

### INSTRUCTIONS FOR USING WILSON PRIMER POCKET REAMERS

Congratulations on your purchase! Thank you for supporting our MADE IN THE USA family owned business! LE WILSON has been manufacturing high quality reloading tools since 1927. By using WILSON TOOLS & GAGES, you are on your way to developing more accurate uniform handloads.

**Primer Pocket Reamers** were designed for use in conjunction with the **WILSON Case Trimmer**, the trimmer acting as a jig for obtaining correct alignment between cartridge case and reamer and providing a substantial support during the reaming operation.

#### First Time Set Up

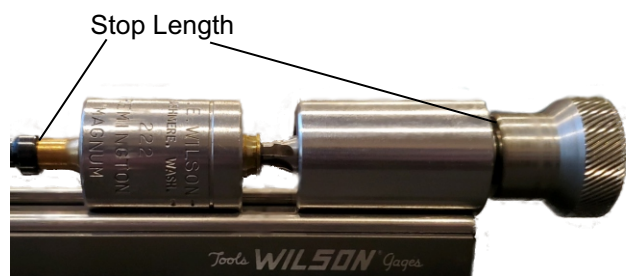
- 1) In use, the trimmer cutter is removed and the reamer inserted in its place.
- 2) The trimmer parts act as to support the reamer during the operation. The case is "bumped" lightly into the shell holder, the same as for trimming, but is held in the trimmer reversed. (Case mouth facing stop screw).
- 3) If many cases are to be reamed, adjust the stop so that it will take the thrust of the reamer.
- 4) With case in case holder, set on trimmer rails, case mouth to stop side.
- 5) Primer pocket depths vary, so the best way to assure uniform rounding at the mouth of the pocket is to trim the cases to uniform length first, then use the stop on the trimmer to position the case so that the corner-rounding from the reamer goes no deeper than necessary.
- 6) While turning reamer, run cutting edge in and out of case mouth in one fluid motion.
- 7) Repeat process

- NOTE: .45 ACP cases must be forced into the holder with a press.

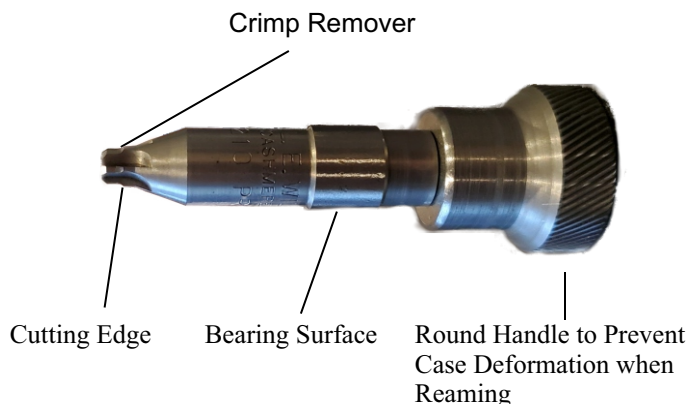
#### IMPORTANT INFORMATION:

This is **NOT** a primer pocket uniformer, and does **NOT** cut the bottom of the primer pocket. The WILSON Primer Pocket Reamer;

- .210 size, is designed to remove the crimp from 30-06 and 7.62 NATO military cases and to enlarge .45 ACP pockets so as to accept commercial primers
- .175 size removes the crimp from the M-1 Carbine and 5.56mm cases. The design of the cutting end assures a smooth pocket with straight sides and a rounded edge for easy primer insertion.
- 50 Caliber Reamer will remove military crimps on .50 BMG cases to prepare for reloading. (For use with 50 Caliber Trimmer).
- No pounding, forcing, or swaging and the reamer stops cutting when it contacts the bottom of the pocket.
- The bearing length of these reamers is purposely made short and ground slightly undersize to allow a slight "float" or universal joint effect. This permits the reamer to align itself with the primer pocket in spite of slight errors that may be present.
- Occasionally, we receive a letter from some worried customer who has been reaming crimped pockets and reports that some of the pockets are scraped bright on one side. He is afraid to use them for fear they will leak. This scraping is caused by the fact that some cases have a heavier crimp on one side than on the other, which tends to crowd the reamer slightly. The pockets being black from having been fired, this scraping shows up as a bright place. This scraping effect is of no consequence and the new primer will seal as well in such a pocket as any other. Primers are slightly larger than the pockets they are squeezed into and will shape themselves to the pockets against gas leakage by the familiar "pump" leather action under pressure, which is very effective.



Pocket Reamer Shown In Case Trimmer



### FREQUENTLY ASKED QUESTIONS:

- 1) Why don't you make a crank handle for the Primer Pocket Reamer?  
The primer pocket reamer handle is a knob so it is not to distort the pocket of your cases. The tool is designed to have a little slop in bearing surface so it can do this. If we had a crank handle on the reamer it would tend to move up and down causing an oblong pocket, therefore destroying your cases.  
The handle is removable and you could try and chuck that to a hand drill at very low RPM. Test a few cases to make sure that it will allow you to remove the crimp and seat a primer with your desired result.
- 2) Will this uniform my primer pockets?  
No, this is not a primer pocket uniformer. The front of the reamer does not have a cutting edge and the flats on the lands are NOT up-sharp.
- 3) Can I ream cases that do not have a crimp?  
There is no reason to ream cases that do not have a crimp. The only time I would recommend reaming cases without a crimp would be if you see some sort of imperfection on the rim of the primer pocket and you believe the reamer could take care of this issue.
- 4) Why is the bearing surface so short on the reamer?  
This is done to make sure the reamer follows the natural path of your cases pocket.
- 5) I am using the standard trimmer with the 3/8ths diameter stop screw. The head is not large enough to support the case when using the reamer?  
The trimmer comes with a 3/8ths - 16 nut this is to enlarge the stop for this operation. Please remove stop screw and thread nut all the way until it bottoms out on the end of the stop screw. Now reinstall and set up stop, case mouth should rest on installed nut.

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