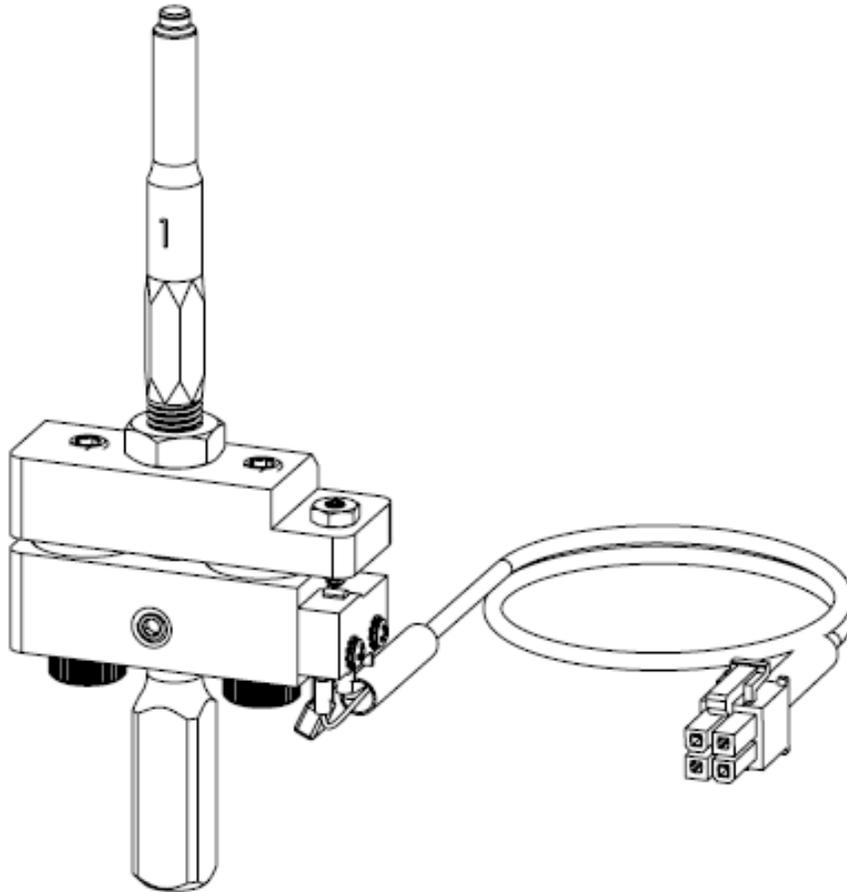




101-1015: Mark 7[®] SwageSense 1050 Super , RL 1050

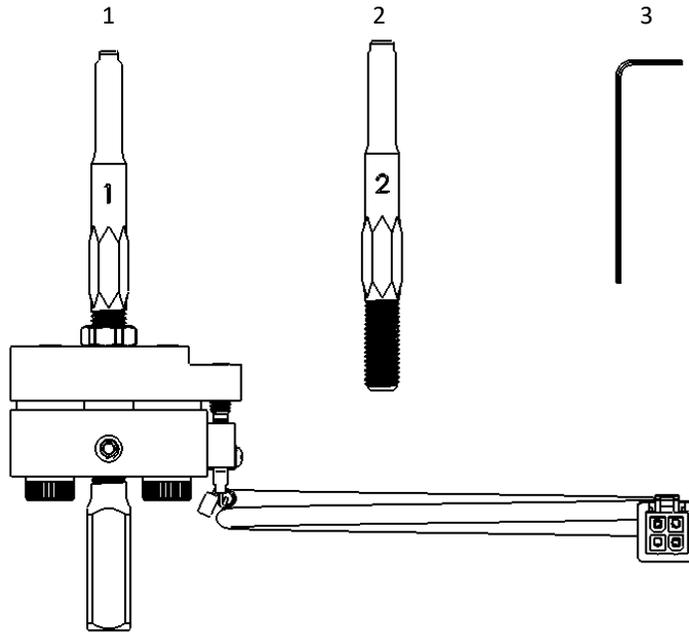
Instruction Manual V 1.1



Read this manual completely. Understand all safety and operating instructions. Failure to comply with the warnings and instructions may result in serious injury, illness or death.

