

WARNING:

Eye protection must be worn as SRT may produce brass shavings!



EYE PROTECTION MUST BE WORN

PROTECTION MUST BE WORN

Thank you for choosing "The UGLY SRT" (Shoulder Referenced Trimmer). Please read these instructions before trimming your brass.



Scan QR CODE to watch instruction videos!

How to roughly set the trimming length

Remove the Micro Adjustment Ring with M3 Allen key. Insert a new/measured piece of brass with standard SAAMI length. Loosen both grub screws on main body with M3 Allen key. Hold the brass tight against the cutter. Lock the main body grub screws on both sides. Now the resulting brass length should be very close to SAAMI length.

How to use micro adjustment ring to precisely adjust the cutting depth.

• To cut more material (To reduce the brass length)

Main body grub screws remain tight→ Loosen grub screw on the micro adjustment ring→ Insert a feeler gauge or a piece of paper in between the ring and main body→ Lock grub screw on the micro adjustment ring→ Loosen the grub screws on main body→ Push the cutter bit and ring firmly against the main body→ Lock grub screws on main body The cutting depth is now increased by the thickness of the inserted feeler gauge or the piece of paper.

• To cut less material (To increase the brass length)

Micro adjustment ring grub screws remain tight→ Loosen grub screws on main body→ Insert a feeler gauge or a piece of paper in between the ring and main body→ Lock grub screws on main body

The cutting depth is now decreased by the thickness of the inserted feeler gauge or the piece of paper.

Trimming Multiple Calibres - Pre-set.

Additional cutter bits and micro adjustment rings can be purchased for making pre-sets for different calibres. The cutting depth will remain exactly the same when you re-install the cutting bit and locked micro adjustment ring back on the main body.

Cutting RPM and Push force

The UGLY SRT can be used on a battery powered drill or on a drill press. 1200-2500RPM should work. Hold the brass with your fingers and push the brass into the chamber of the collet insert. Push the brass firmly when you feel the cutter stop cutting material. This will force the bearing inwards therefore achieve more consistent results.

If you find the cutter bit bites into the neck and seizes, this means you are cutting too much or too fast. You can reduce the cutting depth by changing the push force or change the cutting RPM. Play a bit more and you will nail it.

Collet O-Ring size=16*2mm. Do NOT use 16*1.9mm!
DO NOT OVER TIGHTEN GRUB SCREWS TO PREVENT THREAD DAMAGE!

At time of printing Jul 2023. We produce following calibre collet inserts. This list may be expanded without notice. You can order extra collet inserts, SRT sets or spare parts from our dealers or directly from www.derraco.com.au

