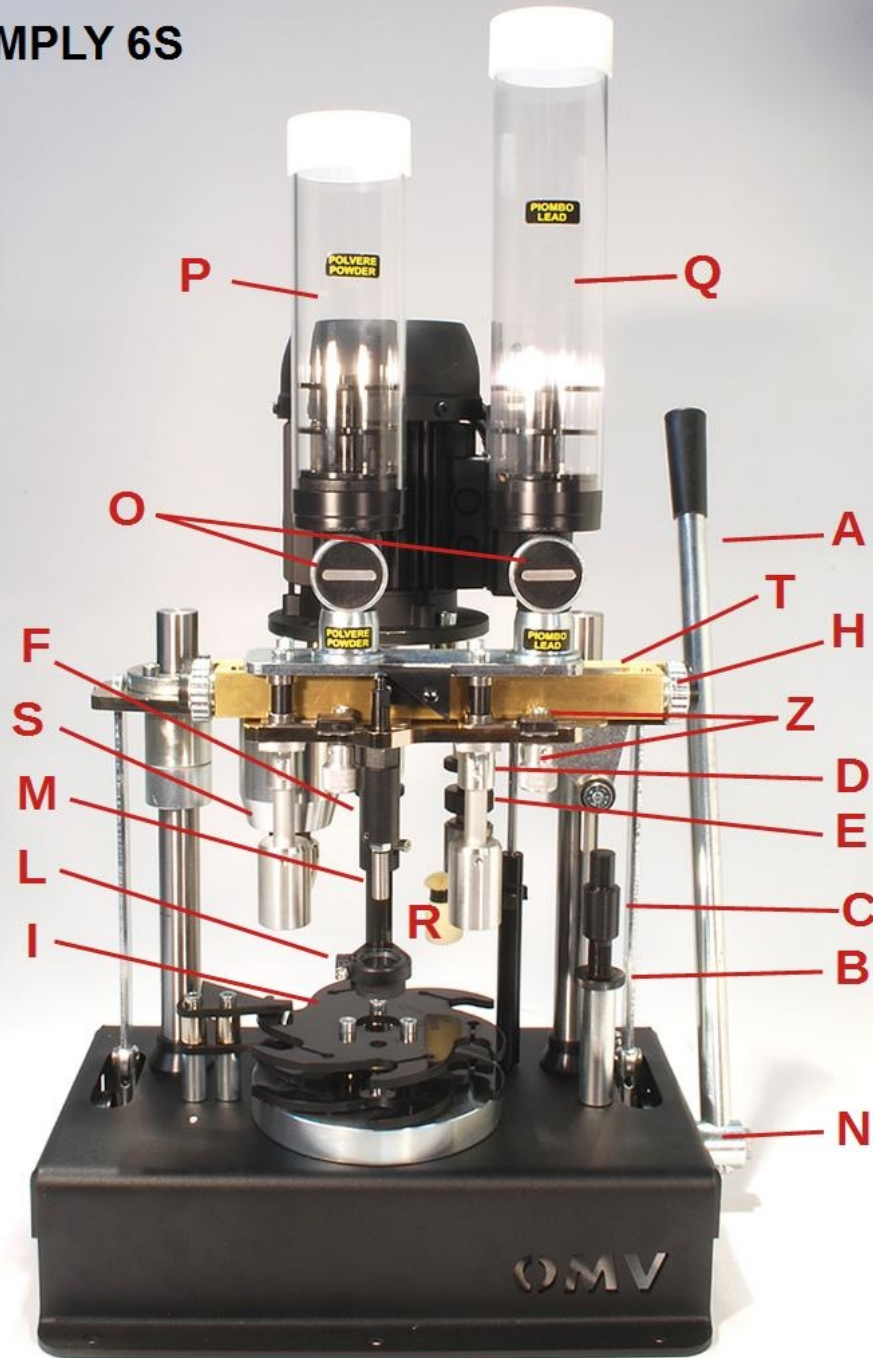


SIMPLY 6S



OMV

Passion for hunting and shooting

ROTATING PRESS SIMPLY 5S-6S

- A Movement machine lever
- B Locking seal capo of finished shell
- C Finished shell height regulator
- D Locking seal cap engraver height regulator
- E Engraver height regulator
- F Crimper pre closure height regulator
- H Regulating seal cap for powder and lead dosers
- I Rotating disc
- L Wadding guide
- M Wadding pushers
- N Maneuvering lever regulator
- O Powder and lead tank closure taps
- P Powder tank
- Q Lead tank
- R Cartridge case oiling sponge
- S Hemmer head
- T Micrometric scale
- Z Open-close selector powder-lead with safety block

