

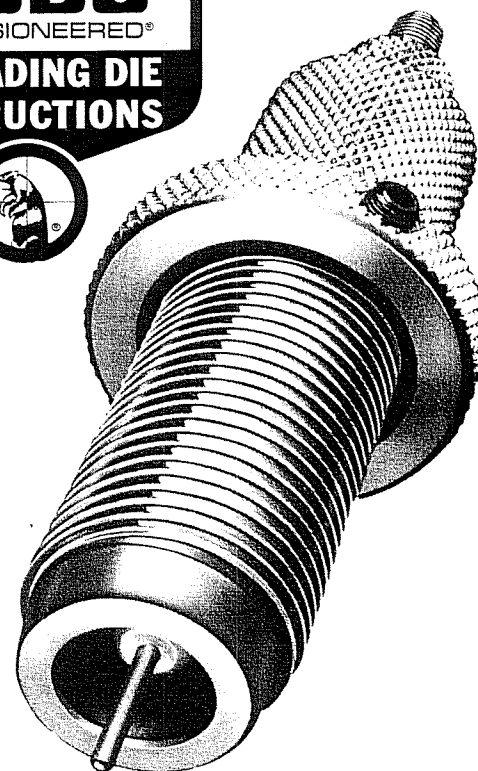
RCBS LIMITED WARRANTY

All RCBS Reloading Equipment has been carefully inspected before shipment, and is warranted against defects in workmanship. Our obligation assumed under this warranty is limited to the replacing of any part or parts which prove to our satisfaction upon examination to have been defective, and which have not been misused or carelessly handled. The complete unit must be returned to the factory, transportation charges prepaid. We reserve the right to decline responsibility where repairs have been made or attempted by others. No other warranty, written or verbal, is authorized on our products.

INSTRUCTION FORM 4-B

PRINTED IN U.S.A.

RCBS, INC. P.O. BOX 1919, OROVILLE, CALIFORNIA 95965



RCBS RELOADING DIES INSTRUCTIONS

● IMPORTANT

Please read instructions very carefully in order to obtain optimum results. DO NOT use other manufacturers instructions, especially when adjusting Seater Dies.

A WORD ABOUT YOUR RCBS DIES:

All RCBS Dies are manufactured with the standard $\frac{7}{8}$ "-14 thread and are designed for use with a shell holder having a lip thickness of 0.125". The only exceptions are the .45 Auto Rimmed, 11mm (.43) Mauser and .43 Spanish, which must have a shell holder lip thickness of 0.150". Any variations of these dimensions may cause headspace or insufficient sizing problems.

WRITE FOR FREE CATALOG



Loaded with photos and drawings. Shows complete line of famous RCBS Precisioneered® reloading tools and prices; lists reloading dies for over 200 calibers, reference tables, and a heap of other interesting information. Most informative and most descriptive reloading catalog available anywhere.

ABOUT YOUR WARRANTY:

All RCBS Dies are carefully checked and thoroughly inspected before shipping. Each Die will reload fired cases from any standard chamber of the caliber stamped on the Die. Should the Die perform unsatisfactorily, please write RCBS explaining your problem in detail. Be sure to state the caliber. Most of the time we can help you overcome the problem without the inconvenience and expense of returning the Dies. If necessary, we will grant permission to return the Dies with three sample fired cases and will include a special return shipping label. **PLEASE DO NOT RETURN ANY ITEM UNTIL PERMISSION IS GRANTED!** If the problem was caused by a defect in materials or workmanship, the necessary repair or replacement will be made. Should the trouble be caused by an oversize or undersize gun chamber or some other factor beyond our control, a \$5.00 service charge will be made to cover the cost of producing the new Dies, handling and return postage. If Special Tooling is required, an additional charge will be made. **DO NOT ATTEMPT TO ALTER THE DIES IN ANY WAY.**

If Seater Plug mars the bullet, please return Seater Plug to RCBS, along with two sample bullets you are using; necessary adjustment will be made at no cost to you. Prior permission to return Seater Plug to RCBS is not required in this instance. Sample bullets in handgun calibers cannot be returned to sender due to provisions of the Gun Control Act. **To remove Seater Plug:** remove Seater Plug Lock Ring and screw Seater Plug down into Seater Die and out. Send Seater Plug and sample bullets with your name, address, and ZIP Code to:

RCBS, Inc.
Customer Service
P. O. Box 1919
Oroville, CA 95965

Cases stuck in the Sizer Die may be removed with an RCBS Stuck Case Remover — available at your dealer. Or you may return the Die (without prior permission) along with your check or money order for \$1.50 to cover handling and return postage. Send the Die, payment and your name and address including ZIP Code to the above address. We will remove the stuck case and return the Die to you.

