



**EYE
PROTECTION
MUST BE WORN**

WARNING:

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



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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

COLLET #	CARTRIDGE	SHOULDER TAPER
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	30
6	7.62X39 MM	17deg30min
7	22-250 REM	28
8	30-06 SPRINGFIELD	17deg15min
9	204 RUGER	30
10	222 REM/223 REM	23
11		
12	243 WIN	20
13	270 WIN	17deg30min
14	300 WIN MAG	25
15	300 ACC BLACKOUT	23
16	303 BRITISH	16deg58min
17	308 WIN	20
18	338 LAPUA MAGNUM	20deg00min23sec
19	300 PRC	30
20	300 WIN SHORT MAGNUM	35
21	7MM REM MAG	25
22	25-06 REM	17deg15min
23	22 HORNET	5deg29min
24	7MM-08 REM	20
25	7.62X54 MM R	18.56653 deg
26	30-30 WIN	15deg39min
27	260 REM	20
28	17 HORNET	25
29	300 NORMA MAGNUM	20deg30min
30	284 WIN	35
31	6 DASHER	40
32	8X57mm (8mm MAUSER)	19
33	7mm REM SAUMI	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: derracopp@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.

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