

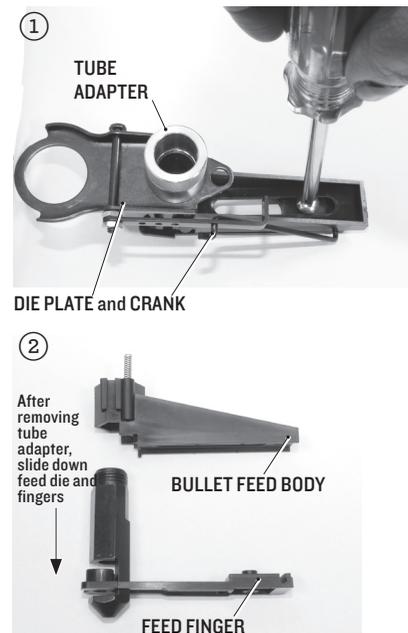
INITIAL TESTING

- ① Install correct feed tube. The small feed tube slips inside the large tube for installation.
- ② Carefully cycle press making certain the fingers and mechanism clear everything. **Use caution when cycling the .45 caliber empty. It is very easy to pinch the fingers between the die and shell plate if no bullet is in the feed finger.**
- ③ Raise shell plate carrier a small amount to slide the feed fingers forward and fill the feed tube with bullets (base down).

Note: A full tube of large caliber bullets may be too heavy for the feed fingers to pull one out of the bottom of the stack. Bullets that have a concave base or that are fully coated with Alox or wax should not be stacked as high. You will have to experiment to find out how many can be stacked. About 15 cast bullets or 20 jacketed bullets work fine.

- ④ Try it without cases to get a feel of the tool and ensure that it is installed correctly and functioning correctly. The feed fingers should slide forward with a bullet in the jaws.

SWITCHING SIZES- FEED DIE & FINGERS



- ① Remove bullet feed assembly from reloading press. Remove 8-32 x 3/8" Phillips screw from bullet feed body.
- ② Unscrew tube adapter, lift off die plate and crank assembly from feeder link and feed finger. Slide down die body and feed fingers from underneath body.
- ③ Slide in new feed die, re-attach feed fingers around die body, put die plate and crank on top of feed die, screw tube adapter back on, and re-install Phillips screw into bullet feed body and feed finger.

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TROUBLESHOOTING

BULLETS NOT BEING PULLED FROM THE STACK

Too many bullets in feed tube	Reduce the number of bullets in feed tube
Nose nesting in hollow base	Select bullets that do not nest together
Bullets too sticky from wax or excessive Alox	Reduce the number of bullets in feed tube or change lube technique

BULLETS DROPPING OUT TOO SOON

Wrong feed finger	Be sure correct feed finger is installed Large fingers are marked with 'L' next to gripper
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BULLET TIPS WHEN EXITING THE FEED DIE

Spring not installed on top of attach plate over friction actuator	Be sure spring is installed on friction actuator on top of attach plate.
Bullet feed die opening too long	Select bullet feed die with shorter opening.

IMPORTANT

- ⊘ DO NOT STORE press with bullet in the feed fingers or fingers will take a set in the open position.



