

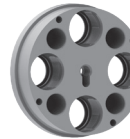
ACCESSORIES:

5 hole Tool Carrier # 92177



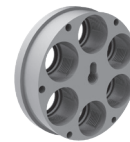
4 hole index rod # TP5494

4 hole Tool Carrier # 92088



4 hole index rod # TP5524

3 & 6 hole Tool Carrier # 92087



3 hole index rod # TP5525
6 hole index rod # TP5523

Oil ram using heavy household or motor oil before every reloading session. **Place a large drop in the base chamfer surrounding the ram.** Also apply a drop of oil to all linkage points and tool head every few thousand rounds.

Smart Lock Bushing, standard equipment on Lee Breech Lock Dies. No tool die adjustments.

Spline Drive Quick Change Bushing



See page 6

CONGRATULATIONS!

Congratulations, you have purchased the most versatile and convenient turret press ever made.

The press is topped with an indexable tool carrier. The tool carrier is supported by a steel ring. Just enough clearance both radially and axially to allow easy indexing and radial float to provide perfect die alignment. Because the tool head is supported on the circumference no tool head tipping can occur. When an operation is performed, the tool carrier is raised until it contacts the steel support ring maintaining perfect perpendicularity to the ram.

The round tool carrier is precision machined on all surfaces. Available in 4, 5 and 6 die positions. Each die position is machined to accept any Lee Breech lock bushing. Tool heads can be switched in under two minutes with a simple $\frac{1}{4}$ " hex key wrench. Each die position has a corresponding locating hole to receive a positive locating pilot pin. This locating pin provides positive location of the tool carrier on the presses up stroke and locks the tool carrier for die changing and adjustment.

Every downstroke of the press automatically advances the carrier to the next tool position. A 60-tooth ratchet clutch is overload protected and works with all number of carrier configurations. A case ejector travels with the indexer and ejects the completed round to the included bin.

The Big Press all-steel compound toggle linkage sizes the most difficult cases with ease.

Ergonomics are excellent with the formed lever and roller handle. The balanced lever design is easy to operate and will not drop and pinch a finger.

The finishing touch, a tool rack surrounding the steel tool carrier holds Die wrench, $\frac{1}{4}$ " hex key wrench, alternate primer arm and Safety prime.



DANGER



CAUTION

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.

Safety Considerations:

- Wear safety glasses and hearing protection when reloading or shooting.
- Be sure of proper powder and charge for bullet weight selected.
- Keep powder away from heat and open flames -- don't smoke.
- Store powder and primers in their original containers in a cool, dry place.
- Read and follow instructions.
- Exercise care and common sense at all times.
- Do not permit distractions while loading.

Setup Tools required:

- Safety glasses & ear protection
- 1/2" wrench or socket
- 1/4" hex key wrench

1

LEE BENCH PLATE #90251



The most convenient way to mount your press is with our **Lee Bench Plate System # 90251**. This system includes all of the mounting hardware and allows for quick press removal without unbolting from bench.

For those without a bench, consider our **LEE RELOADING STAND #90688**.

Both the #90688 Reloading Stand and #90251 Bench Plate include a steel mounting plate.

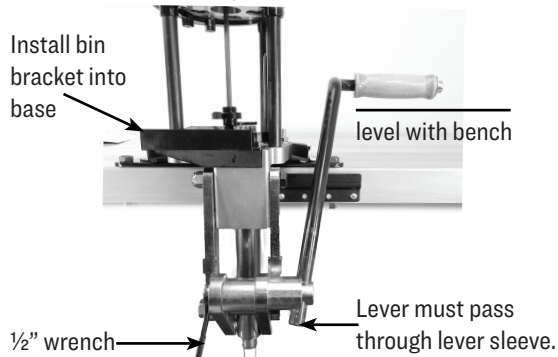


SCAN ME

Or, purchase [qty. 3] 1/4" bolts and nuts and prepare your workbench for use with this press using drill template available: leeprecision.com/files/instruct/TMPSP.pdf

2

Loosen the lever bolt with a 1/2" or 13mm wrench. With the ram in the down position adjust the lever rearward so that it clears the workbench edge and the roller handle is level with the bench top.



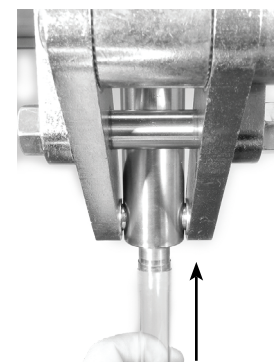
3

Before you cycle the ram install a universal shell holder, else the indexer and ramp may slide off the ram. The shell holder is retained with a Nylon retainer that allows free rotation for smooth case ejection. Align the shell slot with the ramp arrow.