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

The powder and lead dosing system is performed by means of a dosing bar and micrometric knobs for adjusting the doses; the bar is equipped with a mechanical vibration system to settle dust and lead, and 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 incision of the case we used a rotating quick coupling system, to resume the old stellar folds of the cases already fired. Usually for new cases a steel engraver is used, while for recovery 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 a 220 volt electric motor. The engine runs at 1400 rpm, but there is a reduction ratio that reduces the rpm to 900, making it also buy power. This system ensures that motor overheating is not transmitted to the hemming bobbin.

The machine can be used in semi-automatic mode, with all stations active, and a finished cartridge will come out at each pull of the lever, or by excluding the powder and lead dispensers also in manual mode.

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

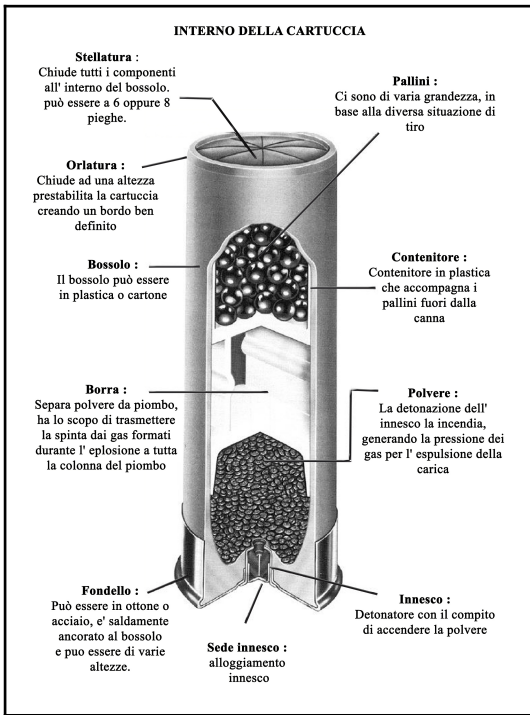
The caliber change is carried out by replacing the rotating disc, engraver and hemmer.

On all the machines it is possible to mount the pneumatic movement system, or with a hydraulic control unit where with a simple button we can make the press go down and up, avoiding to pull the lever.

INSTALLATION

Block the machine on a stable work surface through its fixing holes, if we work standing we must have the press at a comfortable height, positioned on a floor from the ground of about 120-130 cm, this to have the leverage to a right angle with our elbow and have less effort.

Connect the motor power plug to a 220 volt electrical socket and position the cable so that it is not an obstacle during the descent and ascent of the press.