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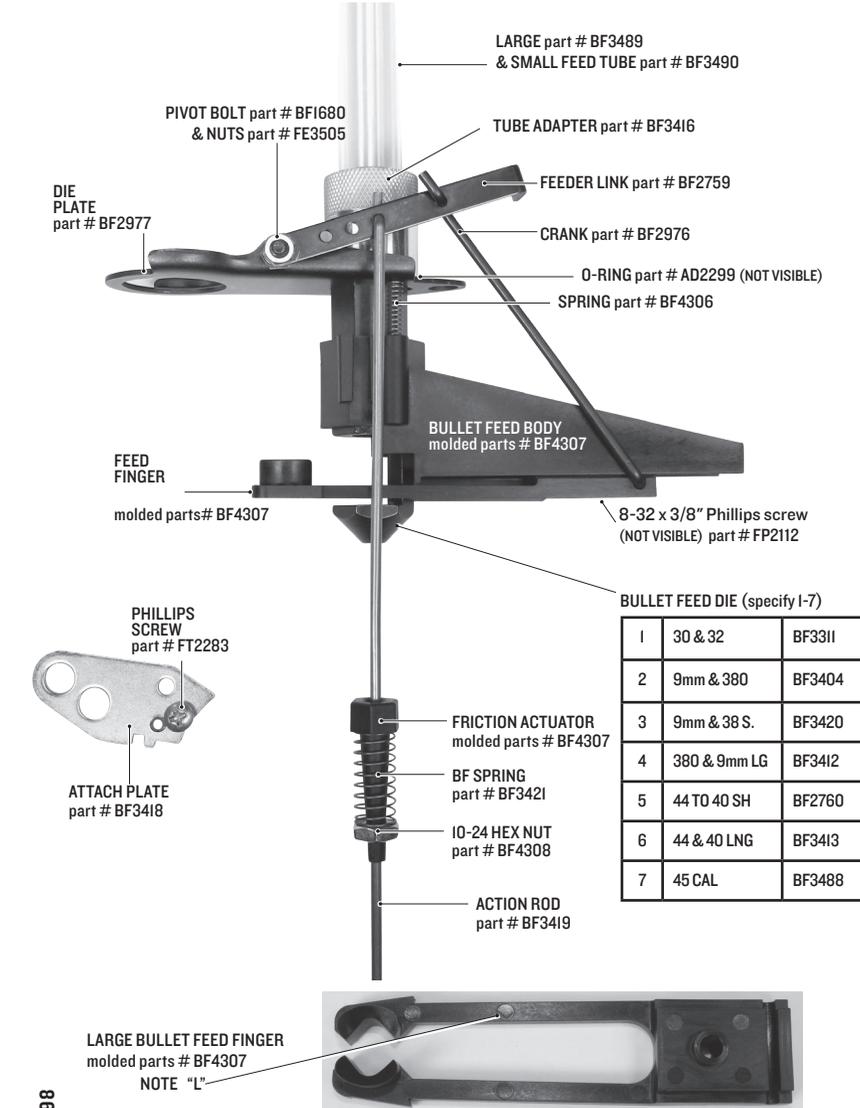
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BULLET FEED KIT INSTRUCTIONS

The Lee Bullet Feeder has been designed to function with all Lee progressive presses using Lee Bullet Seat & Crimp dies.

Lee Bullet Seat & Crimp dies are standard on most Lee handgun dies and can be purchased separately if using other brands of dies:
leeprecision.com/pistol-bullet-seating-die-only

Read and follow these instructions to ensure proper operation.



BF3498

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.

BULLET FEED DIE (specify I-7)		
1	30 & 32	BF3311
2	9mm & 380	BF3404
3	9mm & 38 S.	BF3420
4	380 & 9mm LG	BF3412
5	44 TO 40 SH	BF2760
6	44 & 40 LNG	BF3413
7	45 CAL	BF3488

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IMPORTANT

This tool must be used with a Lee Bullet Feed and Seat Die. Attempts to use any other die will damage the bullet feeder. This die has a tapered end to release the bullet feed fingers and is shortened to allow space for the fingers while crimping. If you have a very old Lee die set or other brand of die, you may purchase a bullet seating die only on our website: leeprecision.com/pistol-bullet-seating-die-only



Start by selecting the correct bullet feed kit for your bullet diameter and length. The feed die opening should be just long enough to freely feed your bullet. Do not select an excessively long feed die as bullet tipping and misfeeds will result. See chart listing for currently available feed dies.

Feed dies are marked with 3 characters on the end—the first character denotes die number; the last 2 characters (xx) are manufacturing date codes.

DIE	BULLET SIZE & LENGTH	FINGER SIZE	FEED TUBE	KIT	FEED DIE & FINGERS
1xx	.30 & .32 cal Bullets, up to .60 long	Small feed fingers	small	90892	90885
2xx	9mm through .365 diameter, up to .46 long	Small feed fingers	small	90893	90886
3xx	9mm through .365 diameter, .47 to .60 long	Small feed fingers	small	90894	90887
4xx	9mm through .365 diameter, .61 to .75 long	Small feed fingers	small	90895	90888
5xx	.40 cal through .44 caliber, up to .65 long	Large feed fingers	large	90896	90889
6xx	.40 cal through .44 caliber, .66 to .80 long	Large feed fingers	large	90897	90890
7xx	.45 caliber, up to .67 long	Large feed fingers	large	90898	90891

1 SET UP

- A** If you are reloading on a 2023 Pro 1000 or Load-Master, fasten attach plate to press using a stubby Phillips screwdriver. Attach plate rests underneath carrier.