4

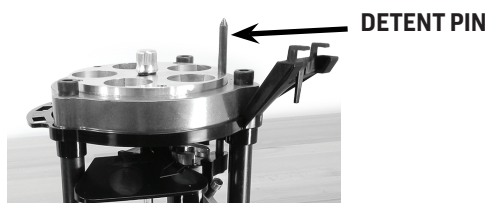
Attach spent primer catch tube to barb located at the bottom of the ram.



5

INSTALL DIES INTO TOOL HEAD, 5 station shown.

Raising the ram to the top of the stroke engages the detent pin with the turret preventing rotation allowing easy installation and tightening of the dies.



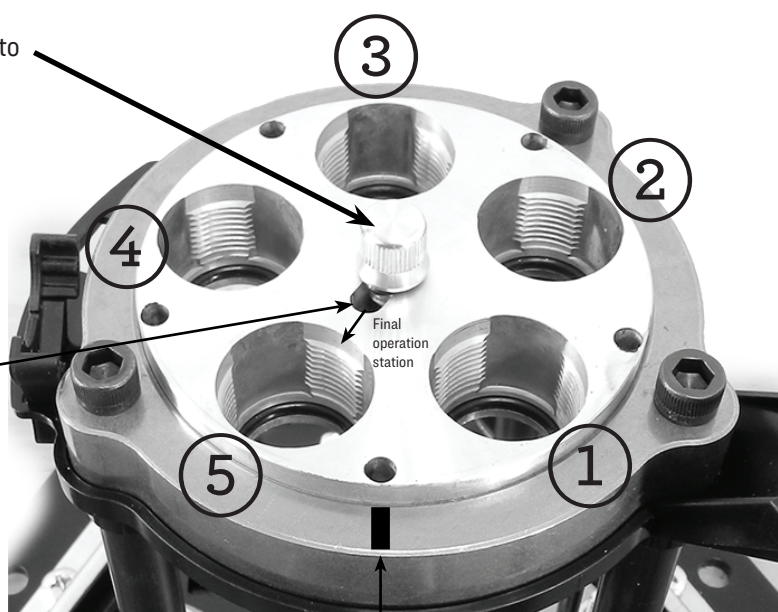
Position 3 = Lee Inline Bullet Feed Die

Hold down bolt (3/8-16 thread) must be installed to automatically index.

Position 4 = Bullet Seating Die

Index rod slot must point to the final operation in your reloading sequence

Position 5 = Factory Crimp Die or Final operation



Position 2 = Powder Through Expanding Die or Rifle Charging Die. Use Spline Drive Bushing.



See page 6

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

Apply a register mark with felt tip marker or pencil. Position varies with tool head positions.

6 INSTALL POWDER MEASURE

Install a case activated powder measure, adjust die in or out for proper operation. Handgun cases are flared to freely accept bullets in this station. Adjust die inward to increase flare on case.

Deluxe Auto-Drum included with kit

See powder measure instructions for installation instructions.

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

Remove
the funnel
adapter

7 VERIFY POWDER CHARGE

Safety Scale, product 90681 included with kit

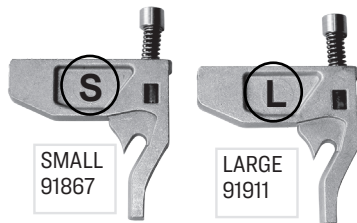
This step is critical for safety.



8 INSTALL PRIMER ARM AND SAFETY PRIME

Raise the ram, install the large or small primer arm. Return the arm not in use to the tool rack so you do not lose it.

Slide appropriate trigger into primer feed bracket.
(SMALL OR LARGE)



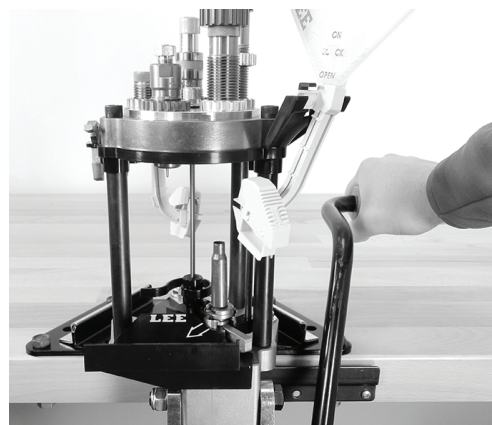
Cartridges with overall length up to 3.00" can be reloaded using auto index.
Cartridges 3.00" to 4.00" can be manually indexed or operated as a single stage press.

