

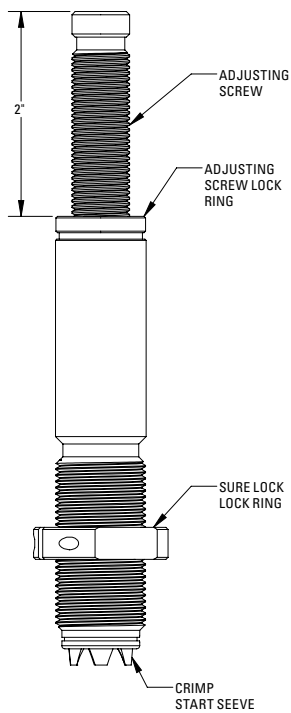
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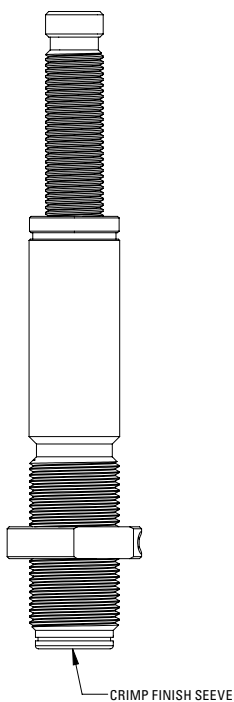
Universal Blank Dies



CRIMP START DIE



CRIMP FINISH DIE



INSTRUCTIONS

These dies are designed to allow shooters the opportunity to manufacture/load blank rounds for use in activities centered around this type of sport; i.e. Cowboy Action Shooting, Honor Guard, Reenactments, dog training, etc.

See drawing on opposite side for reference.

- 1.** Start with approximately 2" of the adjusting screw showing above the adjusting screw lock ring of the Crimp Start Die.
- 2.** Place cartridge case into shell holder and run the ram to the top of the stroke of the press.
- 3.** With the ram at the top of the stroke, thread the Crimp Start Die into the press until one of the following happens:
 - A.** The Crimp Start Die makes contact with the cartridge case (some rifle cases).

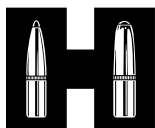
B. The Crimp Start Die contacts the shell holder, in which case, un-thread die one-half to one full turn (most pistol cases).

- 4.** At this point, the crimp die lock ring can be threaded against the press and locked.
- 5.** If the crimp start sleeve has not made contact with the cartridge case (instance 3B), thread the adjusting screw into the die until contact is made.
- 6.** Obtain a “star shaped” crimp by lowering the ram of the press and threading the adjusting screw into the die. Raise the ram to the top of the stroke again. Continue this step until the serrations in the cartridge case come nearly to a point or the mouth of the cartridge case is closed.

The Crimp Start Die is now set. In some instances, the crimp start die will sufficiently close the cartridge case to form the blank round and no finish crimp will be necessary.

7. If a finish crimp is necessary to close the case mouth, remove Crimp Start Die from the press continue with step 8.
8. Repeat steps 1-6 using the crimped cartridge case with the Finish Crimp Die until cartridge case mouth is closed enough for the desired blank round.

Please Note: Adjustments can be made to the amount of crimp start and finish to obtain the ideal round. For example, if too much of either start or finish crimp force is applied to the cartridge case, it may bulge and not chamber properly.



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