

BENCH-SOURCE ANNEALING MACHINE

Model: 10G107

VERTEX MANUFACTURING CORPORATION



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Specifications and subject matter contained herein are subject to change or revision without notice.

I. Introduction:

Thank you for purchasing a **BENCH-SOURCE** case neck annealing machine. This unit is used exclusively to anneal and refurbish your Bottle Neck and Long Straight Wall cartridge cases for reloading. It will restore your case necks to 'like new' condition and extend the life of your cartridge cases. The net result is reduced reloading cost and improved accuracy. The uniformity of case neck tension will allow you to seat your bullets with less run out and more consistency in your reloads.

Other benefits not found on other competitors models-

- 1)** You may use one or two heat sources. Not necessary to **perfectly** setup two nozzles because the cartridge case spins on a stationary spindle while heating.
- 2)** Torch tips are adjustable in height, angle, distance and vertical tilt by two clamp knobs. (No Wing Nuts) Sets up in 2 minutes from 22 Hornet to the Largest Magnum Cases after you are familiar with the unit. (Can be supplied for .50 Caliber)
- 3)** Time of heating is adjustable from 1.5 to 10.0 seconds. Precise control is supplied by micro-processor unit and 10 bit analog/digital converter. Processor has both a 'Setup' (Manual) control and 'Automatic Cycle'.
- 4)** Table Top and Index Plate are made from aluminum and fan cooled by a huge 50 CFM Fan Unit. They will not heat up significantly during use! No plastic to bow or warp. Table acts as a heat sink to help maintain hardness in the cartridge case head.
- 5)** Index Plate is fixed and indexed by a Geneva Drive Wheel. The wheel is always engaged and will not "free wheel". This reduces the chance of binding and over loading motors. It also eliminates the necessity of confirming wheel position before operation.
- 6)** The unit has a small foot print of 10" Wide x 12" Long x 6" Tall (Excluding Clamp Posts). Weight is approximately 12 pounds. Unit is sized for portability.
- 7)** Supplied with a built in level and (4) adjusting feet. (Unit only needs to be moderately level). The Drive Wheel thickness is 1/4" eliminating cartridge tip over in almost any caliber.
- 8)** All aluminum parts are anodized either Black or Clear to prevent oxidation over time and has a very pleasing look. Guarding is made from #3003 decorative aluminum with a natural finish for long term eye appeal.
- 9)** The unit will process about 500-600 cartridges per hour. Average time is 4-5 seconds for heating and 2 seconds for indexing on most .308 and Magnum case sizes. (Can be programmed up to 10 seconds heating time for single torch use or .50 Caliber Annealing)
- 10)** Limited lifetime warranty on materials and workmanship to original owner. (Electronics & Motors are limited to 2 years).
- 11)** If ordered direct from BENCH-SOURCE the unit has a 15 day, no questions asked return guarantee. (Please contact us for details).

II. Cautions

As with any piece of equipment with moving parts and extreme heat in close proximity to the user, one must be alert and aware of the dangers that could cause personal injury to themselves and others. Below are just a few of the 'COMMON SENSE' rules that must be exercised while using your new CASE NECK ANNEALER.

1. **ALWAYS** place your unit on a solid, rigid bench or table top to prevent the chance of being knocked over or off of the work surface.
2. **NEVER** allow children to operate the annealer or play in the immediate vicinity while annealing cases.
3. **ALWAYS** anneal in a location that will provide plenty of ventilation and fresh air to the area.
4. **NEVER** anneal in a closed room or shop area! Carbon Monoxide will be present in the immediate area from the burning of your torches. It may build up in a very short time causing personal injury or death. **Read the Instructions and Warnings** that came with the torches you decide to use.
5. **NEVER** anneal cases without first de-priming them. Even if they are fired, it is extra insurance that your cases will run true on the spindle of the machine and that no one accidentally mixed in a primed case by mistake.
6. **ALWAYS** confirm that there is no loaded ammunition, primers, powder or flammable substances in the vicinity of the annealer while it is being used.
7. **NEVER** leave the area where your annealer is being used or while the torches are lit. A phone call or other distraction could spell disaster if 100% of your attention is not directed toward the machine while in use.
8. **ALWAYS** be cognizant of the fact that the annealing machine may be hot enough to severely burn you or others. Although we have implemented a cooling fan into the design of the unit, some parts may be too hot to touch. This may be the result of your setup and the torches putting excessive heat into the Table Top or Carrier Plate. It is normal for the Clamp Assemblies which hold your torch nozzles heat up, and may be too hot to touch during use.
9. **NEVER** attempt to anneal short cases such as **PISTOL Brass**. While the brass itself may be annealed by using more controlled machinery, the BENCH-SOURCE Annealer is not designed to properly anneal this type of spent cartridge. **CASE HEAD SOFTENING WILL OCCUR**, rendering the cases useless. They will lose the necessary head hardness leading to failure upon firing! **This may result in damage to your firearm and injury or death to yourself and others.**
10. **NEVER** try to modify or use your new annealing machine to do something other than that for which it is designed. Your annealer was designed and manufactured to anneal Bottle Neck or Large Straight Wall Cartridge Cases after firing. **Use your machine only to anneal Fired & De-primed cartridge cases!**

