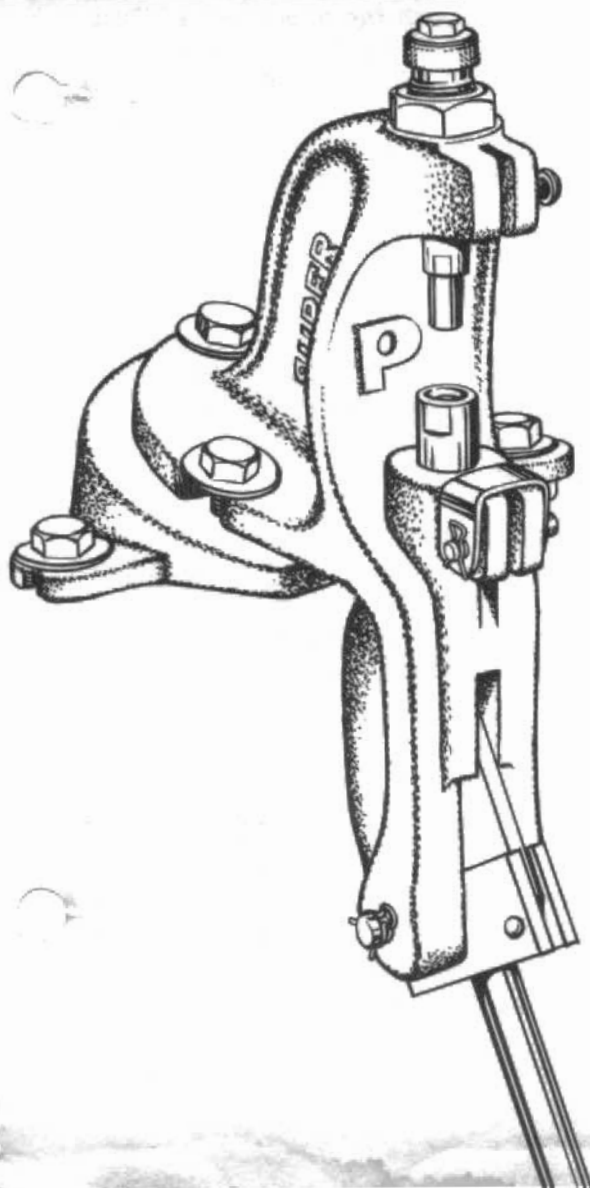




PACIFIC SWAGE DIES



- INSTALLATION
INSTRUCTIONS
- OPERATING
PROCEDURE
- PARTS &
PRICE LIST



PACIFIC Swage Die

INSTALLATION INSTRUCTIONS

The Pacific Super Deluxe Tool, designed for all types of reloading jobs, including Bullet Swaging. Cobra-like construction and Paximate Cast Iron have been incorporated into the new Pacific tool, thus giving more than adequate strength for all sizes and types of Bullet Swaging. Use only Pacific Swage Dies with the Super Deluxe Tool, they were designed for use with each other. The Pacific Bullet Swage Dies have been designed to swage lead rifle or pistol bullets using either gas checks or bullet cups, frequently called half-jackets. Bullet cups are recommended when using high velocity loads.

CAUTION: DO NOT attempt to form plain base lead bullets, as this will cause dies to malfunction.



FIG. 1

Be sure your Pacific Super Deluxe Tool is fastened securely to a sturdy bench. This is important as there is a tremendous amount of force applied to the tool when swaging larger caliber bullets. Fig. 1 shows the Pacific Super Deluxe Frame and the new Pacific Level Block. When swaging bullets the Level Block is highly recommended as it places the tool and ram in a vertical position.

IMPORTANT: Before assembling swage parts, remove all shipping preservatives with soft cloth.

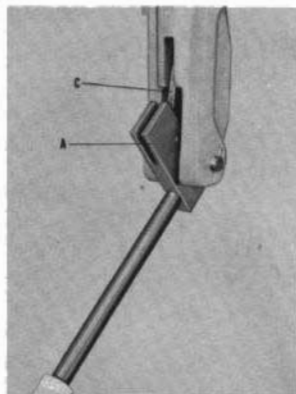


FIG. 2

Place toggle block (A) link (C) and ram (not shown) into tool as shown. Place original Super Tool handle and toggle pin in position as per Fig. 2. Keep handle tight.

