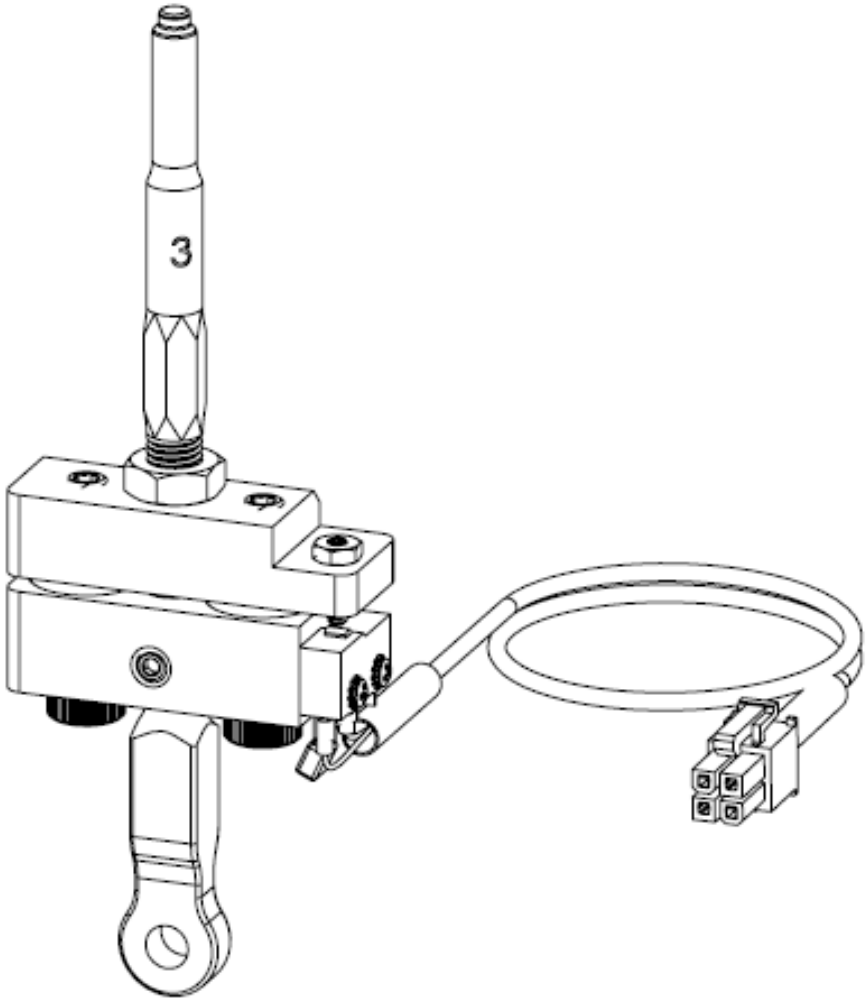
101-1031: Mark 7® SwageSense APEX 10, Evolution & Revolution

