



DELUXE RELOADING DIES



FL



S

DELUXE TWO DIE RIFLE SET

Pacific Rifle dies are marked for easy identification:

- FL** Full length die. This die should be used on all cases that you desire to return to factory dimensions.
- N** Neck size only. This die should be used on cases that will be used in the same rifle in which they were originally fired.
- S** Seating Die. This is used with either FL or N die for seating and/or crimping bullets.



#1



#2



#3

DELUXE THREE DIE PISTOL SET

Pacific Pistol dies are marked for easy identification:

- #1** Used to size case to original dimensions.
- #2** Used to remove primer and expand mouth of case to receive bullet.
- #3** Seating die, used for seating and/or crimping bullets.

PACIFIC DIE WARRANTY

All Pacific Die Bodies are warranted, to the original purchaser, for his lifetime, against defects in workmanship or material and dimension changes caused by normal wear.

This warranty is exclusive of breakage or damage incurred by improper use or maintenance of the dies, or scoring caused by inadequate preparation or cleaning of cases used in these dies.

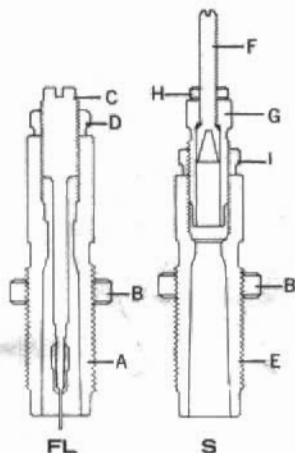
Pacific Gun Sight Company's liability in connection with this transaction is expressly limited to the replacement or repair of defective parts covered by this warranty. All other damages, statutory or otherwise being hereby expressly waived.

This warranty effective only on dies purchased after January 1, 1964.





DELUXE 2 DIE RIFLE SET



When a cartridge is fired, the case expands to conform with the chamber. Since there are seldom two chambers the same, it is imperative that cases be full length resized if they are to be re-fired in another chamber. However, if cases are to be fired in the same chamber, neck sizing is more desirable. This results in longer case life, more uniform chamber pressures, more case capacity and better accuracy.

It is important that all cases to be sized be free of foreign matter, sand, etc. Cases to be full length sized must be lubricated on the body of the case with a thin film of Pacific Case Size Lubricant. Care must be taken to keep lubricant off the shoulder and neck of case as this will cause dents in the case. Lubrication of the inside of the case neck will insure easier extraction of the case from die and will prevent stretching when expanding case neck. Lubrication must be used very sparingly on inside of case neck to prevent misfires from excess lube entering primer through flash hole. Lubricate case necks by using a nylon bristle brush, of the proper caliber, that has been lightly coated on the bristle tips by gently rolling across the pad or rag that was used to lubricate outside of case. In time the vent hole in your size die may become clogged with old lubricant. It is advisable to wash your dies periodically in solvent before this condition occurs. Dented cases coming from sizer are an indication of clogging. The use of too much lubricant will also cause wrinkles or dents in the shoulders of the case.

IMPORTANT:

Remove all oil from inside new dies before adjusting. This is a protective oil used by the manufacturer, and if not removed could cause bent or buckled case.

To adjust sizing die (rifle):

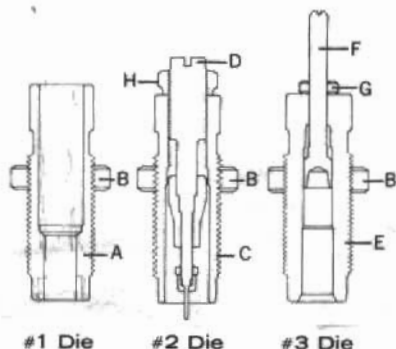
1. Thread size die (A) into tool head until it comes to rest against the shell holder when at the top of its stroke. Tighten lock ring (B).
2. Adjust decap unit (C) in center of sizer to remove fired primers properly. Tighten lock nut (D). NOTE: Adjust expander decapper unit only far enough down into die to decap case. If this part is adjusted down too far, it will prevent case from entering die the full length.

To adjust seating die (rifle):

1. Thread seater body (E) into tool until bottom of seater body rests against top of shell holder when at top of stroke. Tighten lock ring (B).
2. Thread crimper (G) down as far as it will go. Then adjust crimper back up 4 to 5 complete turns. Tighten lock nut (I). Place shell into shell holder and bullet on mouth of case and raise shell holder to top of stroke. Thread seating stem (F) down until bullet seats to desired depth. Secure with lock nut (H). NOTE: If crimp is desired, crimper (G) is adjusted by threading seating stem (F) up 3 to 5 turns, then threading the crimper (G) down until the proper crimp is achieved. Tighten lock nut (I). When proper crimp has been reached thread the seating stem back down until contact is made with the bullet. Tighten lock nut (H). CAUTION: Over-crimping will cause case to collapse at shoulder and cartridge will not chamber properly.



DELUXE 3 DIE PISTOL SET



The **THREE DIE PISTOL SET** is designed for ease in complete pistol loading. By following the step-by-step instructions closely, you will acquire speed and uniformity in pistol loading.

A fired case expands beyond maximum cartridge standards; therefore, considerable friction is encountered when sizing cartridge cases. It is imperative that cases be cleaned and **EACH ONE** lubricated with a thin film of **PACIFIC CASE LUBRICANT** before sizing.

IMPORTANT :

Remove all oil from inside new dies before adjusting. This is a protective oil used by the manufacturer, and if not removed could cause bent or buckled case.

Instructions for adjusting Pacific pistol dies:

#1 Die: Full length and trimmer body:

1. Thread #1 Die body (A) into tool head until it comes to rest against the shell holder at the top of its stroke.
2. Lock die with lock ring (B) and tighten set screw.
3. Place case into shell holder and force into die. When case is removed, it will be properly sized.