Package Contents

Please review these contents and inform us right away if you appear to be missing any of these items:

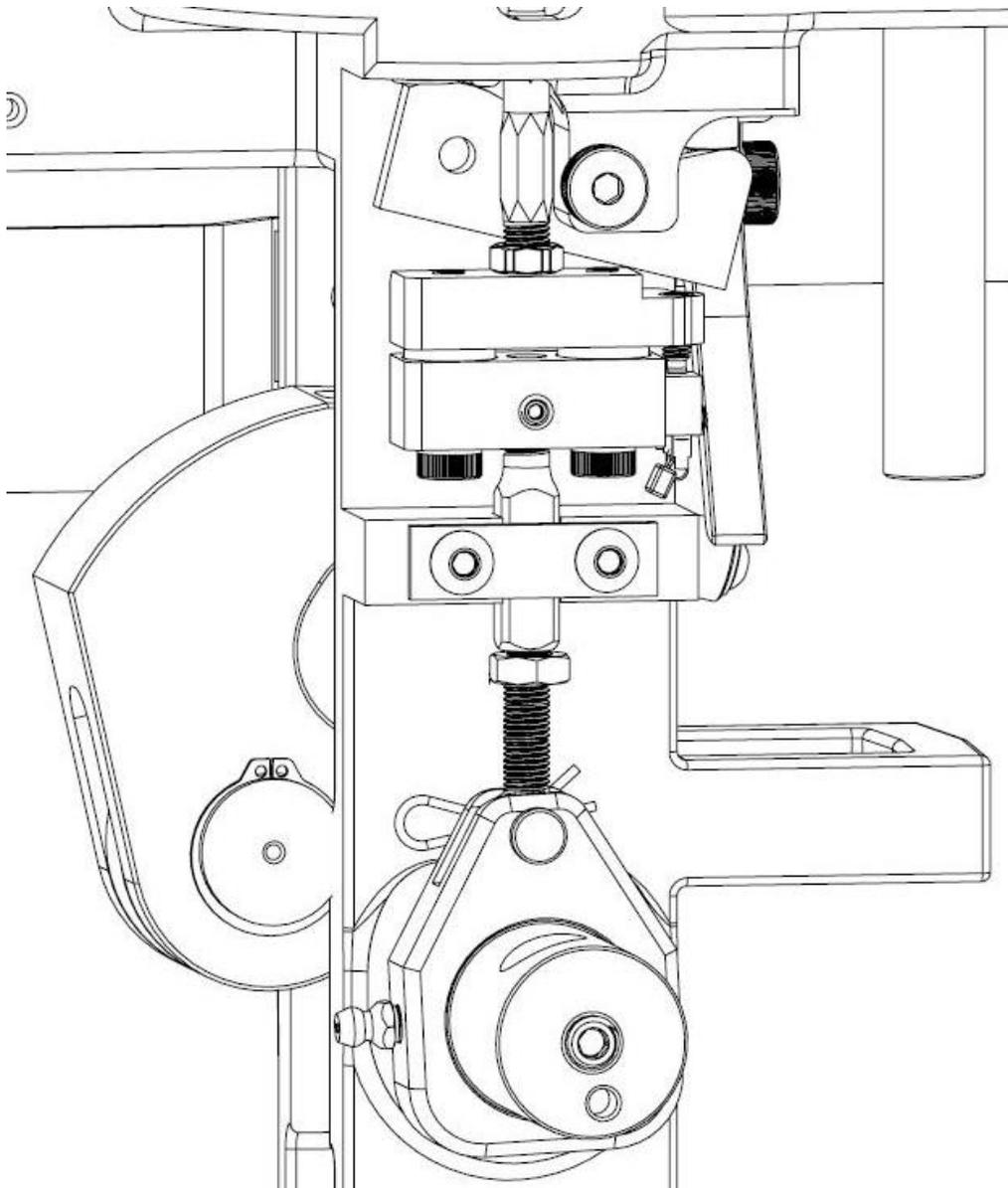


Item No.	Description	QTY
1	SwageSense Core Assy	1
2	Swage Rod Upper - LG	1
3	.05" Allen Key	1

