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## Model No. 2400 Case Trimming Lathe Operating Instructions

**Congratulations!** You have just purchased one of the finest case trimmers available. With proper care, your trimmer should provide many years of service and satisfaction. To be sure that you get the most from your new Redding Model No. 2400 Case Trimming Lathe, please take a few minutes to read the following instructions.

### Introduction

The Redding Model No. 2400 Case Trimming Lathe is designed to trim all popular rifle and handgun cases. Redding Case Trimmers are constructed on precision lathe principles where the cutter is held stationary while the case is turned. This arrangement produces case mouths that are perfectly square, resulting increased accuracy from your handloads.

### Micrometer

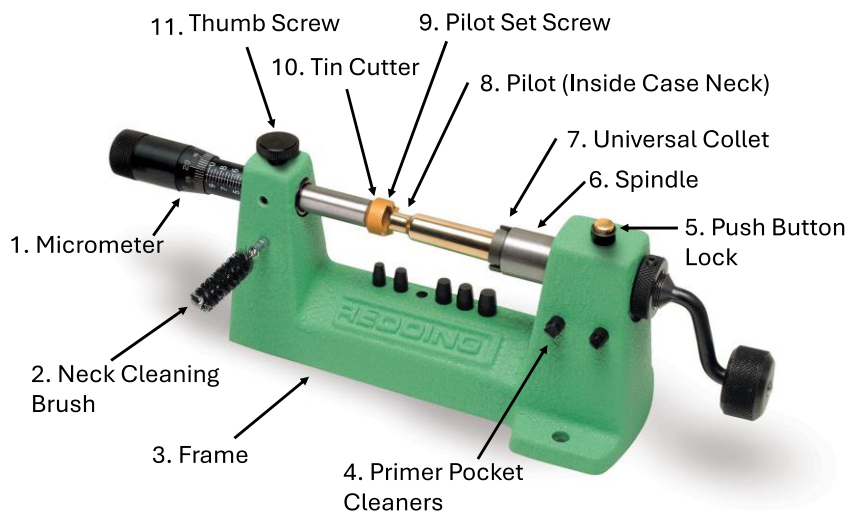
With the addition of a micrometer to the Model 2400, case length can be easily adjusted in .001" increments. The micrometer has a total adjustment range of 1.500" and by using the 1" cutter shaft extension, case lengths from 1/2" to 3" can be trimmed. (Cases measuring 3" to 3.25" can also be trimmed, but the micrometer becomes ineffective when extended off the scale).

### Titanium Nitride Cutter

The cutter in the Model 2400 Case Trimming Lathe has a Titanium Nitride (TiN) surface treatment that increases its effective surface hardness. Should the cutter become dull, simply unscrew it and replace it with a new one (Part #14050).

### Mounting

The Model 2400 Case Trimming Lathe should be rigidly mounted to a bench top or other solid work surface by means of the two holes in the base. The trimmer may be mounted parallel to the front edge of the bench, or at any angle to it, according to the preference of the operator. An alternative mounting method is to use a Redding Double "C" Clamp (Part #30520). The clamp accommodates bench tops up to 2-1/4" thick and allows easy removal of the trimmer when not in use.



## Pilots

Install a pilot of the proper caliber in the TiN cutter and tighten the set screw to hold it securely. Six pilots of 22, 6MM, 6.5MM, 270, 7MM and 30 caliber are included. Additional pilots can be purchased separately. Pilots are approximately .004" smaller than bullet diameter and may be ordered by caliber.

## Universal Collet

The Universal Collet has a series of steps that accept all popular cartridge cases.

To operate the collet:

- Depress the push-button collet lock and rotate the handle
- Within 1/2 turn, the collet lock will engage and the collet will open or close.

*Counterclockwise* rotation will open the collet.

*Clockwise* rotation will close the collet.

**Note:** An extra collet for the 470 Nitro Express (Part #99301) is available.

**Important: Do not close the collet when it is empty. It may be permanently damaged by the over-stress.**

## Micrometer Adjustment

To adjust the micrometer, follow these steps:

- Loosen the thumb screw at the top of the left post on the frame casting.
- Once the screw is loosened, the micrometer will turn smoothly either direction.
- After making an adjustment, be certain to retighten the thumb screw to prevent cutter shaft rotation.

The micrometer is calibrated in .001" increments and may be adjusted from 1-1/2" to 3". A 1" cutter shaft extension is included to allow adjustments from 1/2" to 2".

## Loading and Unloading Cases

Before placing a case in the collet, release any tension on the collet by depressing the collet lock and rotating the handle counterclockwise to open the collet. Place a case in the opened collet in the smallest step that will accept it, and then slide the collet and handle assembly toward the cutter until it stops. At this point, the pilot should have entered the case neck, and the case mouth should be firmly contacting the cutter. This is necessary to keep the case fully seated in the proper step of the collet while the collet is being closed.

If the case mouth does not firmly contact the cutter, adjust the micrometer until it does so. Then, while maintaining contact of the case mouth with the cutter, depress the collet lock and rotate the handle clockwise to close the collet. When the case is properly inserted in the collet, the slots in the collet will appear parallel and approximately 1/8" wide. To remove a case from the collet, slide the collet and handle assembly away from the cutter until it stops. Depress the collet lock and rotate the handle counterclockwise to open the collet. The case will now drop free.

## **Case Length Adjustment**

It is important to note that cases must be resized and their necks properly expanded before trimming. This ensures proper fit of the pilots and avoids length changes that may occur during sizing. (Straight wall rifle and handgun cases should have their mouths expanded without a flare or bell-mouth). Please refer to your reloading manual for “trim to” length.

The simplest method of using the Model 2400 is to use the micrometer as a reference gauge only. Trim a case slightly to square the case mouth and measure it to determine how much more you want to remove and adjust the micrometer accordingly.

## **Deburring**

Deburring the inside and outside of the case mouth after trimming is very important. The small chamfers created help ensure accurate case sizing and proper bullet seating. Deburring is easily accomplished with a quick twist of the Redding Deburring Tool (Part #09000).

## **Lubrication**

A periodic light oiling of the spindle and micrometer threads will keep them functioning smoothly. The frame is made of cast iron, a natural bearing surface, so you never have to worry about wear or galling.

## **Accessories**

Included with your trimmer are large and small primer pocket cleaners and two case neck cleaning brushes. Threaded holes are provided on the trimmer frame to mount the primer pocket cleaners and one of the brushes.

## **17 & 20 Caliber**

An optional TiN caliber (Part #14040) is available that accepts 5/32” shank pilots. Redding 17 and 20 caliber pilots (Part #15168 & #15200) have 5/32” shanks and require the use of this cutter.

## **Power Adapter**

An optional power adapter (Part #14025) is available for use with cordless screwdrivers. It replaces the stock handle assembly and provides a 1/4” hex shaft.

If you have any questions regarding the above procedures, please do not hesitate to contact our tech support members.

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**Lifetime Warranty Disclaimer:**

***All Redding Reloading Equipment has been carefully inspected prior to shipment and is fully warranted to be free from defects in materials and workmanship for life.***

***Any product or parts which prove to be defective will be replaced or repaired without charge if returned prepaid to the factory.***

***Note: We reserve the right to decline responsibility where misuse or careless handling is evident or where repairs or modifications have been made or attempted by others.***