0 12L14 collet blank with 4.5mm hole NA 1 6.5 GRENDEL 30 2 6.5 PRC 30 3 6.5 CREEDMOOR/6.5X47 LAPUA 30 4 6.5X55 SWEDEN 25deg15min 5 6 CREEDMOOR/6 NORMA BR 17deg30min 7 22-250 REM 28 8 30-06 SPRINGFIELD 17deg15min 9 204 RUGER 30 10 222 REM/223 REM 20 11 300 WIN MAG 23 15 300 ACC BLACKOUT 23 16 303 BRITISH 16deg58min 17 308 WIN 20 18 33 LAPUA MAGNUM 20 20 300 PRC 30 21 7MM-08 REM 25 22 25-06 REM 25 23 17 HORNET 5deg29min 24 7MM-08 REM 20 25 7.62X54 MM R 15deg33 deg 26 30-30 WIN 20	COLLET #	CARTRIDGE	SHOULDER TAPER
6.5 GRENDEL 6.5 PRC 6.5 CREEDMOOR/6.5X47 LAPUA 6.5X55 SWEDEN 6.5X55 SWEDEN 7.62X39 MM 22-250 REM 20-06 SPRINGFIELD 204 RUGER 222 REM/223 REM 270 WIN 270 WIN 300 ACC BLACKOUT 303 BRITISH 300 PRC 300 WIN SHORT MAGNUM 7MM REM MAG 25-06 REM 25-06 REM 7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	0	12L14 collet blank with 4.5mm hole	NA
6.5 PRC 6.5 CREEDMOOR/6.5X47 LAPUA 6.5X55 SWEDEN 6.5X55 SWEDEN 7.62X39 MM 22-250 REM 20-250 REM 204 RUGER 222 REM/223 REM 2270 WIN 270 WIN 300 WIN MAG 300 ACC BLACKOUT 303 BRITISH 303 BRITISH 300 WIN SHORT MAGNUM 7.62X54 MM REM MAG 22 HORNET 7MM-08 REM 22 HORNET 7MM-08 REM 217 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	ם נ		30
6.5X55 SWEDEN 6.CREEDMOOR/6 NORMA BR 7.62X39 MM 22-250 REM 30-06 SPRINGFIELD 204 RUGER 222 REM/223 REM 270 WIN 300 ACC BLACKOUT 303 BRITISH 303 BRITISH 308 WIN 338 LAPUA MAGNUM 300 PRC 300 WIN SHORT MAGNUM 300 PRC 300 WIN SHORT MAGNUM 7.62X54 MM R 30-30 WIN 25-06 REM 217 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	ω 1	6.5 CREEDMOOR/6.5X47 LAPUA	30
7.62X39 MM 22-250 REM 30-06 SPRINGFIELD 204 RUGER 224 WIN 270 WIN MAG 300 ACC BLACKOUT 303 BRITISH 303 BRITISH 300 PRC 300 PRC 300 WIN SHORT MAGNUM 7MM REM MAG 25-06 REM 25-06 REM 25-06 REM 17 HORNET 300 NORMA MAGNUM 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER)	4	6.5X55 SWEDEN	25deg15min
7.62X39 MM 22-250 REM 30-06 SPRINGFIELD 204 RUGER 222 REM/223 REM 243 WIN 270 WIN 300 ACC BLACKOUT 303 BRITISH 308 WIN 338 LAPUA MAGNUM 338 LAPUA MAGNUM 300 PRC 300 WIN SHORT MAGNUM 7MM REM MAG 22 HORNET 7MM-08 REM 7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER)	5	6 CREEDMOOR/6 NORMA BR	30
22-250 REM 30-06 SPRINGFIELD 204 RUGER 224 WIN 270 WIN MAG 300 ACC BLACKOUT 303 BRITISH 308 WIN 308 WIN 309 PRC 300 PRC 300 WIN SHORT MAGNUM 7MM REM MAG 25-06 REM 25-06 REM 25-06 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER)	6	7.62X39 MM	17deg30min
204 RUGER 222 REM/223 REM 243 WIN 270 WIN 300 ACC BLACKOUT 303 BRITISH 308 WIN 338 LAPUA MAGNUM 300 PRC 300 WIN SHORT MAGNUM 7MM REM MAG 25-06 REM 22 HORNET 7MM-08 REM 7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER)	7	22-250 REM	28
204 RUGER 222 REM/223 REM 243 WIN 270 WIN 300 WIN MAG 300 ACC BLACKOUT 303 BRITISH 308 WIN 308 WIN 300 PRC 300 WIN SHORT MAGNUM 7MM REM MAG 25-06 REM 25-06 REM 22 HORNET 7MM-08 REM 7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER)	8	30-06 SPRINGFIELD	17deg15min
243 WIN 270 WIN 300 WIN MAG 300 ACC BLACKOUT 303 BRITISH 308 WIN 338 LAPUA MAGNUM 300 PRC 300 WIN SHORT MAGNUM 7MM REM MAG 25-06 REM 22 HORNET 7MM-08 REM 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	9	204 RUGER	30
243 WIN 270 WIN 300 WIN MAG 300 ACC BLACKOUT 303 BRITISH 308 WIN 338 LAPUA MAGNUM 300 PRC 300 WIN SHORT MAGNUM 7MM REM MAG 25-06 REM 22 HORNET 7MM-08 REM 22 HORNET 7MM-08 REM 30-30 WIN 60 REM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	10	222 REM/223 REM	23
243 WIN 270 WIN 300 WIN MAG 300 ACC BLACKOUT 303 BRITISH 308 WIN 308 WIN 338 LAPUA MAGNUM 300 PRC 300 WIN SHORT MAGNUM 7MM REM MAG 25-06 REM 22 HORNET 7MM-08 REM 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM			
270 WIN 300 WIN MAG 300 ACC BLACKOUT 303 BRITISH 308 WIN 308 WIN 338 LAPUA MAGNUM 300 PRC 300 WIN SHORT MAGNUM 7MM REM MAG 25-06 REM 22 HORNET 7MM-08 REM 7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER)	12	243 WIN	20
300 WIN MAG 300 ACC BLACKOUT 303 BRITISH 308 WIN 338 LAPUA MAGNUM 300 PRC 300 WIN SHORT MAGNUM 7MM REM MAG 25-06 REM 22 HORNET 7MM-08 REM 7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER)	13	270 WIN	17deg30min
300 ACC BLACKOUT 303 BRITISH 308 WIN 338 LAPUA MAGNUM 300 PRC 300 WIN SHORT MAGNUM 7MM REM MAG 25-06 REM 22 HORNET 7MM-08 REM 7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER)	14	300 WIN MAG	25
303 BRITISH 308 WIN 338 LAPUA MAGNUM 300 PRC 300 WIN SHORT MAGNUM 7MM REM MAG 25-06 REM 22 HORNET 7MM-08 REM 7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	15	300 ACC BLACKOUT	23
308 WIN 338 LAPUA MAGNUM 300 PRC 300 WIN SHORT MAGNUM 7MM REM MAG 25-06 REM 22 HORNET 7MM-08 REM 7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER)	16	303 BRITISH	16deg58min
338 LAPUA MAGNUM 300 PRC 300 WIN SHORT MAGNUM 7MM REM MAG 25-06 REM 22 HORNET 7MM-08 REM 7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	17	308 WIN	20
300 PRC 300 WIN SHORT MAGNUM 7MM REM MAG 25-06 REM 22 HORNET 7MM-08 REM 7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER)	18		20deg00min23sec
300 WIN SHORT MAGNUM 7MM REM MAG 25-06 REM 22 HORNET 7MM-08 REM 7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	19	300 PRC	30
7MM REM MAG 25-06 REM 22 HORNET 7MM-08 REM 7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	20	300 WIN SHORT MAGNUM	35
25-06 REM 22 HORNET 7MM-08 REM 7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	21	7MM REM MAG	25
22 HORNET 7MM-08 REM 7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	22	25-06 REM	17deg15min
7MM-08 REM 7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	23	22 HORNET	5deg29min
7.62X54 MM R 30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	24	7MM-08 REM	20
30-30 WIN 260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	25	7.62X54 MM R	18.56653 deg
260 REM 17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	26	30-30 WIN	15deg39min
17 HORNET 300 NORMA MAGNUM 284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	27	260 REM	20
284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	28	17 HORNET	25
284 WIN 6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	29	300 NORMA MAGNUM	20deg30min
6 DASHER 8X57mm (8mm MAUSER) 7mm REM SAUM	30	284 WIN	35
8X57mm (8mm MAUSER) 7mm REM SAUM	31		40
7mm REM SAUM	32	8X57mm (8mm MAUSER)	19
	33	7mm REM SAUM	30