NOTE: Lubricate bearings areas of Super Tool lightly with lubricant provided.

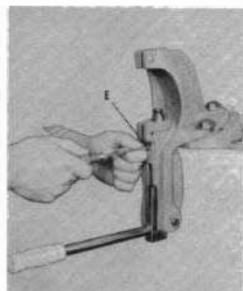


FIG. 3

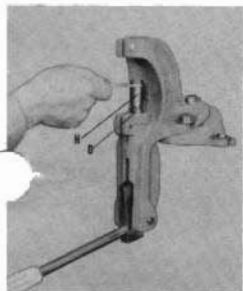


FIG. 4

Thread swage body (H) on ram (D) and tighten with wrench provided. See Fig. 4.

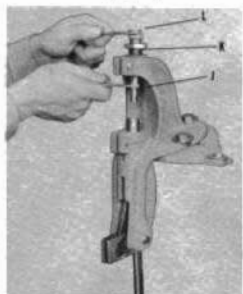


FIG. 5

Place nose punch bushing (K) into head of tool. Place shoulder bolt (L) through bushing and thread nose punch (J) into position and tighten with wrenches provided. See Fig. 5.

CAUTION: Shoulder bolt (L) and nose punch (J) when attached are designed to be free floating in nose punch bushing (K). DO NOT attempt to secure them by over-tightening.

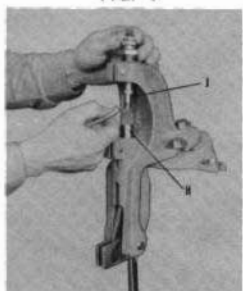


FIG. 6

IMPORTANT: To insure ease of operation and long life, we suggest that the outside of nose punch (J) be lightly coated with lubricant provided, prior to inserting into swage body (H). See Fig. 6. It is recommended that the nose punch be relubricated every 50th bullet. Caution must be taken not to allow lubricant to enter inside of nose punch (J).

IMPORTANT: Before attempting to swage bullets, be sure your lead cores consist of dead soft lead. Alloyed wire will not form satisfactorily and may cause undue strain on swaging equipment and operator. We recommend use of either preformed cores or bullet swaging wire. If you plan to cast bullet cores from salvaged lead, be sure proper material is used. We will not warrant replacement of swage assemblies due to use of improper materials. Swage die parts (H), (I), and (J) must correspond with one another. Do not interchange these dies once they have been used together.

CAUTION: Use only proper diameter cup or gas checks and preformed cores or lead wire when forming bullets.

OPERATING PROCEDURE

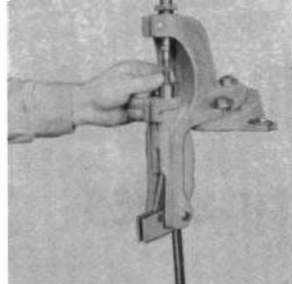


FIG. A



FIG. B

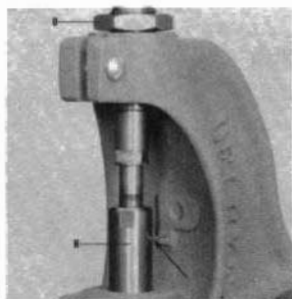


FIG. C

1. Place proper size lead core into corresponding bullet cup or gas check, and place into position as shown in Fig. A.

NOTE: When determining bullet weight desired, cut lead core and weigh with cup or gas check. They should be 2 to 5 grains over finished bullet weight. It is important to keep cups, cores and jackets clean of grit or dirt which may scratch the dies and impair their accuracy.

2. Move operating lever to top of stroke. Adjust nose punch bushing (K) while activating handle until you feel the handle "cam over" at the top of its stroke, (see Fig B) and a small amount of lead appears (about $\frac{3}{8}$ " to $\frac{1}{2}$ ") in the form of lead wire out of bleed hole (see arrow in Fig. C) in swage body (H). Thread bushing lock nut (O) down against frame and tighten set screw. Return handle to down position ejecting swaged bullet.