2023 PRO 1000

LOAD-MASTER

Remove screw that attaches the primer trough to the carrier.



(1) Breech Lock bushing and (1) lock ring are required to utilize Automatic Bullet Feed Product # 90600 and Part # SD4239



ACTION ROD INSTALLED HERE

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- B** Install friction actuator and spring through carrier cover. Screw 10-24 NUT on friction actuator (fits tightly). Finger tighten 10-24 NUT.

HINT

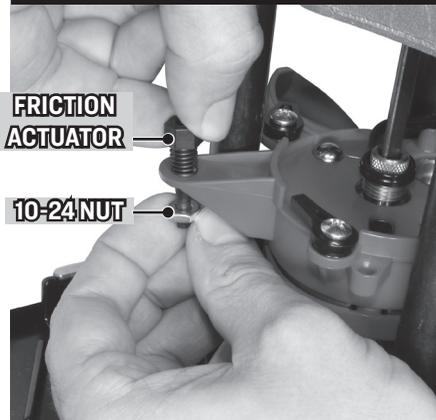
If finger tightening is uncomfortable, **lightly** snug with $\frac{3}{8}$ wrenches.



PRO 4000

FRICION ACTUATOR

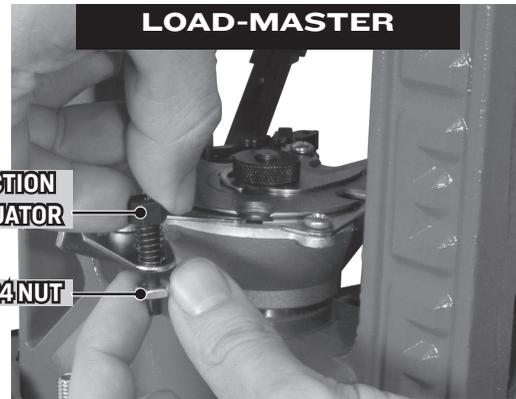
10-24 NUT



LOAD-MASTER

FRICION ACTUATOR

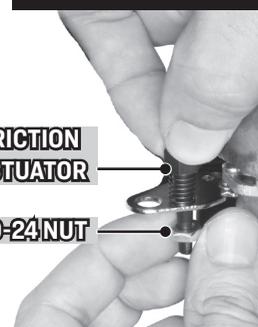
10-24 NUT



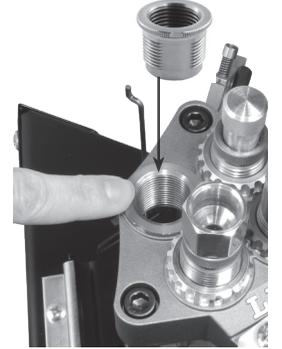
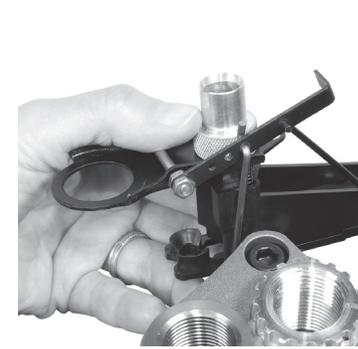
2023 PRO 1000

FRICION ACTUATOR

10-24 NUT



- C** Install action rod into feeder link. Use end hole as shown.



PRO 4000 | 2023 Pro 1000: Breech Lock Bushing # 90600 must be used in Bullet Feed station.

- D** Slide down action rod and bullet feed assembly into the friction actuator.

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(1) Breech Lock bushing and (1) lock ring are required to utilize Automatic Bullet Feed Product # 90600 and Part # SD4239

- E** Install bullet seating die and feeder assembly into position so action rod is close to vertical.

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2023 PRO 1000



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