



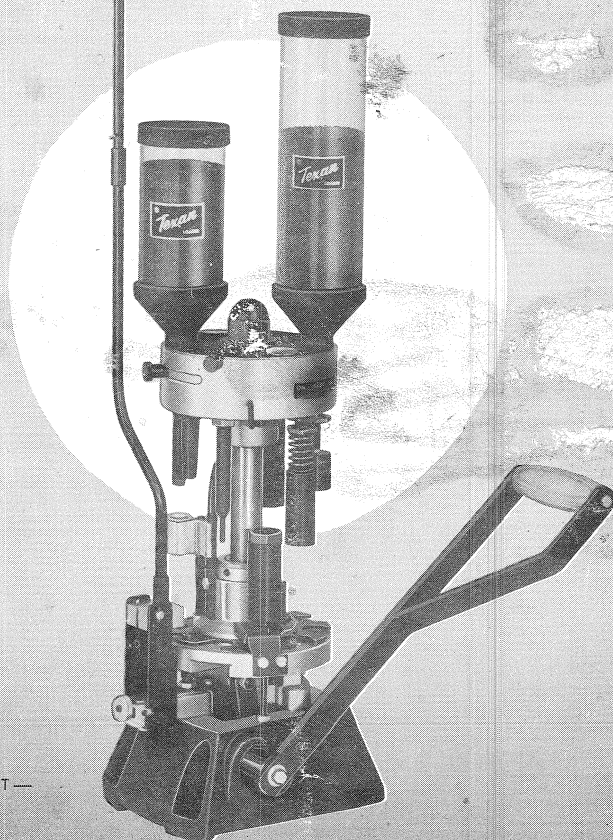
Texan[®]

AUTOLOADER

MODEL M 11-A

INSTRUCTION

MANUAL



WE DO NOT SELL THE MOST —
WE SELL THE **BEST**

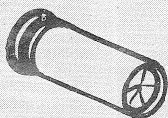
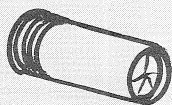
Texan[®] Reloading Equipment

ROTEX MANUFACTURING COMPANY

8222 CHANCELLOR ROW • DALLAS, TEXAS 75247

Texan

AUTOLOADER



Your TEXAN AUTOLOADER is the finest, fastest reloading machine made for the automatic loading of shotshells.

It will load all $2\frac{3}{4}$ " shellcases in the gauge you select with one pull of the handle. Three minor adjustments are required to change loads—change charge bushings, adjust wad pressure and column height, and adjust the sizing die setting.

The knowledge that your reloaded shotshells are reloaded with the uniformity and exactness of the Texan Autoloader will increase the pleasure of your shooting and hunting.

ASSEMBLY INSTRUCTIONS

Inspect your machine when you remove it from the packing carton. The Autoloader is shipped completely assembled, except handle, and factory adjusted to begin loading immediately.

ATTACHING HANDLE

The handle is attached by removing the hex head screw and sliding the handle in the slot, using this screw to hold the handle.

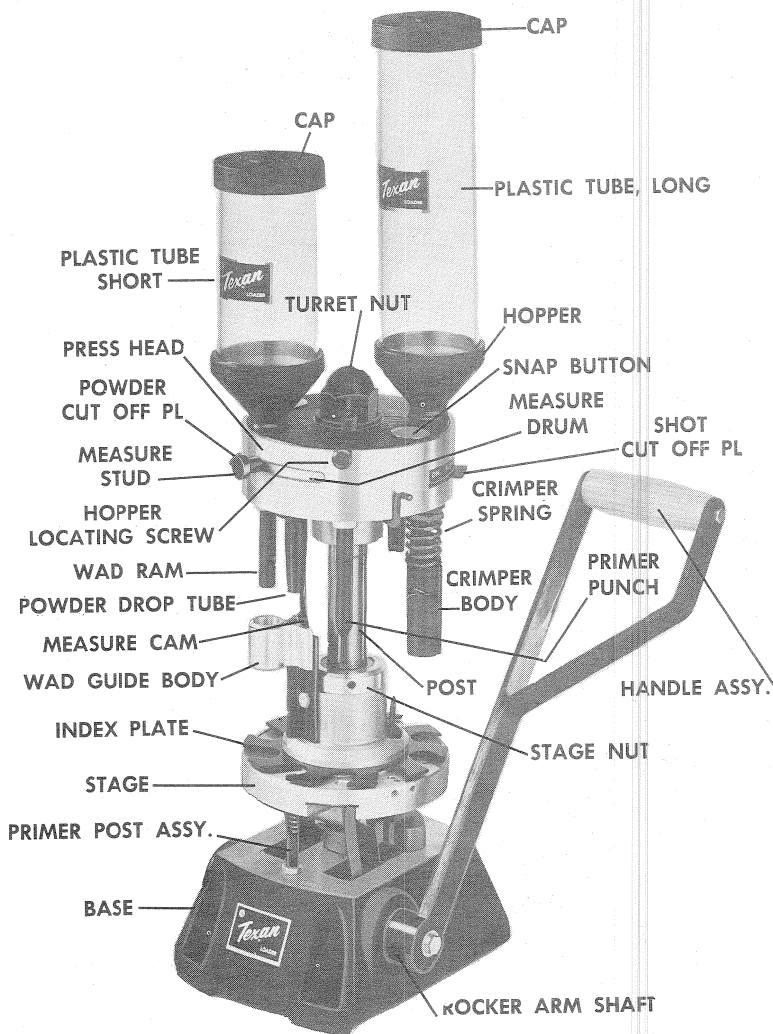
MOUNTING

Mount your Autoloader on a sturdy bench or table with three screws or bolts. Be sure the machine is not set back so far the handle will hit the bench or table top when at the forward end of its stroke. Leave space on the left hand side for wadding and primers and space on the right side for empty and loaded shells.

EXTRA BUSHING AND TOOLS

Extra powder and shot bushings and a hex socket wrench that fits all the set screws are shipped with each machine.

Each Texan Autoloader is adjusted at the factory to load the standard trap, skeet, or light field load in a $2\frac{3}{4}$ " low brass shell case using powder requiring 50 pounds wad pressure. No adjustments are necessary to start loading this type of shell.



WARRANTY

The Manufacturer warrants each new Reloading Tool manufactured by it to be free from defects in material and workmanship under normal use and service, its obligation under this warranty being limited to making good at its Factory any part or parts thereof supplied by the Manufacturer.

The obligation of the Manufacturer under this warranty shall be limited to the repair or replacement of parts proved defective within Ninety (90) days from date of original purchase, it be returned to the Manufacturer with transportation charges prepaid, and which its examination shall disclose to its satisfaction to have been thus defective; this warranty being expressly in lieu of all other warranties expressed or implied, and of all other obligations or liabilities on its part, and it neither assumes nor authorizes any other person to assume for it any liability in connection with the sale of its Reloading Tool or parts thereof.

This warranty shall not apply to any Unit or part which shall have been repaired or altered outside of an authorized dealer in any way so as, in the judgment of the Manufacturer, to affect its stability or reliability, nor which has been subject to misuse, negligence or accident.

SELECTION OF COMPONENTS

SORTING SHELL CASES

Your shell cases must be separated as to the height of the brass base and the height of the inside base wad. Ironing will improve the looks of your finished crimp. Wet or damp shellcases will not load properly.

SELECTION OF COMPONENTS

The standard powder load for shotshells is expressed as "Drams Equivalent." This standard is used by all manufacturers of shotgun shells. It means: "This load is equal in velocity to a shell loaded with blank number of drams of black powder with correct breech pressure."

The loading table gives the correct type and grain weight of powder, ounces of lead shot, and the wad pressure to be applied to the top of the wad column to equal these dram equivalent loads.