#2 Die: Expander and Decapping:

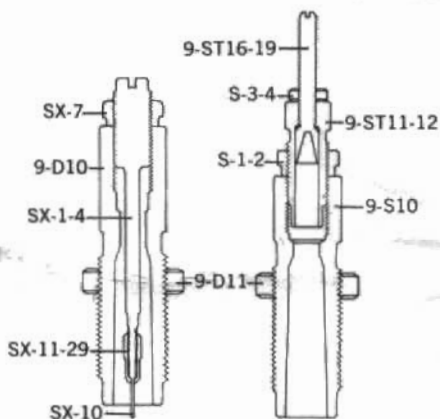
1. Thread #2 Die body (C) into tool head until bottom of die comes to rest against shell holder at the top of its stroke. Screw expanding unit (D) part way out. Secure die (C) with lock ring (B) and set screw.
2. Place shell into shell holder.
3. Run shell holder up to top of stroke and adjust expander (D) down into die until proper bell is obtained on the mouth of the case. (Do not over-bell mouth).
4. Tighten lock nut (H) to secure part (D).

#3 Die: Seating and Crimping:

1. Thread #3 die body (E) into tool head until bottom of die is approximately $\frac{1}{4}$ " above shell holder at top of its stroke.
2. Place shell and bullet into shell holder. Run shell holder to top of stroke, adjust seating stem (F) until bullet seats to desired depth.
3. Thread seating stem (F) up about $\frac{3}{16}$ ".
4. Thread die body (E) down into tool head until proper crimp is obtained on case.
5. With seated and crimped cartridge in die, run seating screw (F) into die until it comes to rest on nose of bullet. Tighten lock nut (G).
6. Lock die with lock ring (B) and set screw. It is now properly adjusted.

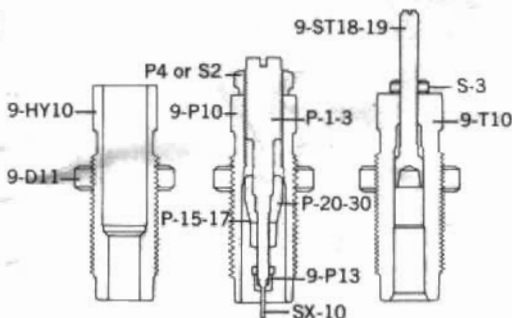
Note: If trouble with inconsistent crimping is experienced check case lengths. To obtain uniform, trouble free crimping all cases must be trimmed to exactly the same length.

DELUXE DIES PARTS AND PRICE LIST



TWO DIE RIFLE SETS

Part Number	Description	Price
FL DIE		
9-D10	Die body (state cal.)	\$5.70
9-D11	7/8 x 14 Lock Ring	.60
9-D12	Lock Ring set screw (not shown)	.20
SX-1-4	Spindle (state cal.)	1.00
SX-7	Spindle nut	.40
*SX-10	Straight decap pin	.20
SX-11-29	Expander nipple (state cal.)	.70
SX-100	FL die assembly complete (state cal.)	8.00
N DIE (not shown)		
9-D54	Die body (state cal.)	5.70
9-D11	7/8 x 14 Lock Ring	.60
9-D12	Lock Ring set screw	.20
SX-1-4	Spindle (state cal.)	1.00
SX-7	Spindle nut	.40
*SX-10	Straight decap pin	.20
SX-11-29	Expander nipple (state cal.)	.70
N-100	N Die assembly complete (state cal.)	8.00
S DIE		
9-S10	Die Body (state cal.)	5.40
9-D11	7/8 x 14 Lock Ring	.60
9-D12	Lock Ring set screw (not shown)	.20
S-1-2	Crimper nut (state cal.)	.40
S-3-4	Seating stem nut (state cal.)	.20
9-ST11-12	Crimper (state cal.)	1.00
9-ST16-19	Seating stem (state cal.)	.70
S-100	S die assembly complete (state cal.)	6.50



THREE DIE PISTOL SETS

Part Number	Description	Price
#1 DIE		
9-HY10	#1 Die body (state cal.)	\$6.00
9-D11	7/8 x 14 Lock Ring	.60
9-D12	Lock Ring set screw (not shown)	.20
#1-100	#1 Die assembly complete	6.50
1-100C	#1 Die assembly w/carbide insert	24.00
#2 DIE		
9-P10	#2 Die body (state cal.)	4.80
9-D11	7/8 x 14 Lock Ring	.60
9-D12	Lock Ring set screw (not shown)	.20
SX-10	Decap pin (state cal.)	.20
9-P13 (S-L)	Pistol expander nipple (state cal.)	.40
P-1-3	Spindle (state cal.)	.80
P4 or S2	Spindle nut (state cal.)	.20
P-15-17	Expander collar (state cal.)	.30
P-20-30	Flaring collar (state cal.)	.30
#2-100	#2 Die assembly complete	6.50
#3 DIE		
9-T10	#3 Die body (state cal.)	5.20
9-D11	7/8 x 14 Lock Ring	.60
9-D12	Lock Ring set screw (not shown)	.20
9-ST18-19	Seating stem (state cal.)	.80
S-3	Seating stem nut	.20
#3-100	#3 Die assembly complete (state cal.)	6.50

NOTICE: Prices and/or specifications are subject to change without notice. Discontinued products may or may not have replacement parts available. Call for availability 800-338-3220.

*224 Weatherby and 218 Bee takes decap pin #9-DP-37

Pacific Gunsight Company cannot assume any liability for damage which may result from the use of the products or information given herein. This is necessary because Pacific Gunsight Company has no control over the manner in which products or components are used in the reloading operation.

All prices and/or specifications subject to change without notice

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