

# FORSTER PRODUCTS

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## User Instructions for Co-Ax® XL Reloading Press

Issue 1

### 1.0 GENERAL INFORMATION

Co-Ax® XL Press is designed for two rifle handloading steps:

1. Case resizing
2. Bullet seating

Co-Ax XL Reloading Press accepts any 1-1/4" x 12 reloading die or 7/8" x 14 reloading die using Forsters adapter lock ring.

For proper press operation, you must use the aluminum Cross Bolt Die Lock Rings provided in the Important Parts Packet (Figure 3) either on Forster Products Reloading Dies or your own dies. The Cross Bolt Die Lock Rings are important for two reasons:

- They keep the Co-Ax XL Press T-Slot free from wear that may be caused by other harder steel lock rings
- They are the proper thickness to allow the dies to "float" in the T-Slot for optimal reloading

#### CAUTION PRODUCT DAMAGE

- Do not drop Co-Ax XL Press or expose it to sudden stresses.
- Failure to comply with these instructions may result in product damage.**

### 2.0 SHIPPING PACKAGE CONTENTS (Figure 3)

Your shipping package should contain the following:

- **Section A:** Co-Ax XL Press already assembled
- **Section B:** Important Parts Packet
- **Section C:** Loose Components

### 3.0 SAFETY INFORMATION

#### ⚠ WARNING PERSONAL INJURY

- Avoid possible pinch points.
- Failure to comply with these instructions may result in injury.**

Always wear safety glasses.

### 4.0 MOUNT CO-AX XL PRESS TO A WORK SURFACE

Co-Ax XL Press may be directly mounted to a work bench or a board, for later use on the range or in the field.

1. See Figure 10 on page 5 for a mounting diagram.  
Drill four 1/4" holes as shown.
2. Mount the Co-Ax XL Press using 1/4" lag bolts.

**NOTE:** When sizing 50 BMG brass it is advised, due to the extreme force that is needed, that you attach your Co-Ax XL Press to a reinforced and securely fastened work surface or bench.

### 5.0 SETUP AND ASSEMBLY

#### 5.1 Install the Handle

1. Insert the Handle into the top XL Bracket (-095).
2. Using the 5/32" Allen Wrench (SHORTARMHEXKEY5/32), tighten the 5/16-24 Handle Set Screw (-028).

A short handle with a ball end is also available separately for use when less leverage is needed.

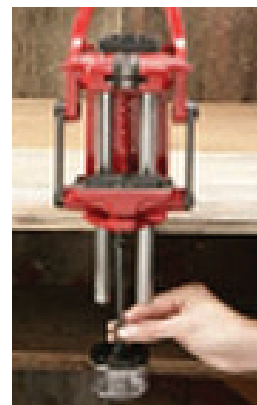
#### 5.2 Install the Primer Catcher

1. Insert the Primer Drop Tube (038271-057) through the hole in the Primer Catcher Cap (038271-050). Secure the cap with the o-ring (038271-056) which is installed on the Primer Drop Tube (remove o-ring before inserting tube).
2. Screw the Primer Catcher Cap to the Primer Catcher Cup (038271-051), as shown in Figure 1.
3. Pass the Primer Drop Tube through the middle hole in the bottom of the Frame (038271-031), as shown in Figure 2.
4. Screw the Primer Drop Tube into the tapped hole in the bottom of the Guide Block (038271-045) until finger-tight.