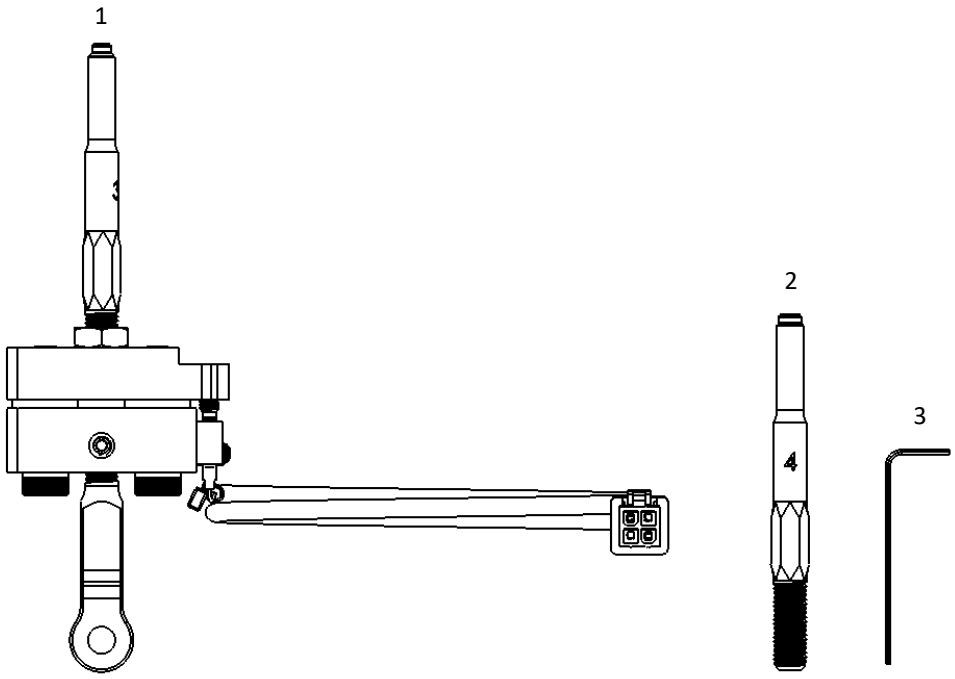
Instruction Manual V 1.1



⚠	**Read this manual completely. Understand all safety and operating instructions. Failure to comply with the warnings and instructions may result in serious injury, illness, or death.**

Package Contents

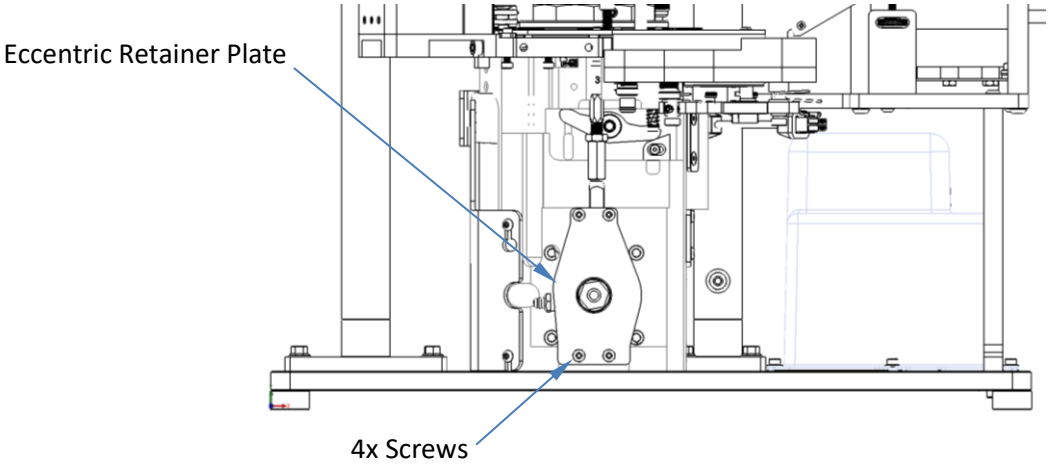
Please review these contents and inform us right away if you appear to be missing any of these items:



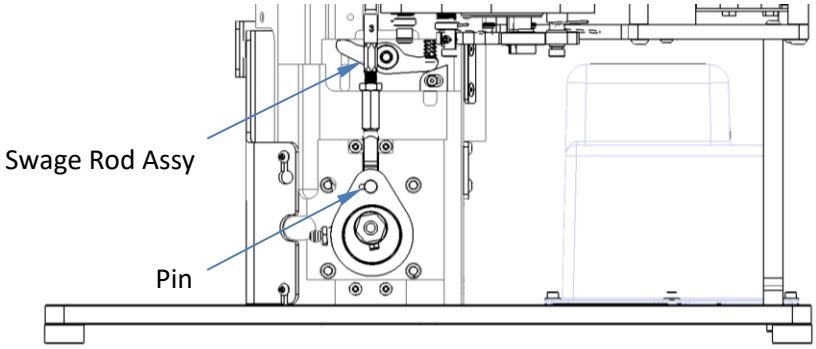
Item No.	Description	QTY
1	SwageSense Core Assy	1
2	Swage Rod Upper - LG	1
3	.05” Allen Key	1