LOCK RINGS ASSURE PROPER SETTING:

Once the large lock ring on the Die is set, it can be locked in the desired position by tightening the Allen-type setscrew. The Die will then hold the proper setting and may be re-used without re-adjustment. To “break” the setting by the Allen-type setscrew and lead bumper, loosen the setscrew about ½ turn and tap it firmly with a plastic or hard, rubber-faced hammer or block of hardwood — a metal hammer may damage the setscrew.

PREPARING YOUR RCBS DIES:

RCBS Sizer Dies for bottle-neck type cases have a tiny vent hole through which trapped air escapes during resizing. Sometimes vent holes plug up with factory polishing compound. This compound will scratch cases and dent shoulders unless removed as follows:

Unscrew Expander-Decapping Assembly from Die. Then insert a needle, straightened paper clip, or similar object into vent hole — located just above the Die thread. This will push compound into chamber, and can be removed by the following procedure for cleaning all Dies:

Thoroughly clean the inside of each Die, using a patch saturated with solvent, Hoppes Powder Solvent #9, or any similar cleaning fluid. This will help prevent damaging and scratching Die interiors and cases.

IMPORTANT: Nickel-plated cases must be extremely clean before resizing because they scratch more easily than brass.

As soon as you note scratches on a resized case, we recommend lightly polishing the interior wall of the Sizer Die in a lathe — using #320 (fine) emery cloth to remove dirt and other foreign particles.

PREPARING THE CASES:

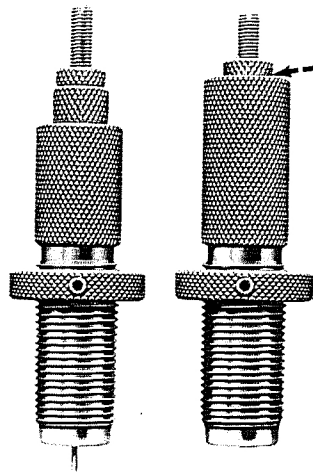
Clean and inspect cases before lubricating and sizing. Discard any cases with indications of a split neck or partial head separation. Check cases for the correct overall length and trim if necessary. If bullets are to be crimped, it is imperative that cases be trimmed to the same overall length. Trimmed case mouths should be deburred and lightly chamfered inside and out with an RCBS Burring Tool.

Cases must be properly lubricated before sizing. Remember overlubrication will result in a dented case shoulder. Improper or no lubrication will result in a case stuck in the Sizer Die. For best results use only RCBS Resizing Lubricant applied to an RCBS Case Lube Pad. Case mouths should be very lightly lubricated with an RCBS Case Neck Brush. These accessories are available from your dealer as individual items or combined in the RCBS Case Lube Kit.

DO NOT LUBRICATE THE CASE SHOULDER!

After the cases are lubricated they are ready to reload. Turn to one of the pages listed below for Die descriptions and reloading instructions.

BOTTLE-NECK TYPE RIFLE AND PISTOL CASES (2-DIE SET)	Page 4
STRAIGHT-WALL TYPE RIFLE AND PISTOL CASES (3-DIE SETS)	Page 10
STRAIGHT-WALL TYPE PISTOL CASES (4-DIE SET)	Page 18
TUNGSTEN-CARBIDE SIZER DIE	Page 20

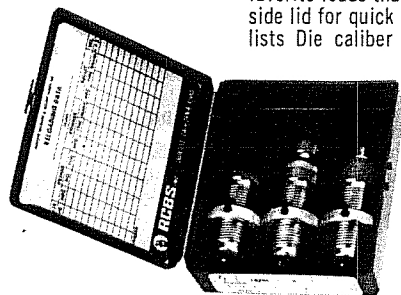


RCBS 2 DIE SET

FOR BOTTLE-NECK TYPE
RIFLE AND PISTOL CASES

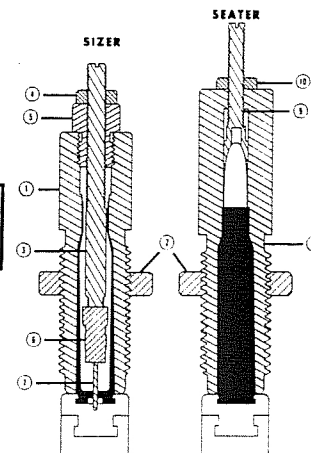
LOOK HERE
for Die Type,
Die Caliber,
Year of
Manufacture
& RCBS name.

