

Dillon Square Deal 'B'

Instruction Manual

November 2009



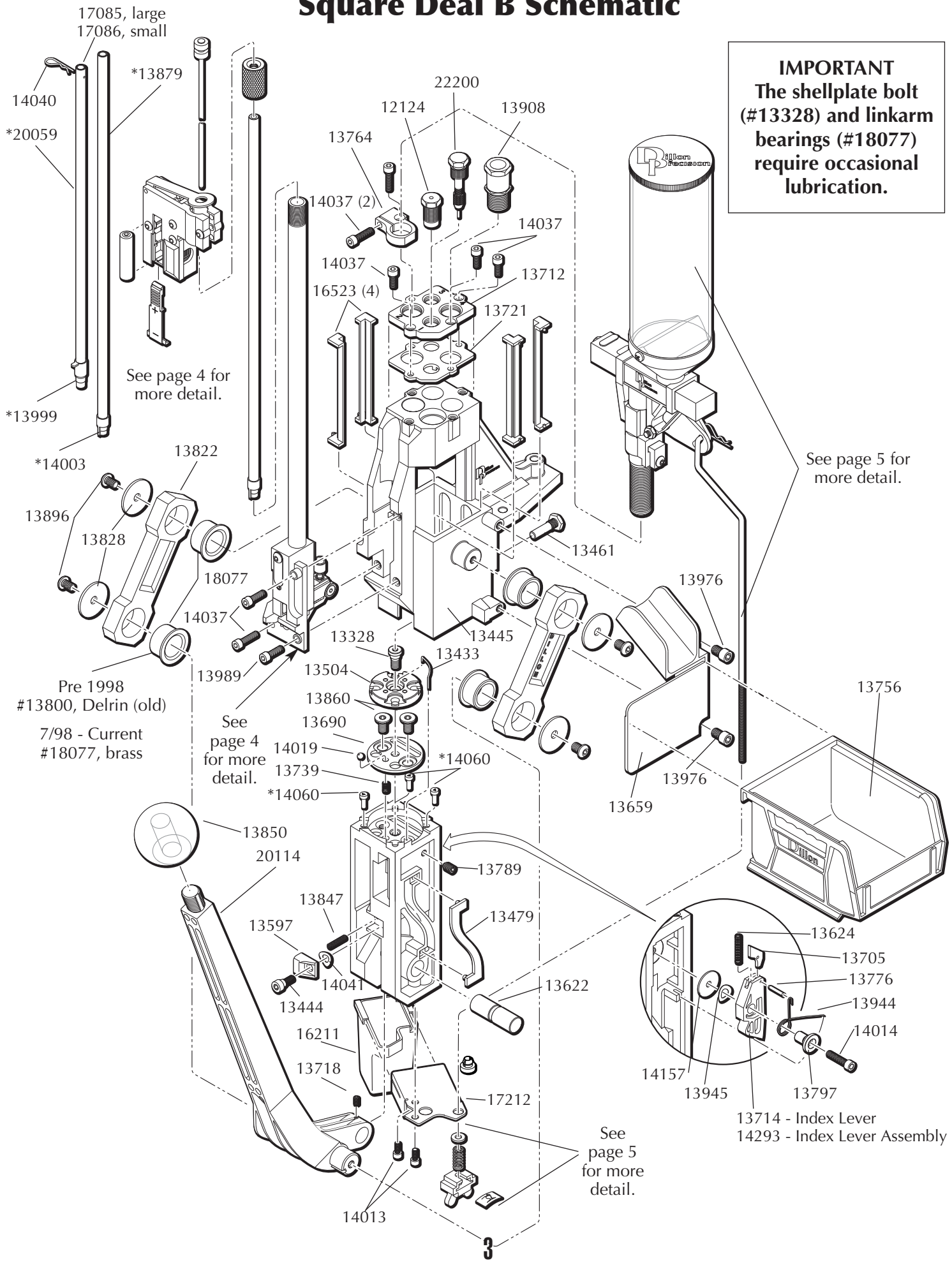
Dillon
Precision
Products, Inc.
Manufacturers of
The World's Finest
Loading Equipment