11. **ALWAYS** wear eye protection and have a fire extinguisher near by while annealing. The use of heat resistant gloves such as those sold at welding supply stores is also necessary. Never wear cotton, latex or any other type of glove that is not heat resistant. They may melt to your hands or catch on fire causing severe and or permanent damage.
12. **ALWAYS** unplug your unit **FIRST** from the electrical source and then disconnect the fuel supply from your torches. Also, be sure to connect your fuel supply **FIRST** then wait a few minutes before plugging in the Power Supply that came with your unit. Minute amounts of fuel vapors may be present and must dissipate prior to any electrical connection to the machine.
13. **ALWAYS** replace a blown fuse with one of the same ratings as supplied with your unit. **DONOT** replace the fuse supplied with one larger than shown on the OPERATOR PANEL just above the fuse holder. This may lead to destruction of your power supply or worse yet, cause harm to your power outlet.
14. **ALWAYS** select a safe & secure storage place to prevent unauthorized use or misuse by someone not familiar with your annealer. If you loan your unit to a friend, include this manual and caution them to the dangers involved.
15. **ALWAYS** remember, shooting and reloading are fun recreational activities as long as we stay safe. A little common sense will go a long way toward safety and enjoyment of our sport. We want you to be a **BENCH-SOURCE** customer for a long time to come!

REMEMBER: SAFETY FIRST. PAY ATTENTION!

If you have problems, concerns, questions or comments, **BENCH-SOURCE** is here for you. Please contact us anytime via the methods below.....

EMAIL: Contact@BENCH-SOURCE.COM

Click on the "CONTACT US" Tab on
OUR WEB SITE: www.bench-source.com

PHONE: 662-895-0803

FAX: 662-895-6317

HOURS of OPERATION:

8:30 A.M. – 5:00 P.M. Central Standard Time Monday~Friday

Or

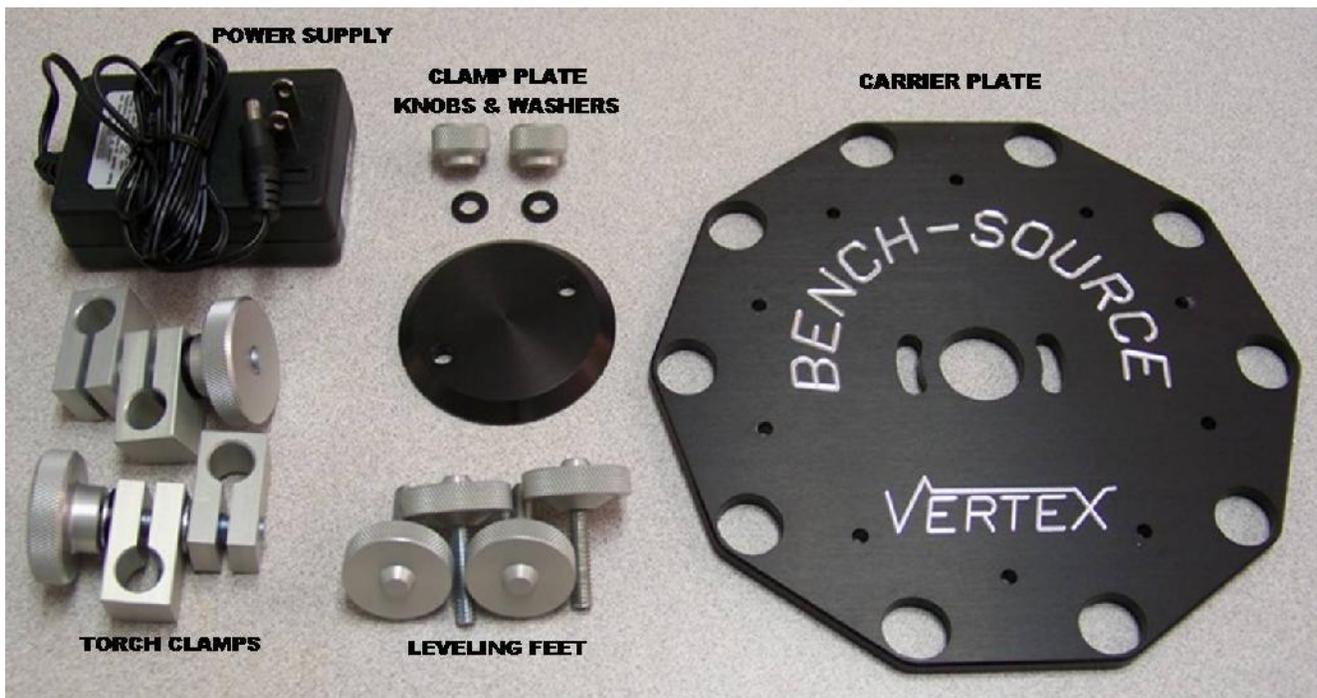
Write to: Vertex Manufacturing Corporation
PO Box 949
Olive Branch, MS 38654-0949