**Figure 1. Drop Tube in Primer Catcher Cap, Ready to Attach to Cup**

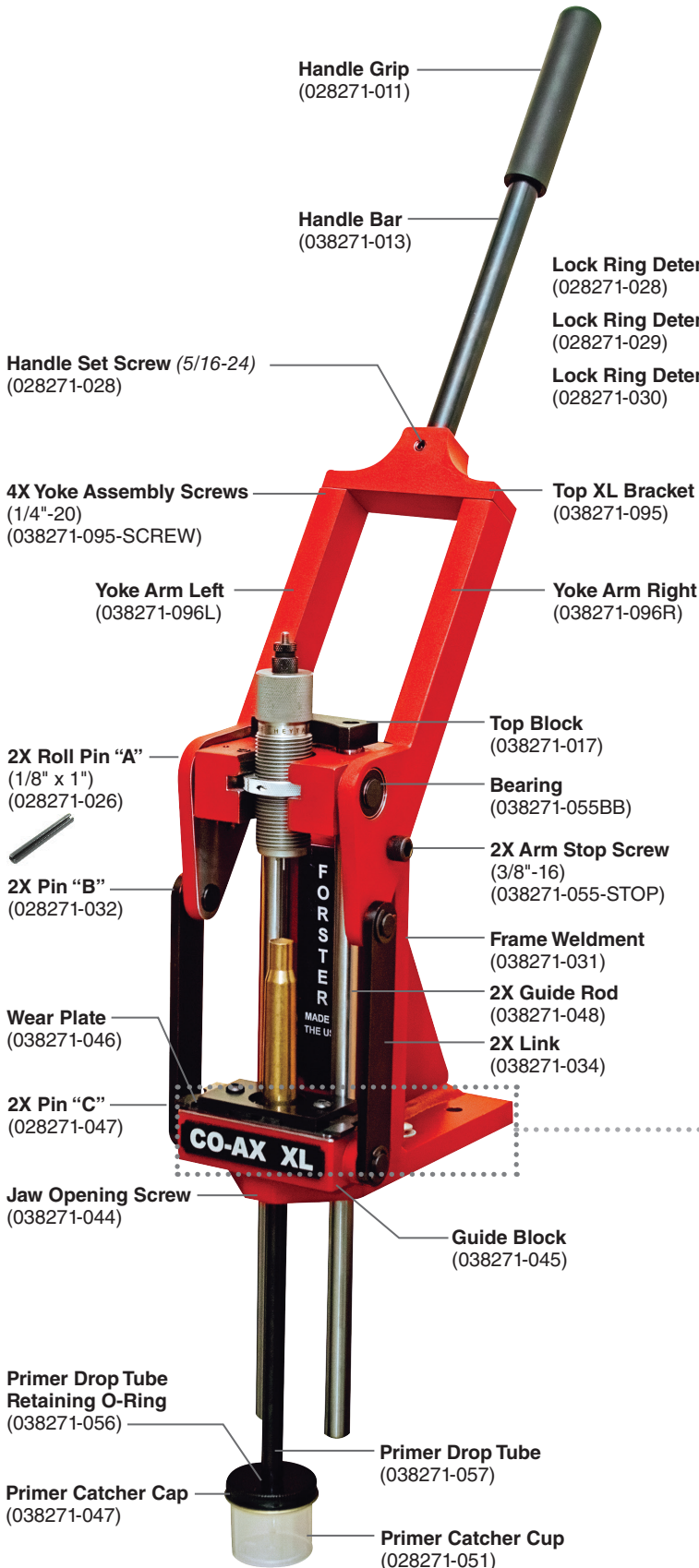


**Figure 2. Primer Catcher under Press**



**Figure 3. Co-Ax XL Reloading Press (038271) Nomenclature**

**Section A. Co-Ax Press with All Components  
Not Noted in Sections B and C Already Assembled**



**Section B. Important  
Parts Packet**

**1/8 Allen Wrench**  
(SHORTARMHEXKEY1/8)

**5/32 Allen Wrench**  
(SHORTARMHEXKEY5/32)

**7/64 Allen Wrench**  
(SHORTARMHEXKEY7/64)

**Primer Drop Tube**  
(038271-057)

**Primer Drop Tube Retaining Ring**  
(038271-056)

**Reduced Wear Plate**  
(038271-146)

**S-XL Jaws**  
(038271-141)

**Two Cross Bolt Lock Rings**  
(DIE-G-30)

**Two 7/8 Adapter Cross Bolt Lock Rings**  
(DIE-G-40)



**Section C. Loose Components**

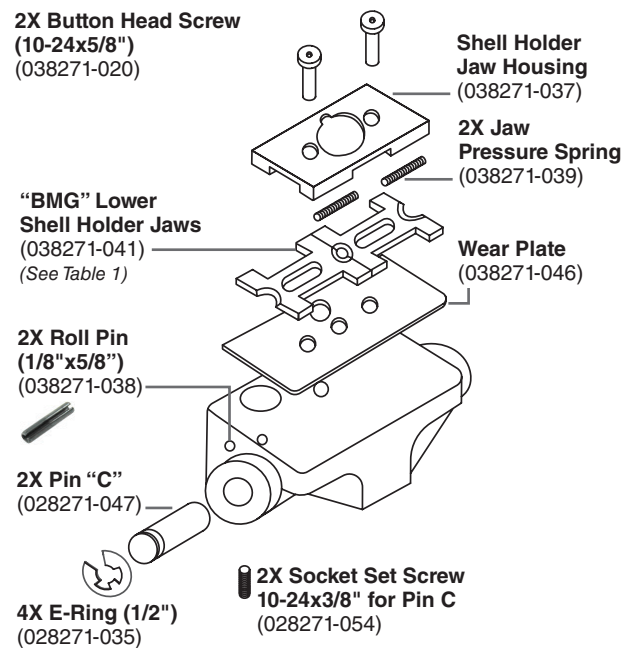
**Primer Catcher Cap**  
(038271-050)

**Primer Catcher Cup**  
(038271-051)

**Light**  
(038271-LIGHT)

**Handle:**

- **Handle Grip**  
(038271-011)
- **Handle Bar**  
(038271-013)



**FORSTER VIDEO LIBRARY**



Go to the online Video Library under  
"Resources" at [forsterproducts.com](http://forsterproducts.com) to see  
videos of Co-Ax Press.