PRIMER

The primer ignites the powder. Remington and Peters shellcases require one size of battery cup primer .226 inches in diameter. These are known as 157 or G57G primers. Winchester, Western, Federal and most other shell cases require battery cup primers .240 inches in diameter. These are known as 209 or 109 primers.

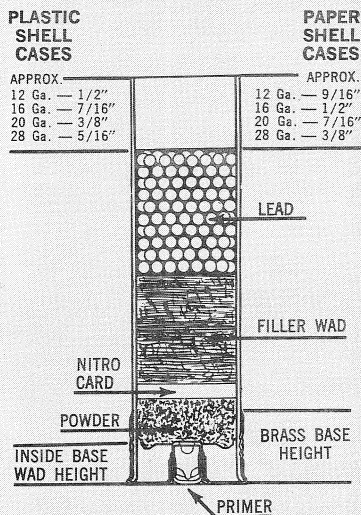
Some primer manufacturers make their primers .0015 inch larger than the standard. Once a shellcase has one of these large primers pressed into the primer pocket, standard primers will fall out.

POWDERS

The type of powder selected for each load is determined by its burning time. Red Dot and Alcan-120 powder burns at a rapid rate, giving a peak breech pressure for a short period of time. It is good for light field, trap, and skeet loads.

Herco, AL-5, AL-7, AL-8 are of the progressive burning type. Although a greater quantity of this type of powder is used, it will not generate any greater peak pressure at any point in the gun chamber than the small load of the faster burning types; however, the duration of the pressure is extended, giving an entirely different pressure curve. The same peak of pressure is sustained for a longer period of time, giving the heavier shot loads a greater velocity. If a faster burning powder is used with heavier shot charges, the peak pressure will increase, causing damage to the gun. This is why different powders are used for different loads.

NEVER EXPERIMENT WITH MORE POWDER THAN THAT RECOMMENDED IN THE LOADING TABLES.



WAD PRESSURE

Each powder is ignited better under proper confinement. By proper confinement we mean wad pressure and proper shot load. The wad pressure on the loading table is the maximum pressure to be applied to the top of the wad column. Variations may be as much as 20 pounds lighter, but more pressure will distort the loaded shells, or at best tend to swell the shell after prolonged storage.

WAD COLUMN AND THICKNESS

The wad column is made up of nitro cards and filler wads. The nitro card is placed over the powder charge. It seals the powder, preventing wax or lubricant from the filler wad from migrating into the powder. It also seals the gas pressures generated when the powder burns behind the wad column. The cards add firmness to the wad column, preventing distortion of the shot pattern. The filler wad is used to cushion the shock of the powder explosion against the lead shot. If all cards were used, the lead pellets would be deformed and give poor shot patterns. If all filler wads were used the wad column would be too soft and would probably distort when the shell was fired allowing gas leakage, making good, uniform loads virtually impossible.

WAD COLUMN THICKNESS

The inside base wads are different heights in shellcases. This difference requires different wad column thickness. You must sort your cases as to the wad column required to load automatically. Load the correct amount of lead shot, then measure the distance from the top of the lead shot to the top of the open shellcase. For a star crimp on 12 gauge shells, this should measure approximately 9/16 inch, 16 gauge approximately 1/2 inch, and 20 gauge approximately 3/8 inch. Increase or decrease the wad column without increasing the pressure applied to the wad column.

SHOT

The weight of the shot is as important as the powder load. A larger load of shot than that recommended will hold the wad column in place longer, building up a greater breech pressure. This is dangerous. Lighter loads of shot will move sooner, thereby decreasing the pressure, resulting in poor patterns of shot and shortened range.

The size of shot is left to your choice. Small sizes of shot is used for small bird game, trap, and skeet. The larger shot gives longer range and more killing power for bigger birds and game, but it decreases the number of pellets in your shot pattern. A good thing to remember is the smaller the shot, the more chances of hitting your target — the larger the shot, the more killing power of each pellet.

LOADING TABLE

Unless indicated, this loading table refers to loads using paper cards and filler wads.

SHOT BUSHING TABLE
No. 88660
All Sizes \$1.00 Each

CASE LENGTH	DRUM OUNCES EQUIV. SHOT	RED DOT	GREEN DOT	HI-SKOR	HI-SKOR 700X	HERCO/UNIQUE	PB	WAD PRESSURE							540MS	SR 4756	2400	4727
								AL-5	AL-7	AL-8	AL-126	480-L5	500- H5	540MS				

12 GAUGE

2-3/4"	2-3/4	1-7/8	20(Q)	22(C)	21(D)	19(J)		21(A)	21(B)			22.5(T)						
2-3/4"	2-3/4	1-7/8	18(B)*	21(Q)*	18(C)*	18(A)*						20(V)*						
2-3/4"	2-3/4	1-7/8	18(B)*	20(Q)*	17(B)**	17(P)**						18.5(Z)**						
2-3/4"	3	1	21(C)	23(D)	23(J)	23(G)		23(J)	23(G)			23(C)	23.5(M)					
2-3/4"	3	1-1/8	23(D)	24(R)	23(J)	24(S)		23(J)	24(S)			23(D)	25.8(N)					
2-3/4"	3-1/4	1-7/8	23(D)	24(R)	23(J)	20.5(G)		23(J)	27(H)									
2-3/4"	3	1-1/4	23(D)	24(R)	23(J)			23(J)				24.5(U)						
2-3/4"	3-1/4	1-1/4	24(R)	23(D)	30(D)	24(B)	25(D)	30(G)				34(P)						
2-3/4"	3-3/4	1-1/4	24(R)	31(R)	25(G)	33(C)		33(C)				36.5(A)						
2-3/4"	4	1-3/8		34(E)				36(D)					40(Q)					
2-3/4 Mag.	4-1/4	1-1/2						38(R)										
3" Mag.	4-3/8	1-5/8						38(R)										
3" Mag.	Max.	1-3/4						36(F)				47(S)						

16 GAUGE

2-3/4"	2-1/4	7/8					17(B)											
2-3/4"	2-1/2	1	17(J)	18(J)	15(N)							20(B)						
2-3/4"	2-3/4	1	18(B)	19(B)	16(P)							20(B)	19.2(L)					
2-3/4"	2-3/4	1-1/8			19.5(P)	19.5(J)	26(A)											
2-3/4"	3	1-1/8			20(P)	23(G)		26(A)				23(Z)						
2-3/4"	3	1-1/8			21(A)			21(J)										
2-3/4"	3-1/4	1-1/8			26(C)	21(A)		28(J)				25.5(V)	30.5(P)	26(Q)				
2-3/4"	3-1/4	1-1/4						33(H)					29.5(N)					
2-3/4"	Max.	1-1/4						36(E)					30.5(P)					

20 GAUGE

2-3/4"	2	7/8	15(P)															
2-3/4"	2-1/8	3/4					16.5(M)											
2-3/4"	2-1/8	7/8	17(J)	18(J)														
2-3/4"	2-1/4	3/4					22(N)											
2-3/4"	2-1/4	7/8	16(A)	17(A)	15(A)	14(T)												
2-3/4"	2-1/2	1			18(P)	18(U)		17(M)	19(A)	24(P)								
2-3/4"	2-3/4	1			20(A)	19(N)		18(P)		22(U)								
2-3/4"	2-7/8	1						20(A)		25(A)								
2-3/4 Mag.	3	1-1/8			21(U)	19.5(P)		32(R)										
3 Mag.	1-3/16							33(H)										

28 GAUGE

2-3/4"	1-3/4	5/8																
2-3/4"	2-1/8	3/4																
2-3/4"	2-1/4	3/4																

410 GAUGE

2-1/2"		1/2																
3"		3/4																

*Paper case with one-piece plastic wad column.

