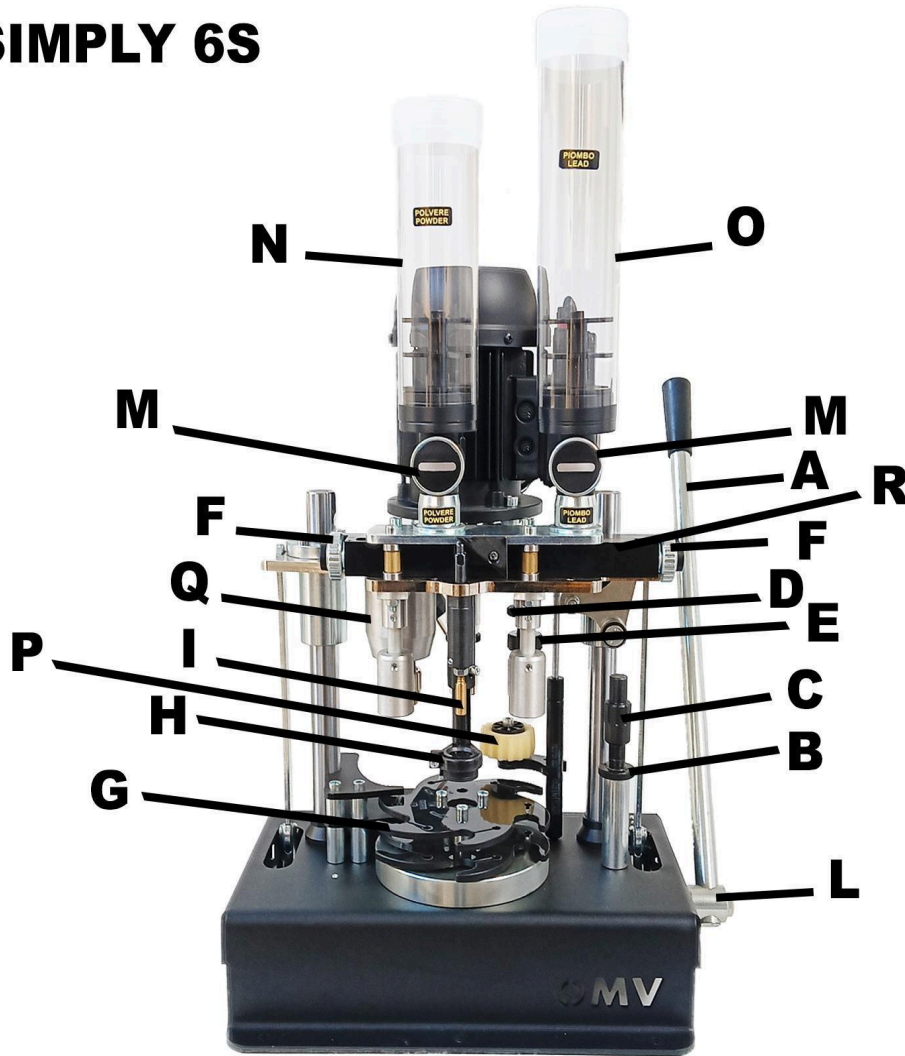


## SIMPLY 6S



### SIMPLY 6S ROTARY PRESS

- A Press operating lever
- B Finished cartridge height regulator locking ring
- C Finished cartridge height regulator
- D Engraver height regulator locking ring
- E Engraver height regulator
- F Powder and lead dispenser adjustment ring
- G Rotating disk
- H Wad guide
- I Wad pusher
- L Operating lever regulator
- M Powder and lead tank closing taps
- N Powder tank tube
- O Lead tank tube
- P Case oiling sponge
- Q Hemming head
- R Micrometric bar



The press is available in the following calibers: 12-16-20-24-28-32-410

SIMPLY 6S closing in three steps (engraving, lowering and hemming) can load new cases, or fired cases, but previously regenerated outside the machine.

The press has been designed trying to make it very simple in the initial adjustment and in the use during loading, in fact once acquired the necessary experience, a few simple operations are enough to change caliber and adjust the machine.

The powder and lead dosing system is performed using a dosing bar and micrometric knobs for dose adjustment; the bar is equipped with a mechanical vibration system to settle the powder and lead, and to have as little error as possible.

For the powder tank, a special glass tube is used, in order not to transmit electrostatic charges to the product, making it smoother and consequently more precise doses.

For the engraving of the case we used a rotating quick coupling system, to recover the old star folds of the cases already fired. Usually for new cases a steel engraver is used, while for recovered cases that already have an old fold it is advisable to use a special plastic engraver.

In the cartridge closing station we have a tempered steel hemmer, mounted on a support with two ball bearings, driven by a toothed belt with an electric motor. The motor turns at 1400 rpm, but there is a reduction ratio that reduces the rpm to 900 making it also gain power. This system ensures that the motor overheating is not transmitted to the hemming coil.

The machine can be used semi-automatically, that is with all the stations active, and with each pull of the lever a finished cartridge will come out, or by excluding the powder and lead dosers, even manually.

