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JMK-1-S Jacket Maker

Corbin
Manufacturing &
Supply, Inc.
PO Box 2659
White City, OR
97503 USA

Contact: Dave
Corbin, CEO
Phone: 541-826-
5211
Mon-Thur 09:00-
12:00, 14:30-18:00

E-mail:
dave@corbins.com

[\(JMK-2-H jacket
maker\)](#)

[\(JMK-1-H jacket
maker\)](#)

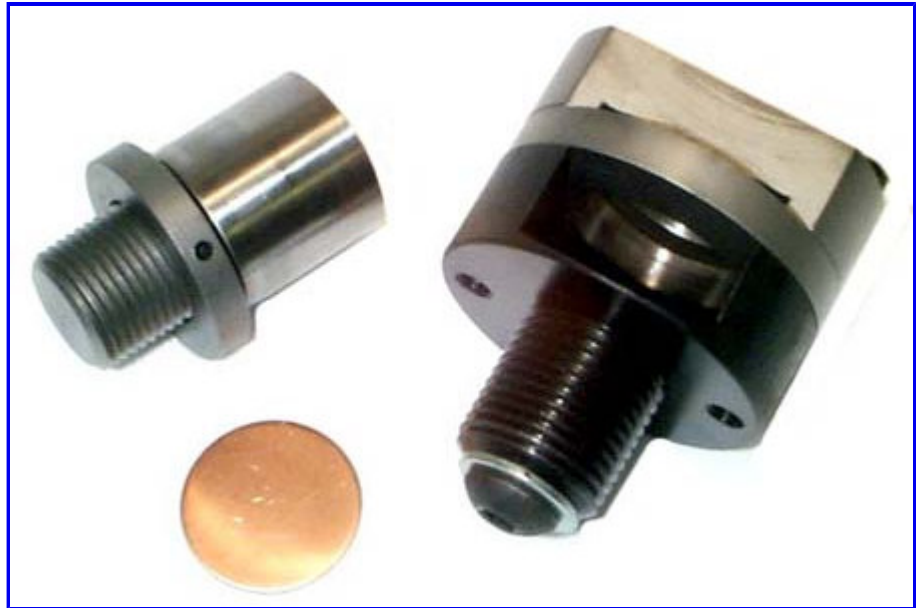


Corbin JMK-1-S Bullet Jacket Making Kit

The Corbin JMK-1-S Jacket Making Kit, for use with the Corbin S-Press, makes precision bullet jackets in .452 caliber, which can then be redrawn to other calibers and trimmed to length by adding a JRD-2-S commercial grade jacket draw die and an adjustable trim die (ET-2-S) for each smaller caliber desired. The die set uses 1-inch

wide by .030-thick copper strip, deep drawing grade with finished edges. Corbin furnishes copper in 5-lb bundles or 50-pound copper coils.

The strip is first passed through a slot in the Disk Cutter Die, where a punch mounted in the standard floating punch holder, in the press head, cuts a disk from the inch-wide strip and drops the disk out an angled exit port in the lower die section. The die itself screws into the press ram. The press is used in the short stroke or swaging mode (2-inch ram travel) for maximum power.



The strip is pulled through the slot, the handle moved up and down in short strokes, just enough to cut the metal, and the strip advanced to the next position by observing the relation of the last hole in the strip compared to the edge of the die, leaving enough metal between holes for a good disk to be cut on the next stroke.



After the disks are cut, the cupping die and punch assembly are put into the press. The cupping die itself goes into the ram from the bottom side, which is the opposite of most dies. The spring-supported guide and punch screw into the ram. A lubricated disk is placed in the top of the guide, which in turn is held in position on top of the punch.

The press is operated, raising the ram and clamping the edge of the disk under spring pressure as the guide engages the die. The punch then pushes the disk into a cup shape as it goes upward, into the die. The cup then emerges from



the top of the die, and the cycle is repeated. The die forms a short, thick-walled cup of about .600 diameter.



The .600 diameter cup is then lubricated and placed over the .500 first draw punch, which screws directly into the ram. The .500 draw die screws into the top of the press, and the press is set for the long stroke or reloading mode. The .600 diameter cups are drawn to .500 diameter, while the walls are made thinner and the length increases.

The special jacket drawing dies used with the JMK-1-S are not the usual JMK-1-S reducers, which are used for certain less stringent applications. They are a commercial grade JMK-2-S which uses special heat treated alloy steels, a longer punch, and a nesting-style die configuration for more precise jacket wall concentricity. The same dies can also be used, with adapters, in the -H presses made by Corbin.

After reducing to .500, the cup is then drawn through the second draw die, to make a .452 jacket. The jacket wall will be approximately .015 inches thick, and the jacket 0.75 inches long, but in need of trimming to make the mouth even. The ET-2-S adjustable trim die is used to snip off the rough mouth section and leave an exact length, evenly trimmed jacket. Additional draws can be from .45 to any caliber down to .40, and from .40 to any caliber down to .30. Each additional draw is an optional JRD-2-S and ET-2-S pair, to reduce and then trim so that the drawn length does not exceed the punch length of the next stage.

Additional draws can take the cup down to .22, or from .22 to .20, .19, .17, .14, .12, or .10. The jacket maker works well with the CSP-1 press, and it is extremely efficient when used with the [CSP-1H Hydro Mite](#) press. The long, powerful stroke of the Hydraulic bench press is ideally suited to jacket making.



Corbin Manufacturing & Supply, Inc.
PO Box 2659
White City, OR 97503 USA

Phone 9am-5pm Mon-Thurs: 541-826-5211

Fax 24-hrs: 541-826-8669

Website: <http://www.swage.com>

E-mail: sales@corbins.com

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