**Plastic case with one-piece plastic wad column.

No.	Ounces
1	3/4
2	7/8
3	1
4	1 1/8
5	1 1/4
6	1 1/2
7	1 3/4
8	1 1/2
9	1 1/4
10	1 1/4
11	3/4
12	1/2
13	5/8

CONVERSION KITS

Gauge

12	\$32.50
16	32.50
20	32.50
28	37.50
410	37.50

NOTE — IT IS RECOMMENDED TO REDUCE CHARGE BY 10% WHEN USING ANY TYPE PLASTIC OVER POWDER WAD.

DRAMS EQUIVALENT: The standard of all manufacturer's of shotgun shells. This load is equal in velocity to a shell loaded with that many drams of black powder with correct breech pressure.

WAD PRESSURE: The maximum lbs. per square inch of pressure applied to the top of the wad column to confine the type powder used.

NOTE: Letters in parenthesis are recommended powder bushings for "A" and "D" type loaders. Check bushing powder table for "M" loaders.

CRIMP STARTER

12, 16, 20, 28, 410 Gauge

\$5.50

M II SIZER

12, 16, 20, 28, 410 Gauge

\$13.50

CAUSES OF VARIATION IN CHARGES

1. Moisture content of powder.
2. Density of powder and shot.
3. Size of shot.
4. Inconsistent operation.

Information shown in this loading table has been obtained from sources and tests considered reliable. This information has been carefully compiled and is published for the express purpose of being a GUIDE ONLY. We assume no responsibility or any liability resulting from the use or misuse thereof, nor guarantee any performance.

Loading information shown on these pages has been revised and supercedes all information printed before 1-1-67. Destroy all old loading information.

POWDER CHARGE TABLE

THIS IS NOT A LOADING TABLE

EJECTION CAM

\$2.50

This table gives approximate number of grains of powder dropped by Texan bushings in Model "A", "D" and "M" machines.

BUSHINGS

\$1.00 Each

REVISED 1-1-67

Bushing	Green Dot A&D	Red Dot M	Herco A&D	Hi-Skar 700 X A&D	Unique A&D	AL-5 A&D	AL-7 A&D	AL-8 A&D	AL-120 A&D	450 SL A&D	500 HS A&D	540 MS A&D	Hi-Skar A&D	Bushing
A	15.1	15.1	19.5	16.5	20.5	24.4	24.9	19.9	16.8	28.7	35.4	32.3	14.5	A
B	17.1	17.3	22.3	18.6	23.3	27.6	28.2	22.8	19.0	32.6	39.9	36.4	16.3	B
C	19.5	20.0	25.8	21.3	26.7	31.6	32.2	26.3	21.7	37.4	45.6	41.6	18.7	C
D	21.0	21.7	27.8	23.0	28.7	34.0	34.6	28.5	23.3	40.0	48.8	45.1	19.6	D
E	24.5	25.4	32.6	26.8	33.6	39.7	40.2	33.6	27.1	47.4	57.0	52.3	23.5	E
F	27.8	29.2	37.5	30.6	38.4	45.7	45.8	38.6	30.9	54.3	65.0	59.6	27.0	F
G	17.6	17.8	23.0	19.2	23.9	28.4	29.0	23.5	19.5	33.8	41.0	37.5	16.8	G
H	23.2	24.0	30.8	25.3	32.7	37.6	38.2	31.7	25.7	44.8	54.0	49.5	22.3	H
I	16.2	16.3	21.1	17.7	22.2	26.2	26.7	21.4	18.0	30.8	37.9	34.5	15.6	I
K	8.1	7.5	9.9	8.6	10.8	12.6	13.6	10.7	9.0	15.0	19.0	17.3	7.7	K
L	9.7	9.4	12.1	10.4	13.1	15.5	16.3	12.1	10.9	18.1	22.8	20.8	9.3	L
M	11.8	11.8	15.3	12.9	16.1	19.0	19.7	15.2	13.2	22.2	27.8	25.1	11.3	M
N	13.0	13.0	16.7	14.1	17.7	20.9	21.5	16.9	14.5	24.6	30.5	27.8	12.5	N
O	14.1	14.2	18.2	15.4	19.2	22.7	23.2	18.5	15.7	26.8	33.1	30.1	13.5	O
P	18.1	18.5	23.9	19.8	24.8	29.4	30.0	24.4	20.2	34.6	42.4	38.7	17.4	P
R	22.3	23.0	29.5	24.3	30.0	36.0	36.6	30.4	24.6	43.0	51.9	47.5	21.4	R
S	32.7	34.5	44.1	35.3	44.1	51.3	53.7	45.4	36.3	63.8	78.8	71.6	31.6	S
T	11.3	11.2	14.4	12.3	15.4	18.2	18.9	14.5	12.7	21.5	26.7	24.3	10.9	T
U	12.5	12.4	16.1	13.5	17.4	20.0	20.6	16.1	13.9	23.5	29.2	26.6	12.0	U
V	10.0	9.7	12.6	10.8	13.6	16.0	16.8	12.5	11.2	19.8	23.6	21.4	9.6	V
W	8.5	8.0	10.6	9.2	11.5	13.5	14.4	10.4	9.6	16.0	20.2	18.3	8.2	W
X	7.4	6.9	9.1	8.0	10.3	11.6	12.7	9.0	8.4	14.0	17.7	16.1	7.2	X
Y	10.5	10.2	13.3	11.4	14.3	16.8	17.6	13.3	11.8	19.8	24.8	22.4	10.1	Y
Z	9.3	9.0	11.6	10.1	12.6	14.8	15.7	11.6	10.4	17.5	21.9	19.9	8.9	Z

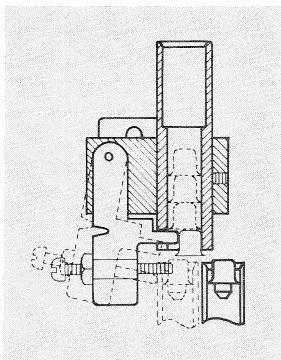
Specify Gauge Size
and Part Number
When Ordering

Minimum Parts Order
\$2.00 Each Order

When Ordering Parts
From the Factory, Add \$1.00
for Postage and Handling

All Prices Subject to
Change Without Notice

ADJUSTMENTS FOR AUTOMATIC PRIMER FEED MODEL M II-A



The Automatic Primer Feed should be fastened tight to the machine base. To tighten, pull the handle all the way forward. You will then see a Socket Head Bolt (Key 116). Tighten, using the 7/32 Hex Wrench (Key 115). Be sure that the Slide Cams (Key 126) are in Alignment with the Rocker Arms (Key 87).

Adjust the primer post (Key 123) to seat a primer to the correct depth by screwing the primer post up or down. When tightening the $\frac{3}{8}$ Jam Nut (Key 91), the Primer Post should be in the hole in the stage to insure alignment.

Adjust the slide stop (Key 129) until it hits the base (Key 135) of the automatic primer feed, while the primer post is in the hole in the stage. Lock the slide stop in place with the 1/4-20 hex jam nut. (Key 128) With the handle all the way forward, adjust the bracket assembly. (Key 132) Loosen the hex head bolt (Key 125) on the bottom of the bracket. Move the bracket

assembly back or forward until the primer post has passed the tube socket (Key 141) by 1/16 inch or more. Tighten the hex bolt. Passing too far or too short will cause primers to tilt. To adjust the height of the drop head (Key 139) loosen two screws (Key 133) on each side of the bracket. With a primer in the cup of the primer post, set the drop head using the 5/64 inch hex wrench (Key 144) as a spacer between the primer and the primer tube socket. (Key 141) The height of the primer to be used, controls this setting or primer will tip over. Drop head must be in alignment with the bracket. Tighten screws on both sides. To adjust the drop arm (Key 136) put four primers in the drop tube. Be sure they do not turn upside down. The primer post should be empty. Pull the handle for a complete stroke. Screw the adjusting screw (Key 143) in the drop arm against the primer post until a primer drops into the post. Lock in place with hex nut (Key 142). Push the handle back and forth to drop the other three primers, removing the primer each time. Primers should drop with a one, two action. First action drops primer into the post second action drops next primer into position. A small adjustment on adjust screw may be required to make primer fall exactly into post cup.