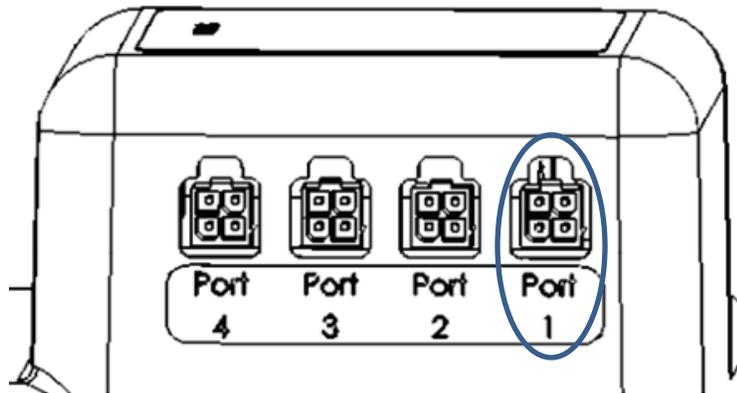


Set-Up Procedures:

1. Disassemble Dillon 1050 to remove and replace Dillon Swage Rod Assembly with SwageSense Core Assy. Refer to Dillon manual for complete steps. Be sure to keep all necessary Dillon components to complete SwageSense installation.
2. See image below for SwageSense installation onto Dillon Press.



3. Connect **SwageSense Cable** into **Console Port 1**.



4. Back off the Swage back-up expander die and swage rod off a few threads and insert a de-capped case into station #3. Move the press head to the bottom position. Adjust the swage back-up expander so it bottoms out against the bottom of the case and lock down the die. Next using 5/16 wrench thread the swage rod up until it bottoms out into the case pocket. Then turn it a $\frac{1}{4}$ turn more and lock down the jam nut. See the figure below.

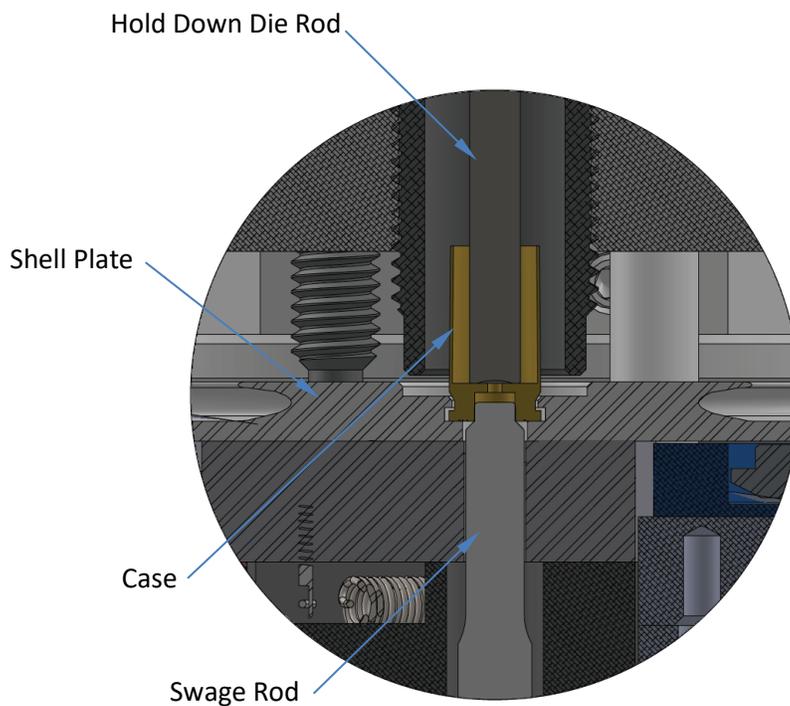


Figure 1: Cross-section of properly adjusted Swage Rod.



- The **Microswitch** is pre-adjusted so it will be triggered immediately when the SwageSense® assembly starts to close. If you want to change the engagement of the switch use a .05" Allen Key and a ¼" open end wrench. We do not recommend adjusting the setting unless it becomes out of adjustment. To adjust tighten the **Set Screw** until you hear the switch trigger, then back it off a ¼ turn and lock down with the Jam Nut.

