

Instructions for Lyman 50 BMG Case Trimmer

A metallic cartridge case will stretch after a number of firings and it then becomes necessary to trim it back to its proper length so it will chamber properly.

The Lyman 50 BMG Case Trimmer is designed expressly for the large 50 BMG case. The trimmer has been scaled up to easily handle the extra length and diameter.

MOUNTING:

The base of your trimmer is drilled with offset holes for mounting directly to the top of your reloading bench without splitting the wood. This is the recommended method of mounting. Some reloaders prefer to clamp their trimmer in a vise when using it. If the trimmer is to be used in this manner, Lyman recommends that it be fastened to a block of wood. The wooden block can then be held firmly in the vise jaws without damaging the base.

INSTALLING THE CUTTER AND PILOT

Thread the cutter on to the cutter shaft until tight to the shaft. An easy method we use to ensure tightness is to finger tighten the cutter to the shaft. We then insert the hex head wrench into the pilot set screw and apply clockwise pressure on the handle while holding the wrench firmly. When tight the cutter is secure and ready to use.

The pilot is inserted into the hole at the center of the cutter. Loosen the set screw with the wrench provided until the pilot sits flush to the cutter. Tighten the set screw. Use caution, as the cutter edges are extremely sharp. Note: Pilot in plastic vial with hex wrench.

PREPARING THE CASES:

Before trimming, cases must be full-length or neck resized and deprimed. Pilots are designed to be used with sized necks only.

MEASURING THE CASES:

You will need an accurate means of measuring case length. We recommend Lyman precision calipers. When your cases have lengthened to the point where they exceed the maximum case length allowable for your cartridge, they must be trimmed.

Maximum Case Length for 50 BMG – 3.910"

Suggested "Trim – to Length" for 50 BMG – 3.890"

LOCKING THE CASES IN PLACE:

Place the case into the shell retainer. The shell retainer has been slotted to properly fit the 50 BMG case only. Slide the cutter shaft towards the case until the pilot enters the case mouth. This helps to align the case and cutter head. With the pilot positioned in the case mouth, turn the "T" handle clockwise until it makes firm contact with the case. You are now ready to trim.

ADJUSTING THE CUT:

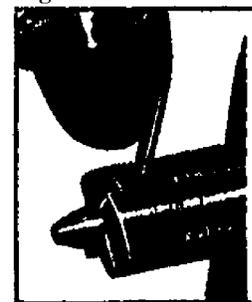
Two knurled adjustment rings, located on the cutter shaft (see figure B), provide for both fine and coarse adjustments. Before making any adjustments, hold the large ring with your finger and turn the small ring counterclockwise, four full turns. This will leave about $\frac{3}{32}$ " space between the rings and allow room for fine adjustment. Make certain the cutter face is still positioned against the case mouth and slide the adjustment rings in tight against the side of the shaft bearing. Tighten the lock screw in the small ring.

The large ring has a series of indicators each representing .001 inch of travel on the shaft. Used as reference marks, they enable the user to return to an approximate setting for various cases without time consuming trial and error testing.

PROCESSING YOUR CASES:

Once your trimmer is in adjustment, the entire lot of cases may be processed to bring them all to the correct length. As you turn the crank handle, keep an inward pressure on the cutter so that it is always bearing against the case mouth, but do not force it. After trimming, small burrs will be present on the case mouth. These can be easily removed from both inside and outside the case mouth with the Lyman 50 cal. Deburring tool. When your correct trim length is set, leave the lock rings locked in place to ensure constant trim length.

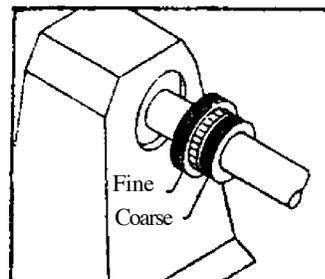
Figure A



Insert pilot into cutter head and lock in place with allen wrench.

Note: Pilot in plastic vial with hex wrench.

Figure B



Both fine and coarse adjustments are provided.

Key	Description	Part No.
1	T-Handle	7993023
2	Shell Retainer	7993024
3	Cutter Head Assembly	7822011
4	Cutter Shaft Bearing	7993005
5	Stop Collar, Coarse	7994417
6	8-32 x 1/8 Set Screw (2)	7994418
7	Stop Collar Fine	7994416
8	Nylon-Ball (2)	7990076
9	10-32 Socket Head Cap Screw (2)	7993006
10	Cutter Shaft Assembly	7993025
11	50 BMG Trimmer Base	7993011
12	50 BMG Pilot	7821982

