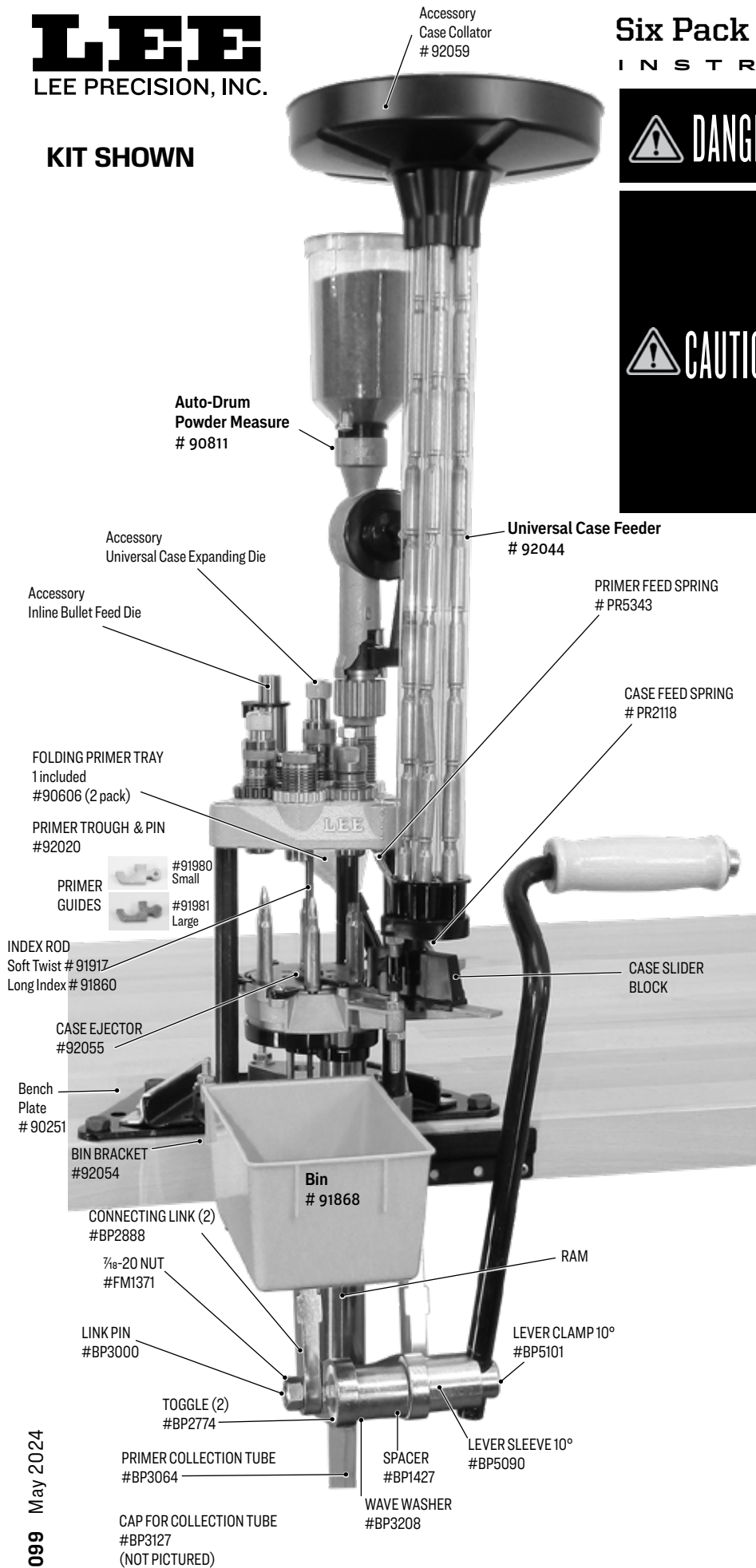


KIT SHOWN



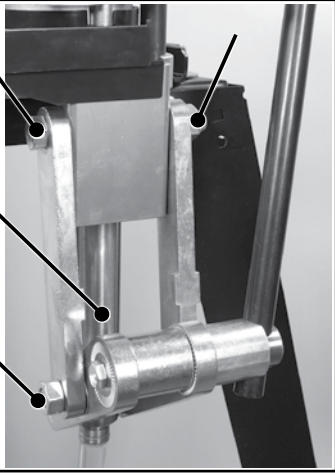
Ammunition reloading can be dangerous if done improperly and can result in serious injury or death.



- Reloading should not be attempted by persons not willing and able to read and follow instructions exactly.
- Children should not be permitted to reload ammunition without strict parental supervision.
- Always wear safety glasses and hearing protection when reloading and shooting.
- Ammunition loaded with these tools and data should only be used in modern guns in good condition.
- We do not accept responsibility for ammunition loaded with these tools or data as we have no control over the manufacture and storage of components or the loading procedure and techniques.
- Primers and gun powders, like gasoline and matches, can be dangerous if improperly handled or misused.