Square Deal B Parts List

Stock #	Description		
11628	Bullet Seater Insert	13864	Switch Lever
11734	Crimp Insert	13865	Powder Die
*12124	Seating Stem	13871	Bellcrank Cube
12864	Carbide Sizer Insert	13879	Primer Magazine – Small
13028	Square Deal B Manual	13882	Powder Measure Lid
13328	Shellplate Bolt	13893	Powder Bar Post – Large
*13427	Powder Funnel	13895	Clamp Screw
13429	Decap Pin Nut	13896	1/4-20 3/8 BH Screw
13433	Ejector Wire	13908	Crimp Adjustment Screw
13437	Shaft	13921	Powder Measure Spacer Plug
13444	Overtravel Block Bolt	13943	Powder Bar Adjustment Bolt
13445	Square Deal Frame	13944	Indexer Return Spring
13461	Index Bolt	13945	Pivot Bolt Wave Washer
13479	Spent Primer Track Cover	13951	Powder Bar Post – Small
*13504	Shellplate	13957	Primer Shield Cap
13597	Over Travel Block	13958	Powder Bar Washer
13621	Primer Cup – Large	13961	Primer Adjustment Screw
13622	Crank Pin	13964	Spring Screw
13624	Indexer Spring (RL1000)	13967	Primer Punch – Large
13644	Smaller Powder Bar Spacer	13976	Chute Bracket Screw
13657	Primer Cup – Small	13979	Primer Return Pin Spring
13659	Chute Bracket	13982	Primer Punch Spring
13673	Primer Magazine – Large	13986	Collar Clamp
13689	Primer Slide Roller	13989	Feed Body Screw
13690	Platform Base Disc	13999	Pickup Tube Tip (yellow) - Small
13691	Powder Measure Tube	14003	Magazine Orifice (red) - Large
13705	Indexer Pawl	14010	Pickup Tube Tip (green) - Large
13707	Follower Rod	14013	8/32"x3/8" Cap Screw
13712	Toolhead Plate	14014	10-24x7/8 SHCS
13714	Indexer Lever	14019	Detent Ball
13718	Crank Pin Set Screw	14024	Magazine Orifice (blue) - Small
13721	Delrin Die Lock/Friction Plate	14033	Primer Cup Spring (RL550B)
13722	Primer Slide Bearing	14036	Powder Bar Spring
13726	Return Spring Roll Pin	14037	Clamp/Bracket Screw
13739	Detent Spring	14040	Retaining Clip
13754	Primer Slide	14041	Bowed Washer
13756	Bin Box	14051	Primer Retaining Pin
13757	Primer Punch – Small	*14060	Locator Button (3)
13764	Powder Die Ring Clamp	14157	#10 Washer
13776	Pawl Pin	14293	Indexer Lever Assembly
13789	Set Screw	16211	Spent Primer Cup
13790	Primer Slide Return Pin	16523	Plastic Wave Bearing - 4 pack
13793	Body Collar Roller	16814	Failsafe Rod
13797	Pivot Bushing	17085	Dispensing Tip, Large
13798	Return Spring	17086	Dispensing Tip, Small
13799	Blue Failsafe Strip Nut	17212	Spent Primer Cup/Return Bracket
13801	Tinnerman Insert	18077	Brass Link Arm Bearing
13809	Roller Bolt	18086	#10 Rod Washer
14037	Toolhead Mount Screw	20059	Primer Pickup Tube – Small
13818	Powder Bar Insert – Small	20060	Primer Pickup Tube – Large
13822	Link Arm	20062	Powder Bar Assembly – Small
13823	Primer Punch Set Screw	20063	Powder Bar Assembly – Large
13828	Link Arm Washer	20114	Crank Handle
13843	Upper Decap Pin	20302	Complete Early Warning System
13845	Collar Sleeve	20642	Body Collar Assembly
13847	Overtravel Spring	20900	Primer Feed Body
13850	Handle Knob	22200	Decap Stem w/ Cap & Pin
13853	Powder Bar Insert – Large	22273	Powder Measure Body
13857	Battery Cover		
13860	Base Disc Screws		

* Indicates a caliber/size specific part. See the caliber conversion chart for the caliber you are loading for.

Square Deal B Schematic



IMPORTANT
 The shellplate bolt (#13328) and linkarm bearings (#18077) require occasional lubrication.