III. What's in the Box & What You Will Need

After you unpack your machine and see the quality construction we know that it will be tempting to jump right in and get things going. Please take a few minutes to ensure that everything listed below has been removed from the packaging and take note of what else you will need to begin annealing.

Contents:

Inside the box is a poly bag containing (4) Leveling Feet, (2) Nylon Washers, (2) Clamp Knobs, (2) Clamp Sets for securing your torch nozzles and (1) Clamp Plate. Also included is your AC Adaptor to power the electronics & drive motors. You should find separately packaged, a Carrier Plate for indexing your cartridge cases. Please see below....



Assembly:

1. After removing the contents from the package, please turn your annealing machine up side down and screw the (4) adjusting feet into the bottom of the tapped holes in the legs.
2. Right the machine with the index sprocket and clamp posts up as shown on the cover of this manual.
3. Place the Carrier Plate over the 5/8 diameter pin in the Sprocket with the two 1/4 studs passing thru the kidney shaped slots in the plate. Make sure that the Carrier Plate rotates freely around the 5/8" pin.
4. Next place the Clamp Plate over the studs (with the bevel side up) and the 5/8" center pin. Top these off with (1) Nylon Washer and (1) Clamp Knob on each stud. It is not necessary to tighten the knobs more than finger tight. Carrier Plate orientation is not important at this point.

Other Items You will Need:

We have used several torches to anneal cases while developing your new machine. The Clamps supplied with your annealer are manufactured slightly oversize to accept 1/2" diameter nozzles. Any propane torch made by 'Bernz-O-Matic'®, 'Worthington'® and others should work fine as long as they have 1/2" diameter nozzles.

(NOTE: When placing the nozzles into the clamps, ensure that you do not cover up the inlet holes at the base of the nozzle. This will make them burn lean and possibly overheat the nozzles and Clamp Assemblies.)

What we have most often used is a pair of kits from 'Bernz-O-Matic'®. The Torch Kit Part Number is #UL100 and comes with one propane tank & one torch. Cost is about \$11.00 per set from your local hardware store. If you would like to purchase the torches separately, the Part Number is #UL2317.

Aside from the torch units, we recommend using a temperature sensing liquid named 'Tempilaq'®. It is made by Tempil® Corporation, South Plainfield N.J. We buy ours from McMaster-Carr®. You can order via the internet, <http://www.mcmaster.com/#temperature-indicators/=69wlzo> or by phone (609) 689-3415. Tempilaq® is also available from many welding supply houses. (NOTE: Do not use the temperature crayons. The liquid is far superior on cartridge cases.) **Also, please read all warnings and directions for use in the Tempilaq® package.** While ordering, go ahead and purchase a bottle of thinner for the Tempilaq®. A few drops of thinner will restore the solution to its original condition after it begins to dry out and thicken over time.