LUBRICATION POINTS

use STP™ motor oil treatment or motor oil on link pins and ram.



A drop of oil on the index rod smooths operation.

Lee Inline Bullet Feeder



All steel construction featuring ball bearing escapement mechanism. Spring loaded positive ball carrier return assures reliable operation. Jacketed, cast, coated cast bullets are reliably fed. Configurable for long and short bullet lengths. Each die is caliber specific so there is nothing to change or adjust. See pg. 4 for caliber listing.

Lee Breech Lock Die Set

Kits include Breech Lock Die Set. Smart Lock bushings utilize an integrated o-ring to keep dies firmly in place, yet remain finger adjustable. Color coded for easy identification.



SAFETY CONSIDERATIONS

- Be sure of proper powder and charge for bullet weight selected.
- Wear safety glasses and hearing protection when reloading or shooting.
- Be extremely careful to avoid a double charge. If in doubt, empty the case and recycle it.
- Do not permit distractions while loading. This is a complex machine that needs your fullest attention.

SMOOTH OPERATING TIPS

- Always move the lever smoothly in complete strokes. An interrupted stroke can cause a jam or double charge.
- Do not force it or you will break something. If it does not feel right, stop and check out the problem.
- Oil ram using STP™ motor oil treatment. Using any oil, lubricate link bolts every few thousand rounds.

SETUP TOOLS REQUIRED

- Safety glasses & ear protection
- ½ inch wrench
- ¼ inch allen wrench (included)
- Lock ring wrench (included)

1 The most convenient way to mount your press is with our **Lee Bench Plate System # 90251** or **Lee Reloading Stand #90688**.

This system includes all of the mounting hardware and allows for quick press removal without unbolting from bench. Or, purchase (qty. 3) ¼" bolts and nuts and prepare your workbench for use with this press.

90251 Bench Plate



90688 Reloading Stand



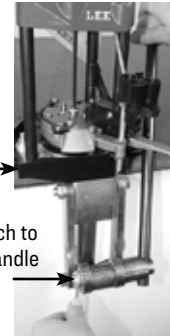
2 Slide primer collection tube assembly onto bottom of the ram.



B Slide bin bracket into press base. Press lever ships in **SHIPPING** position. With ½" wrench, loosen hex head cap screw. Rotate handle counterclockwise to near workbench edge. Tighten securely.

Slide bin bracket into base

½" wrench to adjust handle position

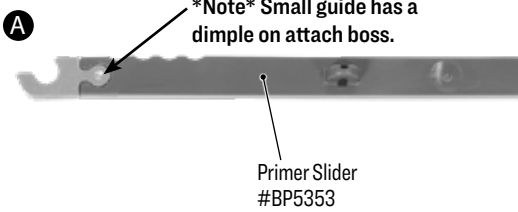


C Reloading handgun ammo? You may also shorten the lever 2" to reduce travel.



3 PRIMER FEED SETUP

IMPORTANT Do not operate primer feed without a small or large primer guide installed into slider. Doing so will cause damage to your primer slider.



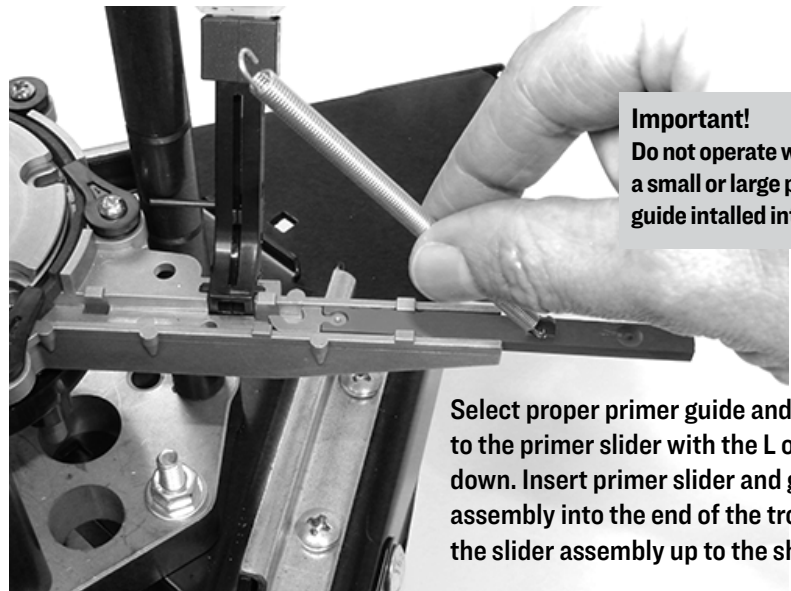
Important!
Do not operate without a small or large primer guide installed into slider.

Primer Guide 91980 Small



Note Small guide has a dimple on attach boss.