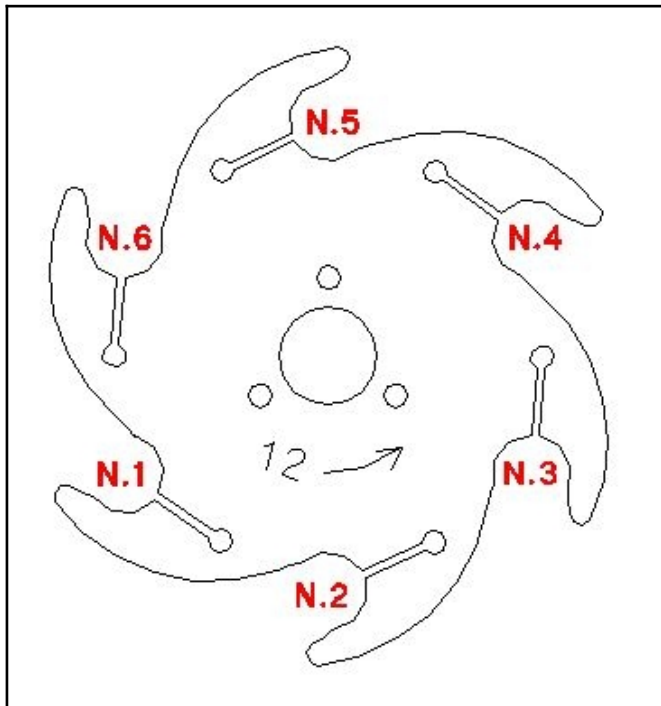
ENGRAVING



DEPRIMER



HEMMING



Description of work phases SIMPLY 5S version

- Station N.1: Insertion of a new case for powder entry
- Station N.2: Wad insertion and wad pusher
- Station N.3: Lead dose insertion
- Station N.4: Engraving station
- Station N.5: Hemming and closing of the cartridge then ejection
- Station N.6: Used shell expander cone (If necessary)

Description of work phases SIMPLY 6S version

- Station N.1: Insertion of a new case for powder entry
- Station N.2: Wad insertion and wad pusher
- Station N.3: Lead dose insertion
- Station N.4: Engraving station
- Station N.5: Deprimer station
- Station N.6: Hemming and closing of the cartridge then ejection

PHASE 1

First of all, make sure that the taps of the tanks are closed in a horizontal position and fill the right tank with lead and the left one with powder; also the selectors placed underneath must be closed in the closed position, and the safety knobs must also be blocked so that when the machine is moved, nothing can escape from the nozzles. Now we can adjust the hemming height, insert a new empty case in any station and rotate the disc manually until it is in position (N.5 for 5S press) (N.6 for 6S press) turn on the motor and lower lever A as far as it will go, 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 we have obtained, and if it is not the right size, loosen the locking ring B and adjust the knob C to (+ -), tighten the ring again locking. 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, as during all the simultaneous loading phases, some dimensions may slightly vary.

PHASE 2

Let's now pass to the setting of the engraver, that is station N.4

Insert a new case in this station and pull lever A as far as it will go, then turn back. Check the folds on the case and possibly adjust the height using the regulator E after loosening its ring nut D.

The engraving on the case must be similar to the one in the photo attached above; if it is more there is a risk of bending the case, if it is less there could be a hole in the center of the finished cartridge closure. It is possible to change the height of the engraving even during loading, by adjusting the engraver little by little according to 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 2 BIS (ONLY FOR SIMPLY 6S VERSION)

Place the case already engraved in station N5, pull lever A as far as it will go, then go back. Check the imprint on the case (as in the figure above) and possibly adjust the height using its regulator.

PHASE 3

Lead dosage adjustment placed above station N.3

Insert an empty case into this station; after opening the lead tank tap O and checking that the sheet Z placed underneath is also open, pull the operating lever and discharge a dose inside the case. Using the balance, weigh the dose, and consequently act on the H regulator to change the dose if necessary. Repeat the procedure until the required dose is reached. Attention, before moving on to the next phase and adjusting the powder, it is absolutely necessary to close the lead Z selector, loosening the ring nut and moving the foil to the CLOSED position. (Moving the sheet Z in opening or closing it must always be blocked by means of its safety knob placed under it.)

PHASE 4

Powder dosage adjustment, located above station N.1

Follow the same procedure described in phase 3, adjusting the powder dose using the left H 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 get to the right dose gradually.

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

Close selector Z as described in step 3.

PHASE 5

Wad pusher station (N.2)

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

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

After first loosening the nut of the regulator M, screw the pusher bar all the way up, operate the control lever as far as it will go, and keep it forced in that position; at this point let the pusher go down by unscrewing it until it rests on the wad and lock the nut. It is important that the wad comes to rest on the powder.

LOADING A USED SHELL CASE.

If we want to load recycled cases (already fired) we can do it, they must first be recalibrated and primed 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 which descends to the right height by loosening the lateral screw.

LOADING A NEW SHELL CASE.

