**Setup Tools required:**
- Safety glasses & ear protection
- ½” wrench or socket
- Qty. 2, ¾” wrench
- # 1 Phillips screwdriver
- ¾” Hex Wrench

**Optional Accessory:**
- CASE COLLATOR # 90667

**Helpful setup & operation videos available on leeprecision.com**

**Lee Precision, Inc.**
4275 Hwy. U
Hartford Wisconsin 53027
www.leeprecision.com

**PRO 1000 3 STATION RELOADING PRESS COMPLETE INSTRUCTIONS**

**Setup & Operation videos available on leeprecision.com**

**Case Feeder Tubes (4 Included)** (7-PACK) # 90661
**Turret # 90497**
**Action Rod # TR2438**
**Folding Primer Tray (1 Included)**
**Folded Primer Tray (2-Pack) # 90696**
**Shell Plate Carrier # TR3975**
**Base Casting # TR3642**

**Optional Accessory:**
- CASE COLLATOR # 90667

**Pro Auto-Disk Powder Measure**

- Primer attachment # 90650
- Folding Primer Tray (1 Included) (2-Pack) # 90696
- Shell Plate Carrier # TR3975
- Base Casting # TR3642

**Optional Accessory:**
- RELOADING STAND # 90688

**Configuration:**

- **Ram Pin # OF3221**
- **Ram STP® motor oil treatment works well**
- **Link bolt**
- **30 & 32 cal. Bullets up to .60 long # 90892**
- **9mm to .365 diameter up to .46 long # 90893**
- **9mm to .365 diameter .46 to .60 long # 90894**
- **9mm to .365 diameter .60 to .75 long # 90895**
- **40 cal. through .44 cal. up to .65 long # 90896**
- **40 cal through .44 cal. .65 to .80 long # 90897**
- **45 cal. Bullets .50 to .67 long # 90898**

- **Primer Disposal Tube # BP3064**
- **Primer Cap # BP3127**
- **1/3 Hex Washer # OF3609**
- **1 1/4 Bolt # FO2113**
- **1/3 Nut # FB1181**

**Lubricate these points often, household oil works well:**
- Link bolt
- Ram pin

**Rust proof these points often:**
- Turret ring
- (3) Columns
- Handle & lever clamp

**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.

**DANGER**

- Ammunition reloading can be dangerous if done improperly and can result in serious injury or death.
- Reloading rifle ammunition requires extra care due to extremely high pressures. Make sure your cases are in good condition. Inspect them before each reloading for damage and wear. Cases must be trimmed. An excessively long case will pinch the bullet in the end of the rifle chamber and cause dangerously high pressure that could damage your gun and cause personal injury.
- Use only Remington™ or CCI™ primers. Other brands like Federal™, can explode with sufficient force to seriously injure the user or persons nearby. Never place more than 100 primers in the tray.
- Reloading should not be attempted by persons not willing and able to read and follow instructions exactly. Do not permit distractions while loading. This is a complex machine that needs your fullest attention.
- 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 powder, like gasoline and matches, can be dangerous if improperly handled or misused.
- Verify proper powder and charge for bullet weight selected.
- Be extremely careful to avoid a double charge. If in doubt, empty the case and recycle it.

**CAUTION**

- Ammunition reloading can be dangerous if done improperly and can result in serious injury or death.
- Reloading rifle ammunition requires extra care due to extremely high pressures. Make sure your cases are in good condition. Inspect them before each reloading for damage and wear. Cases must be trimmed. An excessively long case will pinch the bullet in the end of the rifle chamber and cause dangerously high pressure that could damage your gun and cause personal injury.
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**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.
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 (qty. 3) ¼” bolts and nuts and prepare your workbench for use with this press using the drill template available: leeprecision.com/files/instruct/PROVTP.pdf

For added convenience in catching completed rounds, consider the bin and bracket # 90687.

Attach the handle with clamp assembly.

Raise the retaining ring and slide the primer collection tube assembly into the ram. Slide retaining ring on to assembly.

[FIG 2] Snug bolt with a 1/2" socket or wrench, tighten securely to 25 ft/lbs. minimum.

[FIG 3] Slide in the roller handle into the lever clamp assembly, make sure the handle passes completely through as shown.