You are ready to begin reloading. It is best practice to operate the lever from stop to stop on every cycle. Every complete cycle advances the tool head one position. At the bottom of the ram stroke, you may rotate the tool head freely to backup or skip a station. If you manually rotate the tool head you must roughly align the die with the ram or register mark before raising the ram.

[A] Verify ram is at the top of its stroke. Place finger or thumb **DIRECTLY OVER "S" or "L"** and steer the trigger on to the primer arm, briskly push to dispense primer into cup.

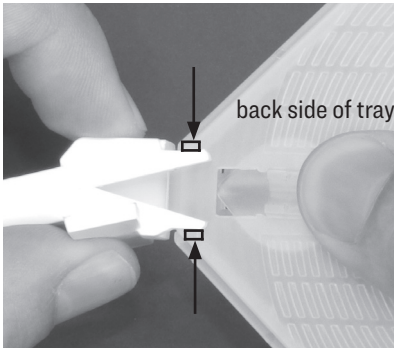


[B] LOWER ram to seat primer. The primer should be flush, to slightly below flush, when properly seated. Some primers may require a firm push.

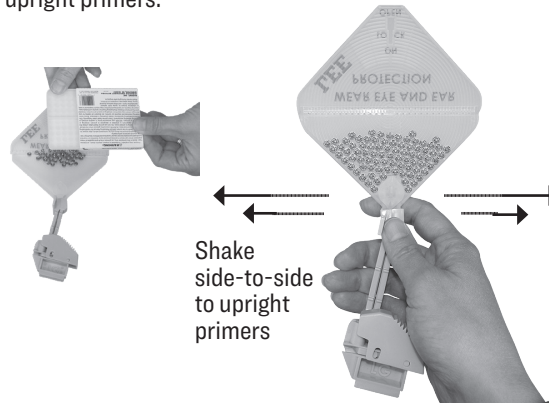


SAFETY PRIME ASSEMBLY AND FILLING

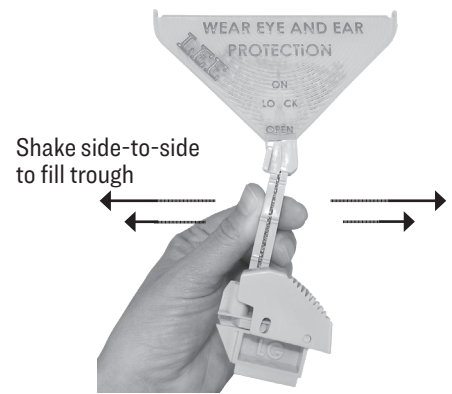
[A] Make sure trough fingers are between and completely engaged with tray latch lugs highlighted below.



[B] Open tray and deposit 100 primers, shake side to side to upright primers.



[C] Fold and close cover slide latch to ON position shake side to side to fill trough.



OPTIONAL TOOL CARRIERS AVAILABLE

While reloading with a turret press, no station should be left empty. This wastes a stroke of the press and, therefore, time.

It is easy to change the number of positions on your Ultimate Turret press. Select a tool carrier that leaves no station empty. We have 3, 4, 5 and 6 position tool carriers.

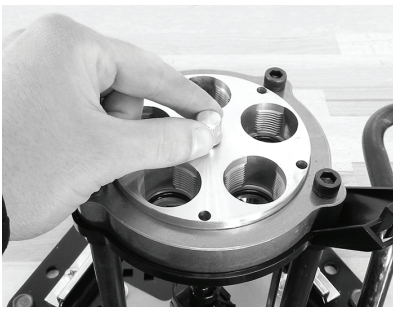
Select the three-position carrier when loading brass of known quality and condition (cases fired in your gun). Use a Lee 3 die set and an automatic powder measure. **Three strokes to a finished round!** Many millions of rounds have been successfully reloaded using three die sets. The three position carrier does not actually exist, you use the 6 position carrier with the three position "double index rod."

Select the four position carrier if you are using range brass. For feeding dependability nothing beats "Factory Crimped ammo." If you are using other brands of dies, you will need the extra station for powder charging; as only Lee dies include a powder through expanding die as standard equipment. If you are using Lee dies, **four strokes to a factory like round!**

The five position carrier with Lee dies and an Inline Bullet feeder is the fastest most convenient way to reload factory like ammunition with the simplicity of a single station press. The addition of the inline bullet feeder allows uninterrupted operation as no pause is required to place a bullet.

The six station carrier is necessary when using other brands of dies that don't include powder through expanding dies.