See page 4 for more detail.

See page 5 for more detail.

See page 4 for more detail.

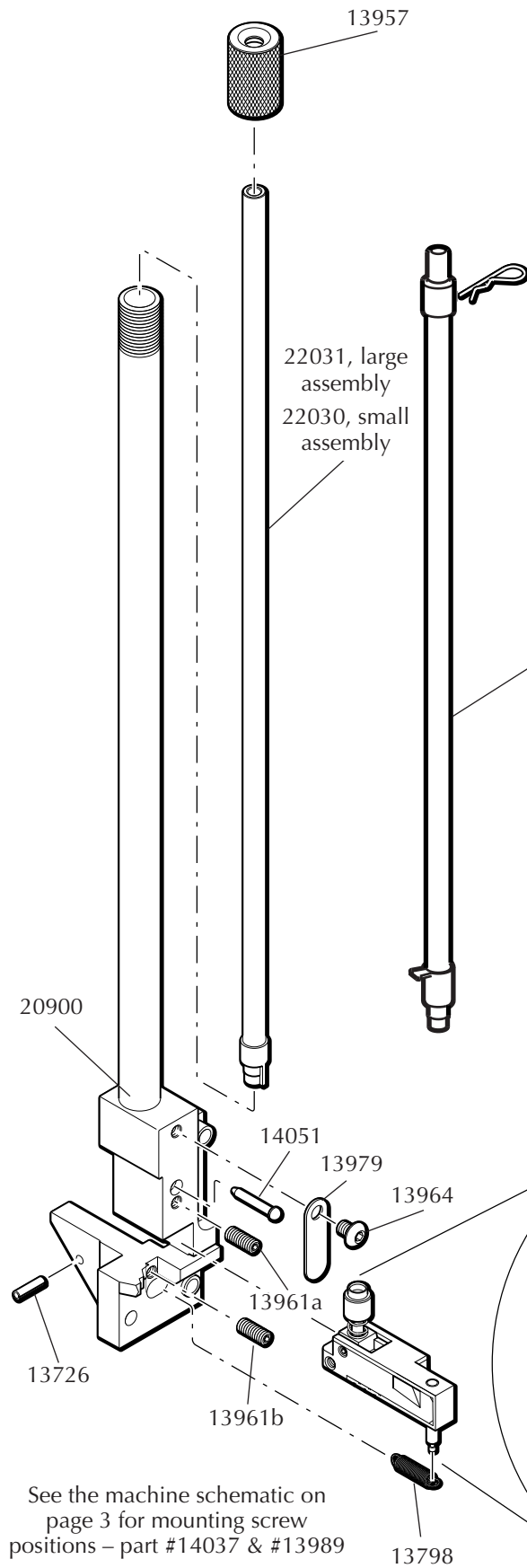
See page 5 for more detail.

Automatic Primer System

20253 large, 20012 small

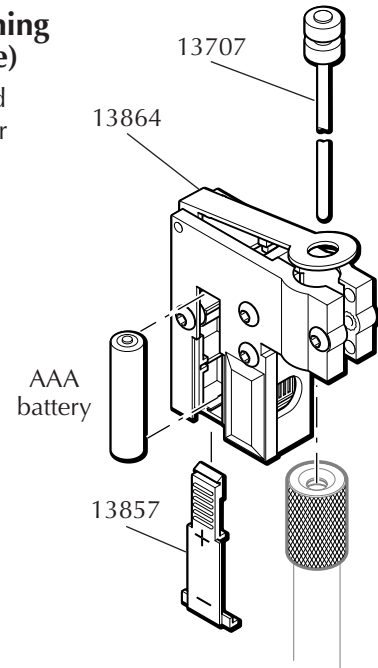
- 13726 Return Spring Roll Pin
- 13798 Return Spring
- 13957 Primer Shield Cap
- 13961a Primer Feed Adjst Screw
- 13961b Slide Stop Adjst Screw
- 13964 Spring Screw
- 13979 Primer Return Pin Spring
- 13989 Feed Body Screw