All RCBS Dies are packed in convenient plastic storage boxes (shown below), specially designed by RCBS to protect your Dies in shipment and during storage. Unique cradle holds Dies firmly in place to prevent damage and rolling around. Convenient "T" lock holds lid closed even if box is dropped. Each box contains a label for recording your favorite loads that can be mounted on inside lid for quick reference. Label on box lists Die caliber for fast identification.



- 4 -

NOTE: Replacement
parts for RCBS Dies
are available from
your gun dealer.

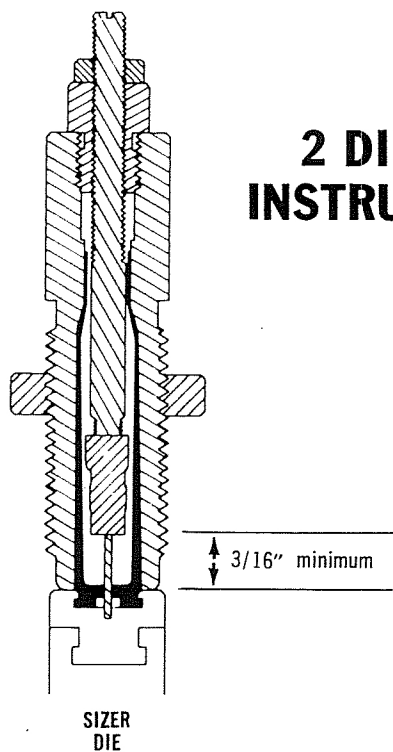


KEY	COMPONENTS DESCRIPTION	PRICE
1	Sizer Body†	\$ *
2	Large Lock Ring Assembly, 7/8"-14	.90
3	Expander-Decapping Rod†	.90
4	Expander-Decapping Rod Lock Nut†	.60
5	Guide Bushing†	.90
6	Expander Ball†	1.80
7	Decapping Pin (Package of 5)†	.90
3,4,5,6,7	Expander-Decapping Assembly†	3.00
3,6,7,	Expander-Decapping Unit†	2.40
8	Seater Body	*
9	Seater Plug‡	2.10
10	Seater Plug Lock Nut, 1/4"-28	.60

† Specify Caliber ‡ Specify Caliber & Bullet Type
* Price varies — see your dealer or the RCBS Catalog.

PRICES SUBJECT TO CHANGE

- 5 -



2 DIE SET INSTRUCTIONS

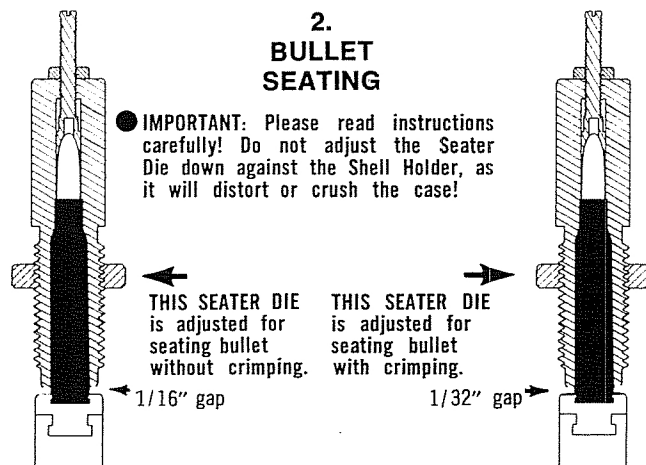
1. FULL LENGTH OR NECK SIZING

(Including Small Base, Ultra Small Base and Browning Automatic Rifle Sizer Dies)

Screw the Full Length or Neck Sizer Die into the Press until the Die touches the Shell Holder when the Shell Holder is brought up to the top of the press stroke. Be sure all play is removed from the press leverage system. To do this, adjust the Die as above, lower the Shell Holder and set the Die $\frac{1}{8}$ of a turn lower. Set the large lock ring securely against the face of the press.

