



## ET-1-H Jacket Trim Die Set

The Corbin ET-1-H Expand/Trim die set fits the Corbin MegaMite, Hydro Junior, or Hydro Press. It trims jackets of a given caliber to precise, shorter lengths with a clean, even beveled mouth. The caliber is specific to a given set, and the length of trim is specific to the trim punch (location of shoulder from the tip = trimmed length of jacket). A stripper kit is generally used to pull the trim from the punch on the downstroke of the press. Stripper kits are universal except for a washer that fits the punch diameter and are available separately.

There are two dies and punches in the set. The first die and punch is set to flare the jacket mouth. The second die and punch snip off the jacket against the sharp shoulder of the hardened trim punch.

The flaring punch has two diameters, but the junction is a slope (about 45 degrees). Place the jacket over the end of the punch, and raise the ram to push the jacket into the flaring die. Push the jacket just far enough to create an expanded (flaired) mouth. Only flare the mouth far enough to allow the jacket to go over the trim punch (second punch) all the way, so the end of the punch can contact the inside bottom of the jacket. The flare simply allows the jacket to slip over the larger diameter of the trim punch.

The flaired jacket will easily come out of the die, but if it should wish to stay in the die, simply tap the plunger on top of the die to push it out.

After flaring a quantity of jackets, change to the trim die. Install the stripper kit, which has its own instruction sheet. The kit includes disk or washer that slips over the trim punch. This washer is made for the exact size of the punch, whereas the rest of the stripper kit works with any other washer or caliber of trim die and punch. Put the washer over the trim punch.

Use a small amount of Corbin Swage Lube on your fingertip and wipe the punch with it. Then put a jacket over the end of the punch, and raise the ram. The jacket should enter the die mouth. The trim punch will enter the jacket and expand the diameter of the portion to be removed. As the punch continues upward through the die, the shoulder on the punch will enter the die and snip off the rest of the jacket. When you lower the press ram, the stripper kit will stop the washer while the punch continues down, pulling the trim off the punch. The jacket will come off in the die and be pushed through with one or more additional jackets. If it should stay on the punch, it will be removed along with the trim on the down stroke.

**Warning:** The cut jacket edges are sharp. Be careful handling them.

**Caution:** Do not use the wrong punch with the trim or flair die, or with another caliber of the same kind of die. Each die and punch set is made for proper trimming of a certain caliber of jacket and may be damaged if used incorrectly. The trim punch has a sharp shoulder. The flaring punch has a sloped shoulder, and is shorter.

**Note:** Do not attempt to trim jackets that are significantly thicker than the samples for which the set was built. If there is any doubt, send sample jackets to Corbin, along with your die and punch, so we can test them at our risk rather than yours. Do not grind, turn, polish, or attempt to modify the die or punch: if you feel there is a problem, call for an RMA number and return it with a clear explanation of the problem and samples of the jackets. Copper tubing, steel, brass, or jackets other than those for which the set was designed and tested should not be used. Doing so may destroy it and the warranty.