Insert the curved primer tube (Key 107) in the tube socket.

With the cotter pin (Key 106) in the straight tube (Key 105) fill the tube with primers with the flange side of the primer toward the cotter pin. Insert the straight tube in the formed tube. The primers will fall into place when cotter pin is removed. When the top of the last primer appears in the cut out of the formed tube, you should refill the tube. The tube socket is set at the factory and does not require adjustment. If the drop arm does not swing free or align with the slot in the tube socket, loosen the set screw (Key 140) in the drop head. The tube socket can be turned to align the slot. The height of the tube socket should be set in the drop head so the top notch on the drop arm will touch the tube socket. If the tube socket is set too low the drop arm will not hold the primers.

MODEL M II INDEX PLATE

The Model M II index plate comes in two parts and can be changed in about five minutes. To change your index plate, loosen two set screws in the stage nut and unscrew the nut about $\frac{1}{4}$ of an inch. Loosen the two set screws in the measure cam holder, slide the holder up about $\frac{1}{4}$ of an inch and remove the index plate. When changing gauge, replace index plate and pull down measure cam holder with your fingers. Align the wad guide holder with the wad ram. Also make sure the measure cam is against the backup roller. When these two are in alignment, reset the two set screws (but not too tight), screw the stage nut down until the index plate can be rotated by hand when the index cam is not engaged. Replace and adjust all dies for proper alignment and pressure, being sure to change powder and shot bushings for correct load for new gauge to be loaded. Consult loading and bushing table. Drop tubes and ejection punches are screwed in until they hit the cut-off plates, then back off one-half turn on each. Replace wad guide assembly by removing the retaining ring on the stop rod, then reassemble.

INSTRUCTION FOR MINOR MAINTAINENCE AND TO CONVERT THE MODEL MII TO OTHER GAUGES

1. Remove the Primer Ejection Punch, powder and shot drop tubes, the wad ram, the sizing die, the wad pressure assembly and crimper assembly.
2. Replace wad guide assembly by removing the retaining ring on the stop rod, two paper clips in the holes makes for easy removal. Slide the assembly off and the new assembly on. Replace the retaining ring. (Model MII-A uses 8-32 screw).
3. To change the index plate, loosen two set screws in the stage nut and unscrew the nut. Loosen two set screws in the measure cam holder. Raise the nut and measure cam holder as high as possible. Lift on one half of the index plate at the same time tap lightly on the other half. They will come apart and can be removed.
4. When converting to 28 gauge or 410 gauge, place the stage spacer plate in the groove on the stage, with the locating pins in the holes at station 3 and 8. If converting from 28 gauge or 410 gauge remove the stage spacer plate.
5. Lubricate both sides of the index plates with a light grease where contact is made. Place one half of the index plate on the stage with the index cam in one of the rectangular slots. Make sure the index ball and spring are in the hole in the stage. Place the other half of the index plate over the ball, locking the two halves together. Pull the measure cam holder down. Be sure the index cam goes through the slot in the flange of the measure cam holder.
6. Tighten the stage lock nut hand tight. Make certain the thread protector brass plugs are in the set screw holes of the lock nut. Rotate the measure cam holder until the back side of the measure cam touches the back up roller on the press head. Stage must be raised. Tighten the two set screws in the measure cam holder. (But not too tight) These prevent the measure cam holder from

turning. If tighten too tight the stage will bind on the center post.

7. Using the hex wrench as a lever in the set screws, tighten the stage lock nut. Operate the machine handle, rotate the index plate with the index cam, slowly, if the index plate jumps into position at the end of the cycle. Tighten down more on the measure cam holder. If you cannot move the index plate — loosen. After correct tension is obtained tighten one set screw in the stage nut.

8. Screw the primer ejection punch with the lock nut on it into the press head. Adjust until a shell will index without touching the punch. Lock in place.

9. At this time it is advisable to check the alignment of the press head with the stage. With the stage raised, the primer punch should center in the hole in the stage. If adjustment is required, loosen two set screws in the hub of the press head. Rotate the press head on the post to align the primer punch and stage. Tighten the two set screws. Make sure the press head is at the top against the retaining ring. Reset the measure cam holder (See Step #6).

10. Tighten the two lock nuts on the rocker arm cross stud connecting the links to the stage, these will work loose over a long period of time. Allowing the stage to be loose.

11. If the index plate does not move far enough, or too far, to seat a primer the timing is off. To adjust the timing push the handle all the way back. The cam follower roller against the index cam, rolls on an eccentric bushing. Loosen the hex head bolt. Rotate the eccentric bushing until the roller is against the index cam. If the adjustment is too loose the index plate will not index far enough. If it is too tight it will index too far. Tighten the hex bolt. The eccentric can be set at two different points for correct timing to seat a primer. However, if set with the eccentric hanging below the hex bolt, may cause the index to start too soon not allowing the shells to clear the primer ejection punch or the crimper body. When setting rotate the eccentric over the top of the hex bolt

letting the roller fall against the index cam. Hold the eccentric in place while tightening the hex bolt. Early Model M & MII do not have the eccentric adjustment, the cam must be tilted or the roller, eccentric and bolt replaced. List price \$1.95.

12. Screw the powder and shot drop tubes into the press head until they touch the cut off plates then back off one half turn. Lock in place with the $\frac{7}{8}$ " lock nuts.

13. The wad ram, with the $\frac{1}{2}$ nut on it, is screwed into the press head. Adjust to the wad column used in loading. Wads must be started far enough to clear the wad guide fingers before indexing. Lock in place with $\frac{1}{2}$ nut.

14. On 12, 16 and 20 gauge conversion kits, the wad pressure plunger button is changed on the wad pressure gauge. Screw the button out of the wad pressure plunger. These are right hand threads. See illustration in your instruction manual page 4. On 28 and 410 gauges the complete pressure gauge assembly is changed due to the smaller diameters required.

15. Screw the wad pressure gauge assembly into the press head. Be sure two, $\frac{3}{4}$ -16 lock nuts are on the body. To adjust for desired pressure place a shell filled with powder and wads in station 6. Pull the handle down. Read the gauge, the center of the cross pin aligns with line on the pressure gauge. Push the handle back to release the pressure on the gauge. Screw the gauge up to decrease pressure and down to increase pressure. Lock the pressure gauge in place with the $\frac{3}{4}$ -16 lock nut on top. If loading magnum loads the pressure plunger on the pressure gauge is exchanged with the hopper locating screw.

16. Screw the sizing die on to the pressure gauge as far up as possible. Place a shell case on the stage. Raise the stage to the top. Screw the sizing die down until the sizing die touches the brass on the shell base. Tighten the lower lock nut against the sizing die. DO NOT TRY TO SIZE THE BRASS part of the shell case.

17. Place new crimper in press head and adjust. Note: Old crimper plunger setting may be retained by screwing spring nut

(lower) up against plunger lock nut and then removing assembly by top nut.