Primer Guide 91981 Large



Select proper primer guide and connect to the primer slider with the L or S face down. Insert primer slider and guide assembly into the end of the trough. Slide the slider assembly up to the shell plate.



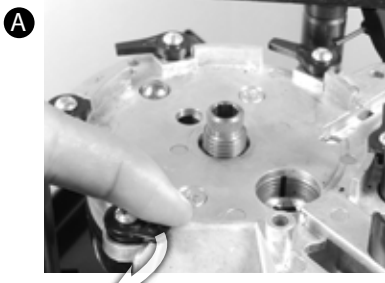
Locate boss on under side of tool head. With carrier in the up position, attach spring through the hole.



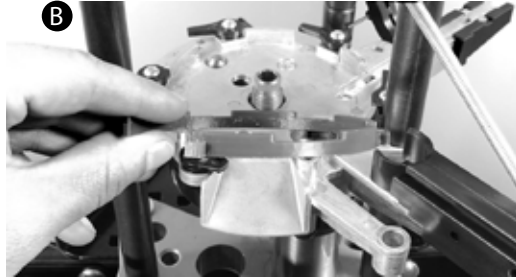
Verify primer feed spring is installed as shown. **IMPORTANT**, do not operate without a small or large primer guide installed into slider.

4 INSTALL small case retainer if you will be reloading 40 S&W and smaller diameter cases.

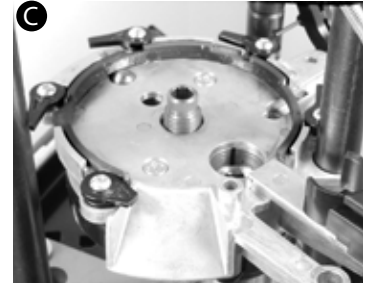
IMPORTANT: The BP5353 small case retainer must be removed when reloading cases with a rim diameter greater than .430" (11mm) 40 S&W. Failure to remove the retainer will prevent free rotation of the shell plate and may damage the indexer driver clutch.



Swing case retainers outward.



Install notch side up, straight down.



Verify case retainer appears as shown. Proceed to install shell plate, swing in case retainers to complete.

5 INSTALL SHELL PLATE see top of page 5 for listing



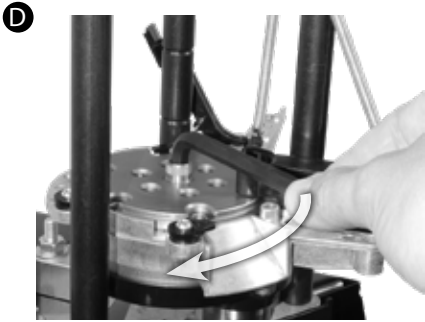
Remove Breech Lock Bushing Die from station 4 to access the index rod.



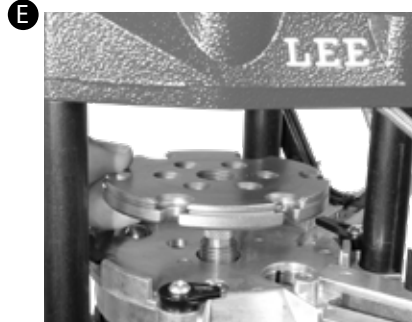
Lower carrier to bottom of the stroke then raise slightly remove index rod.



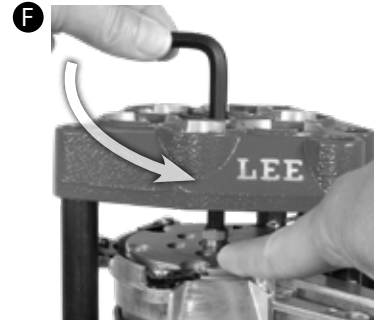
Remove case ejector



Lower carrier to bottom of the stroke (handle up). With 1/4 inch hex key, rotate key **clockwise** to loosen.



Raise carrier 3/4 of the way up. Install shell plate, spin on clockwise.

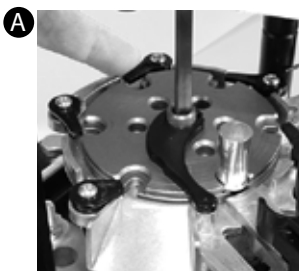


Lightly tighten with 1/4 inch hex key, hold shell plate and rotate key counterclockwise

Set case retainers & dry run (no primers, powder or bullets)

Note

If you are dry cycling small primer pocket cases, we suggest not running the press all the way to the bottom of the stroke. If there is any contamination in the primer pocket, it may cause the primer pin to stick into the primer pocket and not retract.

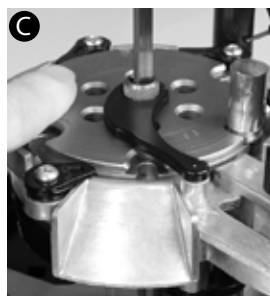


Verify the small case retainer is removed on cases with rim diameter larger than .430" (11mm).

