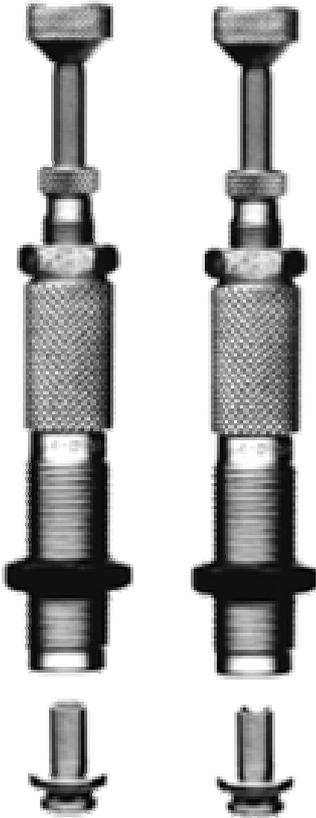


CH Jacketed Soft-Point and Jacketed Hollow-Point

SWAGING DIES



When CH first introduced the No. 203 Swag-O-Matic bullet making press along with their half-jackets, it opened up a brand new field for handgunners. For the first time handgun shooters could make their own special swaged half-jacketed bullets. However as velocity increased, leading of the bore became a problem. This can be overcome by the use of a top bleed nose punch to a certain extent. However there is still a small area of lead that touches the bore.

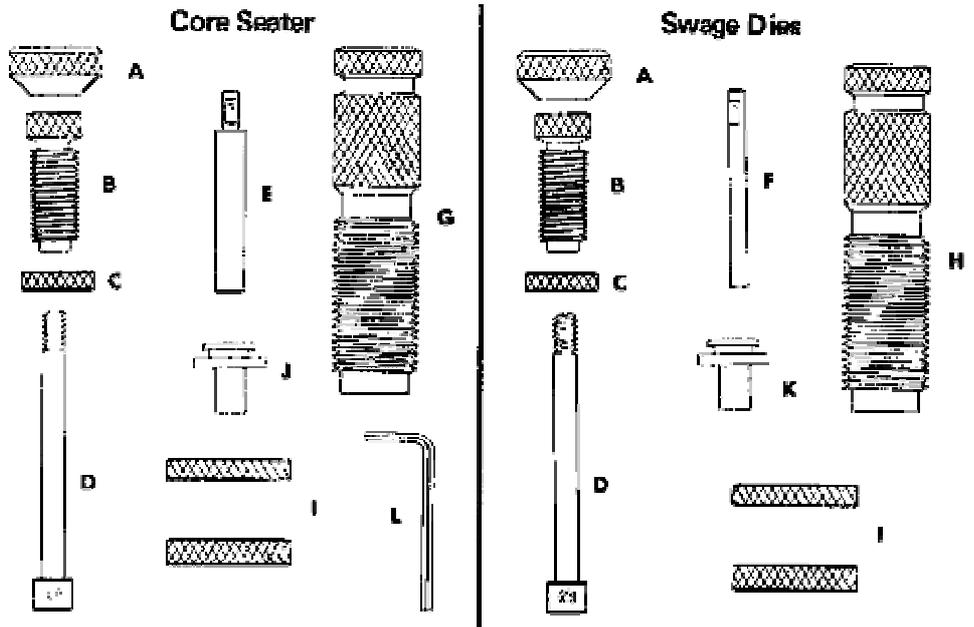
These new C-H bullet swaging dies take into consideration the faults of the original press. Now you can make your own full-jacketed pistol bullets, with no lead in contact with the bore. The jacket is swaged up over the ogive of the bullet, forming a perfect bullet every time.

Dies are threaded 7/8x14 and can be used in any press capable of full-length sizing. We recommend our Champion press which is designed to do all phases of reloading, including the swaging of the largest bullets.

With these CH Swaging Dies you can produce an infinite range of bullet weights by adjusting your dies accordingly. With these CH Swaging Dies you can make your own bullets of a quality to compete with the finest marksmen in the world!

Your CH Swaging Dies come to you complete. The exploded drawing shows you the component parts of the dies.