When ordering, you will have to specify the temperatures you desire. We most often use 650° F for sensing neck & shoulder temperatures and 350°F or 400°F on the lower half of the case body. Temperatures may vary according to the way you use your annealer, but these will be good starting places. We will explain in detail how to apply the Tempilaq® to sense the temperature while you are annealing in the SETUP SECTION.

IV. Annealing Info and Why Annealing Helps

Please take a minute and read why **BENCH-SOURCE** made the decision to provide our Annealing Machine to shooters like you. After all we have been shooting for longer than we will be truthful about!

First off, the term annealing is applied to many different types of materials throughout many industries in the world. The term is used to indicate that a material such as steel, brass, copper, plastic and some rubber needs to be softer. The purpose for this softening varies as much as the types of materials that can be annealed.

For example, when we anneal any type of steel in general, it is usually to improve machinability, to modify features or add features that can not be done in a heat treated state. Sometimes it is used to make the properties of the material last longer or more stable and sometimes to accelerate wear to minimize failure of mating parts.

When steel is annealed it is heated to perhaps 1800° F or more and allowed to slowly cool in still air. This will bring the material to its most malleable or soft state. After annealing it will bend or deflect with less resistance and usually without breaking or splitting.

When we anneal cartridge cases, we are also softening the material in an attempt to lower the hardness. While most steel will harden by working it excessively, all brass, bronze, copper and other non-ferrous materials are easily work hardened.

Most cartridge cases are made from material known as Cartridge Brass. It is an alloy of 70% Copper and 30% Zinc. Alloys of the brass will vary slightly from one manufacturer to another but 70/30 is the base line. The reason this material is chosen is because it forms well, is less expensive than other brass or bronze with a higher copper content and is well suited to being hard in one area such as the case head area, while remaining fairly soft in areas such as the neck and shoulder. As you may imagine or by referencing your reloading manuals, flame temperatures in modern cartridges using smokeless powders are usually in excess of 5000°F. If the cartridge case didn't expand and seal in our chambers properly on firing, many of us would not be here today! This brings us to the explanation as to why we need to anneal.

Many people reference the fact that you heat steel to make it harder. While this is true, it is not heated to the same temperatures as to anneal the material. The effect of heating both of these materials is essentially the same. When your cartridge cases are heated to 650°-700°F they are annealed, but not to a dead soft state. The intent is to lessen stresses from sizing & re-sizing and to soften the brass in the desired areas to minimize work hardening. When you anneal you are transforming the grain structure from rather small and tightly constrained into an elongated and more loosely constrained state.

By returning your brass to this condition, you will give it a longer life by eliminating neck/shoulder splits while realizing better accuracy from uniform neck tension on your reloaded cartridges. Of course other areas such as the primer pockets, case stretch and head condition will determine how long your brass will last in a given caliber and type of cartridge.

CAUTION:

Based on the information above, we would like to caution you, the reloader, that special attention to important items such as recording the number of firings and

documenting cartridges from lot to lot in your reloading log. Annealing your cartridge cases does not mean that your brass will have an infinite life! Pay attention to things such as case stretch and overall length as well as the number of trimmings. There are many reloading manuals available which explain dangerous situations and what to look for. We hope you are an experienced and conscientious shooter. If not, please take our advice and seek help if you're not sure of what you are doing!

V. Machine Setup and Operation

At this point you should have your machine located on a solid bench or work surface. The Leveling Feet should be installed and the Drive Plate, Clamp Plate Washers & Knobs in place.

There are only a few steps involved in setting up your new machine. After you have used it a few times, you may develop your own routine, however we suggest you start as described below.



Steps:

- 1) Level your machine by centering the bubble in the circle on the round level mounted in the table of your machine. This is for reference only. The Table Top does not have to be perfectly level to prevent cartridge cases from tipping while indexing.
- 2) Referring to the picture above of the Operator Panel that is mounted on the left side of your machine, please plug the Power Supply into your wall outlet and the other end into the bottom right of the Operator Panel.
- 3) Turn the machine on by toggling the 'On/Off' switch to the "I" position. You should hear the fan inside come on and the green power indicator light should shine bright.
- 4) Rotate the 'Timer Control Knob' counter-clockwise to its minimum setting of approximately 1.5 seconds as shown in the picture.

At this point we would like to explain the operation of the MANUAL/AUTO Switch located on the top right of the Operator Panel. (Don't worry about the position of the Drive Plate or the fact that no cartridge cases are in the plate at this time).