The end of the expander ball must be at least $\frac{3}{16}$ " above the bottom of the Die (see drawing at left). The expander ball and decapping pin are adjusted by loosening the small lock ring at the top of the Die and turning the expander-decapping rod until the desired setting is obtained. When the expander ball is adjusted correctly, the decapping pin will protrude below the bottom of the Die just enough to knock out the spent primer.

The case is sized (full length or neck), decapped, and expanded in one operation. The next step is to prime the case and fill it with the predetermined powder charge. Then seat the bullet as shown on the next page. NOTE: Normally the reloader performs one operation at a time on one lot of cases. He sizes and decaps the cases, primes and fills them with powder and then seats the bullets.



A. BULLET SEATING WITHOUT CRIMPING

Most rifle and pistol bullets for bottle neck type cases do not have a cannelure or crimping groove and the bullet is therefore seated without crimping. To adjust the Seater Die, place the sized, primed and powder-charged case in the Shell Holder and run it to the top of the press stroke. Then screw the Seater Die into the press until you feel it touch the mouth of the case. Back up the Die $\frac{1}{8}$ of a turn (never more) and set the large lock ring. This will leave a gap between the bottom of the Die and Shell Holder about $\frac{1}{16}$ ", or the thickness of a nickel. Next lower the case and insert the bullet in the case mouth. Slowly run the case into the Seater Die. Generally speaking, the base of a properly seated bullet should be level with the lower end of the case neck. However, this is not always true because of the varying bullet weights and types.

Therefore, check the first reloaded cartridge for overall length with a factory-loaded cartridge. Or try it in the chamber of your gun. If the bullet of the reloaded cartridge seems to project into the lands of the chamber or to be too long, seat the bullet a little deeper by loosening the small lock ring on the Seater Die and adjusting the seater plug downward. Conversely, if the reloaded cartridge is too short, adjust the seater plug upward.

B. BULLET SEATING WITH CRIMPING

IMPORTANT: Cases must be trimmed to the same overall length before crimping.

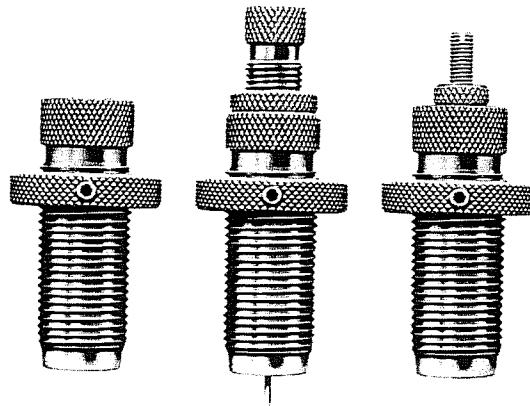
If the bullet you are using has a definite cannelure or crimping groove, the bullet should be seated and crimped, using the following instructions. The crimping feature is machined into the Seater Die body—it is not a special attachment to the seater plug—so the die must be moved up or down to obtain the proper crimp adjustment. Place a sized, primed and powder-charged case in the Shell Holder and run it to the top of the press stroke. Screw the Seater Die into the Press until it is about $\frac{1}{8}$ " above the Shell Holder. Lower the case and insert the bullet in the case mouth. Now slowly run the case and bullet into the Seater Die. Check the bullet for proper seating depth. If the bullet is not seated properly, adjust the seater plug until the proper depth is obtained. Next, adjust the Die to crimp. While the uncrimped cartridge is still in the Seater Die, unscrew the seater plug several full turns. Then screw the Seater Die downward until you feel the built-in crimper touch the case mouth. Lower the reloaded cartridge and adjust the Seater Die down about $\frac{1}{8}$ of a turn. Then run the reloaded cartridge back into the Die and check the crimp. If more crimp is desired, repeat the preceding step by adjusting the Die downward $\frac{1}{8}$ of a turn at a time. After you are satisfied with the crimp, set the large lock ring and run the completed cartridge into the Seater Die and lower the Seater Plug until it touches the bullet. Then set the small lock ring. Once the Seater Die is properly adjusted, the bullet is seated and crimped in one operation!