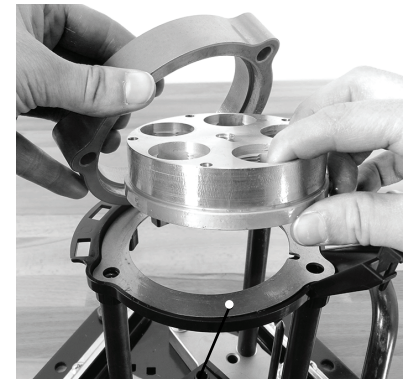
[A] Remove hold down bolt and index rod



[B] Remove retainer ring bolts using 1/4" hex key



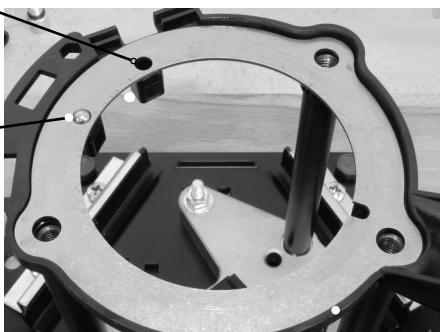
[C] Remove tool carrier and tool head



[D] When changing to a 4 or 6 tool carrier, remove bearing plate to switch detent position.

Position for 4 or 6 hole tool carrier

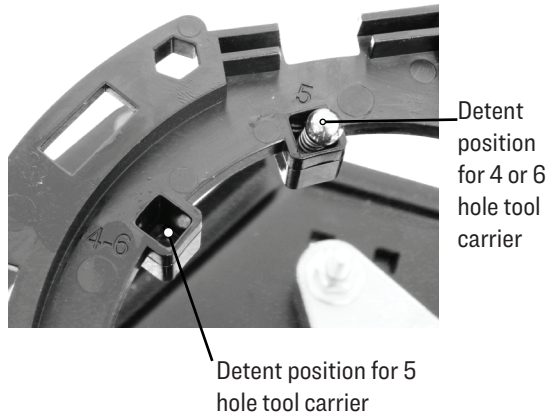
Position for the 5 hole tool carrier



Apply STP™, petroleum jelly, or grease to the bearing plate before re-assembly.

Continued, see page 5

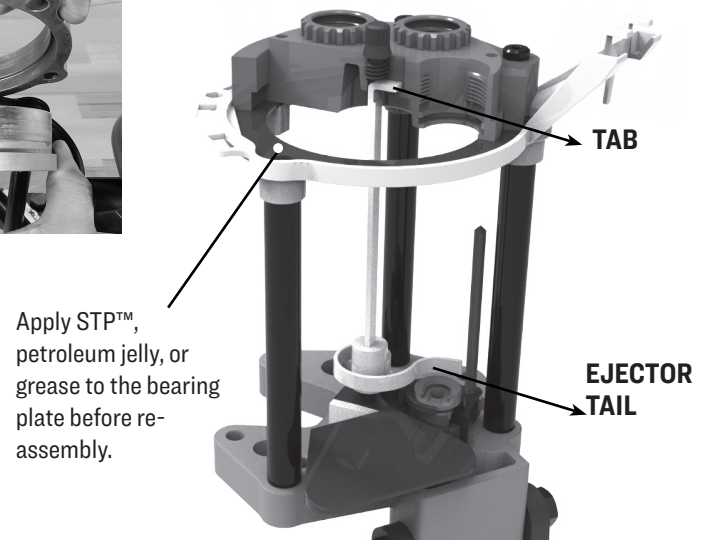
[E] Move ball and spring if switching from 5 hole to 4 or 6 hole tool carrier. Marking next to pocket is the inverse of installation location for operation. Re-install bearing plate.



[F] Re-install tool head



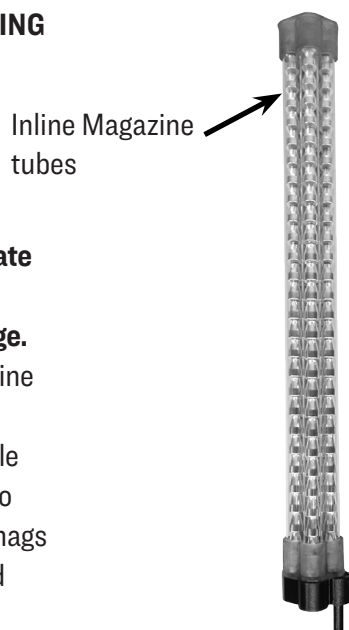
[G] When re-installing the index rod, orientation of the ejector is correct when the ejector tail aligns with the tab on the index rod.