[FIG 4] Snug bolt with a 1/2” socket or wrench, tighten securely to 25 ft/lbs. minimum.

[FIG 1] [FIG 2] [FIG 3] [FIG 4]

IMPORTANT: Using 1/2” socket or wrench, tighten securely to 25 ft/lbs.

SAFETY CONSIDERATIONS

- Use only Remington™ or CCI™ primers. Other brands, especially Federal™, can explode with sufficient force to seriously injure the user or persons nearby. Never place more than 100 primers in the tray.
- 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.

DRY RUN (NO PRIMERS, POWDER OR BULLET)
Cycle the lever up and down to confirm the shell plate is advancing correctly.

TURRET POSITIONS
Never adjust dies in position # 2 or # 3 to contact the shell plate, or damage to the shell plate carrier will occur.

Powder Through Expanding Die or Rifle Charging Die

Bullet Seat and Crimp Die

Shell Plate Carrier

Should the shell plate get out of time, disengage the ratchet by raising the shell plate carrier 1/4” and advance the shell plate by hand.

SAFETY CONSIDERATIONS

- Oil ram using STP™ motor oil treatment. Using any oil, lubricate link bolts and ram pin every few thousand rounds.
- Don’t let the primer level fall below the tray level. Running out of primers will cause a jam.
- 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.
- Polish the chute with steel wool and wax or Lee Resizing Lubricant to help loaded rounds slide into your container.

SMOOTH OPERATING TIPS

- Oil ram using STP™ motor oil treatment. Using any oil, lubricate link bolts and ram pin every few thousand rounds.
- Don’t let the primer level fall below the tray level. Running out of primers will cause a jam.
- 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.
- Polish the chute with steel wool and wax or Lee Resizing Lubricant to help loaded rounds slide into your container.
Loosen the black knurled adapter on the powder measure and orientate the measure so the pull back lever aligns with the shell plate carrier hole, then tighten the knurled adapter.

[FIG 10] Attach end bell 5 beads from the end of the chain. Place the buffer spring on top of the end bell. Feed the chain through the hole on the shell plate carrier. With the shell plate carrier in the down position, thread the chain through the outer-most hole in the Pro Auto-Disk actuator lever. Raise the shell plate carrier slightly and pass one additional bead through the hole. Lower shell plate carrier, the chain should be taut. Pass the remaining chain through the inner most hole of the Pro Auto-Disk actuator lever. The case will actuate the powder measure and the bead chain will return the powder measure for the next charge. Consult your powder measure instructions and reloading die instructions for setting the charge.

Spin the lock-ring up to the top of the die and unscrew the adjusting screw out five full turns. Put the press lever in the up position (shell plate carrier down). Place a loaded round that you wish to duplicate in turret position # 3. [FIG 11] Raise the shell plate carrier to the top of its stroke and hold (shell plate carrier up). Screw the bullet seating die in until it stops turning, lower the shell plate carrier slightly, thread die in an additional 1/8 turn. Finger tighten the lock ring. Now raise the shell plate carrier to the top of its stroke, screw the bullet seating adjusting screw in until you feel it touch the tip of the bullet.

Consult your powder measure instructions and reloading die instructions for setting the charge on your Auto-Drum instructions pg. 2
Fill the primer feed tray. View help video here for loading primers into tray: leeprecision.com/pro-1000-help-videos.html

Don’t let the primer level fall below the tray level. Running out of primers will cause a mess inside your shell plate carrier. Once the last primer has exited the folding tray, replenish the primer supply, else you will load cases without primers.

DANGER: Use only CCI™ or Remington™ brand primers. Other brands, especially Federal™, can explode with sufficient force to seriously injure the user or persons nearby.

ALL PRIMERS ARE DANGEROUS and it should be anticipated that the primers in the tray could explode through accident, misuse or spontaneously. Should an explosion occur, our tests have demonstrated that safety glasses will normally prevent serious injury to the user if CCI™ or Remington™ primers are used, because the explosion is minimal. Other primers, however, can explode with sufficient force to seriously injure the user, or persons nearby. We do not take any position with respect to the quality of performance of primers available on the market. However, ONLY those primers manufactured by CCI™ or Remington™ are recommended for use in the Pro 1000—and when loading those primers—safety glasses and hearing protection must be used. NO OTHER PRIMERS should be used with the Pro 1000.