Set-Up Procedures:

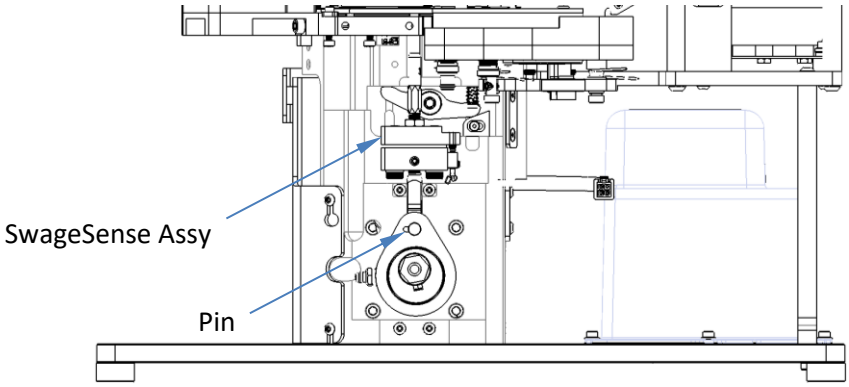
1. Disassemble **Eccentric Retainer Plate** by removing indicated **Screws. Note: the following images are on a Revolution.**



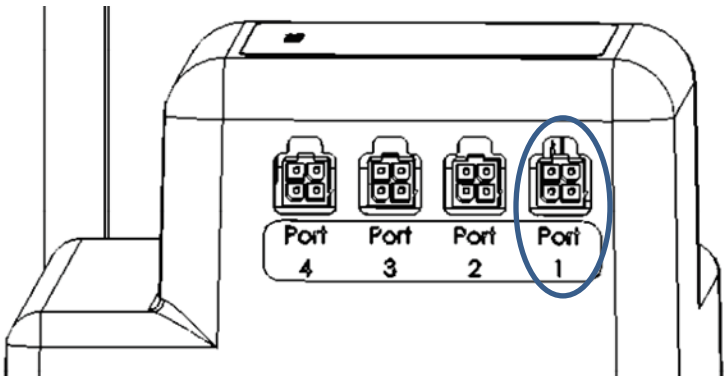
2. Remove **Pin** and slide out **Swage Rod Assy.**



3. Replace **Swage Rod Assy** with **SwageSense Assy.** Secure with **Pin.**



4. Connect **SwageSense Cable** into **Console Port 1.**



5. Back off the Swage back-up expander die and swage rod off a few threads and insert a de-capped case into station #3. Move the press head to the bottom position. Adjust the swage back-up expander so it bottoms out against the bottom of the case and lock down the die. Next using 5/16 wrench thread the swage rod up until it bottoms out into the case pocket. Then turn it a ¼ turn more and lock down the jam nut. See the figure below.

