Set up swage holder with correct swage punch and shell holder.

1. Unscrew swage cap over a clean table top and lift off swage holder.
2. Remove shell holder adapter, spring and swage pin and die spring assembly.
3. Install appropriate swage holder (small/large) in APP base casting. Secure with wrench.
4. Lower the press lever and screw the swage push punch in until it meets the small or large swaging punch.
5. Place a case that you wish to swage in the shell holder. Lower the press lever, notice that the connecting link will not meet the stops on the upper casting (PHOTO 1 & 2). Release the pressure on the press lever and unscrew the push rod in ¼ turn increments until the connecting links meet the stop with 25 pounds of pressure applied to the lever. Continue to unscrew the swage push punch in ¼ turn increments until the connecting links meet the stop with 25 pounds of pressure applied to the lever. When you have it set, lower the lever, and tighten the knurled lock nut.
6. Re-install swage cap, finger tighten.
7. Do not install o-ring if using X-PRESS shell holders. If using a universal press shell holder, install O-ring to prevent shell holder rotation. The X-PRESS shell holders need to be able to float/rotate to allow damaged or out of round rims to pass through without interference.

The best way to determine if you have sufficient swage on the primer pocket is to try seating a primer. If the primer starts and seats properly you have sufficient swage. As the tool is designed, it is impossible to swage excessively. If you misadjust the push punch too deeply, the only consequence is the press lever will be very difficult to push to the stops. Adjusting to apply the least amount of swage to allow easy seating of primers will make the tool more pleasant to use.