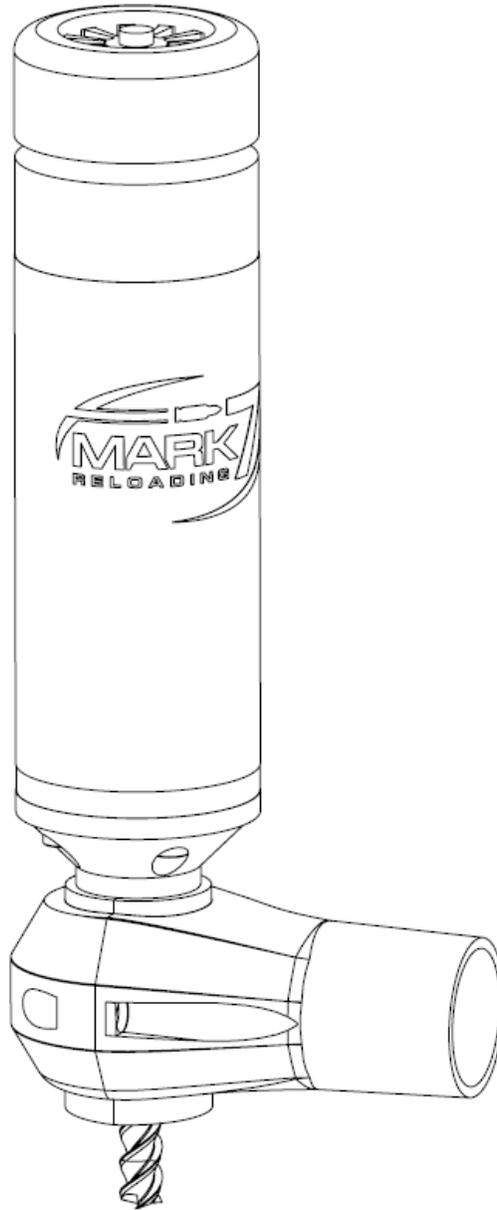




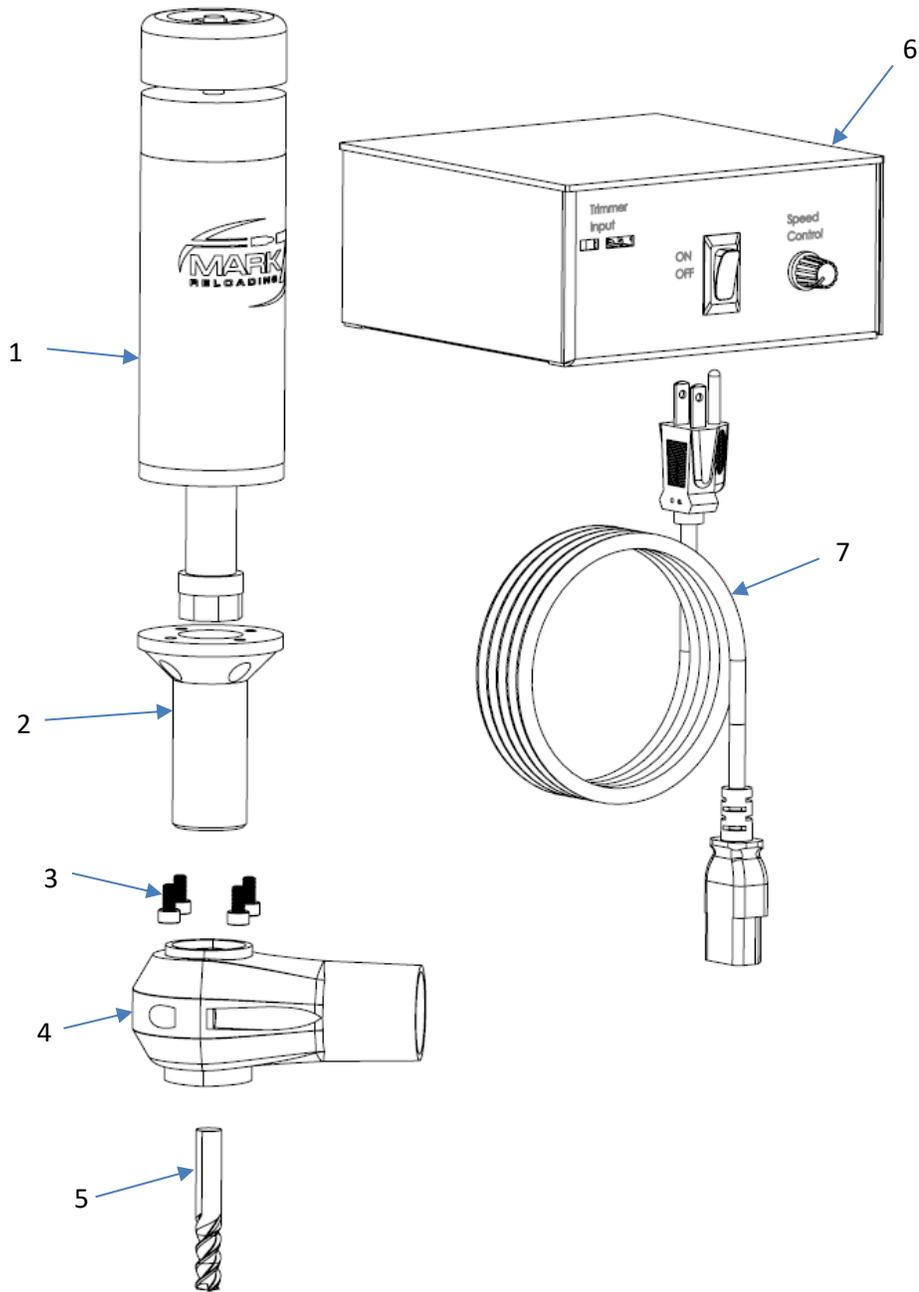
# 101-1196: Mark 7® Power Trim Xpress Instruction Manual V 1.1



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



## Package Contents



Item No.	Description	QTY
1	Brushless Trimmer Body	1
2	Trim Die Adapter	1
3	Socket Head Cap Screw, M5x0.8mm Thread, 10mm Long	4
4	Vacuum Manifold	1
5	3/8" Carbide End Mill	1
6	Trimmer Control Box	1
7	Power Cord	1



## Set-up & Operation

- 1) Install the trim die in your press. **Note:** for some short cases such as the 300 AAC, the trim die lock ring may need to be installed on the underside of the die station rather than on top. An offset toolhead may also be required. Cycle the press so that the shell plate or shell holder are at their full travel and closest to the die station. Turn the die into the press until it contacts the shell plate or shell holder, then back off the die about a  $\frac{1}{2}$  turn.
- 2) Assemble the trimmer, by first installing the carbide cutter. Place the cutter inside the collet approximately  $\frac{1}{2}$ - $\frac{3}{4}$  of an inch and tighten using two wrenches. Install the nose cone with the included 4 screws, do not overtighten.