RCBS 3 DIE SET

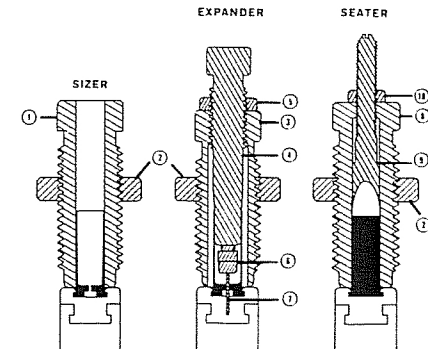
FOR STRAIGHT-WALL TYPE RIFLE AND PISTOL CASES

Reloading straight-wall type cases requires 3-Die Sets instead of two, because it is not possible to expand the mouth of a case in a Sizer Die. In this 3-Die Set the first Die

resizes only. The second Die decaps the case and expands the case mouth to receive the bullet. The third Die seats the bullet and crimps if necessary.



NOTE: Replacement parts for RCBS Dies are available from your gun dealer.



KEY	COMPONENTS DESCRIPTION	PRICE
1	Sizer Body†	\$ *
2	Large Lock Ring, 7/8"-14	.90
3	Expander Body†	*
4	Expander†	2.40
5	Expander Lock Nut†	.60
6	Decapping Pin Holder†	1.50
7	Decapping Pin (Package of 5)†	.90
4,5,6,7	Expander-Decapping Assembly†	3.30
4,6,7	Expander-Decapping Unit†	3.00
8	Seater Body†	*
9	Seater Plug‡	2.10
10	Seater Plug Lock Nut, 1/4"-28	.60

† Specify Caliber ‡ Specify Caliber & Bullet Type

* Price varies — see your dealer or the RCBS Catalog.

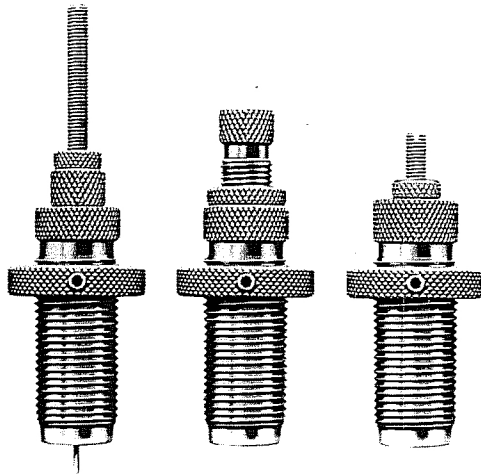
PRICES SUBJECT TO CHANGE

RCBS 3 DIE SET

FOR STRAIGHT-WALL TYPE
RIFLE AND PISTOL CASES

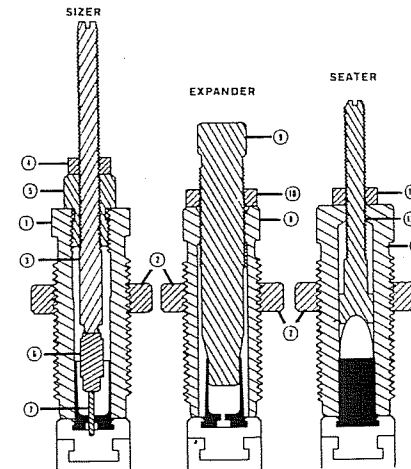
This 3-Die Set differs from the 3-Die Set shown on Page 10 in that the first Die both resizes and decaps the case. The second Die expands

the case mouth to receive the bullet, and the third Die seats the bullet and crimps if necessary.



- 12 -

NOTE: Replacement parts for RCBS Dies are available from your gun dealer.



KEY	COMPONENTS DESCRIPTION	PRICE
1	Sizer Body†	\$ *
2	Large Lock Ring, 7/8"-14	.90
3	Decapping Rod†	.90
4	Decapping Rod Lock Nut†	.60
5	Guide Bushing†	.90
6	Decapping Pin Holder†	1.50
7	Decapping Pin (Package of 5)†	.90
3,4,5,6,7	Decapping Assembly†	3.00
3,6,7	Decapping Unit†	2.40
8	Expander Body†	*
9	Expander†	3.30
10	Expander Lock Nut†	.60
11	Seater Body†	*
12	Seater Plug†	2.10
13	Seater Plug Lock Nut, 1/4"-28	.60

† Specify Caliber ‡ Specify Caliber & Bullet Type
* Price varies — see your dealer or the RCBS Catalog.

