

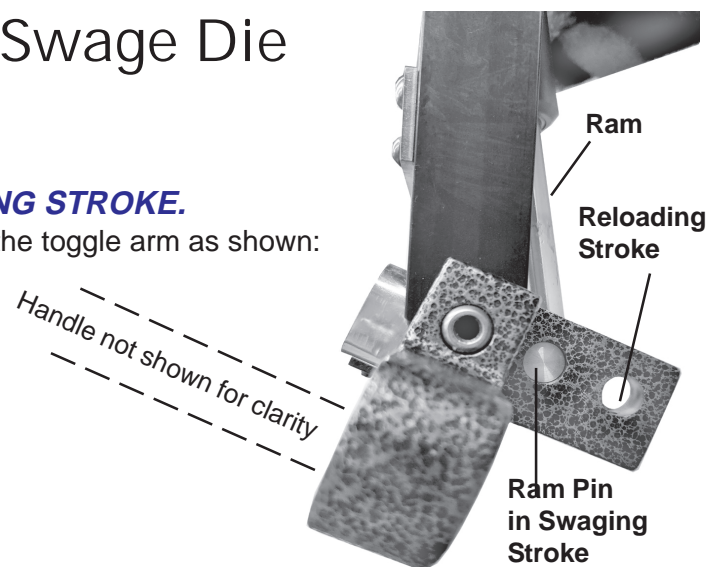
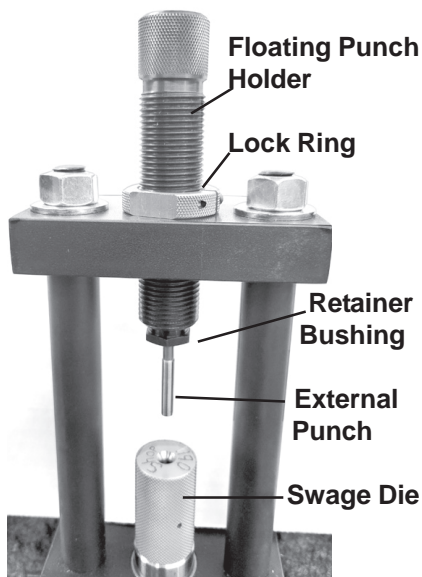
# How to Set Up a Bullet Swage Die in the CSP-1 S-press

## 1. Make SURE your press is in the SWAGING STROKE.

Ram pin must be in the 2nd hole from the end of the toggle arm as shown:

## 2. Screw the swage die into the ram

and put the EXTERNAL Punch in the FPH-1-S Floating Punch Holder..

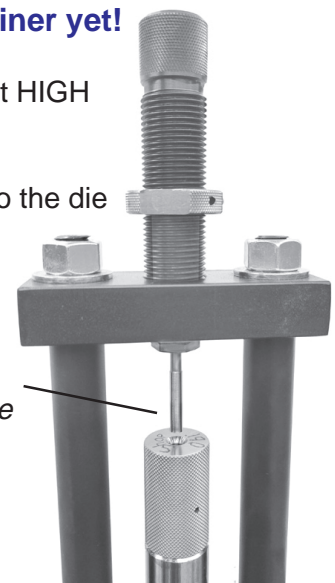


## 3. Leave the Lock Ring and Punch Retainer Bushing slightly loose. It is IMPORTANT not to tighten the punch retainer yet!

Make sure the punch holder is set HIGH in the press head so the punch.

Put the material to be swaged into the die using appropriate lubrication, per the particular die instructions.

Now raise the ram to the TOP of the stroke with the punch still high enough not to contact the material in the die.



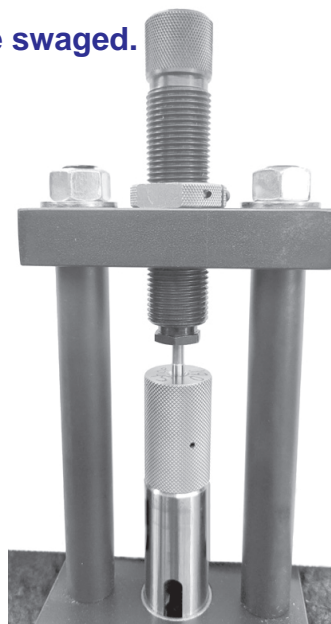
## 3. Lower the Punch Holder and punch into the die to contact the material to be swaged.

(a) Lower the ram slightly, lower the punch slightly, then raise the ram to apply pressure to the material.

(b) Repeat (a) until the material is formed properly, with out excessive force or pressure.

(c) With the punch still contacting the material, firmly hand tighten the punch retainer bushing and lock nut.

**It is NOT necessary to use tools to tighten the lock ring or hex bushing.** Some float is desirable so the punch can self-align.



To check alignment, you can leave out the swaged material and lower the punch into the die about half its distance, then secure the punch retainer bushing by hand. The lock ring can be secured for this test but will be adjusted for the actual swaging operations.