**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.
Before attaching the 4 tube case feeder, place an empty case in front of the case slider. Process 50-100 cases until you have the feel of the entire reloading sequence. Be sure to measure your completed ammunition to verify it is the correct overall length and will chamber in your firearm.

**IMPORTANT:** the primer is seated during the last inch of lever travel. Make a conscious effort to feel the primer enter and fully seat into the case. Incomplete primer seating will not allow the case to eject from the shell plate. This seems to be the biggest problem for first time users. A loose shell plate carrier socket head screw may prevent proper seating of primers.

**12 Install the case slider block and feed plate**

Remove slider block from carrier tongue by unscrewing the Phillips screw on the riser and releasing the spring. Raise the shell plate carrier to the top of the stroke. [FIG 12] Insert case on carrier tongue. Place a coin on top of the case. Slide feed plate assembly into the carrier hole, and adjust the top nut so that the bottom of the feed plate assembly rests on top of the coin. Tighten the nuts using two 7/16” wrenches.

[FIG 13] Re-install slider block and/or riser as shown. Screw with spring goes in rear hole. Install 4 clear case feed tubes and load with cases.

### Troubleshooting

<table>
<thead>
<tr>
<th>Problem</th>
<th>Cause</th>
<th>Remedy</th>
</tr>
</thead>
<tbody>
<tr>
<td>Primers not fully seated</td>
<td>Operator not lifting hard enough</td>
<td>Learn to feel the primer seating when the lever is pushed up.</td>
</tr>
<tr>
<td>Shell plate carrier not fully seated, or loose on ram</td>
<td>Loose socket head cap screw and force shell plate carrier on the ram. Re-tighten clamp screw.</td>
<td></td>
</tr>
<tr>
<td>Obstruction to full travel</td>
<td>Check for primer on base or under shell plate carrier. Carrier should contact the base with no case in the shell holder.</td>
<td></td>
</tr>
<tr>
<td>Primer doesn’t feed onto priming punch</td>
<td>Oil or gunpowder in trough</td>
<td>Remove all oil with solvent or blow out powder or dust with compressed air.</td>
</tr>
<tr>
<td>Primer trough not full</td>
<td>Primer trough not full</td>
<td>Always keep primer trough full.</td>
</tr>
<tr>
<td>Primer doesn’t enter case</td>
<td>Primer crimp not removed</td>
<td>Ream or swage primer pocket.</td>
</tr>
<tr>
<td></td>
<td>Wrong size primer</td>
<td>Caution, some 45 ACP cases now have small primer pockets</td>
</tr>
<tr>
<td>Tipped primers</td>
<td>Case not fully in shell plate</td>
<td>Clean shell plate. Check tension finger. Straighten or replace tension finger as required.</td>
</tr>
<tr>
<td>Spilled powder in primer trough</td>
<td>Clean powder out with compressed air.</td>
<td></td>
</tr>
<tr>
<td>Cases don’t eject</td>
<td>Primers not fully seated</td>
<td>See “Primers not fully seated” problem above.</td>
</tr>
<tr>
<td></td>
<td>Cases wedge against ejector pin</td>
<td>Move ejector pin to other side of screw.</td>
</tr>
<tr>
<td>Case feeder doesn’t work properly</td>
<td>Case feed spring in wrong case slider hole</td>
<td>See case feed spring orientation photo below. Spring should be installed into rear hole.</td>
</tr>
</tbody>
</table>
CHANGING THE SHELL PLATE CARRIER
Remove turret, primer tray, z-bar and case slider block.

A. Loosen 3/16” socket head screw. Place wood block under carrier and pull up on handle to lower ram.
B. Lower carrier so carrier pin passes through shell plate to prevent shell plate from rotating.
C. Remove the trough and priming pin and clean out any accumulated primer dust or powder. Install correct (small or large) primer trough and primer pin before installing a new shell plate.
D. Install shell plate and tighten the drive bolt by rotating the action rod counterclockwise. Re-adjust the zero index as explained under “Zero Adjustment” below.

