

# CORBIN<sup>®</sup> SDD-2

## Serrate/Draw Die

- DDS-2-M
- DDS-2-S
- DDS-2-H

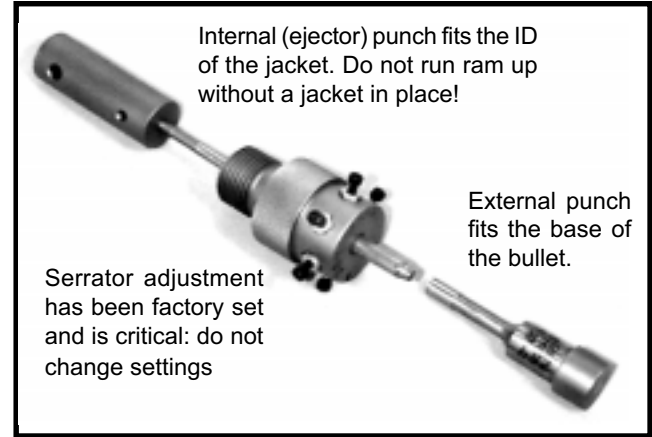
**Caliber:**

**Jacket:**

The SDD-2 die is a version of the serrator/draw die which can serrate just the mouth of a bullet jacket, ejecting the jacket back out after serrating a certain distance toward the base.

The bullet jacket is serrated after seating the core, but before the point is formed. The die fits into the press ram. *The internal punch is a loose fit, serving only as an ejector.*

The jacket (of a specific wall thickness, but any reasonable length) guides the tip of the punch through the serrator. *The ram should not be run up and down without a jacket in place to align the internal punch.*



The depth of cut is set at the factory and should not be changed. Too much depth will cause the jacket to collapse or bend, and stick in the die or on the punch. The purpose is to make shallow cuts which act as stress risers and cause the jacket to peel back along the lines, on impact. The jacket should be placed mouth down into the die, and the external punch used to gently push the jacket down as far as desired without actually entering the die. On the down stroke, the internal punch enters the jacket mouth and pushes the jacket out. Use Corbin Swage Lube on the OD of the jacket to ease the pressure. Brush out the ID of the die to remove chips.