Push in the 5 case retainers to touch the shell plate. At any time if you need to remove the case, simply slide out of the shell plate. Be sure to reset the case retainers. Cycle the lever up and down to confirm the shell plate is advancing correctly.



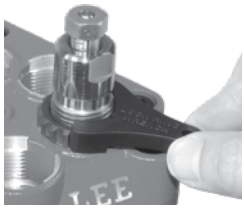
Lower the lever, drop case into the case feed hole port in front of the slider block and raise lever to insert case into shell plate. Lower the lever and the case is raised into the sizing die position. Lift the lever, the case will advance to the priming station and primer will be seated at the carrier's bottom of the stroke. Lower the lever, the case will be in station #2, the powder charging and pistol expanding station. Raise and lower the lever to advance shell plate.



Important Whenever the normal reloading sequence is interrupted, the most important hazard to guard against is a double charge. It is always best to completely remove the offending case.

6 TOOL HEAD POSITION & INITIAL SETUP

We suggest Lee dies as they use a powder through expanding die to conveniently charge your brass while expanding the case mouth. Lock rings are not -required when utilizing the Smart Lock bushing. Follow the reloading die instructions for the type and brand of dies you have selected. The only instructions special to the Six Pack are highlighted here.



How to install Breech Lock Bushings

Drop the breech lock bushing into the press frame, and rotate the bushing 1/6 of a turn clockwise finger tight.

Remove by rotation 1/6

turn counterclockwise and lifting from the frame. To prevent die movement, install and remove by **grasping the spline on the bushing**. A handy die wrench is included.

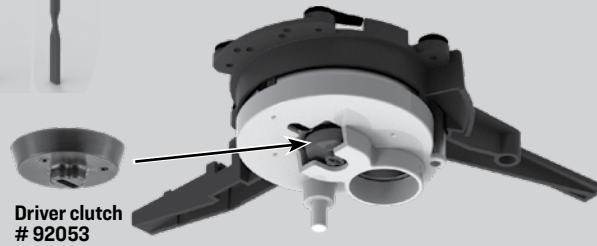
SIX PACK PRO INDEX ROD

Kits include caliber appropriate index rod, Six Pack press only ships with soft twist rod



Index Method	Product #	Cartridge Overall Length
Soft Twist	91917	2.260" and shorter
Long Index	91860	2.260" - 3.000"
Manual	n/a	3.000" - 3.900"

Indexing is controlled by index rod riding inside the - slot of the driver clutch. If you notice the press short cycling, the driver clutch slot might be worn. Loosen and remove bushing from station 4, lower carrier to bottom of the stroke then raise slightly remove index rod. Under the carrier, replace the driver clutch. If no clutch is installed, no indexing will occur.



Driver clutch # 92053

View underneath carrier

Position 4

Works well with a powder check die or inline bullet feed die. Bushing must be installed to hold down index rod.

Position 4 = Accessory

Lee Inline Bullet Feeder

Hands free bullet feeding



INLINE DIE ONLY	TYPICAL	BULLET DIAMETER RANGE	INLINE BULLET FEED KIT
91998	22 CAL 22 Hornet to 222 Rem Mag	.220 - .225	92010
92025	24 CAL 6mm to 243	.238 - .245	92026
92000	26 CAL 6.5 Creedmoor & similar	.250 - .273	92012
91999	30 CAL 30M1 to 30/06	.300 - .320	92011
91995	35 CAL 380 Auto to 357 Mag	.312 - .360	92007
91996	40 CAL 40 S&W	.390 - .406	92008
92071	44 CAL 44 Mag & 44 Special	.425 - .435	92072
91997	45 CAL 45 ACP to 45 Colt	.435 - .460	92009

INLINE BULLET FEED KIT
Includes
Inline die and appropriate multi tube feed magazine

Position 5 or 6 = Bullet Seating Die

Position 5 or 6

May be used for bullet seating. If you are seating and crimping in one operation, use position 6 as it gives you easy access to manually place the bullet. If you are Factory crimping, this die will always be installed in position 6.



Rifle Easy Adjust Dead Length Bullet Seating Die



Handgun Bullet Seating Die

Position 6 = Factory Crimp Die

This die may come with a gold Smart Lock Bushing installed.



Rifle Collet Factory Crimp Die



Pistol Carbide Factory Crimp Die

Position 3

This is an excellent position for the optional Lee Universal Expanding die when loading bottleneck rifle cartridges.