ZERO ADJUSTMENT FOR SHELL PLATE INDEXING
Raise and lower the shell plate carrier, if the alignment pin does not pass through the shell plate it is out of index. Raise and lower the shell plate carrier again. Rotate the Phillips adjusting screw clockwise until the shell plate snaps into position. If the alignment pin is projecting through the shell plate, your index is set. Do not continue to rotate the screw, you’ll strip out the ratchet gear.

Proper index, alignment pin passes through shell plate

CHANGING THE SHELL PLATE CARRIER
With your case slider block removed, and shell plate carrier at mid-stroke position, loosen Phillips screw that holds the case ejector and remove ejector.

A. Do not lose it!
B. Loosen the drive bolt by rotating the action rod clockwise with a 1/4” nut driver.

CHANGING SHELL PLATE ONLY
With your case slider block removed, and shell plate carrier at mid-stroke position, loosen Phillips screw that holds the case ejector and remove ejector.

A. Do not lose it!
INSTALLING THE SHELL PLATE CARRIER

The carrier is attached to the ram with a single socket head screw. This makes it very easy to change the entire carrier for caliber changing.

A. Push the action rod through the carrier from the bottom side until the end slightly protrudes through the top. Be sure the twisted end is down.

B. Be sure to keep the primer trough pin behind the right rear column. Push the assembly onto the ram’s end.

C. Re-install turret with dies and raise your carrier to completely seat it on to the ram. Tighten the carrier socket head screw with a 3/16” hex wrench.

SHELL PLATE PARTS LIST

When changing calibers that use a different primer size, we recommend changing the entire shell plate carrier. If caliber uses the same primer size, you can easily change just the shell plate.

TR2139 1/4 –20x1/4 Bolt
FO1770 #8 - 32 x ¼” Screw
FT1781 #8-32 x ¼” Screw
TR2439 Gear Plate
TR2433 Detent Ball
TR3742 Index Spring
TR2431 Drive Bolt
TR2443 Tension Fingers
(2 installed, 2 spares)
90108 Hex Ratchets (1 installed, 2 spares)
TR2432 Ratchet Gear
TR2164B Primer Trough, Large
TR2164C Primer Trough, Small
90606 Folding Primer Tray (2-pack)
TR2436 Primer Pin, Large
TR2437 Primer Pin, Small
TR2479 Primer Spring
TR2442 Case Ejector Pin
(1 installed; 1 spare)
FT1781 #8-32 x ¼” Screw
TR2435 ¼ x 20 x ¾ Socket Head Screw
TR2550 Sensor Bushing
FT1940 Sensor Screw
TR2548 Case Sensor
CHANGING CARTRIDGE SETUP

To convert the Pro-1000 from a one cartridge to another, you will need the proper shell plate, primer trough and primer pin (# 90660 primer attachment), and appropriate Lee reloading die set. The chart below shows proper configuration with catalog numbers. Identify your current press configuration by cartridge. The chart will list which components shipped with your press (primer feed, shell plate). Then check the cartridge you wish to load, to see which components match with your current press configuration. Order any components that do not match (primer feed and shell plate).

<table>
<thead>
<tr>
<th>CARTRIDGE</th>
<th>SHELL PLATE</th>
<th>SHELL PLATE</th>
<th>PRIMER FEED</th>
<th>FEED PLATE</th>
<th>SLIDER BLOCK</th>
<th>RELOADING DIES</th>
<th>CHARGING DIES</th>
<th>POWDER MEASURE</th>
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<tbody>
<tr>
<td></td>
<td>NUMBER</td>
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<td>FEED HOLE SIZE</td>
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N/A = Not available  LUBE REQ. = # 90006 LEE resizing lubricant required  PRO AUTO-DISK # 90429  AUTO-DRUM # 90811

PREVIOUS PRO 1000 OWNER?

Your previously purchased shell plates will work on this new press if they have three through holes, and your carrier is the “NEW” version.

Assembled as SMALL feed plate

To utilize your old shell plates, your press alignment pin must be removed. Remove the press from your bench, use a plastic mallet and drive the pin through the base.

OLD

NEW

Assembled as LARGE feed plate

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

storage spot for small plug

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.