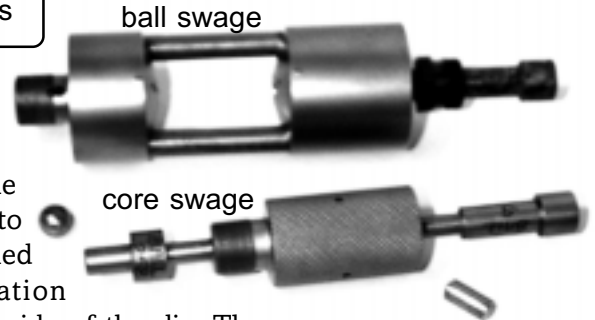




BSK-1-S Ball Swage Kit

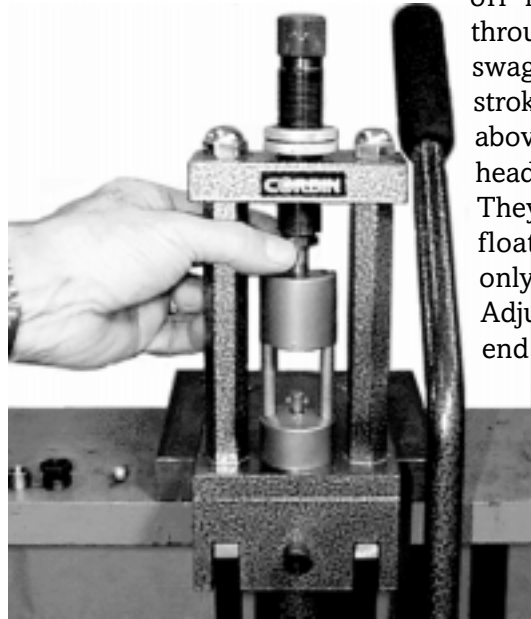
For use in the Corbin CSP-1 Series II Press

Diameter _____ in
Core Weight _____ gr
Final Ball Weight _____ gr



1) Swage the cores to the indicated core weight, above, using the core swage die. The lead cores can be cast, or cut from lead wire to a weight that is from 3 to 5 grains more, and the surplus lead is bled

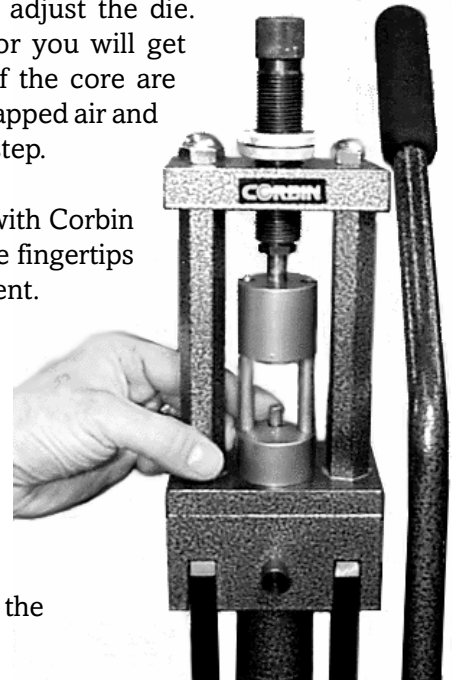
off in the swaging operation through bleed holes in the side of the die. The core swage die fits into the press ram. A stop pin ejects the core on the down stroke. The internal punch fits into the threaded end of the die, as shown above. The external punch fits into a Floating Punch Holder in the press head. A hex bushing, and a round bushing, are provided in the punch holder. They retain the external punch and let it move slightly under pressure for a floating CNC type alignment action. Tighten the hex bushing by hand only.



Adjust the position of the punch holder so that the end of the stroke is being used to adjust the die. The ram must go full stroke or you will get weight variations. The ends of the core are slightly rounded to eliminate trapped air and flat spots in the ball forming step.

2) Lubricate the cores lightly with Corbin Swage Lube. Handling with the fingertips moistened with lube is sufficient.

- 3) Install the ball swage into the press as a unit: Do not take it apart!
 - a) Remove the floating punch holder.
 - b) Tip the assembly so you can put the punch up into the top of the press and then align the assembly with the ram and screw it down into the ram.
 - c) Install the punch holder. Fasten the upper die half in the holder using the build-in hex bushing.
 - d) Adjust the punch holder for light pressure on the die at the end of the stroke.



4) Swage the ball using light pressure. Do not press the two halves of the ball die together with force, as it may damage the die. Lightly push on the ball with a pencil to remove it from the die, should it wish to stick.

5) Remove the sprue from the ball with a sharp blade or close-cutting nips. Any thin flashing will come off in handling. Lubricate the ball again, and place it back in the die with the sprue facing up. Lightly bring the die halves together. (Balls can be re-swaged several times if desired for more perfect roundness, although ramming them home in the gun destroys this fine degree of roundness).

Note: varying initial swage pressure affects precise diameter of the ball. Use as much pressure as is practical without damage to the equipment. The 5/8-24 thread tenion on the base die can be repositioned to allow for convenient alignment of the guide rods in relation to the press frame.