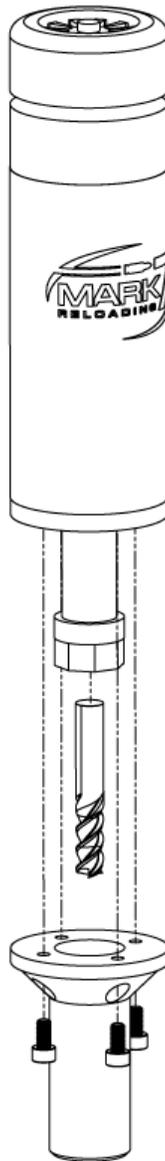


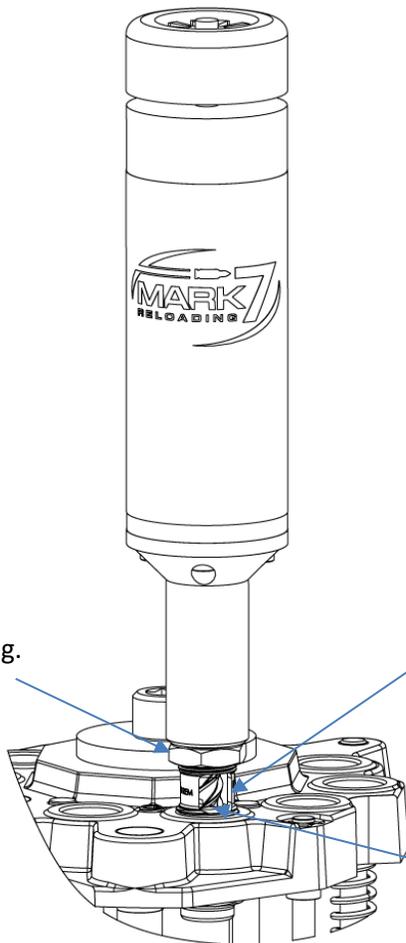
Figure 1. Trimmer Assembly



- 3) We recommend that cases be sized before running them through the trim die. While the trim die is dimensioned to the same specs as a sizing die, sizing first will allow cases to run through the trim die smoother which promotes more uniform results.
- 4) Lube a case and cycle it through the trim die. Wipe it clean and check it in a cartridge headspace gauge. We strongly suggest the use of a headspace gauge to verify that your set-up is correct, and that the headspace is proper (check after sizing and again after passing through the trim die). If the headspace is below the minimum step, back the die further out of the press. If the headspace is above the maximum step, thread the die deeper into the press. Once the headspace is set correctly, lock the die body in place.
- 5) Lube a case that needs trimming and run it fully into the trim die. Leave the case in this position. Thread the trimmer onto the trim die until the cutter stops against the mouth of the case. Remove the case from the die and thread the trimmer about a ¼ turn further down. (Note: the 13/16"x20 mounting thread will lower the trimmer .050" per revolution. A ¼ turn will be .0125".) **Always verify that the cutter is not touching the die body when adjusting the trimmer! If the carbide cutter contacts the die body it will be damaged!** Tighten the lock ring against the trimmer. **Warning: Always have the lock ring securely tightened against the trimmer before turning on the trimmer. If loose, torque from the trimmer motor will cause the trimmer to spin and may damage the cutter or power cords.**



Securely tighten the lock ring against the trimmer before running.



Be sure the trim die is high enough for the windows to be exposed to help with chip evacuation. Offset tool head may be required

Verify cutter is not touching the trim die before running.



Figure 2. Trimmer Setup on Press



- 6) Connect the power cord from the trimmer to the control box and plug in the power cord from the control box to an outlet.
- 7) Move the power switch to On and set the motor speed to position 7-8.
- 8) Run a lubed case through the trim die and then check the overall length of the trimmed case. Loosen the lock ring against the trimmer and adjust the trimmer up or down in the die body if needed to correct the case length. Again, verify that the cutter is not contacting the die body and tighten the trimmer lock ring before trying another case.
- 9) Once the case length is adjusted, the vacuum manifold should be installed around the die and trimmer. Remove the two screws holding the manifold together and place the two manifold sections around the die and trimmer. Reinstall the screws and tighten them securely. Attach you shop vacuum hose to the manifold. The manifold is designed to fit 1 ½" hoses.

