

The expander die is a universal die which is designed to hold an expander plug. Currently, there are no die markings on expander dies; however, in the past, expander dies were sometimes marked as Pistol, Rifle, or Die followed by a number.

Procedure

1. Remove the expander plug from the die body.
2. Raise the press ram fully to the highest point of its stroke.
3. Thread the expander die clockwise into the top of the press until it barely contacts the shell holder. Rotate it counterclockwise one full turn and tighten the lock ring.
4. Place an empty case in the shell holder and raise the case up into the die and leave it there.
5. Insert the expander plug into the die and screw it down until the plug makes contact with the case mouth of the brass.
6. Lower the case from the expander die. Lower the expander plug approximately 2 rotations, then tighten the lock ring.
7. Lube either the case mouth or the expander plug, and then, slowly raise the case up into the die.
8. Lower the press ram and remove the case.
9. Measure the case to verify that it expanded to the desired specifications.
10. Adjust the expander plug up or down in the expander die as needed, until the desired expansion is achieved.

Case Mouth Belling

To "bell the case mouth" means to slightly flare or expand the opening of a cartridge case so you can insert a bullet without damaging the case neck or shaving lead. Our mandrel style M Type Expander Plugs are designed to be able to handle this type of operation by lowering the expander plug further than normal so that the case mouth engages the large bevel behind the expanding area of the plug.

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