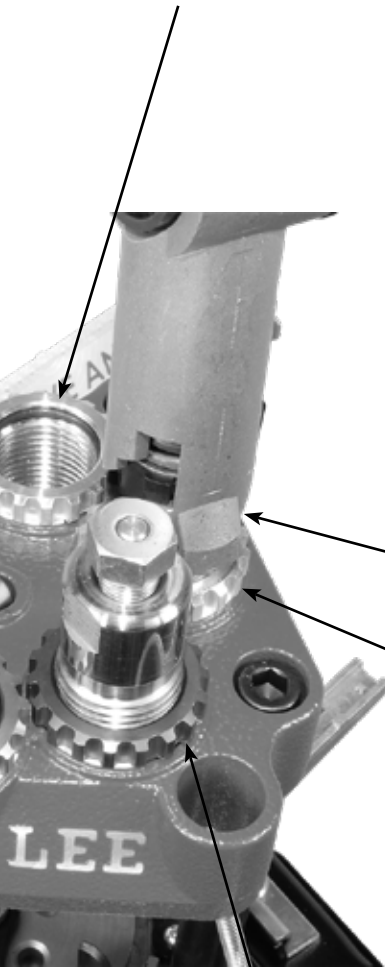


Universal Case Expanding

Die # 90798

SHELL PLATE LISTING	Shell Plate	Product #
38 SPECIAL, 357 MAG	1S	91835
45 ACP, 30/06, 308, 6.5 CREED, 458 SOCOM	2L	91836
30/30, 7x30 WAT., 7.5 SWISS	3L	91837
222, 223, 380 ACP	4S	91838
32 S&W LONG, 32 H&R MAG.	4A	91839
BELTED MAGNUMS, 300 MAG, 303 BRITISH, 30/40 Krag, 7MM WSM	5L	91840
32/20, 25/20	6S	91841
30 M1 CARBINE, 32 ACP	7S	91842
45/70, 348 WIN, 416 RIGBY	8L	91843
41 MAGNUM	9L	91844
220 SWIFT, 6.5 JAP	10L	91845
44 MAG., 44 SPL., 45 COLT	11L	91846
7.62X39, 6MM PPC, 22 PPC	12L	91847
44/40, 38/40, 45 COLT, 460 S&W	14L	91848
5.7X28 FN	15S	91849
500 S&W, 7.62X54R	16L	91850
9MM LUGER, 40 S&W, 38 SUPER, 7.62 x 25 TOKAREV	19S	91851
10MM AUTO	19L	91852
22 HORNET	20	91853
6.8 REM SPC	21L	91854

Position 3 = Universal Case Expanding Die

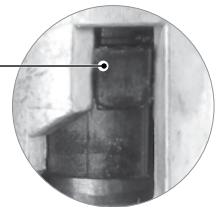


Position 2 = Powder Through Expanding Die or Rifle Charging Die

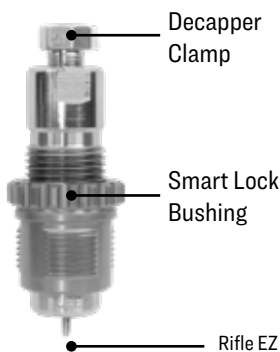
- (A) Install appropriate die and bushing onto Auto Drum powder measure.
- (B) Insert assembly into position 2.
- (C) Position a case under position 2 and raise to top of its stroke (hold lever down).
- (D) Rotate entire powder measure and die inward until the top of stroke indicator nears the top of the slot in the casting.

NOTE: handgun powder through expanding dies should be installed deep enough to flare case mouth to allow easy insertion of bullets.

Dispense position
Note: slider drop tube should not make contact with top of slot



Position 1 = Full Length Sizer Die sizing & depriming must be done in this station



- (A) Install die and bushing in tool head position 1.
- (B) Raise the carrier to top of stroke. (Handle down and hold)
- (C) Screw die into contact the shell plate.
- (D) Release lever, screw in the die additional 1/3 turn further.

Note Using a 1/2" (13mm) wrench on the decapper clamp makes adjustment easy.

7 Install primer feeder



SCAN ME

IMPORTANT - Fill the primer feed tray. View help video for loading primers into tray:

Don't let the primer level fall below the tray level. Once the last primer has exited the folding tray, replenish the primer supply, or else you will be loading cases without primers.

IMPORTANT - When priming, lift firmly on press lever to seat primer.

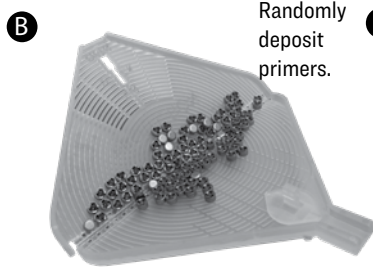
DANGER: Primers can explode with sufficient force to seriously injure the user or persons nearby.

ALL PRIMERS ARE DANGEROUS and it should be anticipated that the primers in the tray could explode through accident, misuse or spontaneously. Should an explosion occur, our tests have demonstrated that safety glasses will normally prevent serious injury to the user. Primers are capable of exploding with sufficient force to seriously injure the user, or persons nearby. When loading primers—safety glasses and hearing protection must be used. Observe the warnings on the primer box.