Main body:

Ugly SRT main body is made of 6061 aircraft grade aluminum alloy (USA made round stock), hard anodic oxidation coated for maximum wear resistance. CNC lathe milled to be within 0.01mm tolerance. We have even upgraded to brass tip grub screws to prevent shank damage.

A high-grade France made AB SKF deep groove ball bearing is press fitted to the main body, provides very smooth trimming operation. This ball bearing itself retails more than \$20 in Australia.

Snap fit caliber collet insert:

Made of 303 stainless steel, CNC lathe milled with high accuracy and smooth chamber finish. This collet insert can be removed easily with our insert removal tool. The collet can be easily inserted by hand.

No.0 collet blank is made of 12L14 easy machining steel for gunsmith or DIY use. 12L14 steel is NOT stainless but it is more friendly to reamers on a manual lathe.

Milling blade cutter:

The milling blade is made of M2AL HSS, extremely sharp and durable. The milling blade and shank is centerless ground to slide fit shank hole with only 0.01mm in gap. Therefore, the cross section cut on the brass will be clean and smooth. The trimmer won't wobble when in rotation thanks to high concentricity.

Innovative Lock n Adjust ring:

Each set comes with an adjustable ring. User can use the feeler gauge or simply a piece of paper for precise trimming depth adjustment. If user wishes to change caliber, this adjustment ring can be locked onto the cutter shank. The cutter can be installed back to the main body to repeat the previous settings without any resetting needed.

Collet removal tool:

Made of 304 stainless steel. Don't attempt to pry the collet out, use the center cut to pull the collet out.

The UGLY SRT is made in China with globally sourced parts. Engineered in Canberra, Australia by Derraco Engineering.

Visit www.derraco.com.au for more information

Email: derracoppc@gmail.com

Thank you for purchasing our amazing SRT Trimmer. We hope you were astonished by the quality for the price, and enjoy the ease of use.

Cheng Fei (studied Civil Engineering in University of Tasmania)