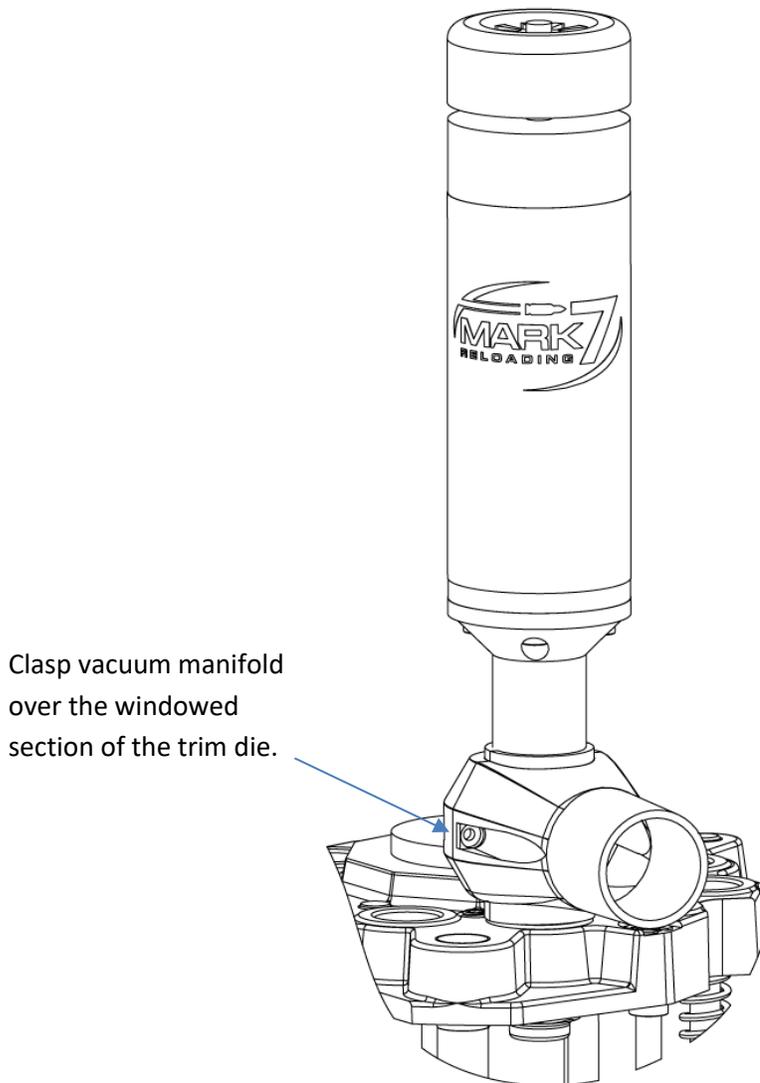


Figure 3. Vacuum Manifold Installation



- 10) Lube your cases and begin trimming. The control box allows for varying the speed of the trimmer. Most often you will want to run it at a medium to high speed. Use the highest speed that produces a clean cut. If you see chatter, try slowing down the motor.



## Cartridge Conversion

The trimmer can convert 223 cases into 300 AAC Blackout in one pass. Be aware however that a considerable amount of brass is being removed during this conversion. Using a slower cycle rate and adding some dwell to the trimming operation will help produce a clean cut. Watch for chip build up in the vacuum manifold and in the vacuum hose. These can become clogged with chips quickly. Check the manifold and hose every 50 to 75 cases and clean out excess chips. **Be sure to turn off and unplug the trimmer before cleaning chips!** The short 300 AAC case (and trim die) often require the use of an off-set tool head. The lock ring may also need to be moved to the bottom side of the tool head to secure the die. **Note: when converting cases, be sure to check the neck thickness of the finished 300 AAC cases. Some 223 cases will be thicker than others and may produce 300 AAC cases with necks that will exceed SAAMI maximum neck diameter. Your 223 cases will need to be separated and only the case brands that will produce in-spec neck diameters should be converted.**

## Changing the Carbide Cutter

- 1) To change the cutter, unplug the control box from the power outlet and unplug the trimmer from the control box. Then unthread the trimmer from trim die.
- 2) Remove the four screws holding the mounting adapter to the trimmer motor and lift the adapter off the trimmer shaft.
- 3) Place a wrench onto the flats on the trimmer shaft and another wrench on the collet nut. Turn the collet nut counterclockwise to loosen the collet.
- 4) Once the collet is loose, the cutter can be slid out.
- 5) Reverse the above procedure to reinstall a cutter.

## 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