18. Screw the crimper plunger into the press head until the plunger touches the cut off plate, then screw out one turn. NOTE: The 410 gauge requires the adapter nut be screwed into the press head first. Use a loaded shell to set the plunger to crimp depth. If you do not have a loaded shell, screw the plunger down one turn at a time crimping a shell until the desired depth is reached. Lock the plunger in place with the top nut. Adjust the spring tension with the lower nut, with the stage up tighten the adjust nut until the spring is fully closed, then back the nut off a turn at a time until desired crimp is obtained. Paper shells require less spring tension than plastic shells. If the shell is crushed the plunger is too low or there is too much wadding in the shell or spring tension is too tight. If the crimp folds overlap the crimp starter is set too low or wad column to high.

19. Change the powder and shot bushings for the load desired.

20. The crimp starter is not used on fired paper shells. When setting the crimp starter screw the stud into the press head as far as it will go then start a crimp on a shell. Screw the stud out until the shell is closed approximately half way. Setting the starter too low will cause the crimp to overlap.

PREPARATION FOR LOADING AND SETTING OPERATIONS

SELECTION OF BUSHINGS

Selection of the charge bushings are made from the bushing and loading tables. The powder bushings are stamped with a letter. Referring to the powder charge bushing table, the grain weight of powder is shown under each type of powder that each bushing will throw under normal operation of the Model M. Spaces left blank are loads not recommended.

The shot bushings are stamped with a number. Referring to the shot bushing table, the ounces of lead shot each bushing will throw are shown.

EXAMPLE:

Select the bushing to be used for your load by referring to the loading table. Example: To load a 12 gauge $2\frac{3}{4}$ shell with ballastic to equal 3 dram equivalent. Refer to the table for 12 gauge. Under Drams Equivalent column, look for "3." Reading across this line, this load requires $1\frac{1}{8}$ ounces of shot and 23 grains of Red Dot powder, or 20 grains of AL-101, or other types of powder can be used. Look at the shot bushing table. The shot bushing for $1\frac{1}{8}$ ounces of shot is number "4." Look at the powder charge bushing table. The powder charge bushing for 23 grains of Red Dot is the Letter "R." If you want to use 20 grains of AL-101 powder you would use powder charge bushing Letter "B."

INSERTING BUSHINGS

To change bushings:

Move the cut off plates into the "Off" Positions. Pull the handle forward so the bushings will be over the drop tubes.

Remove the snap buttons from the top of the hopper casting.

Remove the locating screw holding the hopper in position.

Rotate the hopper in a clockwise direction looking down on the top until the holes in the hopper casting are over the bushings.

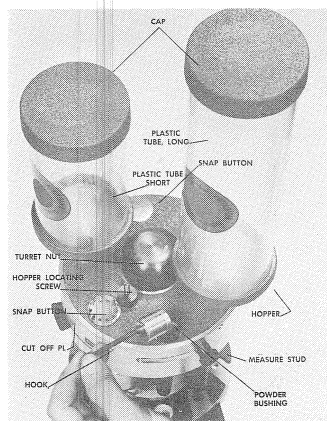
Place an empty shell under the powder drop tube.

Move the powder cut off plate to the "On" Position. This will empty the bushing and allow you to insert a hook to remove the powder bushing.

Place an empty shell under the shot drop tube.

Move the shot cut off plate to the "On" position. This will empty the shot bushing and allow you to insert a hook to remove the shot bushing.

Insert the bushings you have selected into the measure drum.



DOUBLE CHECK THE NUMBERS AND LETTERS TO BE SURE YOU HAVE THE CORRECT BUSHINGS. MAKE SURE THE BUSHINGS ARE CLEAN AND DRY.

Move the cut off plates to the "Off" position.

Rotate the hopper counterclockwise to the loading position and replace the locating screw and snap buttons.

Return the operating handle to the back position.

Fill the short hopper tube with powder.

Fill the long hopper tube with shot.

You are now ready to start loading.

To check the settings of the Texan Autoloader, work one shell case around the stage following the steps outlined.

LOADING AND SETTING OPERATIONS

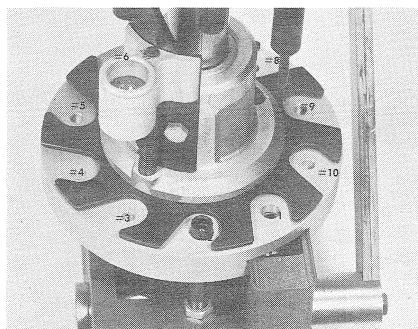
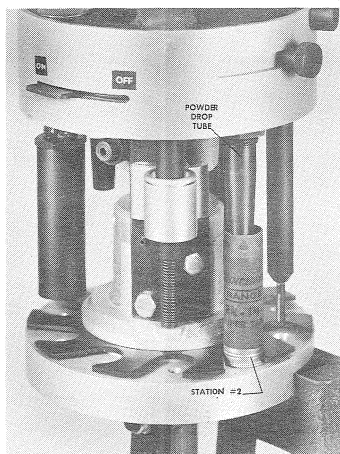
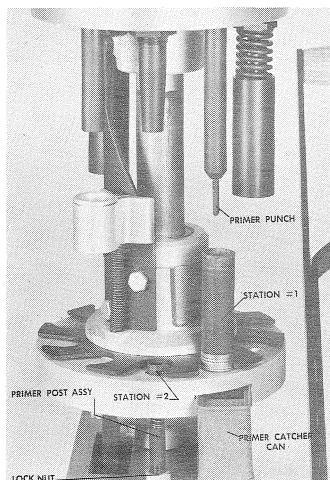
PRIMING — STATION #1

Place a shell case in the station under the primer punch. Pull the handle forward. The stage will rise and the primer punch will eject the battery cup primer. The can attached to the stage will catch the old primer. While the stage is up, place a new primer in the primer post cup, using the left hand. Push the handle back. The indexing cam will engage the index plate, rotating the case to the second station. On the back stroke of the handle the new primer will be seated in the shell case. On the first shell, check the seating of the primer by removing the shell case and looking at the primer. Shell cases can be removed at any station without indexing the turret. Screw the primer seating post up to seat the primer deeper. Screw it down if the seating is too deep. Lock the post in place with the lock nut. If the indexing plate will not index, check the primer ejection and seating. The primer may be hanging on the stage, preventing indexing.

LOADING POWDER — STATION #2

At the second station move the powder cut off plate to the "On" position. Pull the operating handle forward. The measure cam will cause the measure drum to rotate placing the powder bushing over the open drop tube loading one charge of powder. Push the handle back, indexing the shell to station number 3. Move the powder cut off plate to the "Off" position.

Watch the measure stud at the front of the press head. This is the indicator for the measure drum operation. It should return all the way to the left as the handle is moved back. If the measure drum sticks, loosen the set screw in the top nut. Remove nut and hopper. Loosen set screw in the adjust nut. Loosen the adjust nut until measure drum to rotate placing the powder bushing over the open drop tube loading one charge of powder. Push the handle back, indexing the shell to station number 3. Move the powder cut off plate to the "Off" position.



INSERTING WADDNG — STATION #3

Insert Wad Column: Use at least one nitro card over powder wad and one filler or cushion wad (fiber, felt, cork or plastic).

Insert this wad column in the wad guide, nitro card first, pressing down on the guide and the wad column so the wad guide is held down on the shellcase. Use the left hand. Pull the handle. This rams the wadding into the shell case.

The next stations, #4 and #5, are not used. Index shell through these stations.

To load plastic shot protector wads, the wad ram and the wad pressure gauge must be reduced in diameter to prevent pulling the wad up out of the shell case. Use .410 wad ram and .410 wad pressure gauge assembly on all gauge sizes of Shot Protector Wads.

