

Lock-N-Load® Single Stage Primer Pocket Swage Tool

ASSEMBLY & PREPARATION

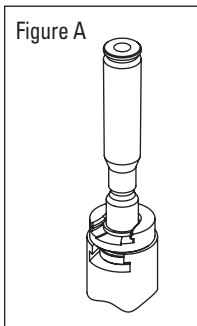
Before using your new swage tool, disassemble and carefully clean the die, removing the rust preventative. DO NOT disassemble the swage punch assembly (1) as it comes preset from the factory. Any commercial solvent or cleaner, like Hornady ONE SHOT® Gun Cleaner and Dry Lube, will suffice. Reassemble the swage die after cleaning.

Cartridge cases should be de-primed and inspected. Discard any that have cracks, splits, or other visible defects. Make sure case necks are round. You may need to run an expander through them or full length size the cases before swaging. Primer pockets should be clean.

IMPORTANT: Sort cases by manufacturer and lot number, if possible. Different brands have varying web thicknesses, which can cause swage variation.

INSTRUCTIONS

With the included shell holder (2) inserted, raise the press ram to the top of its stroke and thread the swage die (3) into your single stage press until it makes contact with the shell holder. Back the swage die off ½ turn and tighten the Sure-Loc™ lock ring (4).



Insert a sorted case onto the swage support anvil (5) and slide anvil/case into shell holder. (Fig. A)

With the swage adjust screw (6) backed out of the swage die, raise the press ram to the top of its stroke bringing the case into the swage die.

Thread the swage adjust screw down until you feel resistance. Lower the press ram about 1-inch and thread the swage adjust screw down half a turn. Raise the press ram. You should start to feel the resistance when raising the press ram. At this point, the primer pocket crimp is starting to be swaged.

Adjustment for the proper amount of swage is done by trial and error. Insufficient swage may make primer seating difficult and over-swaging could damage the cartridge case or the swage support anvil.

NOTE: The Lock-N-Load® Primer Pocket swage is designed to swage the crimp and not the entire primer pocket.

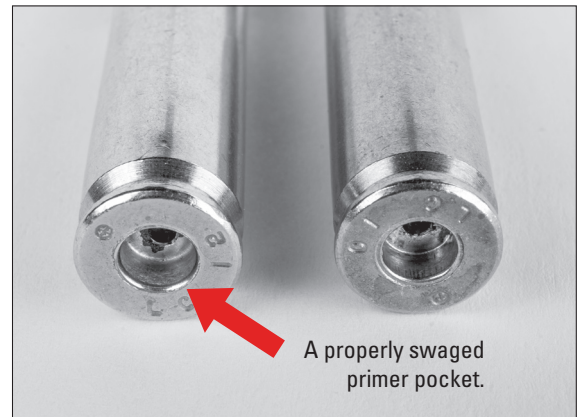
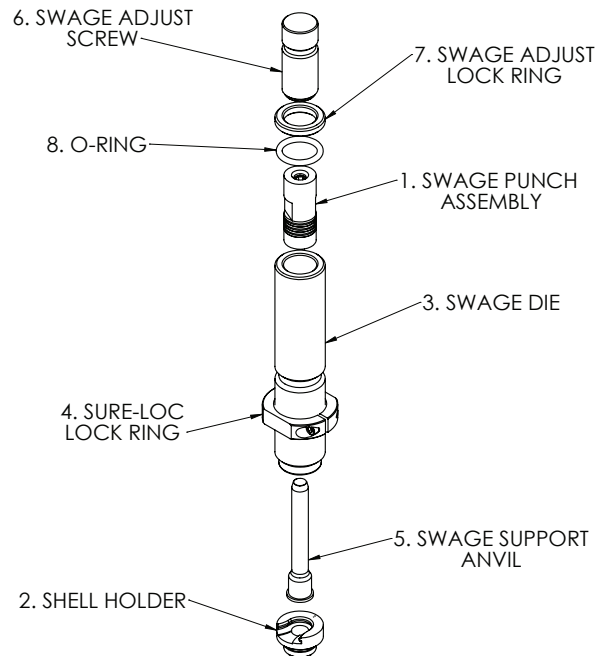
Continue this process, making adjustments in 1/8-turn increments until desired swage is achieved. To remove the swaged case, lower the press ram and slide the anvil and case out of shell holder. If desired, you can use a small amount of case lube on the swage punch or on the primer pocket.

A properly swaged primer pocket will have a small radius at the edge of the primer pocket (see photo). It is wise to set the swage for a minimal radius and test by seating a primer in the case. Adjust until enough swage is achieved to seat a primer properly.

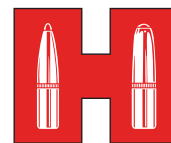
NOTE: If using lube, remove it before priming as many lubes will contaminate primers.

Once proper swage is achieved, thread the swage adjust lock ring (7) down on to the o-ring (8) to lock the swage adjust screw (6) position. At this point, the press is set and ready to swage the pockets.

PARTS



A properly swaged primer pocket.



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