- A. To form the lightest possible bullet, you must have at least $\frac{3}{32}$ " of lead exposed from the top of cup to shoulder of bullet. If this amount of lead is not exposed, the bullet will not bleed, and it will be impossible to obtain exact bullet weight. It is also important to use cups of the proper height. These dies were designed for use with Hornady and Speer cups. Other cups of the same dimensions are also suitable.
- B. **NOTE:** Due to the design of certain bullets, it is sometimes necessary to force the bullet into nose punch twice to complete proper formation of the bullet nose.
- C. It is possible to form bullet without bleeding wire, but your bullet weight accuracy will be limited to your wire core and cup weight consistency. To change bullet weights, repeat operation #2.
- D. To convert swage set to other calibers, repeat operations #4 and #5.

BULLET TYPES AND SIZES	RN RNHP .308	SWC SWCHP .357	WC SWC .429	SWC SWCHP .452 .454
SUGGESTED WEIGHTS	110 gr.	156 gr.	148 gr.	240 gr.
MINIMUM WEIGHT* MINIMUM WEIGHT*	105 gr.	135 gr.	220 gr.	200 gr.

*Will vary due to height of cup being used.

+Use 200 Gr. for .45 ACP Target

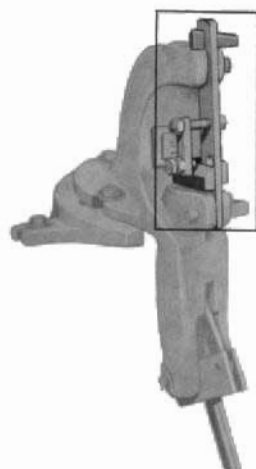
*Not recommended for .45 ACP

NOTE: When seating swaged bullets, the proper seating stem should be used in seating die, to conform with style of bullet nose. The proper stems are available from Pacific for use in PACIFIC DIES. When using regular seating stem, it is recommended bullet be seated in separate operation from crimping. By following the above instructions and maintaining proper care of equipment, you will be able to enjoy many years of accurate bullet swaging.



PACIFIC

Swage Die Accessories



LEAD WIRE CORE CUTTER

Designed for use by those who desire cutting bullet cores from lead wire at the fastest possible rate, rather than using pre-formed bullet cores. The Pacific Core Cutter is completely adjustable and mounts on swage dies in the Super Tools.

Pacific Lead Wire
Core Cutter.....\$10.50



LEVEL BLOCK

The Pacific Level Block is available for those who prefer to use the Pacific Super Deluxe Tool in a vertical position. This is very useful when swaging bullets or loading pistol cartridges. Pacific Level Block\$4.50



GUNSLICK

Found to be one of the most effective lubricants needed to adequately lubricate swage dies when exposed to extreme pressures that are present in the swaging operations.

#400 Gunslick
Lubricant\$0.25

BUY PACIFIC TOOLS AND ACCESSORIES EXCLUSIVELY
THEY ARE MADE FOR EACH OTHER—OVER 30 YEARS RELOADING LEADERSHIP



PACIFIC Swage Dies Parts & Price List



NOTICE: Prices and/or specifications are subject to change without notice. Discontinued products may or may not have replacement parts available. Call for availability 800-338-3220.

S9-J26	Toggle Block.....	\$ 2.40
S9-J18	Toggle Pin.....	.60
S9-J10	Ram	1.40
S9-J19	Link80
S9-J20	Eject Cross Pin.....	.40
S9-J18	Link Pin.....	.60
*S9-J16	Eject Washer.....	.20
*S9-J25	Swage Body.....	4.80
*S9-J11	Eject Punch.....	1.20
*S9-J12	Nose Punch Regular.....	5.00
S9-J13	Nose Punch Hollow Point.....	7.50
S9-J14	Nose Punch Bushing.....	1.00
S9-J17	Shoulder Bolt.....	.80
S9-J27	#2 Wrench.....	.60
S9-J28	#1 Wrench.....	.60
S9-J15	Bushing Lock Nut & Screw.....	1.00
S9-J21	Conversion Set*.....	11.50
S9-J30	Swage Dies Complete (One Caliber).....	\$19.50

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