

How to use the jacket maker...

1. Clean and sort the cases. Throw away any that are punched through at the firing pin dent, or have been smashed. Boil the cases in hot water with detergent and 2 of tablespoons of vinegar to remove corrosion. Rinse them in clean hot water and spread them out on an old towel to dry.
2. Draw the cases. Screw the die into the top of the press. Bottom of the die should be from flush with the press frame to about 1/8-inch below it. Insert the punch into the press ram (screws into Corbin rams, slips side-ways into regular loading press rams like a shell holder). *Corbin CSP-1 press must be in the LONG STROKE or reloading position of the ram and toggle, not the short swaging stroke.* With a film of Corbin Swage Lube on your fingers, wipe a small amount of lube on the punch, and on the O.D. of the case. With 224, push the case through the die. Adjust the die so you just run out of stroke as the jacket goes through the draw, for least effort. With 6mm, just draw the first 3/16-inch to unfold the rim...do NOT try to push the punch through! A stepped-end knock-out rod is provided with the 6mm set to remove cases from the die if they should come off the punch. Insert from the top, and align in the hole, then tap it with a mallet to push out the jacket.
3. Anneal the cases. Wash in hot water again to remove lube. Then the cases must be brought to a temperature sufficient to stress relieve and soften the brass, without burning it. Generally, if the cases are brought to a barely visible red glow in a dimly lit room, they were hot enough to avoid folding at the tip when you form the ogive later. A self-cleaning oven generally gets hot enough. Spread the cleaned cases out on an old cookie sheet and "bake" in the self-clean cycle of your electric range, or heat the cases by using a propane torch to quickly bring them to a red heat visible in dim light. Failure to anneal only means that the ogive may fold over instead of drawing smoothly to a point. Let them cool to room temperature. With large lead tips, you may not need to anneal.

The .243 jackets are actually a kind of "pre-form" jacket. They are not brought to .243 caliber in this operation. The mouth is flared by pressing over the punch angle joining the two punch diameters, so that it will seal the bore of the core seating die and hold the lead pressure during core seating, which will expand the entire jacket to the correct diameter (just like blowing up a balloon, but with thousands of pounds of pressure). Corbin Swage Lube is recommended to increase die and punch life and lower the force required to draw the jackets.

CORBIN[®] Rimfire Case Jacket Maker Kit

Make a Lifetime Supply of FREE 224 or 6mm bullets from scrap material! Very accurate, easy on the bore!
Used by thousands of reloaders for over 30 years!