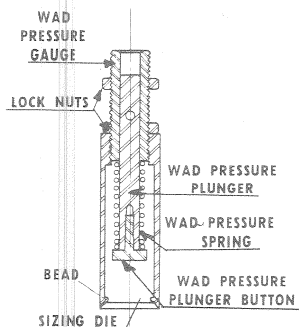
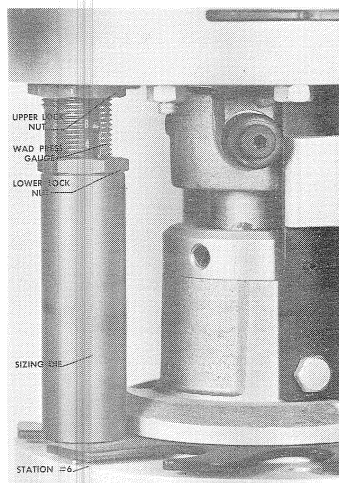
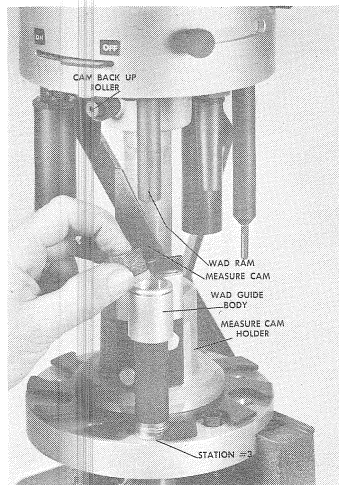
WAD PRESSURE AND SIZING — STATION #6

Wad pressure is applied and shell case is resized. To adjust wad pressure and set sizing die remove the sizing die by loosening the lock nut and unscrewing die. The wad pressure is adjusted at the factory using a 3/16" button on the plunger in the wad pressure station. This button is used for light loads and/or wad pressures of 80# or less. The hopper locating screw is also a wad pressure button 7/16" long that is used for heavy loads and/or wad pressures of 80# or more. If heavy loads or wad pressures are needed remove the 3/16" button and replace with the 7/16" button. The 3/16" button now becomes the hopper locating screw.

To adjust for desired pressure place shell with powder and wads loaded in Station #6. Pull handle down and adjust until scale reads desired pressure by turning left to increase pressure or turn right to decrease pressure.

Each line on the pressure gauge indicates 10#. The gauge requires 20# pressure to move and #4 on the gauge indicates 40# pressure, #8 indicates 80# pressure. One full turn of the gauge equals 10# in pressure change, 1/2 turn equals 5#. Each 1/16" change in the wad column without adjusting the gauge will change the wad pressure 10#.

With the pressure gauge correctly set for the pressure you need, replace die and adjust the sizing bead at bottom of die to just mark the brass with the handle down. This adjustment is changed when the height of brass is changed. Tighten lock nut. Do not try to resize the brass on the shell. Brass portion of shell case should be sized using the M II sizer attachment.



WAD PRESSURE GAUGE AND SIZING DI

LOADING AND SETTING OPERATIONS

LOADING SHOT — STATION #7

Shell case is at Station #7. Move the shot cut off plate to the "On" position. Pull the handle and the measure cam will cause the measure drum to move the shot bushing over the open shot drop tube, loading one load of shot in the shell case.

Measure the distance from the top of the shot to the top of the shell case. 12 Gauge shells should measure $9/16''$; 16 Gauge shells should measure $1/2''$; 20 Gauge shells should measure $3/8''$.

To change this measurement will require changing the wad column thickness. Add wadding to decrease this measurement. Decrease the wad column thickness to increase this measurement. You must reset the wad pressure and sizing die by the same amount. Repeat Step 5.

CRIMP STARTER

Station 8 is used for a crimp starter. This is required for new cases or plastic cases. New cases must be evenly folded the first time they are loaded to form a perfect Star crimp. Plastic cases must have the crimp started each time they are reloaded, as the plastic will not fold where it was folded before previously.

The crimp starter is an extra attachment.

CRIMPING — STATION #9

The complete crimping operation is performed at this station when using fired paper cases.

The crimper is adjusted by the manufacturer for an average depth crimp.

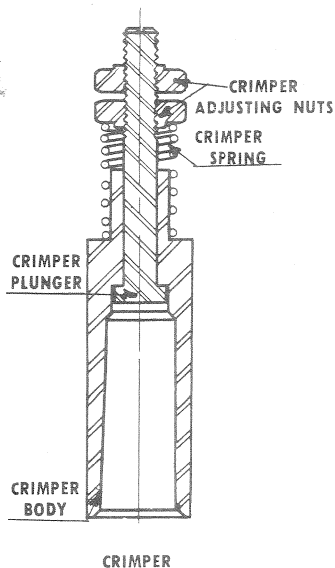
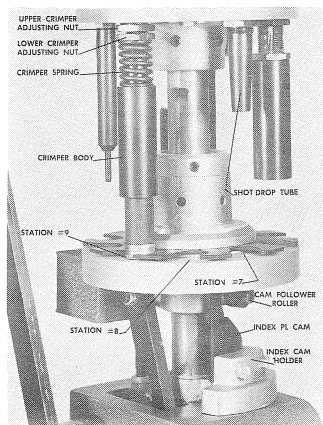
To work properly, the crimper body must contact the turret index plate before the spring closes more than $1/16''$ to $3/32''$. — Check this if trouble develops. Trouble can normally be cured by correcting wad column.

To adjust the crimp loosen lock nut and turn crimper to right for shallower crimp, to left for deeper crimp. Be sure the crimper plunger turns with the crimper body. Pull the handle down and adjust lower nut until the crimper spring is almost collapsed. This spring tension is necessary to maintain even crimps. Tighten top nut.

CAUSES OF VARIATION IN CHARGES

Moisture content of powder, Density of powder and shot, Size of shot, Inconsistent operation of loader and the method of operation can also cause variation in charges from those listed.

WE HAVE NO CONTROL OVER THE OPERATION OF THE TOOL, OF THE COMPONENTS USED, OR THE HANDLING OF SAME, WE ASSUME NO LIABILITY IN CONNECTION WITH THE USE OF THIS TOOL.



M II SIZER ADJUSTMENTS — STATION #10

The sizer for the Model M II can be adjusted in a matter of minutes. First, install the ejection cam. This is done by placing the cam in position at station 10 on the stage. Insert the ejection pin to hold it in place. Attach the bumper rod to the base and adjust it to clear the index plate when indexing. Attach the bracket by using the two hexagon head bolts; attach the pressure plunger to the bracket and attach the anvil in station 10 on the press head. Before attaching the sizing die holder, place a shell on the pressure plunger and pull down on the handle until you complete a full forward stroke.

CAUTION: During this adjustment DO NOT compress plunger spring completely, as damaging or breaking bracket may result. When loading low inside base wad hulls insert the spacer between your wad plunger and spring. When you have made this adjustment, lock it in place with the pressure plunger set screw and brass plug. Next attach the sizing die holder and the sizing die, place a shell in the sizing die, pull forward on the handle until you make a complete stroke. This may mean you need to make some adjustment in your sizing die holder. If you cannot make a complete forward stroke, your holder is too high. If you are not flattening the head of the case, your holder is too low. When you have the proper adjustment, lock in place with a hexagon lock nut. Align sizing die with the anvil by loosening hexagon screws that hold the bracket to the stage, align and retighten.

Now the Autoloader is set and checked. Each time you start to load drop two or three charges of powder and shot either by working the handle or by manually moving the measure stud left to right to establish uniform flow through the powder and shot bushings.

Put an empty shell case in Station 1. Pull the handle with the right hand, pick up primer with the left hand and insert into primer post cup. Push the handle back. The shell indexes to Station 2 and the primer is set. Move powder shut off plate to "On" position. Put empty case in Station 1.

Pull handle with right hand, pick up primer with left hand and put in primer post cup. As handle is pushed back, pick up the predetermined wad column with the left hand, insert it into the wad guide, pressing down on the guide and wad column so the wad will hold the wad guide on the shell case. The right hand picks up a new shell case and inserts it into Station 1.

