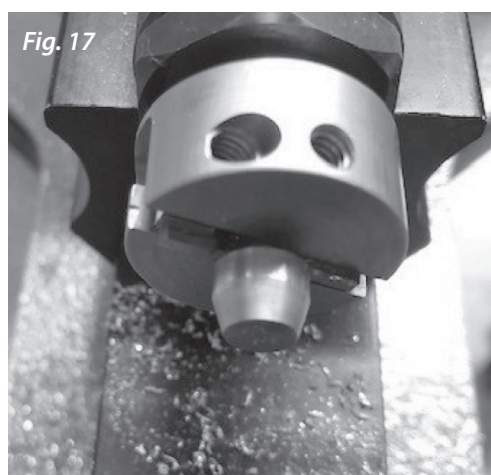
RAISE CASE OFF FACING CUTTER AND ADVANCE CUTTERS, TO GENERATE MORE AGGRESSIVE CUT. THIS IS DONE IF UNABLE TO ACHIEVE DESIRED REMOVAL OF MATERIAL WITH STANDARD PROCESS

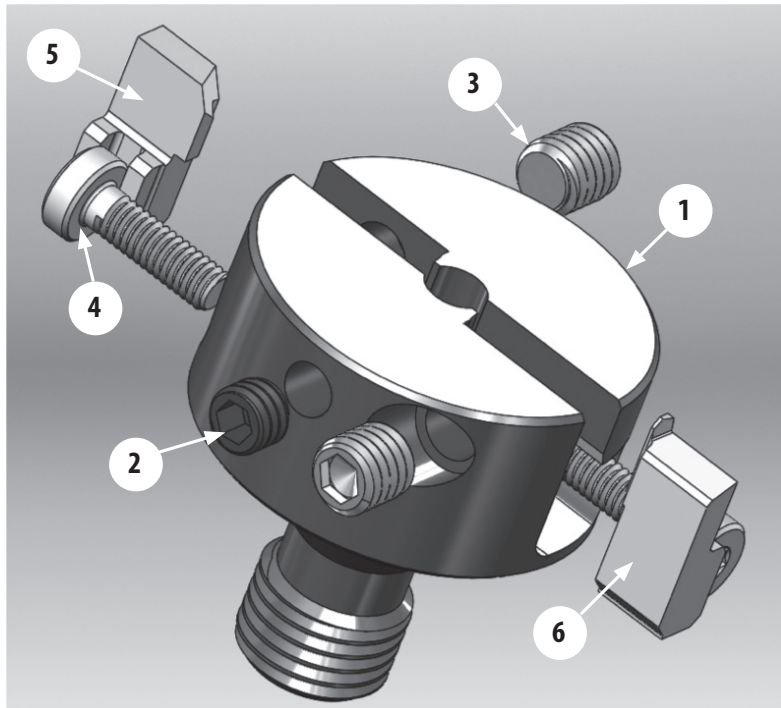


12. After cutter has been set correctly and desired results have been achieved it is time to place your VLD 3-Way Cutter on your Case Trimmer. Follow your case trimmer instructions for proper removal and installation of cutters.
13. Once cutter has been installed on the trimmer, and before desired trim to length is set, insert the same case previously tested by hand and run a test cut on trimmer, at low RPM. Inspect case and ensure cutter is producing the desired cut, if not readjust cutter as needed, following instructions above.
14. When all adjustments have been made and cutter is producing the desired result,  just your trimmer to the appropriate cartridge case trim to length and begin trimming your cases.
15. When cutter is in use, it is important to remove the brass chips from the cutting edge. If this is not done it can have an affect on the cartridge case length as the case is not in full contact with cutting edge. To prevent this from happening, monitor the cutter during use and when brass chips begin to build up on cutter, use a brush to remove. This will keep the cutting edges free of chips (*see Fig. 16 & 17*). 



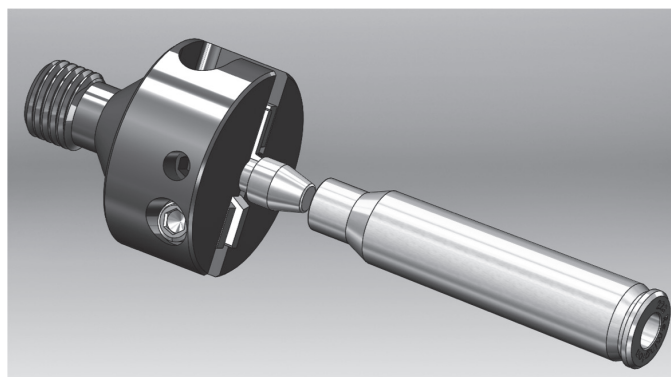
USE BRUSH TO REMOVE BRASS CHIPS FROM CUTTING EDGE





Replacement Parts List

ITEM #	PART #	DESCRIPTION	QTY.
1	20034248	3 WAY VLD CUTTER HEAD	1
2	7109409	8-32 X 1/8L SETSCREW	1
3	20034252	10-32 X 3/16" SHSS	2
4	20034245	DRIVE SCREW 4-48 X 3/8"	2
5	20034254	CARBIDE CHAMFER INSERT	1
6	20034256	FACING & DEBURR CARBIDE INSERT	1



LIMITED LIFETIME WARRANTY

Your VLD 3-Way Cutter is warranted to be free from defects in material or workmanship for as long as the original owner owns it. This warranty is extended only to the original consumer purchaser. This warranty excludes any electrical components or products. All RCBS products are intended for noncommercial use by hobbyists. Any other use of these products will void the warranty. Should you believe you're your VLD 3-Way Cutter is defective in material or workmanship, you must return the VLD 3-Way Cutter to RCBS postage paid for evaluation. If defective, the product will be repaired or replaced at the option of RCBS, at no charge.

Send a dated proof of purchase to RCBS for return shipping and handling, along with the VLD 3-Way Cutter to:

RCBS
605 Oro Dam Blvd East
Oroville, California 95965

Warranty services cannot be provided without meeting the above requirements.

THIS LIMITED LIFETIME WARRANTY DOES NOT COVER DEFECTS OR DAMAGE RESULTING FROM: CARELESSNESS, MISUSE, COMMERCIAL USE, ABUSE, IMPROPER INSTALLATION, MODIFICATION, OR NORMAL WEAR AND TEAR. THE IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE ARE LIMITED TO THE DURATION OF THIS LIMITED LIFETIME WARRANTY. OROVILLE OPERATIONS IS NOT LIABLE FOR DAMAGES IN EXCESS OF THE PURCHASE PRICE OF THE PRODUCT AND UNDER NO CIRCUMSTANCES SHALL OROVILLE OPERATIONS BE LIABLE FOR CONSEQUENTIAL OR INCIDENTAL DAMAGES. HOWEVER, SOME STATES DO NOT ALLOW LIMITATIONS ON INCIDENTAL, OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

The above warranty provides the sole and exclusive warranty available to the customer in the event of a defect in material or workmanship in the VLD 3-Way Cutter. This warranty gives you specific legal rights, and you may also have other rights which vary from State to State.

PRECISIONEERED RELOADING EQUIPMENT

We think we make the world's best reloading equipment.
If you agree, please tell your friends.
If you disagree, tell us—we want to do something about it!

Customer Service

1-800-533-5000 (U.S. or Canada)
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