



ULD Tip Seating Point Form Die



- PF-1-ST
- PF-1-HT

Specifications:
 Caliber _____
 Base _____

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 special ULD (Ultra Low Drag) ogive shape matches the shape of a machined tip insert (ULD Tip). The tip is installed and formed as part of the bullet using the special PF-1-ST or PF-1-HT die, providing extremely high BC bullets with good balance. Two operations are used in this die.



Identification: The die and punches are marked "PT". 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. There are two ejection punches. One has a reduced solid tip, and one has a cavity shaped like the tip of the metal insert.

The die set may require two additional punches for prior stages in order to prepare the core for the tip stem. The two punches replace the standard core swage external and core seat external punches, to create the cavity which accepts and holds the stem of the ULD tip.

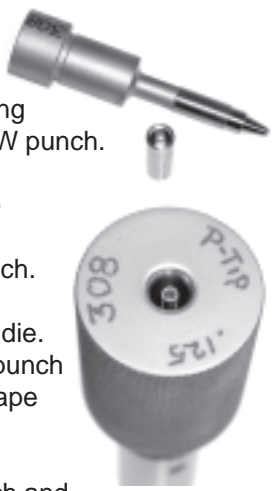
Operation: Install the ejector pin with the projecting nose into die and screw the die into the press ram. Install the external punch in the punch holder. Put the seated core and jacket into the die tip first (down). Carefully adjust the punch holder so that the ogive is formed at the top of the stroke with a small hole in the core, to accept the stem of the tip insert. The amount of lead core used is critical (compared with jacket length) to support and align the tip. Form a quantity of bullets, and change the internal (ejection) punch for the one with the cavity. Reinstall the die and punch. Set a tip insert into the punch cavity, insert the bullet, and seat the tip into the bullet to finish it.

ULD Tip Seating Point Form Die (type -ST or HT)



Operation:

1. Swage the core using the probe shaped CSW punch.
2. Seat the core in the jacket with the special probe shaped CS punch.
3. Install the PF-1-HT die. Use the solid ejector punch to maintain the hollow cavity shape as you form the ogive.
4. Remove the first ejector punch and install the punch which has a cavity shaped to support the insert by the sharp end.



5. Set a metal tip insert into the punch cavity, and raise the ram to finish seating the tip into the bullet nose. Do not use any more pressure than necessary to accomplish this. The bullet is now finished.

Note:

The exact amount of lead core is critical for a given length of jacket, in order to have just enough support for the tip (and to hold firmly on the tip insert's stem). Too much lead spurts out the end of the jacket and prevents the tip from being inserted. Too little fails to come far enough toward the bullet end to create and maintain the tip-grabbing cavity.

Do not use any more pressure than it takes to just form the ogive and seat the tip in place. Too much does no good and can cause harm.

Please note that there are TWO ejection punches with the PF-1-HT or PF-1-ST type point form dies. One is solid and has a stepped end, and one is straight and has a hole shaped like the tip in the end.