5.3 Adjust the Jaw Opening Screw

The Jaw Opening Screw (038271-044) controls the amount that the lower Shell Holder Jaws open to accept cases when the Handle is raised to its highest position.

Adjust the Jaw Opening Screw's height so that the Shell Holder Jaws completely open when the handle is in the full up position, but not so far up that it could damage the Shell Holder Housing (038271-037).

6.0 CASE SIZING AND BULLET SEATING

6.1 Choose the correct Lower Shell Holder for the caliber being sized/seated

Spring-loaded Shell Holder Jaws automatically open and close on the case head when the case is inserted into the die and also when the Co-Ax XL Press handle is lowered for full length resizing, allowing the case to "float." When the handle is raised and the case extracted from the die, these jaws automatically open and release the case.

Co-Ax XL Press arrives with a set of two factory-installed "BMG" Lower Shell Holder Jaws – with the small ends aligned, ready for reloading cases with a .531" to .625" rim. Depending on the caliber, you may need to adjust the size of the "S" Lower Shell Holder Jaws or switch to the included "S-XL" Jaws (038271-141). The caliber dimensions that each Shell Holder Jaw can accommodate are described in Tables 1 and 2.

**NOTE:** In the parts packet there is an additional wear plate that is slightly thicker than what comes standard on the press and is marked "DO NOT USE WITH 50 BMG." The smaller hole is important when using the press to do calibers with smaller case heads. This will need to be removed when doing 50 BMG as the primers are too large to pass through the hole on this wear plate (Part# 038271-146).