COMPONENT PARTS LIST OF DIES



- A Ejector Knob
- B Threaded Collar
- C Small Lock Ring
- D Ejector Holder

- E Core Seating Ejector
- F Swaged Bullet Ejector
- G Core Seating Die Body
- H Swaging Die Body
- I Large Lock Rings
- J Core Seating Punch
- K Bullet Swaging Punch
- L Allen Wrench

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- J Core Seating Punch
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Read Instructions Completely Before Using Dies

The core seating punch is placed directly into the ram of your press in the slot normally used for the shell holder. (Core seating punch is concave on top and has a bleed hole running through the center). The core seating die is screwed into your press until the ram with the core seating punch in place starts to enter the bottom of the die. The core seating punch should enter the die about 1/4". Lock the die in place with the lock rings provided. Any further adjustments can be made with the threaded sleeve on top of the die. Lightly lubricate the cups by rolling them across your lubricating pad. Regular sizing die lube can be used for this purpose. To determine weight of the finished bullet weigh your cut or cast core together with the cup you are going to use. The combined weight of your core and cup should be approximately one grain over finished bullet weight. The properly cut core is placed into the jacket AND INVERTED, so the jacket or cup goes into the die body first. Raise the ram, forcing the core and cup up into the core seating die. If undue pressure is felt, loosen the lock ring on top of the die and turn the adjusting sleeve counter-clockwise, and raise the ram again until you feel the core seating punch make contact with the core. If little or no pressure is felt when seating the core, turn the adjusting sleeve clockwise, thereby lowering the ejector. Seat the core into the cup until about 1/8" of lead is extruded. This die will seat the core and at the same time bleed off any excess lead from overweight cores. A perfect bullet will result if your core is seated to be almost flush with the top of the cup. This will result in the proper amount of lead exposed in your finished bullet. A light tap with a mallet or the palm of your hand will eject the core and cup.

Keep your finished cores and cups clean, as any dirt picked up while in this stage of completion will surely scratch the swaging dies.

When you have finished seating all of your cores, remove the core seating die and the core seating punch from the press. Replace these with the swaging punch (the punch with the flat top) and the swaging die. Adjust these dies the same as you would the core seating die.

The ejectors in these swaging dies are pre-set at the factory. However slight adjustments can be made to more exactly fit your particular needs.

If you are making a light bullet, the swaging punch will have to be forced deeper into the die body than if you were making a heavy one. This is done by screwing the die body either up or down, as the case may be. Once this adjustment has been found, lock the die body into the press with the large lock rings. Swaging dies must be securely locked into place. The swaging of bullets takes much more pressure than the normal sizing operations. The core and cup are placed on top of the swaging punch (cup down) and forced into the swaging die. Keep screwing the die body in until you can feel the pressure of the cup and core being swaged. On adjusting your swaging die you may want to take out the bullet and inspect it until all of the adjustments are made. Merely tap the top of the ejector with the palm of your hand or a mallet and eject the bullet. Continue to screw down the swaging die until your bullets are fully formed. Once this setting has been found securely lock the swaging die in place with the lock rings. Make sure that your lock rings are tight, as the continuing swaging and ejection will loosen your die.

Either flat nose or hollow point bullets may be made with these dies by replacing the ejector punch on the swaging die.

Make sure your lead wire is reasonably clean and there is no foreign material attached to the wire that could obstruct the vent hole. Select the weight of bullet you wish and cut the core so that both the core and the cup will weigh one or two grains over the desired weight. Lead wire that is about 1/16" smaller in diameter than the finished size of bullet will generally work out best for forming. (Example: .300 wire is easiest for forming .38 caliber bullets. Finished formed size for .38 caliber is generally .3575").

The nearer you cut the cores to the exact weight, the easier and more uniformly your bullets will form. **USE ONLY PURE LEAD WIRE FOR BEST RESULTS.** Tin and antimonial wire will not form out as satisfactorily and they require many times greater force than does the pure lead. We recommend pure lead wire or the use of at the most 3% antimonial wire. We cannot guarantee the dies if any other kind of lead alloy is used.