



## Point Form Die with Bleed holes, Sync Ejector



-S type

- PF-1-SB
- PF-1-HB

**Purpose:** The point forming die puts a smoothly curved nose (ogive) on the bullet. The semi-blind hole eliminates the step or shoulder

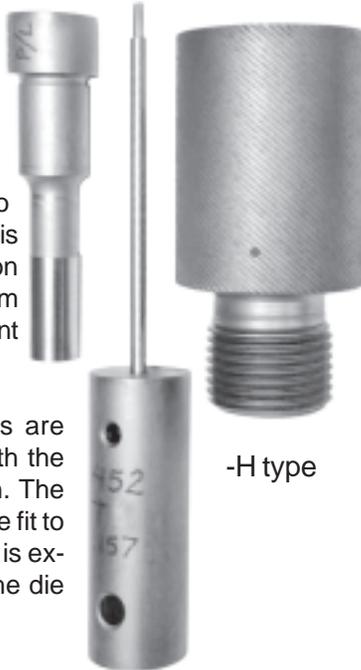
that would be created by using a punch. The bullet is ejected by means of a punch operated by the ram and press stop pin or ko bar on the down stroke. The -B = bleed holes, which allows lead bullets without a step shoulder to be made in one stroke. The bleed holes adjust the weight while the ogive and base are being formed.

The ejector is synchronized with the depth of the cavity, and fitted precisely to the ejection pin hole to seal pressure. This means you can form the meplat or tip on the bullet easily, and with the proper form of ejector punch, can even put hollow point cavities in the bullet in one step.

**Identification:** The die and punches are marked "P". They are also marked with the caliber and the size of the ejection pin. The diameter of the external punch is a close fit to the die cavity. The length of the ejector is extremely important and is marked on the die and on the punch.

To make a new punch, we need to know this number. The dies have both the punch length over-all, and the ejector length. The exact cavity depth determines the sync numbers. Both numbers are required in order to make a replacement or new punch.

<i>Specifications:</i>	
Caliber	_____
Ogive	_____
Base	_____
Ejector Diam	_____
Sync Len	_____
Rod Len	_____
Other	_____



-H type

## Bleed-type, Sync-ejector Point Form Die (type -SB or HB)

**Operation:** Install the ejector pin into die and screw the die into the press ram. Install the external punch in the punch holder. Put the lubricated lead core and jacket into the die.

Carefully adjust the punch holder so that the ogive is formed at the top of the stroke. A small amount of lead must extrude from the bleed holes in order to assure that the weight is adjusted. The press ram (and die) must go fully to the top, or else the weight will vary.



This die is NOT used with jacketed bullets. The jacket would cover the bleed holes and prevent it from operating properly. Also the diameter is adjusted so that lead forms to the desired size, without allowance for spring back of a jacket.

The nose end of the bullet, or "meplat", is formed properly when the lead is pushed firmly against the ejection pin. If an ejection pin that was not build and synchronized for use in the particular die is used, it will likely be too short or too long to exactly seal the end of the die cavity. This may happen if you have several similar dies, and mix up the ejection pins. The sync length is marked on the die and on the matching ejection punch. Be sure to use only the proper combination.

The symptom of a "too long" punch is the punch will form a hole with its full diameter into the end of the bullet, which may leave a fragile and ragged edge at the tip. The symptom of a "too short" punch is that the lead will flow up into the ejection pin hole, and create a post or projection on the tip of the bullet. The proper length of punch leaves the end of the bullet flat across the meplat, with whatever shape may be machined on the tip of the punch to your specification for hollow point, if used.

The projecting HP tip may be broken off if you use an very angled piece of lead core which shoves sideways on the pin. Try to use cores with as flat an end as possible. Cast cores typically have a more flat end than those cut from a spool of lead wire. Flat meplats without a HP cavity use a punch that does not project into the cavity except for ejection, and therefore are unlikely to be pushed sideways even with a very angled core.