For example, we can fill cases with powder and lead with external dosers, and use the machine only for crimping and hemming, this also thanks to the rotating disk that can be rotated back and forth manually, as if it were a simple single-station press and therefore also be able to go over the closure again. Very convenient for making samples.

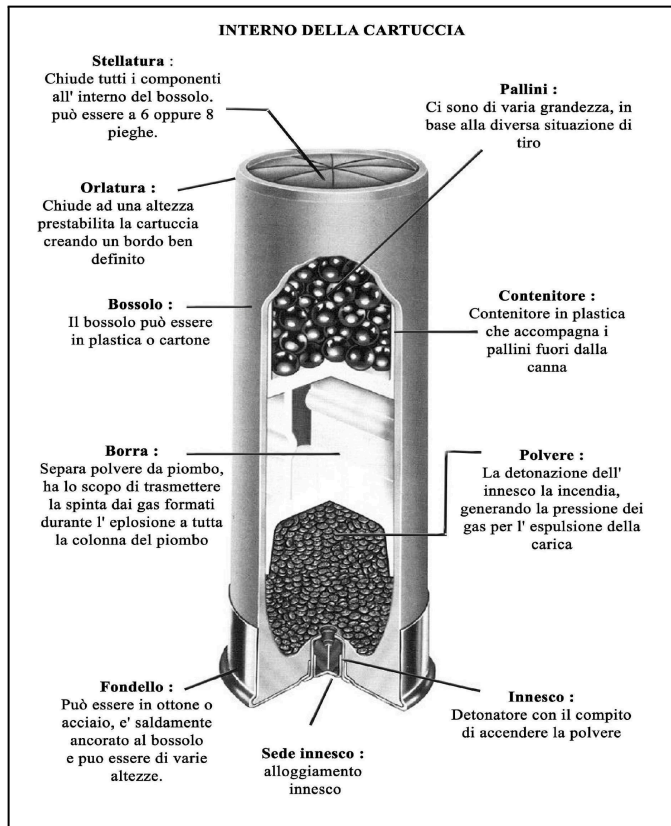
The caliber change is done by replacing the rotating disk, engraver, lowering tool and hemmer.

On all the machines it is possible to mount the pneumatic movement system, or with a pneumatic control unit where with a simple button we can lower and raise the press, avoiding pulling the lever.

## **INSTALLATION**

Lock the machine on a stable work surface using its fixing holes. If we work standing up, we will need to have the press at a comfortable height, positioned on a surface of about 120-130 cm from the ground, to have the lever at the right angle with our elbow and have less effort.

Connect the motor power plug to an electrical outlet and position the cable so that it does not obstruct the press as it goes up and down.



**INCISIONE**



**STAR CRIMPER**

**RIBASSATURA**



**DEPRESSOR**

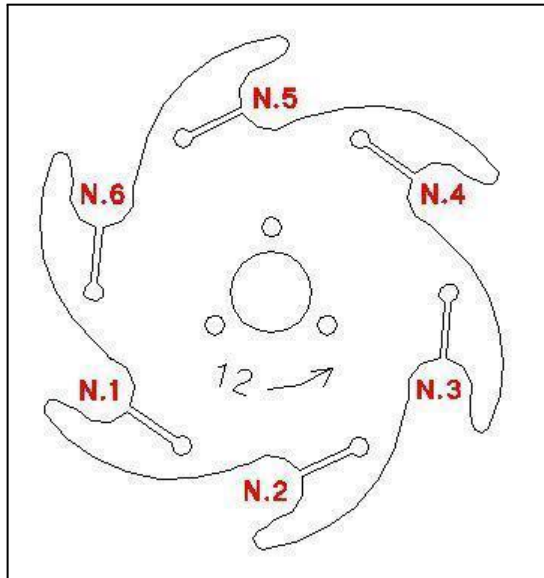
**ORLATURA**



**ROLL CRIMPER**

**SIMPLY 6S work phases description**

- Station No. 1: Insertion of new case for powder entry
- Station No. 2: Insertion of wad and wad pusher
- Station No. 3: Insertion of lead dose
- Station No. 4: Starring of case
- Station No. 5: Lowering of case
- Station No. 6: Hemming and closing of cartridge then ejection



**PHASE 1**

First make sure that the tank taps are closed in a horizontal position and fill the right tank with lead and the left tank with powder. Now we can adjust the height of the hem, insert a new empty case in any station and rotate the disk manually until it reaches the position (N.6 for 6S press) turn on the engine and lower the lever A until it stops, to create a round hem. Return the lever to its initial position, in this way we will have the ejection of the cartridge from the machine. Using a measuring gauge check the length of the case that we have obtained, and if it is not the right size, loosen the locking ring B and adjust the knob C (See photo below) in (+ -), tighten the locking ring again. Repeat the operation on the case until we have the desired size. This is the size of the finished cartridge; then during loading it is possible to vary the height based on the result obtained, since during all the simultaneous loading phases, some heights could vary slightly.

## PHASE 2

Now let's move on to the adjustment of the engraver, that is, station No. 4

Insert a new case in this station and pull the lever A until it stops, then go back. Check the folds on the case and if necessary adjust the height using the regulator E after loosening its ring D.