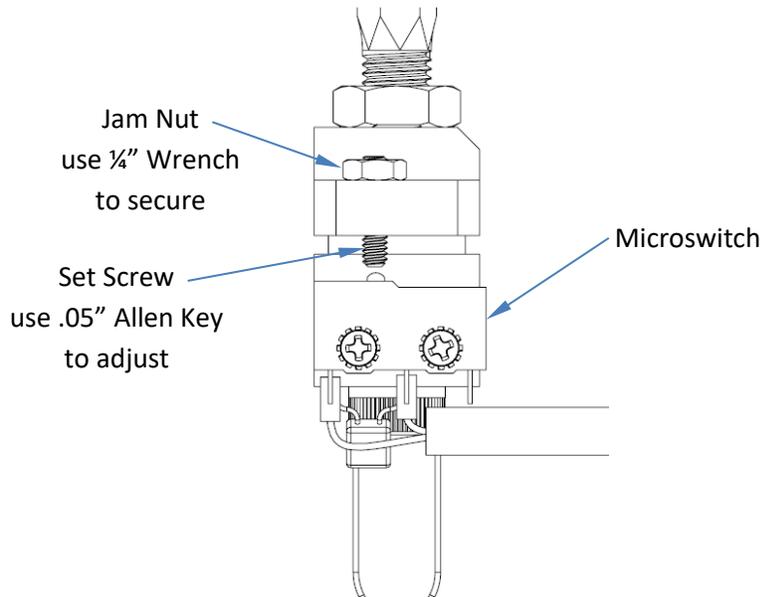


Figure 2: Microswitch Adjustment.

- When the **SwageSense®** switch is triggered the following notification will appear on the reloader application.

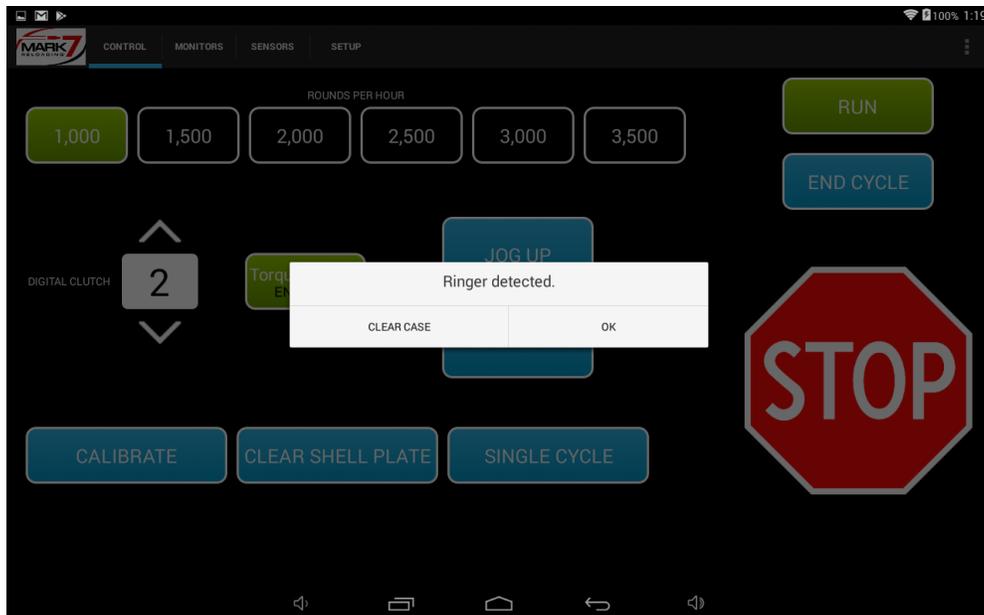


Figure 3: SwageSense® Notification.

