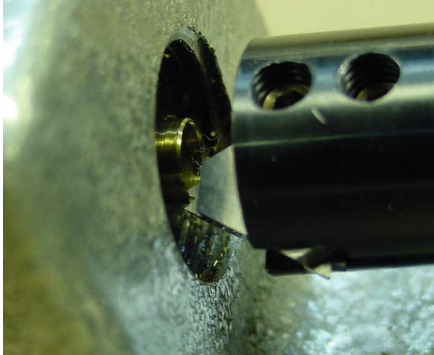


## Giraud Blade for Gracey Trimmers

First remove the two piece blade assembly that came with your Gracey and look through the shell holder at the end of the trimmer shaft. There should be a groove across the end of the shaft approximately 1/8" wide.

With the original blades removed and the set screw loosened, the new blade should fit into the 1/8" groove with one of the three flat sides of the triangle against the bottom of the groove in the shaft. This should leave one corner of the triangle pointing out away from the shaft and directly at the shell holder.



With the shell holder screwed in slightly (shortening the trimmed case length), you can insert a case into the shell holder and see where the new blade's cutting surfaces touch the case. The blade can be moved in the end of the shaft slightly left or right until the case touches right in the bottom of the tiny "v" on the tip of the triangle. Tighten the set screw that holds the blade on the shaft and unscrew the shell holder until a case just barely touches the new blade. Turn the motor on and try trimming a case. I suggest using some of your scrap brass (the ones with the dented shoulders, just about to separate at the head, loose primer

pockets, etc.) because you will probably not get the final adjustment right the first time. It may take 2 to 20 cases to get it finally.

For best results, insert the case into the shell holder and then give it a half turn while still firmly in the shell holder. This will make sure that the cut is even all around the case mouth. The trimmed case should have metal removed from both inside and outside. You can check just how even this is by running your fingernail along the outside of the case from the shoulder to the case mouth. If you feel a slight burr on the outside of the case mouth and it doesn't look like enough metal was removed from the inside, carefully loosen the set screw on the trimmer shaft and move the blade to the outer edge of the shaft by a few thousandths of an inch.

It really doesn't take much movement. Usually you can loosen the set screw holding the blade while using a small screwdriver to keep the blade from moving on the shaft. Once the set screw is loose, you can gently move the blade left or right to adjust the chamfer. Be sure to keep the blade against the back of the slot with the small screwdriver while you tighten the set screw, if you don't the blade will twist as the set screw is tightened. Tighten the set screw firmly, turn it on, and try another case. When you get it right, the case will have a bright clean trimmed surface on the inside of the case mouth that extends into the case about 1/32" deep (a little more than half the thickness of a credit card edge) with no burr on the outside of the case mouth.

I know it can be frustrating, getting it adjusted the first time. I went through about 15 or 20 cases. After playing around with it and changing to different calibers several times, I got it down to my personal best of 1 case. Just remember, once it is set, as long as you only trim one caliber or bore diameter, you never need to mess with it again.



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