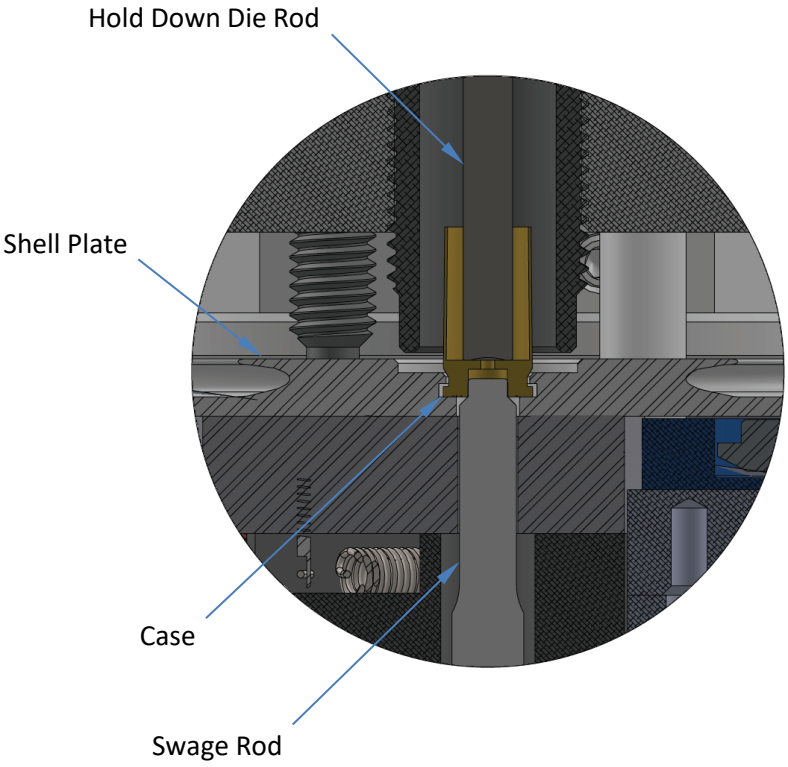


Figure 1: Cross-section of properly adjusted Swage Rod.

6. The **Microswitch** is pre-adjusted so it will be triggered immediately when the SwageSense® assembly starts to close. If you want to change the engagement of the switch use a .05" Allen Key and a ¼" open end wrench. We do not recommend adjusting the setting unless it becomes out of adjustment. To adjust tighten the **Set Screw** until you hear the switch trigger, then back it off a ¼ turn and lock down with the Jam Nut.

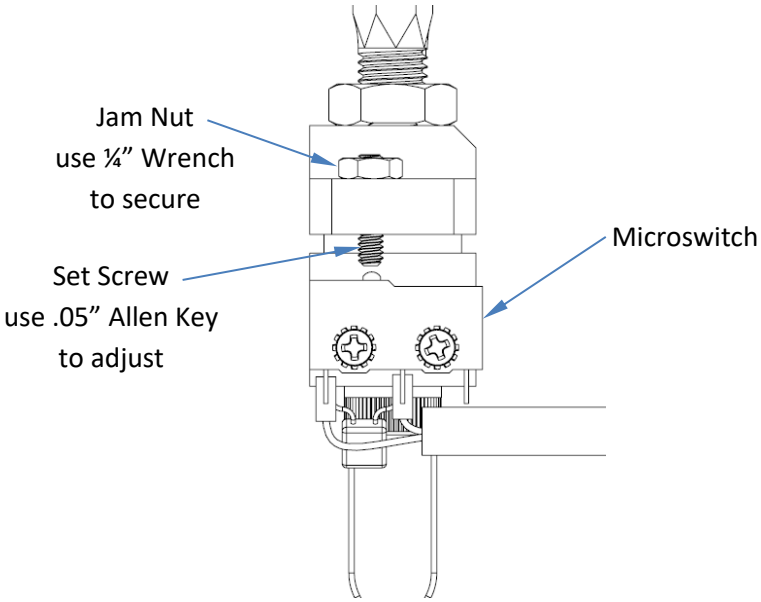


Figure 2: Microswitch Adjustment.