Figure 4. Position of Jaw Opening Screw

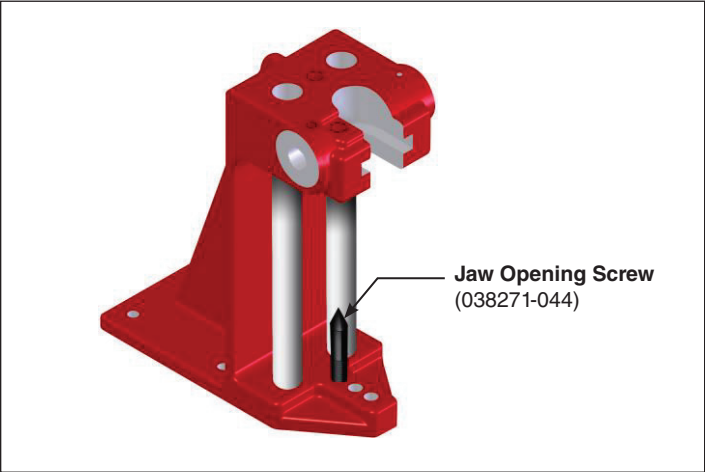


Table 1. Lower Shell Holder Specifications

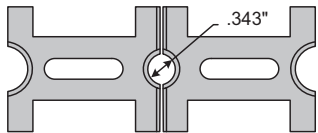
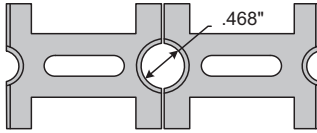
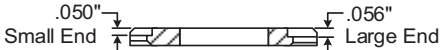
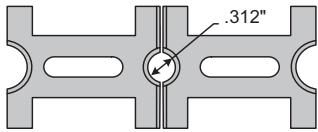
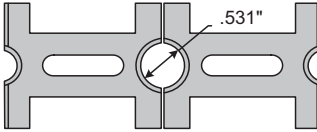
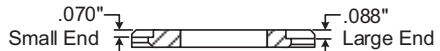
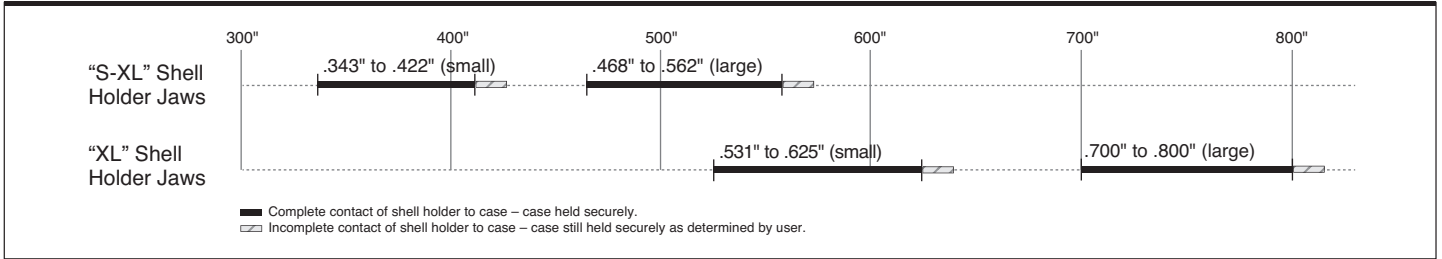
Name	Hole Dimensions		Side View
<b>"S-XL" Lower Shell Holder Jaws</b> (038271-141) <i>In Box Accessory</i>	<b>Small ends: .343" to .422" rim</b> 	<b>Large ends: .468" to .562" rim</b> 	
<b>"XL" Lower Shell Holder Jaws</b> (038271-041) <i>Default Jaws</i>	<b>Small ends: .531" to .625" rim</b> 	<b>Large ends: .700" to .800" rim</b> 	

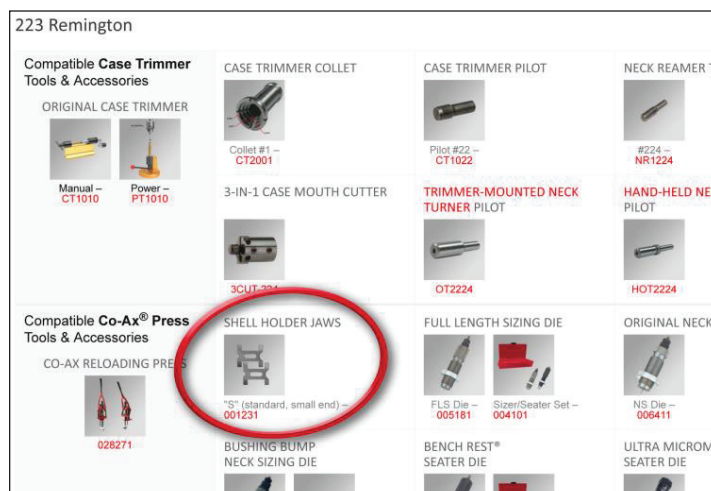
Table 2. Case Rim Diameter Comparison



## 6.2 Choose the correct Lower Shell Holder for the caliber being sized/seated

1. Go to the caliber search at <http://search.forsterproducts.com>. (Links to “Search by Caliber...” and caliber search forms are found throughout [forsterproducts.com](http://forsterproducts.com).)
2. Input your cartridge name (223 Rem is provided here as an example).
3. Click the “Search” button.

Figure 6. Online Caliber Search Results for 223 Rem



The search returns matching tools as shown, including the Lower Shell Holder Jaws when applicable.

## 6.3 Change/Adjust the Lower Shell Holders (if needed)

### 6.31 Change/Adjust the “S-XL” or “XL” Lower Shell Holder Jaws

Figure 7. Lower Shell Holder Jaws Change/Adjustment

#### Step 1

Using the provided 1/8 Allen wrench, loosen the two Button Head Screws (038271020).



#### Step 2

Carefully lift off the subassembly containing:

1. Two Button Head Screws
2. Shell Holder Jaw Housing (038271037)
3. Two Jaw Pressure Springs (038271039)
4. “S-XL” or “BMG” Shell Holder Jaws
5. Wear Plate (038271-046)



#### Step 3

Remove the two Button Head Screws and set them aside. Set the component stack on a work surface.



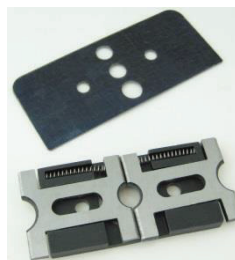
#### Step 4

Carefully turn the component stack over.



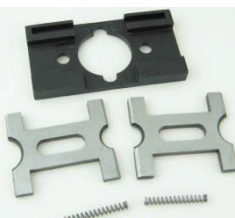
#### Step 5

Carefully slide the Wear Plate off and set it aside. This is to prevent the two Jaw Pressure Springs from coming loose too soon.



#### Step 6

Remove the “S-XL” or “XL” Shell Holder Jaws and the two Jaw Pressure Springs, in that order.



