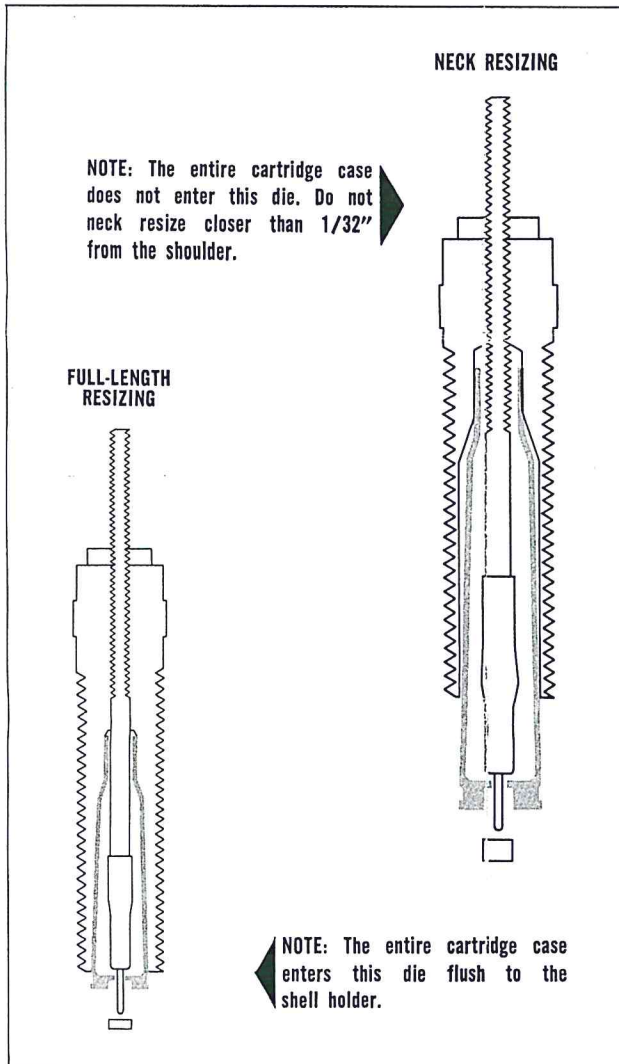


TRU-LINE JR. 2-DIE RIFLE SET

INSTRUCTIONS FOR DIE ADJUSTMENT

ILLUSTRATION A



Tru-Line Jr. Die Instructions

Illustration A pictures a cutaway view of two dies, one is a full length resizing die while the other is a neck resizing die. Full length resizing dies are supplied in two die sets for the following small rifle cartridges only; 221 FIREBALL, 22 HORNET, 218 BEE, 222 REM., 222 MAG., 25/20, 223 REM., 256 WIN., 32/20, 38/40, 44/40. Neck resizing dies are standard in all other rifle calibers.

ADJUSTING A NECK RESIZING AND DECAPPING DIE

Make certain that the expanding button is tight and that the decapping pin does not protrude more than 1/8" below the bottom of the die.

Start the die into the press and put an empty, lubricated *cartridge case into the shell holder. By alternately raising and lowering the handle and screwing down on the die, the case will be forced further and further into the die. The sizing marks on the case neck will tell you how far the neck has entered the sizing portion of the die. Do not attempt to neck resize closer than 1/32" from the shoulder. When the sizing mark on the neck reaches a point about 1/32" from the shoulder, screw down the lock ring and tighten the set screw. The decapping rod is now turned down until it just pushes out the fired primer when the press handle is all the way down. Tighten the decapping rod lock nut and your die is adjusted.

ADJUSTING A FULL LENGTH RESIZING AND DECAPPING DIE

Make certain that the expanding button is tight and that the decapping pin does not protrude more than 1/8" below the bottom of the die. Lower the press handle until the shell holder is at its highest point. Screw the die into the press until the bottom edge of the die makes firm contact with the shell holder. The die is now adjusted, screw down the lock ring and tighten the set screw.

ADJUSTING THE BULLET SEATING DIE

Illustration B shows a cutaway view of the Bullet Seating Die. This die is equipped with a built-in crimping shoulder which may, or may not, be used depending upon the reloaders preference. The cartridge case in the illustration is shown in the non-crimp position.

The die is adjusted as follows; back off several turns on the die lock ring and start the die into the press. Put an empty sized cartridge case into the shell holder and pull down on the press handle until the shell holder is at its highest point. Screw the die down into the press until you "feel" the mouth of the case contact the crimp shoulder in the die. When you feel the end of the case touch the inside of the die, back off 1/2 turn on the die and screw down finger tight on the lock ring. Your case is now in the non-crimp position shown in the illustration.

Your bullet must now be seated to the proper depth. Back off on the bullet seating screw about 1/2". Place a cartridge case into the Shell Holder and a bullet on the mouth of the case. Pull down on your press handle until your shell holder is again at its highest point and turn down on the seating screw until it comes into contact with the bullet.

Alternately, raise and lower the handle turning down the bullet seating screw a little at a time until the bullet is seated to the desired depth. If you are loading jacketed bullets, and do not wish to crimp, your die is adjusted at this point and you should tighten the lock rings and set screw.

If you wish to crimp on jacketed or cast bullets which have crimping grooves, continue as follows; Make certain that your bullet is seated exactly to the crimping groove. Back off 1/2 of a turn on the bullet seating screw. Screw the die down 1 1/2 turns and tighten the lock rings and setscrew. Your die is now properly adjusted.

*Apply a thin film of Size-Ezy lubricant to each case before inserting them into the sizing die. Excessive lubricant should be avoided as it traps air in the die and dents the cartridge case. Dipping the case neck in powdered graphite is also beneficial as it eliminates friction on the expanding button.

The
Lyman Gun Sight Corp.

MIDDLEFIELD, CONN.

U. S. A.

ILLUSTRATION B