Increasing SwageSense Force

1. The swage force on SwageSense is adjustable from very sensitive (SM pistol) to full lockout (military crimp.)
2. The **Gap** between the upper and lower housings determines the pre-load force on the assembly. To adjust the gap first start by loosening the two **Jam Set Screws** on the top of the **Housing**.
3. Then adjust the **Shoulder Screws** on the bottom of the housing to set the desired force. The gap working range is from .075-.095". Never operate SwageSense out of this range. Whenever the gap is adjusted the **Microswitch** will also need to be adjusted. Lastly, lock down the **Shoulder Screws** with the $\frac{1}{4}$ "-20 **Jam Set Screws**.
4. We recommend starting with a gap of .095". Then adjust the **Microswitch Set Screw** so it is just starting to depress the **Microswitch**. Start with this value, by tightening the **Shoulder Screws** you will add more pre-load to the screws which increases the swage force but makes the ringer detection less sensitive.
5. Tighten the **Shoulder Screws** evenly until desired gap is reached. Tighten two **Jam Set Screws**.

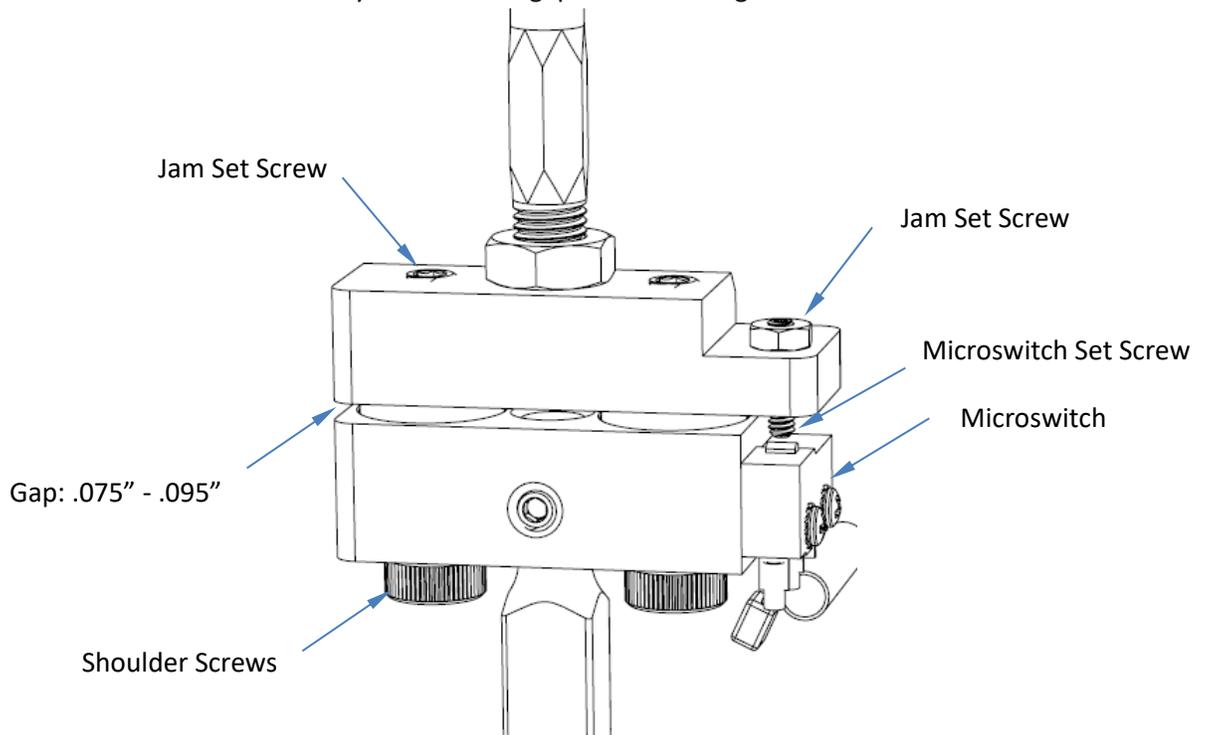


Figure 4: Adding set screws to lock shoulder screws in place.



Troubleshooting

Refer to the knowledge base section on our website under **SUPPORT** for troubleshooting articles relating to setup and operation.

<http://www.markvii-loading.com/knowledgebase>

Please contact us for technical support

Phone: 1-888-462-7577

Hours: 9:00am-4:30pm, ET, M-F