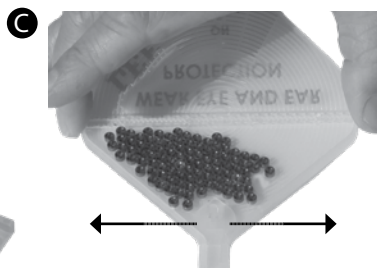
WARNING: Handling live primers and spent primers may expose you to lead or other chemicals, which are known to the State of California to cause reproductive harm and cancer. For more information, go to www.P65Warnings.ca.gov.



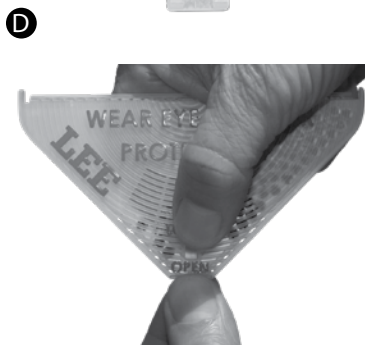
Slide the flow control to **OPEN**.



Randomly deposit primers.



Lift tray so output spout touches table, shake tray side to side to upright all the primers. Allow cover to naturally fold up, notice how the primers glide across hinge upright themselves and work their way towards the outlet.



Fold cover over, slide the flow control to **LOCK** position, feel for the detent. Grasp the top and bottom of the flow control valve using your thumb and index finger above and below tray.

NOTE: make sure it is in the **LOCK** detent position, or else primers may spill.



Slide the tray into the trough. Slide the flow control to the **ON** position.



Tap the trough several times to fill.

IMPORTANT - When priming, lift firmly on press lever to seat primer.

TROUBLESHOOTING

PROBLEM	CAUSE	REMEDY
Primers will not feed properly	<ul style="list-style-type: none"> Wrong primer guide is installed or the primer guide is installed upside down. The S and L must be installed facing down. See Remedy > 	<ul style="list-style-type: none"> Install appropriate primer guide with letter facing down. <p>Large Primer Guide # 91981 Small Primer Guide shown installed. Notice dimple on attach boss. # 91980</p>
Primer doesn't feed onto priming punch	<ul style="list-style-type: none"> Oil in trough Primer trough not full 	<ul style="list-style-type: none"> Remove all oil with solvent or blow out powder or dust with compressed air Always keep primer trough full, there must be a minimum of 5 primers in the trough to feed properly
Primer doesn't enter case	<ul style="list-style-type: none"> Primer crimp not removed Wrong size primer 	<ul style="list-style-type: none"> Ream or swage primer pocket Caution, some 45ACP cases now have small primer pockets
Tipped primers	<ul style="list-style-type: none"> Case not fully in shell plate 	<ul style="list-style-type: none"> Adjust case retainers
Cases don't eject	<ul style="list-style-type: none"> Case ejector 	<ul style="list-style-type: none"> Verify case ejector is installed
Shell plate does not index	<ul style="list-style-type: none"> Driver clutch missing or damaged 	<ul style="list-style-type: none"> Replace driver clutching by ordering product number 92053.
Drag, jerky movement, indexing issues, priming issues, spilt powder	<ul style="list-style-type: none"> Case retainer ring BP5353 is installed 	<ul style="list-style-type: none"> Only have the case retainer installed for cases with a base diameter of .430" or smaller.

Don't install the case feeder until you are confident of the operation and settings of bullet seating depth, powder charge and crimp setting.

8

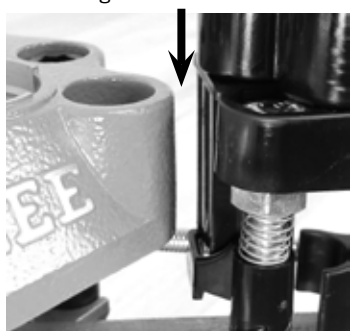
Install case feeder

TOOLS REQUIRED FOR SETUP

QTY. 2, 7/16" wrenches

A Set case feeder height, when set correctly **no further adjustments are needed.**

- (1) Select and install 'A' feed tube.
- (2) Install **short** case slider on rail.
- (3) Slide the feed plate assembly into the carrier mounting hole, adjust the top nut so that the bottom of the drop tube clears the **short** case slider.
- (4) Tighten the nuts so that the feed plate assembly just clears the front face of the press frame using a 7/16" wrench.