- 14037 Bracket Screw
- 14051 Primer Retaining Pin
- 20124 Large Primer Slide Assy
- 20125 Small Primer Slide Assy
- 20900 Primer Housing & Shield
- 22028 Small Primer Pickup Tube
- 22029 Large Primer Pickup Tube
- 22030 Small Primer Magazine Assy
- 22031 Large Primer Magazine Assy

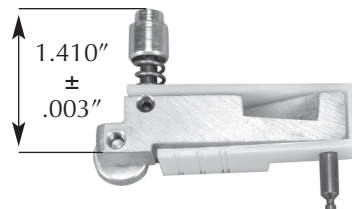


20302 Early Warning System (Complete)

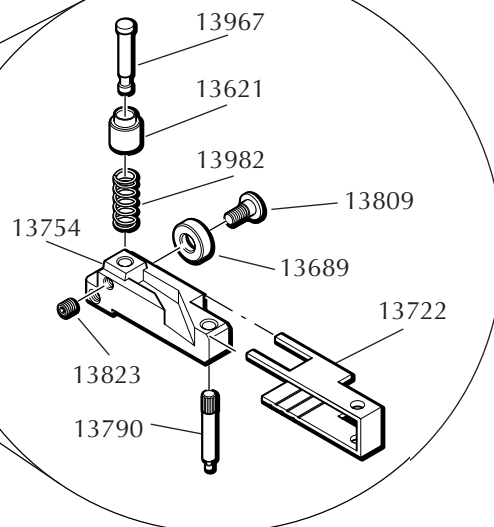
- 13707 Follower Rod
- 13857 Battery Cover
- 13864 Switch Lever



SDB Primer Slide Adjustment



Primer Slide Assembly 20124 large, 20125 small



- 13621 Primer Cup – Large
- 13657 Primer Cup – Small
- 13689 Primer Slide Roller
- 13722 Primer Slide Bearing
- 13754 Primer Slide
- 13757 Primer Punch – Small
- 13790 Primer Slide Return Pin
- 13809 Roller Bolt
- 13823 Primer Punch Set Screw
- 13967 Primer Punch – Large
- 13982 Primer Punch Spring

See the machine schematic on page 3 for mounting screw positions – part #14037 & #13989

