

The PCM-2 uses standard diameter PCM-W cannellure wheels to fit the range of calibers from .224 to .510-inches, or specific diameter wheels made to order for your particular bullet and depth of cannellure. Specific wheels are best for use with the carousel feeder, which itself is diameter-specific. Spacers fit between a floating steel plate and the wheel to position the cannellure vertically. The spacers are .027 and .048 inches thick, making it possible to stack them in various combinations to achieve any practical position for the cannellure ring. To select the proper size wheel for a given caliber of bullet, refer to the chart. Specific size wheels are marked with the proper bullet diameter.

Caliber	Code	Wheel Diam., Inches
.224 to .257	A	2.100
.258 to .308	B	2.014
.309 to .358	C	1.900
.359 to .412	D	1.815
.413 to .458	E	1.710
.459 to .512	F	1.615
.512 to .600	G	1.515
.600 to .690	H	1.415
.690 to .800	I	1.315
.800 to .900	J	1.215
.900 to 1.00	K	1.115

Special back plates also required for these larger calibers.



Standard cannellure width is .050-inches with a vertical serration. The raised portion of the wheel, which impresses the cannellure, is offset from the center of the wheel, so you can turn the wheel over providing different cannellure positions, in addition

to the spacers. Wheels are held in place by a collar, secured to the shaft by a single set-screw, which must be clamped against the flat of the shaft.

CORBIN
 PO Box 2659
 White City, OR 97503 USA
www.Corbins.com



PCM-2 Power Cannellure Machine



Cannellure 50-100 bullets/minute
 Weight: approx. 20.5-lbs.
 Power: 110-120 volts 50/60 Hz.
 or 220-240 volts 50/60 Hz.

Rust resistant, baked-in powder-coated grey finish on the heavy gauge steel cover.

Reversible rotation with mistake-proof center pause switch (must be put in center position and then moved deliberately to reverse direction).

Protected with Buss AGC 3A 250v rated fuse, easily accessed for replacement (below the power/direction control switch).

Massive thrust bearing adsorb the powerful forces that roll precision cannellure rings (serration grooves) into copper, aluminum, lead, gilding metal, brass, or even mild steel bullet jackets. A set of precision spacer disks provides cannellure height settings that cannot vibrate out of adjustment. Cannellure depth is adjustable.

The PCM-2 comes with a set of spacers, Allen wrenches to adjust the depth and lock the back plate into position for the bullet diameter, a universal 224 to 475 caliber back plate for cannellure rolling (optional knurling back plate is available), and one diameter of cannellure rolling wheel (PCM-W) which covers a certain range of calibers (see chart) within the back plate adjustment range. Custom wheels can be made to order. Simply feed bullets in one side of the channel, and they come out the other side evenly cannellured.

The PCM-2 rolls precise cannelure in bullets, and other straight-sided cylinders, made of copper, brass, aluminum or mild steel tubing with walls up to .050-inches thick. It is not recommended for rolling cannelure in solid rod, and is not warranted for such use. Solid copper, brass, aluminum or steel bullets, or other designs having the same resistance to compression, may cause damage to the main thrust bearing or motor, or produce accelerated wear.

Bullets are fed into the left-hand side of the rotating disk, and caught and rotated into and through the channel between the back plate and the wheel, and emerge from the opposite side of the channel. The width of the channel is set by a small movement of the back plate. It can be made to rotate about the left-side mounting bolt in a precise manner, by loosening the right-side mounting bolt slightly and adjusting a set-screw in the front of the back plate. The set-screw bears against a pin and moves the plate precisely to adjust for the correct bullet diameter and depth of cannelure desired.

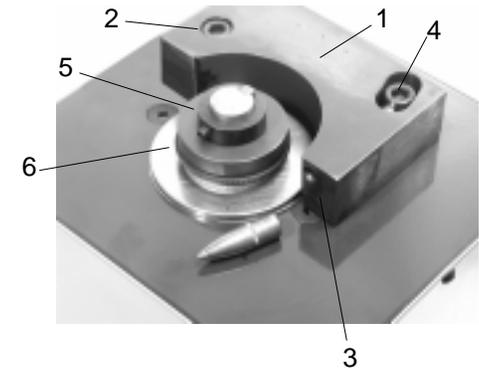
Early models used a spring-loaded gate device on the left-hand side of the back plate to assist in aligning long bullets. Later production does not use this gate, which has been replaced by the optional use of the carousel support unit as required.

A number of automatic feeder designs have been built by Corbin clients to feed their PCM-2 tools, such as vibratory bowl and drop tube feeders. These are limited to specific lengths, weights, shapes or calibers, and often cost many times what the PCM-2 does. Even by hand feeding the tool, it is possible to achieve up to 50 pieces per minute: mounting the tool at a slight angle so the bullets tend to slide toward the channel, yet not fall over, is one simple method of rapid feeding.

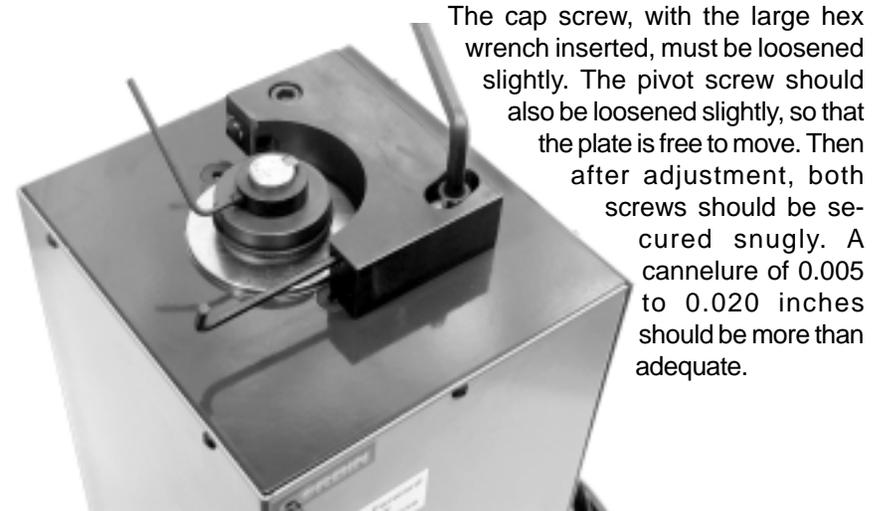
Corbin makes the PCM-F carousel support unit to fit your specific bullet size and length (and base shape), as an option that increases reliability with boattailed or very long bullets. It supports the bullet and guides it through the track, yet stops at the lightest touch for loading.



1. Back Plate
2. Pivot screw
3. Adjustment for depth
4. Locking screw
5. Wheel Locking collar
6. PCM-W wheel



The depth adjustment screw, being adjusted below with the hex wrench, bears against a large cap screw and pushes the backing plate away from it to make the gap tighter, between the wheel and plate. This pushes the cannelure deeper into the bullet.



Note: if a bullet tends to stick, skid without turning, or is deeply marked on one side and lightly on the other, it usually is caused by trying to adjust the tool so the back plate is too close to the wheel, or by using a wheel that is at the very edge of its range for the depth being attempted. Using the next size of wheel may be the solution, or simply using less depth. It is common for bullet makers to believe that a .040 or deeper cannelure is necessary, when in fact as little as .005 inch depth provides sufficient crimp space with far less deformation of the bullet. Custom designs with too much area under the combination of grooves, or with insufficient serrations on the wheel (or no serrations) may or may not turn the bullet. Some adjustment to a custom design may be required in order to get better results.