

CORBIN Jacket Serrate/Draw Die

SDD-1 □-R □-S □-H Caliber: _____



The Corbin SDD-1 Serrate/Draw Die may be used to score the outside of an empty bullet jacket, so the bullet will separate along the score lines on impact. For effective high frangibility projectiles, the empty jacket is pushed *base first* through the die with a *punch that fits inside the jacket*. This scores the length of the jacket. The core is then seated and the ogive is formed, further stressing the score lines in the nose area for rapid expansion at lower velocity than would normally be possible.

Jackets used to make flat base bullets can be serrated before core seating, but jackets to be used for rebated boattail bullets should not be full length serrated, as this will weaken the base area and potentially cause the jacket to crack at the base. For RBT serrated bullets, use the SDD-2 ogive serrator, and adjust it so the base section is not affected.

The serrations are made with six cutting points. The points are factory-set to the most effective depth, a balance between metal displacement, operating force, and expansion effect. Metal displaced from the serration groove causes the diameter of the jacket to increase; this increase is reduced to proper diameter again by a drawing section built into the die, as

the jacket passes up and out through the top of the die. The serrations appear to be very shallow as a result of this ironing, but they are designed to operate in the most effective manner. Changing the depth of the cutter points simply to get a more visible line is not recommended, as it can cause excessive force, oversized jackets, and broken components. The stress of impact follows the lines of least resistance, so it is neither necessary nor desirable to cut any deeper than a few thousandths of an inch. Only light force should be necessary to serrate the jacket.

If it should be necessary to remove or reset the serrating points, a jacket can be put over a punch and used as a "stop" to adjust the points back in again. This will get the points adjusted about the same position. Then, after pushing the jacket out, each of the adjustments can be turned in another 1/8 to 1/4 of a turn and held while the locking nut is turned with a small wrench to lock them in position. A felt tip pen can be used to put a mark on the screws before they are removed, so that the position of the mark can be adjusted to the same place once the approximate depth is found with a jacket as a stop gauge.

Please note: Only EMPTY jackets are pushed through the SDD-1 die. Finished bullets or jackets with seated cores are not suitable.

Attempting to serrate them may damage equipment or cause other problems. The process of seating the core into the serrated jacket helps to expand and thin the material under the cuts, and is part of the over-all preparation for making a fragmenting bullet more effective.

