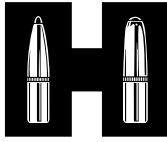


INSTRUCTIONS



Hornady
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Hydraulic Form Die Kit

Begin by raising the press ram to the highest position without camming over the center.

The Hydraulic Form Die Kit includes a special solid shell holder without a hole in the center. Insert it into the ram of the press.

Thread the hydraulic form die into the press so the die contacts the top of the shell holder with the ram of the press raised to its highest position. Tighten the lock ring against the press, and tighten the set screw in the lock ring with an Allen wrench.

When using new unprimed cases, seat a spent primer into the case. When using fired cases, do NOT remove the spent primer. Lubricate the outside of the case with a very light coating of case lubricant. A thin coat of Hornady® One Shot® Spray Case Lube works great.

Fill the case to the top of the neck with water. Wipe any water off the outside of the case with a paper towel.

Insert the water-filled case into the shell holder. Remove the die rod from the die and raise the case into the hydraulic



form die. Insert die rod into die until resistance is felt. Use a large dead-blow hammer with a large-diameter head to strike the hydraulic form die rod briskly two or three times. Be sure to strike the die rod squarely to avoid damaging it.

Remove the rod before removing the case from the form die to avoid spilling water out of the case. Any water that gets inside the hydraulic form die or on the shell holder will need to be dried before forming another cartridge case.

Lower the ram and remove the case. If the case does not appear to be completely formed out, repeat the process by refilling the case with water and wiping the outside with a paper towel. Re-insert the case into the shell holder, raise it into the hydraulic form die, insert the rod into the die and strike with a dead-blow hammer several more times.

The shoulder of the case will not be formed quite as sharply as a fired case and will look very similar to that of a new factory case. Hydraulic forming brings cases very close to final dimensions.

When the case is formed to your satisfaction, remove the water from inside the case. An air compressor or hair drier can be used to blow out the inside. Then remove the spent primer from the case. Use an air compressor or hair drier again to remove any moisture from inside the primer pockets and inside the case. Place the case in a reloading tray with the mouth and neck down to finish drying.

Before proceeding to additional cases, it is recommended that you see how your first hydraulically formed case chambers in your firearm. It is highly recommended that you use a headspace gauge to ensure that you have the hydraulic form die set properly to headspace your cartridge cases. The Hornady® Lock-N-Load® Cartridge Headspace Gauge is excellent for this purpose.

Once cases are fully dried, previously fired cases will need to be full-length resized before reloading. Full-length resizing is not necessary for new, unfired cases.



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