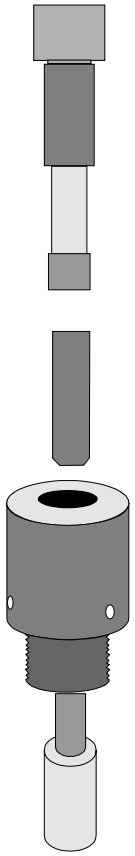
How to make an open or lead tip flat base bullet...

Tools required: for open tip bullets, FJFB-3 set.
for lead tip or open tip bullets, LTFB-4 set.

Step 1.

Cut lead cores from lead wire (LW-10) with core cutter (PCS-1 or PCS-2). Make them 2-5 grains heavier than you will need. Weigh the jacket, subtract from final bullet weight, and add 2 to 5 grains, then make cores this weight.



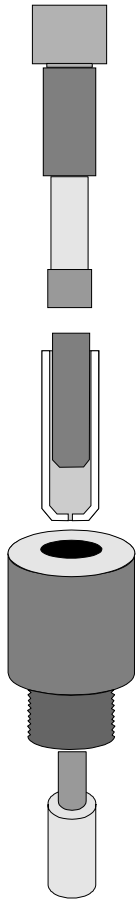
Use Corbin Swage Lube on your finger tips, pick up the cores and spread a thin film of lube on the core as you put it into the Core Swage die (CSW-1). Adjust the punch position so that, at the end of the stroke, you extrude just enough lead through the bleed holes to leave precisely the weight you want.

Note that the core you make must fit easily into whatever jacket you decide to use. If the core does not drop easily into the jacket, then air may be trapped in the jacket base when the core is seated. Lead wire needs to be small enough to fit the core swage die, and the core swage die must produce a core small enough to fit the jacket. If no jacket is used, then the core should fit directly into the core seat die or point form die, depending on the bullet design you make.

Note: The lead hardness should be suitable for the family of dies. Type -M uses only Bhn5 soft lead, -S can use up to Bhn10, and -H may be designed for nearly any hardness of lead but works best with Bhn 5 to 10.

Step 2.

Clean the cores of all lube by dipping them in a solvent or boiling in hot water with a little detergent added. Dry them well, and insert by hand into the bullet jackets (if jackets are to be used).



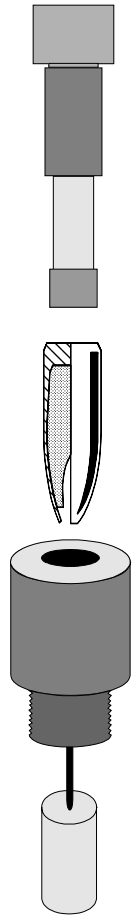
Cores must fit easily by hand to the bottom of the jacket. If not, a smaller core swage must be used with the particular jacket.

Pick up a core and jacket using a slight amount of Corbin Swage Lube on your finger and thumb, and give the jacket a turn to spread the lube on it before inserting into the core seating die. The core seat die must accept the jacket easily by hand. For open tip bullets, use an external punch which fits into the jacket at the point where the lead core will be seated. For large lead tip bullets, use a punch which fits the die bore and a core longer than the jacket.

Seat the core with only enough force to expand the jacket. If the jacket and core stay in the die and expand to just under final diameter, this is enough pressure. If the pressure is excessive, you may crack the die. The external punch diameter is critical and must fit the jacket ID at the core length you wish to use.

Step 3.

The point forming die uses an internal punch which is equipped with a long, thin ejection pin. The head of the punch has a slot, which fits the stop pin in the press front.



Remove the stop pin, grasp the punch by the tip of its ejection pin wire, and slip it into the ram. Hold onto the punch tip and align the slot with the hole in the ram. Insert the stop pin so it locks the punch in place. Slip the die over the punch, and screw the die into the top of the ram.

Pick up the jacket and seated core, and apply another light film of Corbin Swage Lube with your finger and thumb as you insert it into the point forming die. It should go into the die easily by hand. Raise the ram and adjust the Floating Punch Holder so the bullet is formed smoothly in one pass.

Back off the top punch if you get a pipe on the bullet tip. The ejection pin hole diameter is the smallest possible width of the meplat or bullet tip...trying to close the tip smaller only pushes it up the ejection pin hole. The smallest physical closure possible with any die would be twice the wall thickness of the jacket, at the open end.