TROUBLESHOOTING

PROBLEM	CAUSE	REMEDY
Tool carrier not indexing to correct position	• Wrong index rod installed	• Install correct index rod Index positions marked opposite tab. (3, 4, 5 or 6) Note: 3 can be used with 6 hole tool heads.
Case ejection error	• Case ejector or shell holder installed wrong direction	• Turn ejector 180 degrees for proper alignment on index rod. • Shell holder slot should point towards arrow on ramp (See Step 11E or video for additional guidance)
Primer doesn't enter case	• Primer crimp not removed • Wrong size primer	• Swage or ream primer pocket. • Caution, some 45ACP cases now have small primer pockets
Tipped primers	• Case not fully in shell holder	• Be sure case is inserted to the back of shell holder slot

INLINE BULLET FEEDING



Your turret press kit includes the appropriate Inline Magazine feed tubes for your cartridge. Consider adding the Inline Die only to complete your kit. Owning multiple magazines allows you to preload and swap out mags for larger uninterrupted reloading sessions.

INLINE DIE ONLY	CAL	TYPICAL	BULLET DIAMETER RANGE	MAGAZINE INCLUDED WITH KIT*
91998	22 CAL	22 Hornet to 222 Rem Mag	.220 — .225	SMALL 92014
92025	24 CAL	6mm to 243	.238 — .245	SMALL 92014
92000	26 CAL	6.5 Creedmoor & similar	.250 — .273	SMALL 92014
92214	28 CAL	270 Win to 7mm Rem Mag	.277 — .284	MEDIUM 92015
91999	30 CAL	30M1 to 30/06	.300 — .320	MEDIUM 92015
91995	35 CAL	380 Auto to 357 Mag	.312 — .360	MEDIUM 92015
91996	40 CAL	40 S&W	.390 — .406	LARGE 92016
92071	44 CAL	44 Mag & 44 Special	.425 — .435	LARGE 92016
91997	45 CAL	45 ACP to 45 Colt	.435 — .460	LARGE 92016

CARTRIDGE CHANGEOVER GRID

To convert the Ultimate Turret Press from a one cartridge to another, all you will need is the appropriate Lee reloading die set. The chart to the right shows proper configuration with catalog numbers.

Cartridge	Shell Holder	Breech Lock Reloading Dies	Charging die	Primer Arm	Inline Bullet feed die only	Inline Bullet feed kit
32 S&W Long	4	91876		Small		
9mm Luger	19	91882*		Small	91995	92007
38 Super	19	91879		Small	91995	92007
380 Auto	4	91877*		Small	91995	92007
38 SPL & 357 MAG	1	91878*		Small	91995	92007
40 S&W	19	91880*		Small	91996	92008
10mm Auto	19	91880*		Large	91996	92008
44 SPL & 44 MAG	11	91881*		Large	92071	92072
45 ACP	2	91883*		Large or Small	91997	92009
45 Colt	11	91884*		Large	91997	92009
223 REM	4	91932 (LUBE REQ.)	90668	Small	91998	92010
300 AAC Blackout	4	91925 (LUBE REQ.)	90668	Small	91999	92011
308 WIN	2	91953 (LUBE REQ.)	90194	Large	91999	92011
243 WIN	2	91949 (LUBE REQ.)	90194	Large	92025	92026
270 WIN	2	91950 (LUBE REQ.)	90194	Large		
22/250	2	91948 (LUBE REQ.)	90194	Large	91998	92010
7mm REM MAG	5	91951 (LUBE REQ.)	90194	Large		
30-30 WIN	3	91952 (LUBE REQ.)	90194	Large	91999	92011
300 WIN MAG	5	91954 (LUBE REQ.)	90194	Large	91999	92011
6.5 Creedmoor	2	91920 (LUBE REQ.)	90194	Large	92000	92012

LUBE REQ. = # 90006 LEE resizing lubricant required *4 Die Breech Lock set available

SERVICE PARTS | ACCESSORIES

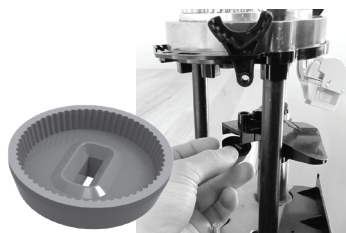
TP5484 molded parts



Bracket



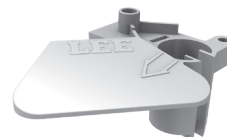
Clutch retainer



Driver Clutch



Shell holder retainer



Chute & Index Assembly



Case Ejector

Smart Lock Bushing

More available:

91933 - 4 PACK



Spline Drive Quick Change Bushing

More available:

90063 - 2 PACK

90095 - 4 PACK



The Lee Guarantee

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:

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.



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.