

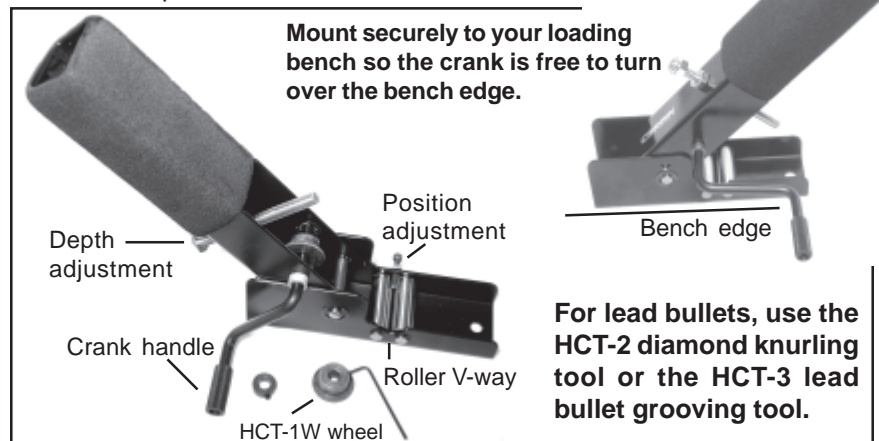
### **HCT-1 Operating and Maintenance Notes:**

The HCT-1 is most effective when the depth of the cannellure is held to a minimum which still allows the desired grip of the case on the bullet. Excessive depth should be avoided: most cannellure problems are rooted in an attempt to make the groove too deep. A drop of oil is required on both of the crank bearings from time to time. A drop of oil may also be allowed to seep into the space around the knurled crank knob and the crank shaft, and between the V-way rolls and the axles. With reasonable lubrication, the tool should give many years of service.

Cannelluring steel or heavy brass jacketed bullets is not recommended. Solid copper bullets also should not be cannellured with this tool. You should not have to press very hard to make a normal cannellure. A firm one-hand pressure on the padded handle should be sufficient. The tool does not remove or cut metal: it embossed the groove by compressing the metal. This maintains the same weight before and after applying the cannellure. The HCT-1 works with hard alloyed lead or jacketed bullets, but not for soft lead. For soft lead use the HCT-3 grooving tool.

The HCT-1 is intended to be an economical tool for home bullet making, a few hundred bullets per day. Corbin's commercial PCM-2 power cannellure machine is designed for industrial production at 30 to 50 bullets per minute. The HCT-1 is not warranted for commercial production.

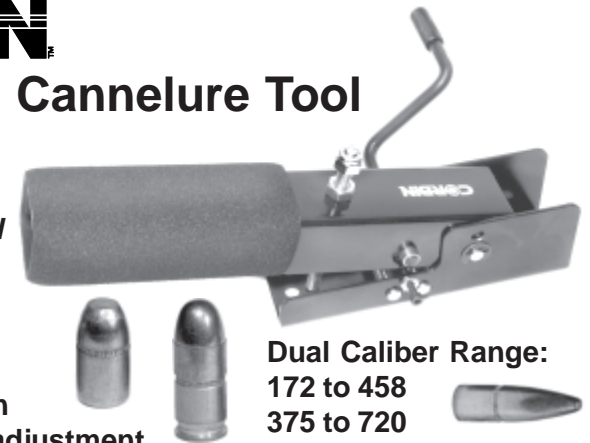
If the bullet tends to jump out of the hard-chromed roller V-way, reverse the direction of turning the crank. This is more likely to happen when the bullet is near maximum diameter for the setting of the tool. Keep the cannellure wheel set screw snug on the flat machined on the crank shaft. There is a collar with a set screw next to the crank handle side of the frame, which maintains side-to-side tension on the crank. This set screw should bear on the round part of the shaft.



# **CORBIN**

## **HCT-1 Cannellure Tool**

**Create fast factory-standard cannellure grooves on jacketed bullets or straight pistol cases...**



- \* Adjustable depth
- \* Adjustable position
- \* Automatic caliber adjustment
- \* Handle can be assembled on left or right side

Place .050-wide serrated cannellure grooves on straight cartridge cases or jacketed bullets, from .17 to .72 caliber. Adjustable depth and location let you put the groove where you want it at the precise depth desired.

Mount the tool on a sturdy bench so that the crank handle is free to turn over the edge of the bench. For bullet or case diameters from .172 to .458 diameter, the lower pivot holes are used (default location). For larger calibers, remove the clip from one end of the pivot pin, and then place the pivot pin in the set of holes closer to the top of the frame, replacing the clip.

Place a bullet or case on the hard-chromed roller V-way in the lower frame. Set the position adjustment screw so that the cannellure wheel, in the top frame, is located where you want to place the cannellure. The position screw should bear on the base of the case or bullet.

Lower the handle, and adjust the depth stop screw so that the cannellure wheel is just lifted off the surface of the bullet or case. Then adjust the depth stop screw for the desired cannellure depth. Each full rotation of the screw provides 0.0357 inches depth. A normal cannellure is 0.010 to 0.015 inches deep, or a little over 1/4 of a turn.

Press firmly on the padded handle and turn the crank two or three full rotations. Lift the handle and the job is completed!