

## Lee Precision 90225

# Lee Precision .218 Bee Case Length Gauge and Shellholder

Model: 90225

## 1. INTRODUCTION

The Lee Precision .218 Bee Case Length Gauge and Shellholder is a specialized tool designed for precise trimming of brass cases to their correct length and squaring the case mouth. This process is crucial for maintaining consistent ammunition quality and accuracy in reloading. This manual provides instructions for the proper use and care of your Lee Precision Case Length Gauge and Shellholder.

This product is intended for use by experienced reloaders and requires additional components, specifically a Lee Cutter and Lock Stud (sold separately), or a Zip Trim system, to function correctly.

## 2. PRODUCT OVERVIEW



*Figure 1: Lee Precision .218 Bee Case Length Gauge and Shellholder.*

This image displays the two primary components of the Lee Precision .218 Bee Case Length Gauge and Shellholder set. On the right is the elongated, cylindrical case length gauge with a threaded top. On the left is the circular shellholder, designed to securely hold a brass case during the trimming process. Both components are made of metal.

The set includes:

- **Case Length Gauge:** A precision-machined rod set to the exact length required for .218 Bee cases.
- **Shellholder:** Designed to securely hold the .218 Bee brass case during the trimming operation.

### 3. SETUP AND ASSEMBLY

---

Before beginning the case trimming process, ensure you have the following additional components:

- Lee Cutter (sold separately)
  - Lee Lock Stud (sold separately) or Lee Zip Trim system
1. **Attach Lock Stud to Shellholder:** Take the Lee Lock Stud and screw it firmly into the center hole of the shellholder.
  2. **Attach Length Gauge to Cutter:** Screw the Lee Case Length Gauge into the Lee Cutter. The length gauge is pre-set to ensure the case is trimmed to the correct specification for the .218 Bee cartridge.
  3. **Prepare Work Area:** Ensure your reloading bench or work area is clean, well-lit, and free of obstructions.

### 4. OPERATING INSTRUCTIONS

---

Follow these steps for accurate case trimming:

1. **Insert Brass into Shellholder:** Place an empty, decapped, and cleaned .218 Bee brass case into the shellholder. Ensure it is seated securely.
2. **Insert Length Gauge into Case:** Carefully insert the assembled Lee Cutter and Case Length Gauge into the mouth of the brass case. The tip of the length gauge should rest against the inside bottom of the case.
3. **Begin Trimming:** While holding the shellholder and case steady, turn the Lee Cutter clockwise. The cutter will begin to remove material from the case mouth. Continue turning until the cutter stops removing brass. This indicates that the case has been trimmed to the predetermined length set by the length gauge.
4. **Remove and Inspect:** Remove the trimmed case from the shellholder. Inspect the case mouth to ensure it is square and free of burrs. Deburr the case mouth as necessary using a chamfer/deburring tool (sold separately).
5. **Repeat:** Repeat the process for all cases requiring trimming.

*Note: For optimal results, ensure your brass cases are clean before trimming. Always wear appropriate safety glasses when reloading.*

### 5. MAINTENANCE

---

Proper maintenance will extend the life and accuracy of your Lee Precision tools:

- **Cleaning:** After each use, wipe down the Case Length Gauge and Shellholder with a clean, dry cloth to remove any brass shavings or residue.
- **Lubrication:** No lubrication is typically required for these components. Keep them dry and free of oils that could attract debris.
- **Storage:** Store the tools in a clean, dry environment, preferably in their original packaging or a

dedicated storage container, to prevent corrosion and damage.

- **Inspection:** Periodically inspect the tools for any signs of wear, damage, or corrosion. Replace components if they show significant wear that could affect performance.

## 6. TROUBLESHOOTING

| Problem                   | Possible Cause  | Solution  |
|---------------------------|---|---|
| Inconsistent Case Lengths | <ul style="list-style-type: none"><li>• Improper seating of case in shellholder.</li><li>• Cutter not fully engaged or dull.</li><li>• Debris interfering with gauge.</li></ul> | <ul style="list-style-type: none"><li>• Ensure case is fully seated and held firmly.</li><li>• Verify cutter is sharp and properly attached.</li><li>• Clean tools thoroughly before use.</li></ul> |
| Difficulty Turning Cutter | <ul style="list-style-type: none"><li>• Excessive brass to be removed.</li><li>• Cutter is dull.</li><li>• Case not properly aligned.</li></ul>                                 | <ul style="list-style-type: none"><li>• Ensure cases are within reasonable trim-to length.</li><li>• Replace or sharpen cutter.</li><li>• Re-seat case and re-align cutter/gauge.</li></ul>         |

## 7. SPECIFICATIONS

| Feature                    | Detail                         |
|----------------------------|--------------------------------|
| Model Number               | 90225                          |
| Cartridge Compatibility    | .218 Bee                       |
| Material                   | Steel                          |
| Included Components        | Case Length Gauge, Shellholder |
| Item Dimensions (LxWxH)    | 5 x 4 x 1 inches               |
| Package Dimensions (LxWxH) | 3 x 3 x 0.2 inches             |
| Package Weight             | 4 ounces                       |

## 8. WARRANTY AND SUPPORT

For specific warranty information regarding your Lee Precision .218 Bee Case Length Gauge and Shellholder, please refer to the documentation provided with your purchase or visit the official Lee Precision website. Warranty terms and conditions may vary.

Should you require technical assistance or have questions not covered in this manual, please contact Lee Precision customer support directly. Contact information can typically be found on the manufacturer's website or product packaging.