The purpose of this switch is to setup the machine (Manual), then place it in 'Auto Cycle' mode after setup is complete.

5. Lets begin. Please press down and release the Auto/Man switch one time. The machine will index one station then stop. At this point, press down and **hold** the switch a 2nd time. The machine will rotate the spindle. This is to check run out of the cartridge case. It will continue to rotate as long as you hold the switch down.

After you release the switch, again press down to 'Manual' a 3rd time. The Drive Plate will again rotate to the next station. The 4th press will rotate the spindle a second time.

The electronics are designed to continue these two recurring functions each two presses of the switch to the 'Manual' position.

6. After rotating the spindle a second time in the "Manual" mode, actuate the switch up to the 'Auto' position. The machine will operate the spindle for 1.5 seconds, then pause rotation and index to the next station. This will repeat indefinitely until you again push the switch to the down or 'Manual' position. Try adjusting the time while the machine is in 'Auto' mode. You will notice that you may adjust the 'Timer' anytime you wish. The timing will change real-time.

(Note: You must push the switch down to the 'Manual' position while the spindle is rotating to stop the function of the machine. The electronics will not recognize that you have pressed the switch if it is pushed while indexing). Also please note you may turn off the power to the machine at anytime using the ON/OFF switch should a problem occur.

Before the machine ceases operation from 'AUTO' to 'MANUAL' modes, it will rotate one extra station to remove the current cartridge case from between the torch flames. This will prevent overheating of the last case in the Drive Plate if you anticipate stopping the unit too soon.

7. Now that we have learned the function of the Auto/Manual Switch, we will explain how to index or adjust your Drive Plate properly. Please select 10 or so cases, preferably some you can discard, that are the same caliber as the ones you intend on starting out with. You will want to place a paint stripe on your sample cases using the 650°F and 400°F degree Tempilaq® . Please refer to the picture below.



Without torches installed, place your cartridge cases in the shell plate. Six or seven will be fine. Free the Carrier Plate by slightly loosening the 2 thumb screws on top of the Clamp Plate. Rotate the Carrier Plate clockwise/counter-clockwise to approximately center the spindle in the drive hole in the Carrier Plate. You can look straight down from above the Carrier Plate to see the Spindle. Tighten the knobs slightly. There is practically no force on the Carrier Plate so only snug the knobs.

Next, operate the switch to the manual position and release. The Drive Plate will index to the next position. After indexing, again actuate the switch to the down or 'Manual' position and hold it long enough to check the run out of the cartridge. The spindle will rotate the case in the counter-clockwise direction. When the case begins to spin, note whether it moves from left-to-right or right-to-left.

If the cartridge moves from left-to-right, the Carrier Plate needs to be adjusted slightly clockwise. If the cartridge moves from right-to-left, the Carrier Plate needs to be adjusted slightly counter-clockwise. It will usually only take a small amount of movement of the Carrier Plate to get it to place the cartridge case in the center of the spindle.

Our intent here is to get the cartridge case to fully rotate without hitting the Carrier Plate while rotating. If you want to get the case to rotate dead true that is okay, but it is not usually necessary.

Please repeat these steps until your cartridge case type runs as described above. Make sure the last operation of the 'Manual' switch was to rotate the spindle. (**'Auto' Mode will not work unless the last 'Manual' function rotates the spindle**).

8. Next remove all of your cartridge cases from the Carrier Plate and install your Clamps and Torches to your machine as shown. Please see below.



Then place a single cartridge case in the next upcoming station. Index the case by operating the switch to the 'Manual' position. After indexing, adjust your torches to approximately pass through the case center line while looking from above. Then looking from the side of the machine, adjust your torches to where it appears that the flame will hit the case approximately in the midpoint of the shoulder. Please try to keep the torch nozzles parallel to the Carrier Plate to prevent it from getting any hotter than necessary. This is especially true if annealing shorter cases.

When you are satisfied that your setup looks like the pictures shown, actuate the 'Manual' switch one more time to rotate the spindle and remove the cartridge case.

9. The next thing you want to do is turn off the machine and unplug the 'Power Supply' from the Operator Panel. If you have not done so already, attach your propane fuel tanks to the nozzles making sure before hand that the nozzles are shut completely off.

10. Wait a few minutes to ensure that any fumes have dissipated from attaching your tanks. After doing so, reattach your Power Supply to the Operator Panel and turn on the machine.

