

AGS Brass Annealer Operating and Maintenance Manual  
PLEASE READ THIS MANUAL BEFORE YOU CALL ASKING FOR  
TECHNICAL SUPPORT

We at AGS Custom Parts are always happy to help if you have any questions, but it's nice to know you have read this first. It will help if you can use the same words to describe parts of the annealer as well.

Please only use deccaped cases in the annealer. This way cases will rotate as they are supposed to (in many occasions firing pin marks protrude lower than the base of case and that can lead to them not spinning properly), plus this is the safer way to go, not to have primed case exposed to excessive heat.

Minor scratches and marks occur in fabrication and transportation process of the AGS Brass Annealer and they are not considered a warranty item.

Upon receiving the annealer, please do check the wiring and overall condition of the unit due to possible damage from shipping.

The use and operation of the annealer is subject to the Terms and Conditions available on the [agscustomparts.com](http://agscustomparts.com) website.

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## Introduction

The annealer you have purchased is a light and compact annealing machine that will supply years of reliable operation if the processes and safety procedures in this manual are observed.

Annealed cases should provide you with prolonged case life and more consistent performance in the final loaded ammunition.

Please ensure you read this manual from start to finish **BEFORE** you use the annealer. Please pay attention to the following key points;

- The best process is to decap and then anneal your cases, then resize them as part of the reloading process. Do not resize them before annealing as the cases can spring back in the process.
- If you wish to de-prime your case as part of your cleaning routine before annealing, use a universal decapper and not sizing die, or a neck sizing die without bushing.
- Under no circumstances should live ammunition or cases with live primers be processed through the annealer as this could result in injury or death.
- Check the rotating plate position is in the locked/indexed position before using the annealer. Failure to do so might lead to lever handle breakage. Also, check the height of the rotating arm is correct – it shouldn't touch the rotating plate, but to be approx. 1 mm above it. Touching the rotating plate can cause motor malfunction, and failure to check these before using the unit, causing the damage will void warranty.
- Lever handle is designed to bend/brake if the case is stuck for any reason as a safety feature.
- Case catch tray should go with tapered side forward and should be positioned and aligned with the notch on it with the annealer housing so the case hits the tapered side of the tray and drop aside (not to remain in upright position).
- Any modifications to the annealer will void the warranty, if you have a question on the annealer or its operation, please ask us.
- AGS Custom Parts products are sold subject to the terms and conditions detailed on the website. Refer to <https://www.agscustomparts.com/terms-and-conditions>

## Safety First

Please note that with all machinery, your safety is critical. Do not allow inexperienced users to access or operate this machine and never allow children or minors near this machine whilst it is operating. Never attempt any sort of work or adjustment on the machine whilst the machine is energized or operating. Work should never be done on the annealer unless the power supply is turned off and the power lead is unplugged from the power supply.

Failure to do this could result in significant injury or death as a consequence.

In addition, you should never process reloaded ammunition or cases with live primers through the annealer, if the ammunition or components are ignited, there is significant risk of injury or death as a result.

## Disclaimer

The purchaser and users of this machine expressly acknowledges and hold harmless AGS Custom Parts, its affiliates, associates and resellers (hereafter noted as AGS Custom Parts), from all liabilities including loss of income, injury, harm or death for the use of the annealer and any actions that the use of the annealer may have.

AGS Custom Parts make no claims or guarantees regarding the suitability of the processed cases for reloading or any other use and it is the responsibility of the user to verify the suitability and purpose of the finished product.

All AGS Custom Parts products are subject to the terms and conditions detailed on the [agscustomparts.com](http://agscustomparts.com) website.

## 1. What is supplied with the Annealer?

The standard annealer will be supplied with the following components:

1. Annealing machine with single torch holder
2. Case tray
3. Two standard inserts set – small for .223 and alike and large for .308 cases and alike – for version 1.0. Version 2.0 comes with additional set that is suitable for cases with .532” heads.

### 1.1 Power supply

Unit is supplied with power adapter with interchangeable jacks, to suite US, UK and EU wall outlets. DC power adapter is 12V 2A with standard 5.5x2.1mm jack, center positive.

## 2. Adjusting time to anneal a case

We strongly advise using Tempilaq for setting up the proper time to anneal the case. Eye observing or brass color change is not a sure way to determine if the brass annealed, under or over annealed. Under annealing has no effect on the brass, and over annealing can lead to dangerous situations.

Case heating time is adjusted over the pwm switch on the side of the annealer. There are no markings on it, because every brass annealing session flame and timing should be adjusted at that time, due to differences in various conditions – like current weather, temperature, gas bottle pressure (unless used with regulator) case manufacturer etc. This is also why we don't offer the annealer with the digital display pwm.

## 3. Torch holder height

Torch holder height is adjusted via one allen head screw. Release it, adjust the height and angle of the torch (most commonly on the shoulder of the case, preferably upwards) and tighten the screw. Be careful, do not adjust it while the holder is hot, because it will get hot from the torch head while being used. Standard torch holder accepts 1/2” torch heads.

## 4. Caliber conversions

Caliber conversion is done under 60 seconds – just remove existing inserts and replace them with the proper sized ones and you are good to go – to adjust the time for the next session.

## 5. What maintenance is required on the AGS Brass Annealer?

The short answer is, very little. Other than keeping it clean, it requires no maintenance, if used in normal conditions and per this instruction manual.

Should you require replacement components please contact us using the contact details below. Should the electric motor stop working, or wiring gets disconnected or pwm fails please do not use the machine, remove the power lead from the wall socket and ensure the machine is not used, place an “Out of Service” tag on the machine if available.

Contact us at [agscustomparts.com](http://agscustomparts.com) using the contact details below.

## 6. How to contact us at AGS Custom Parts

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