The engraving on the case must be similar to the one in the photo attached above; if it is more, you risk bending the case, if it is less, you could have a hole in the center of the finished cartridge closure. It is possible to change the height of the engraving even during loading, adjusting the engraver little by little based on the final result obtained. (Attention: for a correct star closure, always use flared cases).

To load new cases, use a steel engraver, while for those already fired it is advisable to use a plastic engraver which favors perfect realignment with the old engraving.

## PHASE 3

Lead dosage adjustment located above station No. 3

Insert an empty case in this station; after opening the lead tank tap M, pull the operating lever and unload a dose into the magnetic container provided. Weigh the dose using the scale, and act accordingly on the regulator F to modify the dose if necessary. Repeat the procedure until the expected dose is reached. Attention, before moving on to the next phase and adjusting the powder, you must close the tank tap and place the appropriate container under the doser.



#### PHASE 4

Powder dosage adjustment, located above station No. 1

Follow the same procedure described in phase 3, adjusting the powder dose using the left F regulator, taking into account that each notch corresponds to approximately 0.01 gr. (depends on the type of powder you are using). It is advisable to reach the right dose gradually.

Once you have reached the desired dose, set aside a case with the powder inside, which will be used for the next adjustment of the wad pusher.

#### PHASE 5

Adjusting the wad pusher station N.2.

To adjust this step, i.e. the pressure of the wad pusher I on the wad inside the case, it is necessary to use the case with the dose of powder previously set aside.

Insert the case into station 2 with the wad we intend to use inside.

After first loosening the nut of the regulator I, screw the pusher bar all the way up, operate the control lever until it stops, and keep it forced in that position; at this point lower the pusher by unscrewing it until it rests on the wad and lock the nut. It is important that the wad rests on the powder.

#### STARTING WORK WITH NEW CASES .

Insert a new empty case into station No. 1, i.e. under the powder insertion station. Open the powder tap in the vertical position (M). Continue by operating the operating lever until it stops and then goes back up (A). Once you reach station 2, insert the wad manually directly into the case and also insert an empty case into station No. 1. Continue the cycle until station 3 where you will open the lead tap (M). Continue with the same procedure until the end of the cycle. Each time you pull lever A, a finished cartridge will come out.

#### LOADING RECYCLED CASES

If we want to load recycled cases (already fired) we can do so, you must first have recalibrated them and primed them separately with suitable equipment, then they can be mounted in the machine as described for new cases. To insert the wad with this type of case it is necessary to use the special wad guide (H) which descends to the correct height by loosening the side screw.

#### PROCEDURE FOR END OF WORK CYCLE

Once we have reached the end of loading, we want to end the work cycle; proceed as follows: once the last case has been inserted into station 1, pull the operating lever (A), then the machine will insert the dose of powder on that case, and then move it under station 2. Close the dispenser tap and position the container provided under the dispenser to collect the powder left in circulation. Insert the wad and pull the lever (A), at this point the last case will be positioned under station 3 lead. We continue until we reach station 4 engraving, and close the lead tank and position the container to collect the lead left in circulation. Continue forward until the last cartridge is expelled.

If we want to remove the tanks (N O) to empty them of powder and lead, do this: bring the taps M to a horizontal position, place the containers under each tank and empty the powder and residual lead into the dispenser by moving the machine up and down using the lever A for about 3 times. At this point we can safely remove the dispensers from the machine.

## HOW TO DISASSEMBLE THE HEMMING COIL AND SCORING DEVICE

To disassemble the hemming coil is very simple, use two screwdrivers, one inserted into the hole located in the pin just above the hemmer, and one placed directly on the roll crimper. By applying opposite force with these two screwdrivers the coil unscrews.

To disassemble the engraving head that is held up magnetically, just pull it down firmly.

## MAINTENANCE

Keep the machine clean of pellets and residual dust and periodically oil the two bearing guides of the machine, so as to facilitate their sliding. Time, climatic conditions and humidity can damage the materials even if treated, therefore, to prevent these problems, pass a slightly greasy cloth over all the galvanized metal parts, so as not to encourage the appearance of rust. Alternatively, you can also use spray oil.

## NOTES TO READ

\*When choosing the case, keep in mind that for the star closure a flared case must be used, while for the round hem it must not be flared.

\* Be careful if during the loading cycle we stop for a long break or abandon the work, keep in mind that the break will have reopened the folds of the star of the last cartridge. It is necessary to remove it from the disk and bring the folds closer together with some tool, even a homemade one, a small tube of the appropriate size to push down the folds can be fine, if we do not do this operation the final hem will be done badly.

\* Insert oil into the appropriate sponge and adjust it so that it touches the case as it passes, leaving the plastic greasy, this allows you to have a better closure of the cartridge, also avoiding any possible overheating of the hemmer.

With a small brush, oil the calibrator bushing every now and then, we will immediately see an improvement in quality and we will also have less effort on the press.

\* To insert the wad with new cases it is not necessary to use the wad guide tool, which instead is necessary to use with recovered cases.