Automatic Powder System

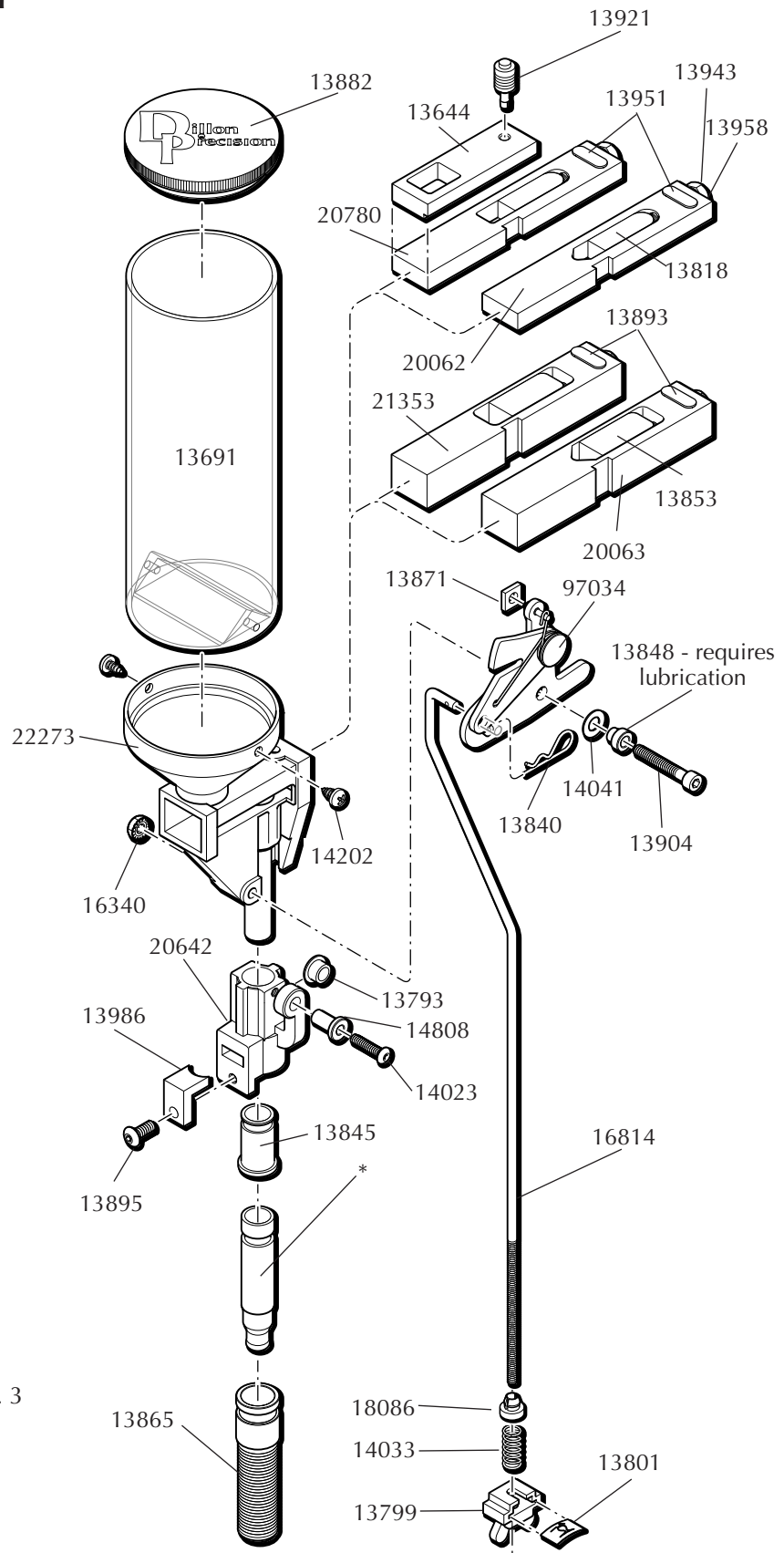
20001 SDB Automatic Powder System

- 13644 Powder Measure Spacer
- 13691 Powder Measure Tube
- *Caliber Specific Part – Powder Funnel
- 13793 Powder Measure Roller
- 13799 Stripper Wing Nut
- 13801 Tinnerman Insert
- 13818 Powder Bar Insert – Small
- 13845 Collar Sleeve
- 13848 Bellcrank Bushing
- 13853 Powder Bar Insert – Large
- 13865 Powder Die
- 13871 Bellcrank Cube
- 13882 Powder Measure Lid
- 13893 Powder Bar Post – Large
- 13895 Collar Clamp Screw
- 13904 10-32x1 1/4 SHCS Bellcrank Bolt

- 13921 Powder Measure Spacer Plug
- 13943 Powder Bar Adjustment Screw
- 13951 Powder Bar Post – Small
- 13958 Powder Bar Washer
- 13986 Collar Clamp
- 14023 8-32x3/4 BH Screw
- 14033 Rod Spring
- 14036 Powder Bar Spring
- 14041 Bowed Washer
- 14202 Powder Measure Tube Screws
- 14808 Collar Roller Bushing
- 16340 Nylon Lock Nut
- 16814 Failsafe Rod
- 20062 Powder Bar Assembly – Small
- 20063 Powder Bar Assembly – Large
- 20642 SDB Body Collar - assembly
- 20780 Powder Bar Assembly – Extra Small
- 21353 Powder Bar Assembly – Extra Large
- 22273 Powder Measure Body
- 97034 Slotted Bellcrank & Cube

20304 Square Deal "B" Failsafe Kit

- 13355 Return Bracket - see schematic on pg. 3
- 16814 Failsafe Return Rod Assembly
- 13799 Stripper Wing Nut
- 13801 Tinnerman Insert
- 13840 Throttle Clip
- 14033 Rod Spring
- 18086 Washer



SDB Caliber Conversion Chart

.32 S&W Long, .32 H&R Magnum - #16774

#D Shellplate - #12507
 #S Powder Funnel - #12845
 #SW Powder Funnel - #13171
 #3 Locator Pin (4) - #14060
 Sizer Die .32 S&W - #22222
 Seater Die .32 S&W - #16543
 Crimp Die .32 S&W - #16544
 Seat Stem .32 S&W WC - #16775
 Seat Stem .32 S&W RN - #16824

