



Custom Point Form Die
 PF-1-SC PF-1-HC



-H

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 spring wire punch pressing against the very tip of the bullet. Custom PF dies are those made to non-stock, non-standard combinations of caliber, diameter, ogive shape, ejector diameters, or with other special custom features not found on

Specifications:
 Caliber _____
 Ogive _____
 Ejector _____
 Base _____
 Other _____

off-the-shelf standard dies. The standard ogives and diameters are listed for standard pricing. Others either singly or in combinations of features require custom work (which may include producing special reamers and laps) and are priced accordingly.

Identification: The die and punches are marked "P". They are also marked with the caliber, the ogive shape (such as "8-S" or "1-E") and the size of the ejection pin. The diameter of the external punch is a close fit to the die cavity. The type -S dies use a hole in the head of the ejection punch, which is held by a long stop pin. Type -H dies use a hole in the head of the ejection punch, held by a 1/4-inch retraction pin.

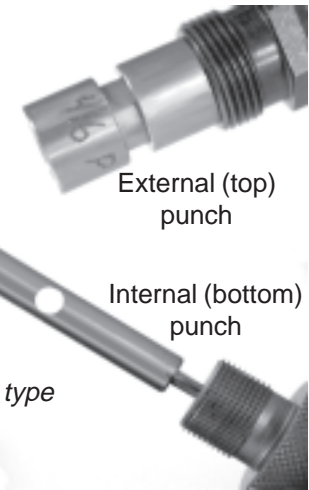
Operation: Install the die in the press ram. Install the external punch in the punch holder. Put the seated core and jacket, or a properly sized lead core, into the die. Raise the ram to the top of its stroke. The punch holder should be set high enough so the bullet does not touch the external punch. Adjust the punch holder downward to contact the bullet. Lower the ram, and carefully adjust the punch holder so that the ogive is formed to the desired degree, or until the tip size matches the size of the ejection pin. Stop short of forming a "pipe" on the tip.



-S



Point Form Die



External (top) punch

Internal (bottom) punch

Type -S die is shown. The -H type operates the same.

Making open tip, lead tip, or full metal jacket bullets:

Open tip: means the core is shorter than the jacket, leaving an open tip. Use a standard OT core seat punch which fits the jacket ID to seal pressure for that core and jacket combo.

Lead tip: means the core is longer than the jacket after the point is formed, leaving exposed lead tip. Use LT core seat punch which fits the die bore, instead of the jacket ID.

Hollow point: means the core seat punch has a projection on the tip and pokes a hole into the lead core. HP-OT and HP-LT are both possible to make. But a LT-OT is a contradiction and cannot be made. You must specify either OT or LT, and then HP if you also want a hole in the core. A hollow point is NOT the same thing as an open tip.

Full metal jackets are made by seating the core in the jacket by using just the point forming die. The jacket and core are inserted into the point form die with the open end of the jacket toward the die mouth. A punch that fits inside the jacket is used to press on the core, forming an ogive or nose on the closed end of the jacket. The bullet is then ejected, turned over and put back into the same point forming die. Light pressure on the nose will force the open end of the jacket to take on a slight taper from the ogive of the die. Then eject, turn the bullet over, and once again insert it into the point forming die. This time, use a special "base turning" punch with a shallow cup face to sharply roll the open end of the jacket over the base. Then change to the normal flat-faced point form external punch and press firmly to close the jacket over the core.