7. When the **SwageSense®** switch is triggered the following notification will appear on the reloader application.

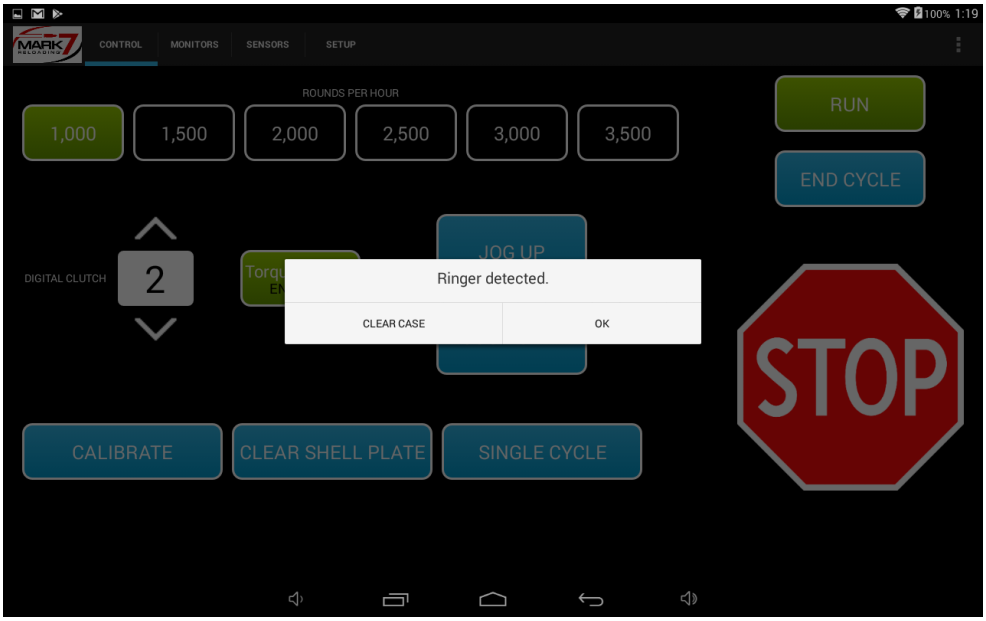


Figure 3: SwageSense® Notification.

Increasing SwageSense Force

1. The swage force on SwageSense is adjustable from very sensitive (SM pistol) to full lockout (military crimp.)

2. The **Gap** between the upper and lower housings determines the pre-load force on the assembly. To adjust the gap first start by loosening the two **Jam Set Screws** on the top of the **Housing.**

3. Then adjust the **Shoulder Screws** on the bottom of the housing to set the desired force. The gap working range is from .075-.095". Never operate SwageSense out of this range. Whenever the gap is adjusted the **Microswitch** will also need to be adjusted. Lastly, lock down the **Shoulder Screws** with the **¼"-20 Jam Set Screws.**

4. We recommend starting with a gap of .095". Then adjust the **Microswitch Set Screw** so it is just starting to depress the **Microswitch.** Start with this value, by tightening the **Shoulder Screws** you will add more pre-load to the screws which increases the swage force, but makes the ringer detection less sensitive.

5. Tighten the **Shoulder Screws** evenly until desired gap is reached. Tighten two **Jam Set Screws.**

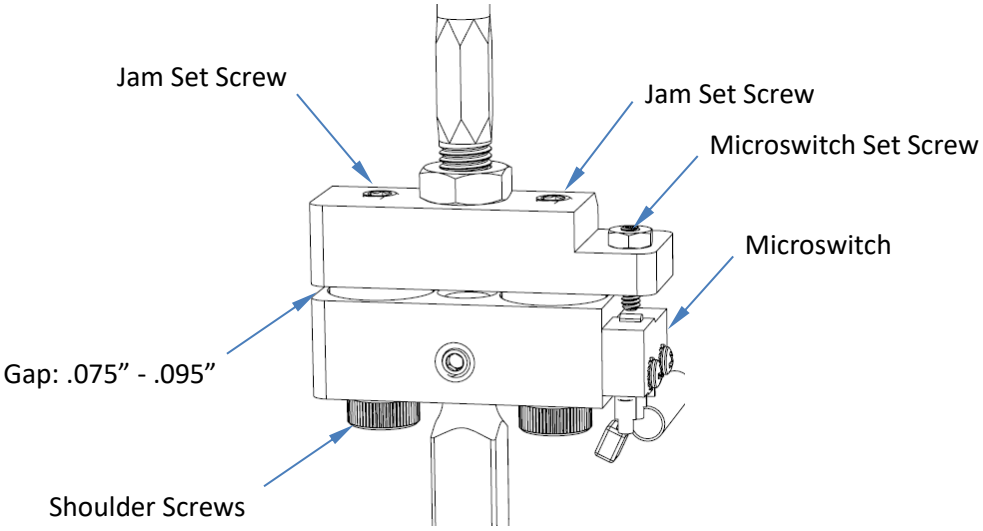


Figure 4: Adding set screws to lock shoulder screws in place.

Troubleshooting

Refer to the knowledge base section on our website under **SUPPORT** for troubleshooting articles relating to setup and operation.

http://www.markvii-loading.com/knowledgebase

Please contact us for technical support

Phone: 1-888-462-7577

Hours: 9:00am-4:30pm, ET, M–F