Insert a new empty case in station N.1, under the powder insertion station. Open the powder tap in the vertical position and the powder selector, fixing it with the safety knob. Continue by operating the operating lever until it stops and rises. Once at station 2, manually insert the wad directly into the case and also insert an empty case into station N1. Continue the cycle up to station 3 where the tap and the selector for the descent of the lead will be opened. Continue with the same procedure until the end of the cycle. Each time we pull lever A, a finished cartridge will come out.

END OF CYCLE PROCEDURE

Once all shells are loaded and the last one is at station 6, disactivate U to avoid the descent of another trigger. Continue loading and close each selector Z (powder and lead) as the last shell goes through these station. Now expel the last shell.

Powder and lead tank removal: bring taps O to horizontal position, put an empty shell case, to unload any residual powder into it by pulling the lever 3 times. Repeat to eliminate lead remaining. It is now safe to remove measurers.

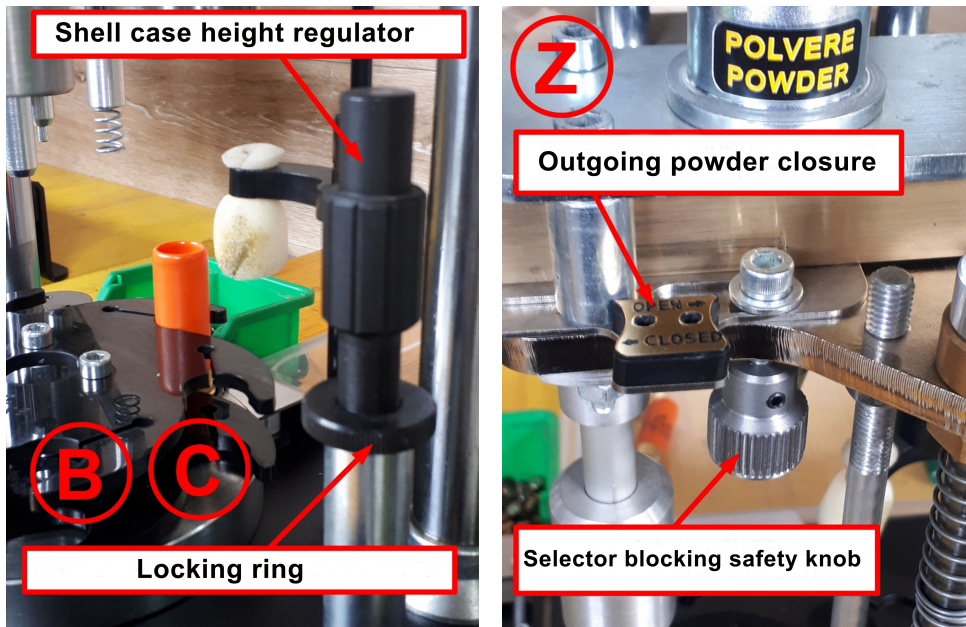
HOW TO DISASSEMBRE HEMMING REEL AND ENGRAVER

Use two screwdrivers for leverage. Put one in the hole in the pivot above the hemmer and the second one on the hemmer. Pushing in opposite direction will unscrew the reel.

The engraving head is magnetic so all you have to do is pull it downwards.

MAINTENANCE

Keep clean the machine from shot 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 affect the materials even if treated, therefore, in order to prevent these problems, wipe all the galvanized metal parts with a lightly greased cloth, so as not to favor the appearance of rust. Alternatively, spray oil can also be used.



NOTES TO READ

- * When choosing the case, bear in mind that a flared case must be used for the star closure, while it must not be flared to make a round rim.
- * Be careful if during the loading cycle we stop for a prolonged break or abandon work, take into account that the stop will have reopened the folds of the crimping station of the last cartridge. It is necessary to remove it from the disc and bring the folds closer together with some tools, including artisanal tools, a tube of the appropriate size to push down the folds can be fine, if we do not do this the final hemming will be badly done.
- * Insert oil in the special 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 overheating of the hemmer.
- * For the insertion of the wad with new cases it is not necessary to use the wad guide tool, which instead must be used with recovery cases.
- * Attention every time the powder and lead selectors are moved, it is very important to lock its safety ring located underneath, otherwise the foils can move while the press is being used and create problems and dosage variations.