



ET-2-S

\_\_\_\_\_ cal.

## Auto Ejecting Jacket Trim Die

The ET-2 jacket trim die is designed for use in Corbin swaging presses. The -S die fits into the ram of the press, and the external punch fits the floating punch holder in the press head. The -H version uses an adapter kit with the -S die, allowing the same die and punch to be used in both -H and -S presses (see info on ET-2-H adapter).



On the upstroke, the jacket is pushed mouth first over the downward pointing top punch, which expand the jacket and then scores it nearly but not quite completely through at the contact of the punch and die. On the down stroke, the internal punch contacts the stop pin in the press. This stops the internal punch while the die continues down, and ejects the trimmed jacket. The surplus material can be easily broken off from the jacket. It is lightly attached to the jacket and is ejected with it (light pressure or tumbling will separate the cut section from the jacket).

1. Put the die and internal punch in the S-press ram, or the adapter with die and punch, plus the -H adapter head, into the type H press ram. Raise the ram, and gauge the depth from the mouth of the die to the face of the internal punch by placing the gauge tool in the die, and adjust the collar position until it rests on the die mouth with the rod pushed firmly into the die (against the internal punch).

2. Write down the length of the rod that represents the distance from the die mouth to the internal punch face with the ram up.

3. Remove the die and punch from the press.

4. Compare the length of jacket you want with the length you measured in step 2. If the jacket you need is shorter than this, move the internal punch nut AWAY from the end of the punch that goes into the die by the difference. If the jacket you need is longer than the measured rod length, move the nut TOWARD the end of the punch that goes into the die, by exactly the difference.

5. Your internal punch is now set up to let the jacket go into the die exactly as far as the final length you need. Anything that projects from the die is scored to be cut off the open end of the jacket.

6. Put the die and internal punch back into the ram finger tight (snug but not forced with tools).

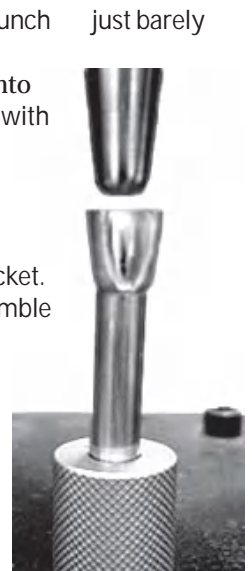
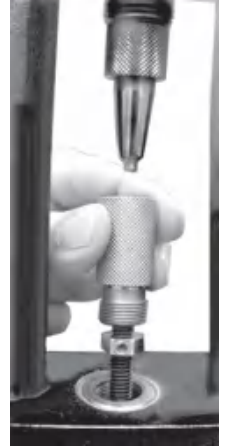
7. Put the external punch, which has a fat, tapered appearance, into the punch holder in the top of the press. Secure it finger tight.

8. Raise the ram all the way to the top of the stroke, and adjust the position of the punch holder so that the punch just barely touches the die mouth. Do not adjust any closer than barely touching, or the die or punch will be damaged.

**CAUTION: All it takes to peen over the edge of the die hole is one "test" stroke that runs the punch into the die firmly.** Never run the punch into the die mouth without a jacket to cushion it. Just bring the ram up with the punch completely out of the way, and then adjust the punch holder down until you barely have contact. SECURE the punch holder so it cannot get any closer during operation!

9. Lightly lubricate a jacket with Corbin Swage Lube and wipe a bit of the lube on the top (external) punch. Raise the ram slightly and insert a jacket with the open end up. Then raise the ram all the way to score the jacket. Lower the ram to eject the jacket. Repeat until all jackets are scored, and either flick off the cut portion or tumble the jackets to knock it off.

NOTE: The die cannot cut through the jacket all the way. To do so would mean the punch has to press against the edge of the die without any cushioning material from the jacket. The edge of the die will be peened over, so that jackets are hard to insert, and are scratched when ejecting. The cut will be poor and the scrap section will be difficult to remove. If these things occur, you have peened over the edge of the die hole. To fix it, a very light face grind at 90 degrees to the axis of the die will restore the sharp edge. You can send the die back for a quick refacing job if necessary.



# ET-2-S with -H Conversion Kit = ET-2-H

The ET-2-S die set consists of a tapered trimming punch, which screws into the threads of the FPH-1-S Floating Punch Holder in the CSP-1 press head, and the trim die, which screws into the 5/8-24 threaded ram of the CSP-1 press.



The ET-2-H adds an adapter kit to allow this trim die to work in the -H presses (such as the CSP-2 Mega Mite or CHP-1 Hydro PPress). The ET-2KIT is the separate adapter kit which can be purchased to use an existing ET-2-S in one of the larger -H type presses.

The punch adapter accepts the 5/8-24 punch thread and adapts it to the larger FPH-1-H floating punch holder.

The die adapter accepts the 5/8-24 threaded die body, and adapts it to the larger ram of the CSP-2 or CHP-1 press with a 1-in x 12 tpi adapter. The normal internal punch of the type -S die is operated by using an extension punch head. This drops into the ram of the CSP-2 or CHP-1 press, and provides the additional "reach" to push the adjustable stop length -S punch up for ejection on the down stroke.

This allows you to use the ET-2-H in either the larger Corbin -H type presses or the smaller -S press. A heavy duty version of the ET-2-H is also available. It dispenses with the adapter and uses a larger diameter die body with its own full size -H type adjustable ejection punch. The heavy duty version does not fit into the -S press, however.



Since for most purposes the S-die is equally strong and long-lasting, the use of the type -S trim die with the -H adapter has no drawback and allows you to use the same die in two different kinds of presses. The heavy duty version may be required for larger calibers.

You can save money by getting one ET-2-H trim set for your CSP-2 Mega Mite or Hydro Press, and adding ET-2-S dies which can use the same adapter kit. It takes no more time to unscrew the adapters from the press than it does to unscrew the die and punch from the adapters.