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.

Press includes Breech Lock bushings, leave them in place or order more for quick change convenience. Lee Breech Lock Bushings work perfectly with Lee dies, other brands work better with the Lock-Ring Eliminators.

Unable to index? Verify driver clutch is installed.

Install driver clutch when no shell plate is installed.

Install driver clutch when shell plate is installed.
Mount your press. 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. Or, purchase (3) 1/4” bolts and nuts and prepare your workbench for use with this press using the drill template provided on the quick start guide attached to your press.

# 90251 Bench Plate

**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 and ram pin every few thousand rounds.

**SETUP TOOLS REQUIRED**
- Safety glasses & ear protection
- 1/2” socket or wrench
- Phillips screwdriver

**HELPFUL SETUP VIDEOS**
Open camera application on smartphone or tablet, hover over the QR code for a direct link to help video.

**STEPS 1-6 BELOW ARE COVERED IN QUICK-START GUIDE ATTACHED TO YOUR PRESS**

1. Mount your press. 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. Or, purchase (3) 1/4” bolts and nuts and prepare your workbench for use with this press using the drill template provided on the quick start guide attached to your press.

2. Re-position handle, tighten securely with 1/2” wrench.

3. **INSTALL shell plate**
   - Remove Lock-Ring Eliminator
   - Remove index rod and case ejector.
   - Raise carrier to the mid-stroke position, install shell plate, lightly tighten clockwise with 1/4” hex head wrench.

4. With the carrier at the bottom of the stroke (handle up), install index rod.

5. Install lock-ring eliminator.

6. Install case ejector.

7. Push case retainer against case rim in each shell plate position.
TOOL HEAD POSITION & INITIAL SETUP

Position 2 = Powder Through Expanding Die or Rifle Charging Die
Lower the lever, the case will rise into the powder charging/pistol expanding station to dispense a charge.

Prime
With clean fingers, place the correct size and type of primer into the primer guide. Or dispense primer using the OPTIONAL Lee Safety Prime primer feeder (never touch the primer from box to shell). Raise the lever, seat the primer to flush to slightly below flush of the case head.

Position 3 = Bullet Seating Die
Put a loose bullet on top of the case mouth. Lower the lever, this will raise the case into the bullet seating/crimping die to seat the bullet.

Position 4 = Factory Crimp Die
Firmly crimps your bullet in place and will give your round factory like feed and dependability.

Position 1 = Size
IMPORTANT
Verify this die is installed as follows: Screw the die in until it touches the shell plate. Lower the ram, and screw die in 1/3 turn more.

If you haven’t reloaded before, we suggest you start out using the Auto Breech Lock Pro as the world’s most convenient single station press. Simply install your sizing die in position one and you’re ready to go. Keep your right hand on the roller handle, cycle the lever to the bottom of the stroke. Pick up a case with your left hand and drop it into the case feed hole next to position one, grab a single primer and place in the primer cup. Raise the lever and the case will be slid into the shell plate and the primer will be seated at the bottom of the stroke (lever up). Lower the lever and the case will enter the sizing die. Drop another case into the case feed hole another primer in the primer cup and repeat the cycle.

You can also operate as you would a Lee turret press and produce a complete round with four cycles of the lever. Install the 3 or 4 dies in the press as shown above. Drop an empty case into the feed hole and cycle the lever four times. A single case will advance through the four stations. You will insert a primer in the priming die, dispense a powder charge into the powder through expanding die, place a bullet into the flared case and cycle the lever a forth time to Factory Crimp and automatically eject the finished round.