11. The next thing you want to do is preset your Timer. If you intend on annealing very small cartridge cases such as .22 Hornets, place your Timer on 1½ seconds. Other cartridges such as .223, .308 or magnum sized cases you can preset to 3 - 3½ seconds.

12. Next you want to actuate the switch on the Operator Panel to the 'AUTO' position. When your machine begins cycling light your torches and adjust them to a point where the flame gets no bigger while opening the valve. At this point, you want to decrease the fuel supply knobs until the flame just starts to get smaller. This way, you know what your setting is for repeating on other cases and distances.

Our testing has shown that we want to anneal standard .223 & .308 cartridge cases in about 4-4½ seconds and 4½ -5 seconds on magnums and short magnums. This should work well for a guide line, however you will want to use the sample cases with the Tempilaq® to fine tune your time. Please note that you want to adjust your torch distance from the case to stay in the time ranges mentioned above.

Caution: When annealing small cases such as the Hornet you want to pay particular attention to the temperature very closely. The walls of these cases are very thin and the case heads will get too soft very quickly!

13. Now we're ready to start annealing cases. Place one setup cartridge case about 3-4 stations from the spindle station. When the cartridge gets to the 'Spindle' station and begins to rotate, watch the Tempilaq® stripes you made on the setup case. If the stripe closest to the case mouth (650F) does not turn clear before the machine indexes, turn up your 'Timer' by about ¼ second and repeat this step. (You can re-load the same sample cases until the proper setup is achieved).

Each time a case leaves the spindle station, note whether or how far the stripe has turned clear from heating. Trust the Tempilaq® and do not over heat your cases. The stripe should turn clear just below the shoulder area as the cartridge case indexes out of the flame. The mouth and neck of the cartridge case will be a little hotter than the body where the Tempilaq® turned clear because there is no material for the heat to transfer to. Pay close attention and make sure that the necks of your cases are not turning to a very dull red or orange color. If so, reduce your time and discard those cases.

After you're satisfied that the cases are indexing just as the Tempilaq® turns clear, note what your 'Timer' setting is. It should be 4-5 seconds on standard cases as we mentioned. Also note the Tempilaq® stripe you placed on the lower half of the cartridge case (350°F -400°F). **The Tempilaq® should not change within 1" or so of the case head! This distance may vary a bit depending on the cartridge case type you're annealing, however, you do not want the case head anywhere near 400°F! If you're unsure, practice or adjust your torch setup for less time in the flame and discard any cartridge cases that may have over heated!**

14. When you're comfortable with the setup you have and convinced that you are not over heating the case heads, continue feeding cases into the Drive Plate until finished with that particular caliber.

15. When done, if you have other cartridges that are similar in head size but longer or shorter in length, now is a good time to anneal them as well. Only a slight adjustment will need to be made in the height of your torch nozzles and your Timer setting will be very close to correct.

16. Otherwise, shut off the fuel supply to your torch nozzles and let the machine, Drive Plate and torches cool down completely. (It is a good idea to let the Drive Plate rotate in 'AUTO' while cooling). Turn off the Power Switch and then unplug your Power Supply from the machine & wall outlet. Remove the fuel tanks from the torches and the torches from the clamps. Store the unit as described in **SECTION II** earlier in this manual.

Tips:

If you ultrasonically clean your cases or brush the insides of the necks, place a swipe of 650°F Tempilaq® inside the mouth of your setup cases. It will work great to indicate neck temperature.

The cleaner your cases are prior to annealing the better they will look. The surface condition also plays a part in the looks of an annealed case. Only experience will help your consistency in annealing. A good practice is to keep a log on the cases you anneal and take pictures of your setups while annealing. We do that all the time when machining less common parts.

Always clean the exterior of your case necks and shoulders if they are smoked up with carbon from firing. The heat from the torches will not travel into the cartridge cases uniformly with carbon suit. As a matter of fact, the torches will bake the carbon in, making it almost impossible to remove.

If your cartridge case necks turn charcoal gray when annealing, we have found that there are usually traces of sizing lube left behind from the last resizing. If the cases were cleaned well prior to annealing, you may be over heating or heating the necks and shoulders too quickly.

A good starting distance for the blue 'pencil' part of the flame tip to the case shoulder is about 3/8"-1/2" away. It will need to be closer for really small cases like the .22 Hornets or .218 Bees. If you don't over tighten the knobs on the clamp posts, you can "wiggle" them farther or closer to the cartridge case without loosening them.

