

## K&M PRIMER / GAGE – Instructions for use

This tool insures that you seat primers to the bottom of the primer pocket because it neutralizes the variables of manufacturing tolerances of primer height and primer pocket depth by measuring the depth of the primer pocket and referencing this to the primer height. This is accomplished when the primer seating rod acts as a probe to locate the bottom of the primer pocket while the dial indicator stem rests on the primer which is placed on the pedestal.

To initially set up the tool install the proper seating anvil and shell holder for your cartridge. Next rotate the shell holder retainer nut so there is ample stroke remaining in the seating handle to properly seat the primer. This is best achieved by placing a primed case in the shell holder and squeezing the handle until it stops. The position where the handle stops should be in the general area as shown in the picture below. A good reference point to note is the end of the handle is near the bottom edge of the safety shield. Rotate the shell holder retainer nut as required to achieve this final position. (This step is complete when the tool is purchased directly from K&M)



Next, begin the operating sequence as follows:

1. Close the handle and hold it closed while you rotate the safety shield to expose the primer pedestal.
2. Place the primer on the pedestal with the pedals of the anvil facing down on the pedestal.



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3. Rotate the safety shield back to the home position and release the handle. The dial indicator stem now rests on the primer.



4. Now place the shell to be primed into the shell holder.
5. Close the handle completely to the body and hold it while you rotate the face of the dial indicator so the needle is at "Zero". At this point the dial indicator stem is resting on the primer and the seating anvil is at the bottom of the primer pocket.



6. Release the handle and remove the shell.
7. Close the handle - rotate the safety cam and transfer the primer from the pedestal to the seating anvil assembly in the shell holder – rotate the safety shield home and release the handle
8. Place the shell back into the shell holder.
9. Slowly close handle and seat the primer until the needle again points to the set "Zero" (note, the indicator will make 2-3 rotations before it reaches your set zero). At the zero point the primer anvil is just touching the bottom of the primer pocket. Now seat it just a little farther to take up the slack caused by the drying process and the slight deformation caused by the seating force. Seat your primer beyond zero, small primers .002" and large primers .003"
10. Open handle – Remove shell.



**Note: Some new shell holders supplied by Lee may have a small burr on the top inside edge of the thru hole. The burr must be removed so the primer seating assembly passes freely through hole. Prep all shells with K&M Primer Pocket Correction Tool.**

**Repeat steps 1 – 10 for each additional shell.**