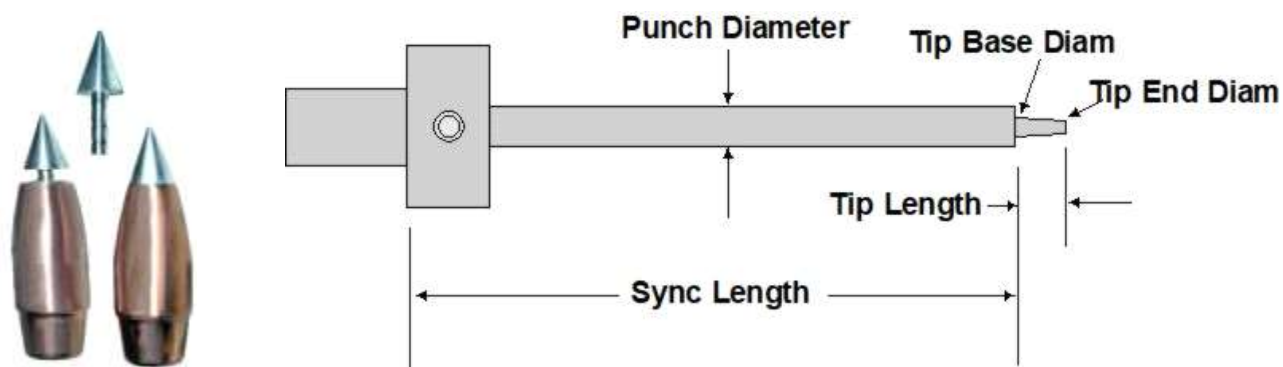


PUNCH-ST Tip Insert Punches for PF-1-ST dies

The PIN-POINT™ and ULT-TIP™ are performance enhancing metal tip inserts designed to increase the BC and improve impact performance, increasing the ability of the shooter place shots in a close group at long range. Each style of tip is inserted in a pre-formed centered cavity created by a special pressure sealing ejector punch used in the point forming die.



First the ogive is formed on the bullet and the centered hole is created by the T1 punch in the lead core to grip the stem of the tip insert. Then the internal punch is changed to a second ejector, designated as T2, which has a cavity in the end, designed to eject the bullet from PF-1-ST die while maintaining the perfect alignment and centering of the insert.

The T2 punch is not a critical length. It is the correct length so long as it is held out of the actual die cavity with the press ram raised (just as with any normal point form ejector punch), and is long enough to push the bullet far enough out of the die to be removed by hand.

But the T1 punch is a critical length for a given die. Each T1 punch is synchronized to the depth of the cavity hand lapped in its matching PF-1 die, so that the major diameter section comes exactly to the end of the die cavity and seals it against swaging pressure. The distance from the end of the major diameter section to the start of the punch head is the "sync length". The length of the tip which creates the hollow point cavity in the core is NOT included in these measurements. (The tip diameters can be specified for making hollow points in a lead bullet without using a tip insert, in a PF-1-SC custom pellet or muzzle loader swage die.)

The complete punch assembly is the PUNCH-ST, with a typical diameter of .157 for Corbin standard tip inserts. The sync length is written on both the die and on the punch head. The PUNCH-SI is the punch insert, without the head. This allows replacement of bent or broken punches at lower cost since the head can be re-used. When ordering the punch separate from the die, or when ordering the insert, be sure to specify the sync length and punch diameter. Do not use the punch in any other die than the one matching those dimensions.