Always remember to set your Timer to a low setting when starting your setup. It is a helpless feeling watching a case glowing orange while you're waiting for the machine to index.

We cannot emphasize enough how important it is, "DO NOT OVER HEAT" the head of your cartridge cases! Please start out using old brass with a lot of firings. Grab 30 pieces and run them over and over again changing your torch tip and flame positions. Afterwards, throw them away. Practice makes perfect and it's much cheaper and safer than melting a case head in your rifle and hurting yourself or someone else nearby!

VII. Warranty Information / Service

VERTEX MANUFACTURING CORPORATION warrants your new case neck annealing machine against defects in **materials and workmanship** for the life of the machine. This warranty is extended to the original retail purchase(r) only. It is not valid on the electronics, motors, fan, power supply & switches. These components are covered and will be replaced by Vertex Manufacturing Corporation for a period of (2) two years. This (2) two year period begins at the time of retail purchase by the original owner. Proof of purchase is required for warranty repairs and proof thereof is the sole responsibility of the owner.

The cost of freight/shipping to Vertex Manufacturing Corporation is the responsibility of the owner and should be insured by the shipping carrier. If deemed defective upon receipt, Vertex Manufacturing Corporation will either repair or replace the defective parts/pieces at our discretion and return to the original owner with freight costs prepaid and insured.

This warranty does not cover normal wear & tear or damage from abuse or misuse. If a unit is returned for warranty reasons and deemed to be damaged from normal wear & tear, abuse or misuse we will notify you after our evaluation. Vertex Manufacturing Corporation will provide an estimate to repair or replace the needed parts and only make the needed repairs with authorization from the owner. The cost of repairs will be itemized in the estimate and must be prepaid along with return shipping costs prior to return shipment. All return shipments will include insurance for the value of the machine and added to the shipping costs.

Vertex Manufacturing Corporation will not be responsible for lost or damaged units during shipment.

Units returned to Vertex Manufacturing Corporation without first contacting us to obtain a Return Materials Authorization may be refused and returned to the sender freight collect.

The unit SERIAL NUMBER should be registered with Vertex Manufacturing Corporation by the owner within (15) fifteen days after purchase. We will maintain that information in our records and we will validate your warranty upon receipt. Please include a copy of your sales receipt. You may scan and email this information, mail it to us or fax it to 662-895-6317. You will find your Unit Serial Number by turning the machine up side down and looking next to the cartridge discharge port. You should receive a confirmation of your Warranty Validation by return mail within 30 days.

Purchased by: _____

Date of Purchase: _____ Serial Number: _____

Mailing Address: _____

Purchased from: _____

Service

In the unlikely event your unit needs servicing after the warranty period please contact us first to obtain a Return Material Authorization. Units returned to Vertex Manufacturing Corporation without first contacting us to obtain a Return Materials Authorization may be refused and returned to the sender freight collect.

When you return your unit, you must specify the reason for return or a description of the malfunction you have experienced. This will help us to better determine the problem you may be having. Also, we may be able to cure the problem over the phone.

After receipt of your unit we will notify you when we complete the evaluation. Vertex Manufacturing Corporation will provide an estimate to repair or replace the needed parts and only make the needed repairs with authorization from the owner. The cost of repairs will be billed based on this estimated cost and must be prepaid along with return shipping. All return shipments will include insurance for the value of the machine and added to the shipping costs.

Your new Case Neck Annealer was designed to anneal many thousands of cartridge cases and we want you as a customer for a long time! After all, we are introducing new products all the time and we want you to look to BENCH-SOURCE first!

We would appreciate any feed back from you as the owner of the machine or any other products that we manufacture. Whether it is to make recommendations, comments, share concerns or complain about quality or customer service, we welcome you to share it with us!

BENCH-SOURCE is here for **YOU!**

EMAIL: Contact@BENCH-SOURCE.COM

Click on the "CONTACT US" Tab on

OUR WEB SITE: www.bench-source.com

PHONE: 662-895-0803

FAX: 662-895-6317

HOURS of OPERATION:

8:30 A.M. – 5:00 P.M. Central Standard Time Monday~Friday

Or

Write to: Vertex Manufacturing Corporation

PO Box 949

Olive Branch, MS 38654-0949

THANK YOU FOR YOUR BUSINESS!