Keep repeating these operations until the first shell is in Station 7. Move the shot cut off plate to "On" position. When the shell is loaded and in Station 10, remove the loaded shell.

Now with each operation of the handle you have a loaded shell. By repeating the operation the same way each time, a natural rhythm will develop which will allow you to increase speed with practice.

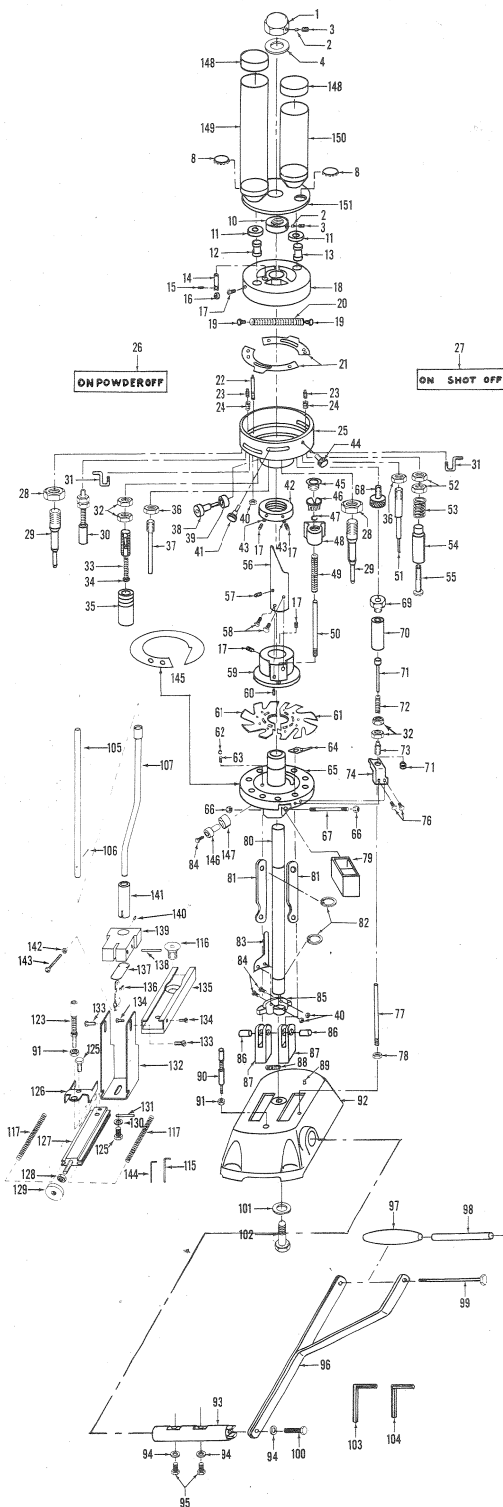
CAUTION: Never stop the handle half-way through an operation. Make full complete strokes forward and back. This will prevent jamming of the indexing plate and dropping of non-uniform powder and shot loads.

CLEARING MACHINE AND EMPTYING RESERVOIRS

When you have finished loading and want to clear the machine, keep pulling the handle, cut the powder off when Station 2 is empty, and cut the shot off when Station 7 is empty.

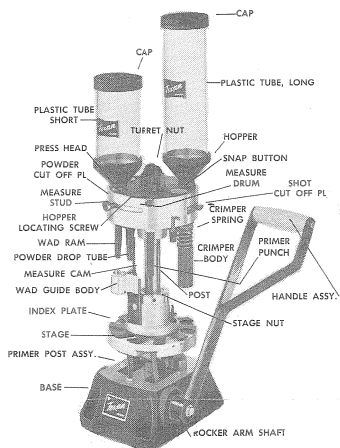
To empty the powder and shot tubes: Remove the hopper locating screw. Move the hopper counterclockwise so the tube of powder is over the powder drop tube. Replace the hopper locating screw. Place your powder storage container under the drop tube. Move the powder cut off plate to the "On" position. Use the Measure Stud or the operating handle to index the measure drum. All the powder will pour out the powder drop tube.

Place the shot storage container under the shot drop tube. Move the shot cut off plate to the "On" position. Index the measure drum. The shot will pour out the shot drop tube.



Key No.	Part No.	Description	Quan. Req.	Price Each
1.	192350	Turret Nut	1	3.00
2.		#2 Lead Shot	3	
3.	32510	Set Screw 10-32 x 3/16	3	.20
4.	192170	Turret Nut Washer	1	.35
8.	148740	Snap Button #1715-AC	2	.20
10.	192240	Lock Nut	1	1.25
11.	88980	Bronze Washer	2	.25
12.	88670	Powder Bushing (See Table)	1	1.00
13.	88660	Shot Bushing (See Table)	1	1.00
14.	148640	Roller Cam Follower Holder	1	1.75
15.	148650	Pin 1/4" x 7/16"	1	.20
16.	148630	Cam Follower Roller	1	.50
17.	148860	Set Screw 5/16-18 x 3/8 Cup Pt.	5	.20
18.	192160	Measure Drum	1	12.00
19.	148690	Spring Plug	2	.40
20.	148680	Measure Drum Return Spring	1	1.00
21.	148180	Cut Off Plate	2	3.00
22.	148590	Measure Spring Stop Stud	1	.25
23.	192370	Cut Off Pin	2	.25
24.	192390	Cut Off Spring	2	.20
25.	192150	Press Head	1	20.00
26.	148810	Powder Decal	1	.20
27.	148820	Shot Decal	1	.20
28.	192360	7/8-14 Lock Nut	2	1.00
29.	192230	Drop Tubes		
		Spec. 12,16,20,28,410 Ga.	2	2.25
30.		Crimp Starter		
		Spec. 12,16,20,28,410 Ga.	1	5.50
		Spec. 6 or 8 Point		
31.	192380	Cut Off Handle	2	.20
32.	148880	Locknut	3	1.00
33.	148550	Wad Pressure Gauge Assy.	1	7.00
34.	148870	Pressure Plunger Button		
		Spec. 12,16,20,28,410 Ga.	1	.75
35.	148370	Sizing Die		
		Spec. 12,16,20,28,410 Ga.	1	4.00
36.	157280	1/2-20 Jam Nut	2	.20
37.	192260	Wad Ram		
		Spec. 12,16,20,28,410 Ga.	1	1.25
38.	148620	Stripper Bolt	1	.60
39.	148610	Cam Backup Roller	1	.50
40.	191280	Nut 1/4-20 Jam Nut	3	.20
41.	148950	Measure Stud	1	1.25
42.	148520	Stage Nut	1	2.25
43.	101430	Brass Plug	2	.20
44.	148750	Pressure Plunger Extension Button		
		Spec. 12,16,20 Ga.	1	.75
45.	88340	Wad Guide Cap		
		Spec. 12,16,20,28,410 Ga.	1	1.00
46.	88350	Wad Guide Fingers		
		Spec. 12,16,20,28,410 Ga.	1	.75
47.	46420	8/32 x 1/4 Truss Head Screw	1	.20
48.	148170	Wad Guide Body		
		Spec. 12,16,20,28,410 Ga.	1	2.50
49.	148510	Wad Guide Spring	1	.60
50.	148280	Wad Guide Stop Rod	1	.75
51.	192290	Primer Punch	1	1.50
52.	148910	Crimper Adjusting Nut	2	1.00
53.	102280	Crimper Spring	1	.40
54.	148240	Crimper Body		
		Spec. 12,16,20,28,410 Ga.	1	4.50