With a die in every position, you can use the press as a full progressive by simply placing a case in the feed hole every cycle of the lever. Because each station performs one operation, every time you cycle the lever you produce a finished round. If you operate the lever at a leisurely 10 seconds per cycle that is 360 rounds an hour.
To convert the Auto Breech Lock 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 SETUP

<table>
<thead>
<tr>
<th>CARTRIDGE</th>
<th>SHELL PLATE</th>
<th>SHELL PLATE PRODUCT #</th>
<th>PRIMER ARM</th>
<th>UNIV. CASE FEED PLATE SIZE</th>
<th>UNIV. CASE FEED SLIDER BLOCK</th>
<th>RELOADING DIES</th>
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N/A = Not available  
LUBE REQ. = # 90006 LEE resizing lubricant required

**Assembled as a SMALL feed plate**

Bolt and nuts are adjacent to small through hole and the small plug.

**Assembled as a LARGE feed plate**

Small plug removed

Storage spot for small plug

Storage spot for universal case feeder, accessory sold separately # 90242
Case feeding, primer feeding, powder measuring and bullet feeding can be automated with the addition of optional Lee accessories.

INSTALLING Universal Case Feeder, accessory sold separately # 90242

This accessory will greatly simplify progressive reloading placing a case every time the press is cycled. The case slider block is already on your press. Longer cases will require you to attach the riser to the case slider block. All you need to do is install the feed plate configured for the case that you will be loading.

A. See chart on page 4. Some cases require riser to be installed on top of case slider block.

B. See chart on page 4. Install the correctly configured feed plate (large or small) keeping the bottom of the case feed plate a pennies thickness above the case mouth. Slide a case through feed plate. Place penny on top of the case, slide feed plate into carrier.

C. The 4 tube feed plate should be a penny’s thickness away from the tool head casting. Verify a coins thickness away from body.

D. Secure the feed plate with a nut above and below the carrier slide rail. Tighten 7/16” nuts under and above carrier.

E. Consider the case collator product # 90667 fill all four case feed tubes in as little as 10 seconds.

INSTALLING Safety Prime, accessory sold separately # 90997

Dispenses primers with a push of the button. Works with all brands of primers and you never have to handle the tiny primers. Fill the tray in seconds rather than filling a tube one at a time like other brands.

A. Install the triangular shaped bracket as shown. Rotate the bracket left to right to best align the trigger and trough with the primer arm.

B. With the carrier at the top of the stroke (lever down) swing the primer trough into the primer arm and push the trigger. Be sure you install the correct primer arm (large or small) and that you have selected the correct trigger assembly (large or small).

IMPORTANT
Only use the Safety Prime manufactured after June 2017. This version can be identified by the light gray color and serrated trigger.
INSTALLING Automatic Powder Dispenser accessory

For volume reloading, nothing beats a Lee Auto-Drum or Pro Auto-Disk or powder measure. Either of these automatic powder measures will dispense a powder charge through the Lee powder through expanding die. They are automatic and will only dispense a powder charge if they are activated by a case.

A. If you are using the pull back feature on the Auto-disk or the disconnector reset feature on the Auto Drum, the chain is installed through this lug.

Auto-Drum Powder Measure # 90811
Pro Auto-Disk Powder Measure # 90429

INSTALLING Automatic Bullet Feeder accessory

RECOMMENDED FOR ADVANCED USERS ONLY. Incorrect use will be a frustrating experience.

LEE BULLET FEEDER OPTIONAL
Automatically feeds bullets into the mouth of the seating die. Aligns bullets more accurately than possible by hand. Increases cyclic rate 50 to 100%.

A. Remove and discard attach plate # BF3418 from bullet feeder assembly using qty. 2, 3/8” wrenches.

B. Install damper and spring into carrier cover. Slide buffer on action rod (fits tightly). Re-tighten buffer and damper with 3/8” wrench.

C. Move Lock-Ring Eliminator from position 4 to position 1. Reset your sizing die in accordance with the die instructions and leave the lock-ring off. Install and set Factory crimp die in position 4, leave on lock-ring.

D. Install action rod into feeder link. Use end hole as shown.

E. Install bullet seating die and feeder assembly into position 3.

Die attach plate should be mounted at the 11 o’clock position. This will place action rod in a vertical position.

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.