.380 Auto - #20246

#3 Shellplate - #12906
 #F Powder Funnel - #13806
 #3 Locator Pin (4) - #14060
 Sizer Die 380 Auto - #22207
 Seater Die 380 Auto - #12198
 Crimp Die 380 Auto - #11870
 Seat Stem 9mm SWC - #11302
 Seat Stem 9mm RN - #12313

.38 Special, .357 Magnum - #20240

#2 Shellplate - #13635
 #D Powder Funnel - #13599
 #2 Locator Pin (4) - #14062
 Sizer Die .38/.357 - #22201
 Seater Die .38/.357 - #12673
 Crimp Die .38/.357 - #12279
 Seat Stem .38/.357 SWC - #12158
 Seat Stem .38/.357 WC - #11647
 Seat Stem .38/.357 RN - #11429

.38 Super - #20229

#5 Shellplate - #13440
 #F Powder Funnel - #13806
 #3 Locator Pin (4) - #14060
 Sizer Die .38 Super - #22208
 Seater Die .38 Super - #12345
 Crimp Die .38 Super - #12473
 Seat Stem 9mm SWC - #11302
 Seat Stem 9mm RN - #12313

9mm Parabellum - #20241

#5 Shellplate - #13440
 #F Powder Funnel - #13806
 #3 Locator Pin (4) - #14060
 Sizer Die 9mm - #22206
 Seater Die 9mm - #11525
 Crimp Die 9mm - #12497
 Seat Stem 9mm SWC - #11302
 Seat Stem 9mm RN - #12313

10mm, .40 S&W - #20469

#W Shellplate - #13523
 #W Powder Funnel - #13600
 #2 Locator Pin (4) - #14062
 Sizer Die 10/.40 - #22209
 Seater Die 10/.40 - #12276
 Crimp Die 10/.40 - #11801
 Seat Stem 10/.40 SWC - #12124
 Seat Stem 10/.40 Trun - #11048

.41 Magnum - #20247

#6 Shellplate - #13284
 #H Powder Funnel - #13240
 #1 Locator Pin (4) - #13930
 Sizer Die .41 Mag - #22202
 Seater Die .41 Mag - #11794
 Crimp Die .41 Mag - #11799
 Seat Stem .41 Mag SWC - #12067

.44 Special, .44 Magnum - #20242

#4 Shellplate - #13504
 #G Powder Funnel - #13427
 #4 Locator Pin (4) - #14047
 Sizer Die .44 Mag - #22203
 Seater Die .44 Mag - #11863
 Crimp Die .44 Mag - #13036
 Seat Stem .44 Mag SWC - #11880
 Seat Stem .44 Mag RN - #12571

.44/40 Winchester - #21035

#N Shellplate - #13095
 #.44/40 Powder Funnel - #13474
 #4 Locator Pin (4) - #14047
 Sizer Die .44/40 - #10853
 Seater Die .44/40 - #10722
 Crimp Die .44/40 - #10847
 Seat Stem .44 Mag SWC - #11880

.45 ACP, .45 GAP - #20123

#1 Shellplate - #13653
 #E Powder Funnel - #13782
 #1 Locator Pin (4) - #13930
 Sizer Die .45 ACP - #22204
 Seater Die .45 ACP - #11628
 Crimp Die .45 ACP - #11734
 Seat Stem .45 ACP SWC - #11303
 Seat Stem .45 ACP RN - #12476

.45 Colt - #20248

#C Shellplate - #13112
 #E Powder Funnel - #13782
 #4 Locator Pin (4) - #14047
 Sizer Die .45 LC - #22205
 Seater Die .45 LC - #12306
 Crimp Die .45 LC - #12588
 Seat Stem .45 LC SWC - #12619
 Seat Stem .44 Mag RN - #12571

.45 S&W Schofield - #20417

#C Shellplate - #13112
 #E Powder Funnel - #13782
 #4 Locator Pin (4) - #14047
 Sizer Die .45 LC - #22205
 Seater Die .45 LC - #12306
 Crimp Die .45 Schofield - #11253
 Seat Stem .45 RN Schofield - #11210

Note: This chart does not list all parts included in a conversion kit.