#### Step 7

Ensure the ends of the selected pair of Shell Holder Jaws are correctly matched. Insert them into the Shell Holder Jaw Housing.



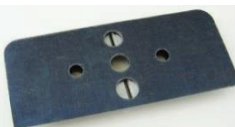
#### Step 8

Replace the two Jaw Pressure Springs.



#### Step 9

Replace the Wear Plate. Ensure the rounded edge of the Wear Plate is placed over the two Jaw Pressure Springs.



#### Step 10

Carefully turn the component stack back over.



#### Step 11

Carefully pick up the component stack and replace the two Button Head Screws.



#### Step 12

Replace the subassembly on Co-Ax XL Press and tighten the Button Head Screws.

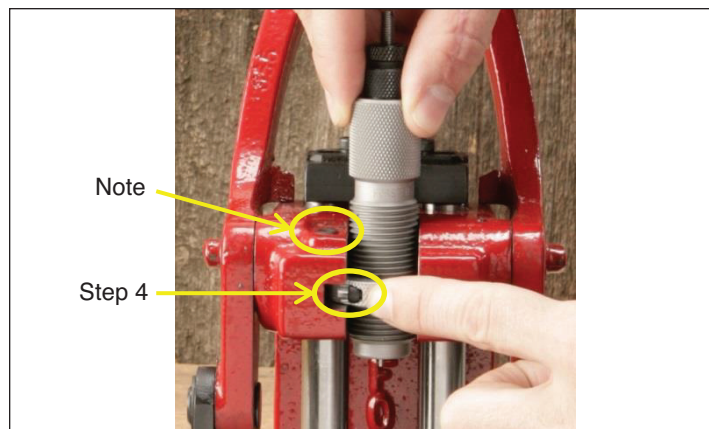




### 6.32 Adjust the Sizing/Seating Die in Co-Ax XL Press

1. Unscrew the die approximately two-thirds out of the Cross Bolt Die Lock Ring, ensuring that its screw is centered in front.

Figure 8. Reloading Die Adjustment



2. Lower the Handle all the way down against the stop.
3. While holding the Lock Ring with one hand, screw the die through the Lock Ring until the die makes contact with the Shell Holder Jaws.
4. Using the provided 7/64 Allen wrench, tighten the Lock Ring in place on the die. For specific Forster Products Sizing and Seating Die Instructions, go to **forsterproducts.com**, then click "Resources | User Instructions."

**NOTE:** Do not overtighten the 5/16" Lock Ring Detent Screw (038271-028). This screw should be just tight enough to keep the die lock ring under tension. The die must be allowed to float for Co-Ax alignment. We recommend using Forster Cross Bolt Locking Rings (DIE-G-30).

**NOTE:** When working with 50 "BMG" there are not as many industry standards as with other calibers. If using another manufacture 1-1/4" die, it may require being set to a different depth within the press. Our Shell Holders are made to grip the case .125". We recommend a liberal use of a high quality oil based case lube due to the extreme variance in the amount of resizing when compared to other more standard cartridges.

### 6.4 Installing the Light on the Co-Ax XL

1. Lower yoke handle.
2. Feed light (032871-LIGHT) through the designated hole in the top of the press.
3. Use the designated clip provided to clip to the back of the frame as shown in Figure 9.

Figure 9. Light Installation



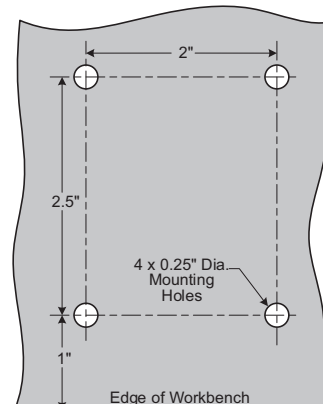
## 7.0 MAINTENANCE

- Use a good quality gun oil to lubricate moving parts, wipe all unpainted parts with oil to prevent rust.

## 8.0 REPLACEMENT PARTS

Every product component is available individually. A complete list of component order numbers and prices is available on our website. Go to **forsterproducts.com**, then click "Replacement Parts."

Figure 10. Not to Scale Mounting Diagram



## WARRANTY

All Forster Products are warranted against defects in materials and workmanship for the life of the product. Parts excluded from the warranty are those that, by nature of their function, are subject to normal wear (such as springs, pins, etc.) or that have been altered, abused, or neglected. If the product is deemed defective by workmanship or materials, it will be repaired, reconditioned or replaced (at Forster's option). This warranty supersedes all other warranties for Forster Products, whether written or oral.