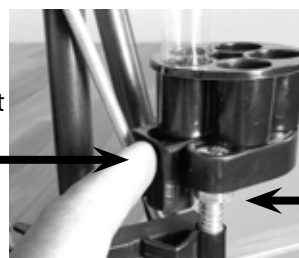


Once set, never adjust again. Simply change feed tube and slider to change calibers

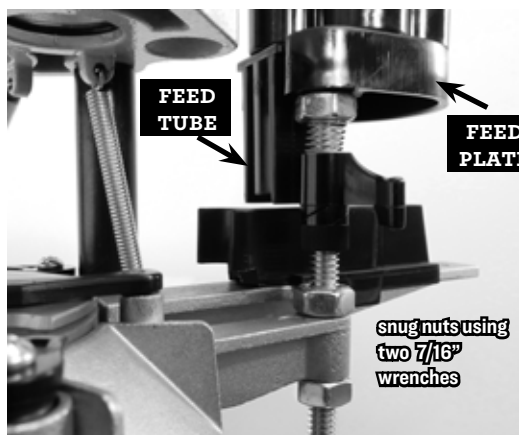
Feed Tube Changeover

(1) Push feed tube from front to snap into place.

(2) Push feed tube from rear to remove.



FEED TUBES



snug nuts using two 7/16" wrenches

CARTRIDGE SETUP CHART

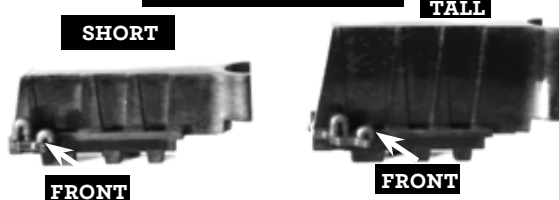
CARTRIDGE	FEED TUBE	SLIDER BLOCK
30 Luger	B	SHORT
30 Mauser	B	SHORT
32 S&W Long	B	SHORT
32 H&R MAG	A	SHORT
9mm Luger	A	SHORT
9mm Makarov	A	SHORT
32/20	D	TALL
357 Sig	B	SHORT
38 Super	B	SHORT
38 S&W	B	SHORT
38 Colt NP	B	SHORT
380 Auto	A	SHORT
38 SPL & 357 MAG	D	TALL
38 ACP	B	SHORT
40 S&W	B	SHORT
10mm Auto	B	SHORT
41 Mag	D	TALL
44 SPL & 44 MAG	D	TALL
30M1 Carbine	C	TALL
44 Russian	D	TALL
454 Casull	D	TALL
45 ACP	B	SHORT
45 Colt	D	TALL
45 GAP	D	SHORT
223 REM	C	TALL
300 AAC Blackout	C	TALL
7.62 x 39	D	TALL
222 REM	C	TALL
6.8 REM SPC	D	TALL
6.5 Creedmoor	D*	TALL
308 Winchester	D*	TALL

B Select and install appropriate case slider block.

Attach case feed spring to front attach point on slider.



CASE SLIDER BLOCKS



C Select and install appropriate feed tube. (see setup chart to right) Top of feed tube has size listed.



D Set case gate.

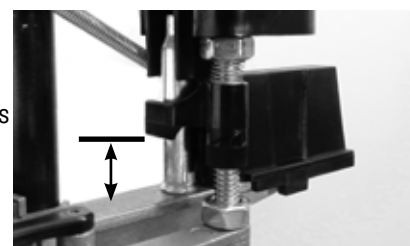
Raise gate and turn cam to adjust.



(1) Adjust gate to clear press frame at the top of the stroke.



(2) Gate should be approximately 3/8" above press rail. No further adjustment required.