REPLACEMENT PARTS



Key No.	Part No.	Description	Quan. Req.	Price Each
	101180	Rocker Arm Yoke	2	1.00
	148490	Index Cam Return Spring	1	.40
	48840	Dowell Pin 1/4" Dia. x 3/4"	1	.25
	18360	Primer Post Assy.	1	3.75
	88910	Nut 3/8-24 Hex. Hd. Jam	2	.25
	192110	Base	1	15.00
	12120	Rocker Arm Shaft	1	7.00
	15550	Washer 5/16 Flat	3	.20
	101190	Screw 5/16-18 x 1/2 Hex Hd.	2	.20
	148440	Handle Frame Assy.	1	3.00
	148420	Handle Grip	1	.60
	148430	Handle Grip Bushing	1	.40
	134230	Bolt 1/4-20 x 4 3/4 Hex Hd. Pl.	1	.20
	148890	Screw 5/16-18 x 1" Hex. Hd.	1	.20
101.	101510	Washer 5/8" Flat	1	.20
102.	101260	Bolt 3/8-11 x 2 1/2 Hex Hd.	1	.25
103.	101450	Hex Wrench 5/32"	1	.40
104.	33590	Hex Wrench 3/32"	1	.40
105.	172260	Primer Tube Straight	1	3.00
106.	121210	Cotter Pin 3-32 x 3/4	1	.20
107.	172230	Primer Tube Assy. Formed	1	4.00
115.	172490	Hex Wrench 7/32	1	.75
116.	172340	3/8-24 x 3/4 HD SK Cap	1	.75
117.	172160	Return Spring	2	.50
123.	172280	Primer Post Assy.	1	3.75
125.	226220	1/4-20 x 3/8 Hex Head Screw	2	.20
126.	226150	Slide Cam	1	4.00
127.	226120	Slide Assy.	1	3.50
128.	191280	1/4-20 Hex Jam Nut	1	.20
129.	226140	Slide Stop	1	1.00
130.	37580	1/4 Flat Washer	1	.20
131.	191170	3/16 Dia. x 1" Pin	1	.30
132.	226160	Bracket	1	4.00
133.	45260	8-32 x 1/4 Pan HD Screw	2	.20
134.	226250	6-32 x 5/16 Pan HD Screw	2	.20
135.	226110	Base	1	4.00
136.	226180	Drop Arm Assy.	1	3.00
137.	226190	Drop Arm Spring	1	.40
138.	31560	1/8 x 7/8 Rollpin	1	.20
139.	226170	Drop Head	1	5.00
140.	34540	8-32 x 3/16 SOC Set Screw	1	.20
141.	226210	Primer Tube Socket	1	1.30
142.	12530	8-32 Hex Nut	1	.20
143.	226230	8-32 x 1 1/8 R Fil HD Scr.	1	.20
144.	34550	5/64 Hex Wrench	1	.40
145.	197440	Stage Plate 410 & 28 Ga.	1	5.00
146.	192420	Index Cam Eccentric	1	1.00
147.	192430	Index Cam Roller	1	.75
148.	219140	Cap	2	1.50
149.	192460	Plastic Tube 2 3/4 x 10	1	2.10
150.	192450	Plastic Tube 2 3/4 x 6	1	1.25
151.	192440	Hopper 2 3/4"	1	13.50
152.	221550	Shell Mouth Spreader Assembly (Specify Gauge)	1	2.00

Minimum Parts Order

\$2.00 Each Order

When Ordering Parts
From the Factory, Add \$1.00
for Postage and Handling

All Prices Subject to
Change Without Notice

Key No.	Part No.	Description	Quan. Req.	Price Each
55.	148410	Crimper Plunger Spec. 12,16,20,28,410 Ga.	1	1.25
56.	148230	Measure Cam	1	4.00
57.	172330	Roll Pin 1/8 x 3/8	1	.20
58.	134310	Screw 1/4-20 x 1/2 Hex Hd. Pl.	2	.20
59.	148350	Measure Cam Holder	1	7.50
60.	121160	Roll Pin 3/32 x 7/16	1	.20
61.	192140	Index Plate Set (2) Spec. 12,16,20,28,410 Ga.	1	5.00
62.	101210	Ball 5/16" Round Steel	1	.20
63.	101394	Index Spring	1	.20
64.	193130	Ejection Cam Spec. 12,16,20,28,410 Ga.	1	2.50
65.	192320	Stage — Spec. 12,16,20,28,410 Ga.	1	20.00
66.	148850	Nut 3/8-24 Hex Elastic Stop	2	.20
67.	148270	Rocker Arm Cross Stud	1	.75
68.	193170	Anvil	1	2.00
69.	193210	Sizing Die Ring Spec. 12,16,20,28,410 Ga.	1	2.50
70.	193120	Sizing Die Holder	1	4.00
71.	193180	Pressure Plunger Assy. Spec. 12,16,20,28,410 Ga.	1	.75
72.	148570	Spring	1	.70
73.	193150	Bushing	1	.75
74.	193110	Bracket	1	2.25
76.	134310	1/4-20 x 1/2 Hex Head Screw	2	.20
77.	193260	Bumper Rod	1	.50
78.	41540	1/4-20 Nut	1	.20
79.	148530	Primer Catcher Can	1	.50
80.	148250	Post	1	12.00
81.	148190	Link	2	1.00
82.	148580	Retaining Ring #5100-118	2	.20
83.	148220	Index Plate Cam	1	4.00
84.	47260	1/4-20 x 1 Hex Head Screw	3	.20
85.	148340	Index Cam Holder	1	5.50
86.	101130	Dowell 3/8 Dia. x 7/8	2	.20

Texan

TOLOADER

TION AND MAINTENANCE

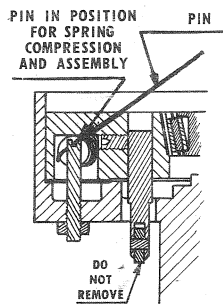
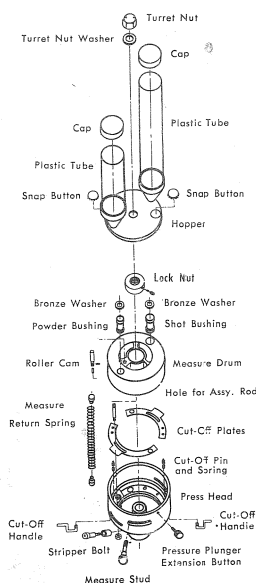
Proper lubrication will insure long life and ease of operation — A few drops of oil or grease should be applied to the moving surfaces as needed. After one or two rounds of loading normally. The measure drum will require adjustment and/or cleaning if the measure drum sticks or jams. Often slight adjustment of the nut on top of measure drum will cure the trouble. If measure drum continues to hang, clean press head thoroughly.

To Disassemble:

1. Empty shot and powder hoppers. Remove hopper locating screw and measure stud.
2. Remove nut on top of hopper. Loosen set screw in nut before attempting to unscrew.
3. Lift hoppers from machine.
4. Remove lock nut and lift out measure drum.
5. Unscrew locknut and spring stop directly above station #4.
6. Cut off plates can be lifted out.
7. Clean and lubricate.

To Assemble:

1. Be sure the cut off plate indexing pin and springs are in place.
2. Replace cut off plates.
3. Replace spring stop.
4. Place measure return spring in measure drum — compress spring past hole — insert small pin or nail in hole to keep spring compressed.
5. Place drum in head — replace measure stud and remove pin.
6. Replace other parts.
7. Tighten lock nut until measure drum will not move freely — Then back nut off until measure drum is just free.
8. Tighten set screw in turret nut — Check measure drum to be sure it returns freely.



Form 148770 Rev. 7-67

Texan Reloading Equipment

ROTEX MANUFACTURING COMPANY

8222 CHANCELLOR ROW • DALLAS, TEXAS 75247