* Raise feed plate for the case to clear the slot

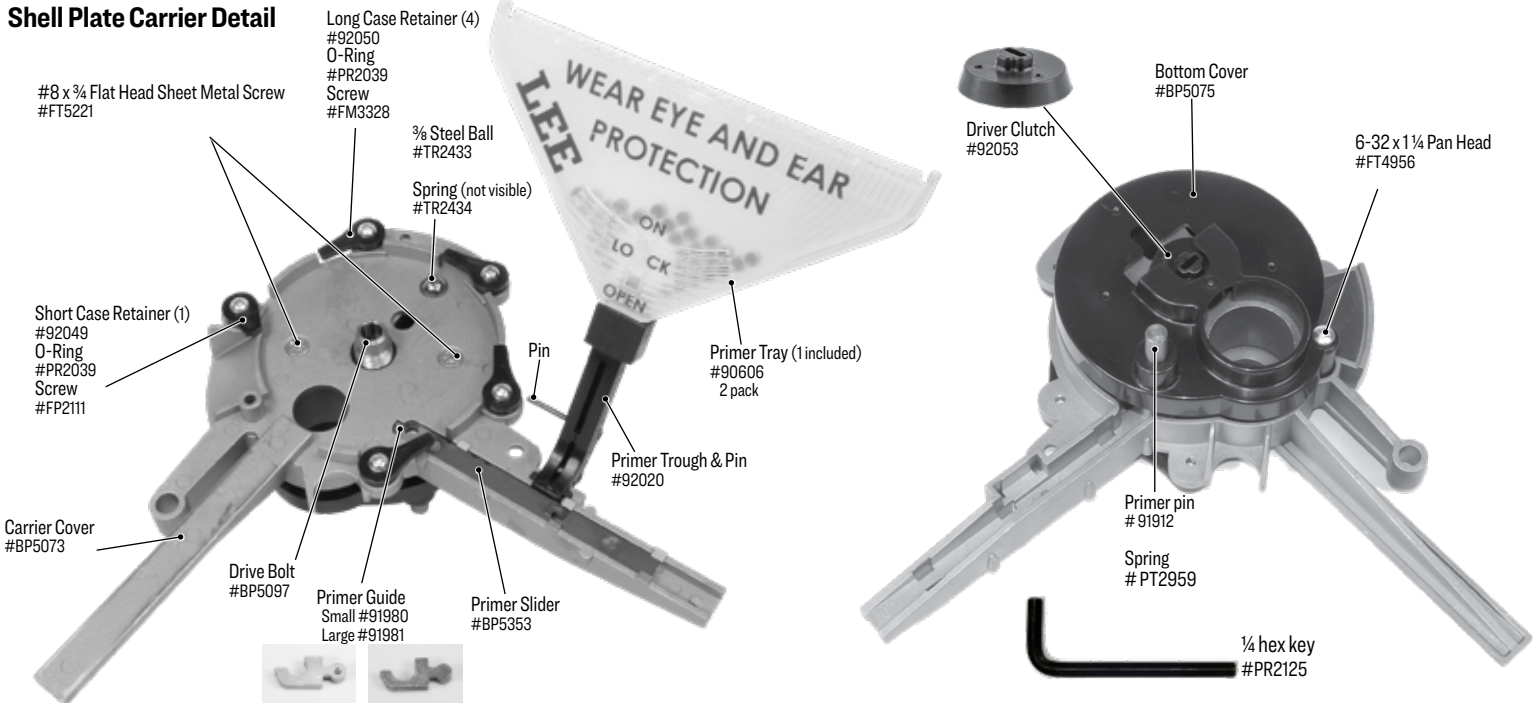
CARTRIDGE CHANGE OVER

To convert the Six Pack Pro from a one cartridge to another, you will need the proper shell plate and appropriate Lee reloading die set. The chart below shows proper configuration with catalog numbers.

Cartridge	Shell Plate	Shell Plate Product #	Breech Lock Reloading Dies	Charging die	Primer Guide	Index Rod
32 S&W Long	4A	91839	91876		Small	91917
9mm Luger	19S	91851	91882*		Small	91917
38 Super	19S	91851	91879		Small	91917
380 Auto	4S	91838	91877*		Small	91917
38 SPL & 357 MAG	1S	91835	91878*		Small	91917
40 S&W	19S	91851	91880*		Small	91917
10mm Auto	19L	91852	91880*		Large	91917
44 SPL & 44 MAG	11L	91846	91881*		Large	91917
45 ACP	2L	91836 SM / LG	91883*		Large or Small	91917
45 Colt	11L	91846	91884*		Large	91917
223 REM	4S	91838	91932 (LUBE REQ.)	90668	Small	91917
300 AAC Blackout	4S	91838	91925 (LUBE REQ.)	90668	Small	91917
308 WIN	2L	91836	91953 (LUBE REQ.)	90194	Large	91860
243 WIN	2L	91836	91949 (LUBE REQ.)	90194	Large	91860
270 WIN	2L	91836	91950 (LUBE REQ.)	90194	Large	MANUAL
22/250	2L	91836	91948 (LUBE REQ.)	90194	Large	91860
7mm REM MAG	5L	91840	91951 (LUBE REQ.)	90194	Large	MANUAL
30-30 WIN	3L	91837	91952 (LUBE REQ.)	90194	Large	91860
300 WIN MAG	5L	91840	91954 (LUBE REQ.)	90194	Large	MANUAL
6.5 Creedmoor	2L	91836	91920 (LUBE REQ.)	90194	Large	91860

N/A = Not available LUBE REQ. = # 90006 LEE resizing lubricant required *4 Die Breech Lock set available

Shell Plate Carrier Detail



The Lee Guarantees

LEE RELOADING PRODUCTS are guaranteed not to wear out or break from normal use for two full years or they will be repaired or replaced at no charge if returned to the factory. Any Lee product of current manufacture, regardless of age or condition, will be reconditioned to new, including a new guarantee, if returned to the factory with payment equal to half the current retail price.



WARNING: Handling live primers and spent primers may expose you to lead or other chemicals, which are known to the State of California to cause reproductive harm and cancer. For more information, go to www.P65Warnings.ca.gov.



WARNING: This product may contain steel alloyed with trace amounts of lead and other elements which are known to the State of California to cause reproductive harm and cancer. For more information, go to www.P65Warnings.ca.gov. To prevent exposure, do not alter the product by welding, grinding, etc.