PRICES SUBJECT TO CHANGE

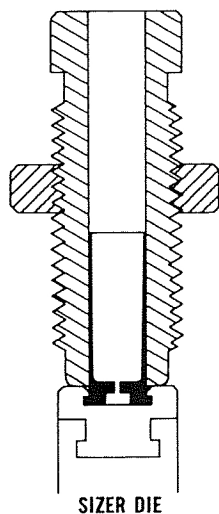
- 13 -

3 DIE SET INSTRUCTIONS

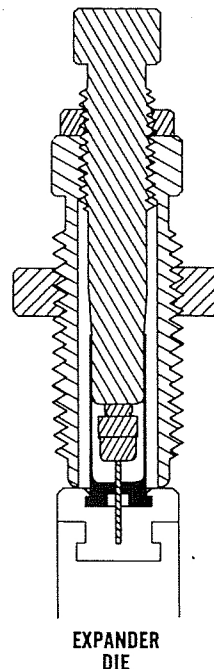
SEE PAGE 20 FOR
TUNGSTEN CARBIDE
SIZER DIE
INSTRUCTIONS

1. SIZING

Screw the Sizer Die into the press until the Die touches the top of the Shell Holder when the Shell Holder is brought up to the top of the press stroke. Be sure all play is removed from the press leverage system. To do this, adjust the Die as above, lower the Shell Holder and set the Die $\frac{1}{8}$ of a turn lower. Set the large lock ring securely against the face of the press.



If the Sizer Die is furnished with a decapping assembly, adjust the assembly so that the bottom of the decapping pin holder is at least $\frac{3}{16}$ " above the bottom of the Die. The decapping pin holder and decapping pin are adjusted by loosening the small lock ring at the top of the Die and turning the decapping rod until the desired setting is obtained. When the decapping pin holder is adjusted correctly, the decapping pin will protrude below the bottom of the Die just enough to knock out the spent primer.



2. EXPANDING

Screw the Expander Die into the press until it touches the Shell Holder when the Shell Holder is at the top of the press stroke. Place a sized case in the Shell Holder and run it into the Expander Die. The case mouth should be expanded or belled just enough to accept the bullet when placed on top of the case—no more! The expander or expander-decapping assembly is tapered and may be adjusted for more or less expanding or belling by loosening the small lock ring on top of the Die and turning the expander or expander-decapping assembly up or down. If the Expander Die is furnished with an expander-decapping assembly, the decapping pin holder and decapping pin are correctly set automatically when the proper expanding or belling is obtained.

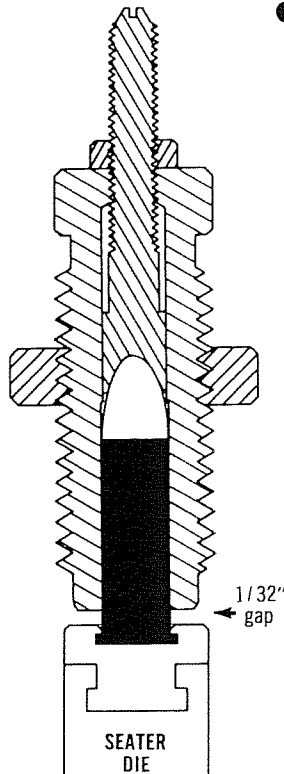
IMPORTANT: Do not allow the expander-decapping assembly to contact the web of the case as damage to the assembly will result.

3. BULLET SEATING

● **IMPORTANT:** Please read instructions carefully! Do not adjust the Seater Die down against the Shell Holder, as it will distort or crush the case!

A. BULLET SEATING WITHOUT CRIMPING

Most rifle and pistol bullets for straight-wall type cases have a cannelure or crimping groove and the bullet must be crimped. However, there are a few calibers where the bullet cannot be crimped. The instructions for seating the bullet without crimping are presented here. (See below for seating and crimping the bullet.) To adjust the Seater Die, place the sized, primed and powder-charged case in the Shell Holder and run it to the top of the press stroke. Then screw the Seater Die into the Press until you feel it touch the mouth of the case. Back up the Die $\frac{1}{4}$ th of a turn (never more) and set the large lock ring. This will leave a gap between the bottom of the Die and Shell Holder about $\frac{1}{16}$ " or the thickness of a nickel. Next lower the case and insert the bullet in the case mouth. Slowly run the case into the Seater Die. Generally speaking, a properly seated bullet should be level with the lower end of the case neck. However, this is not



always true because of the varying bullet weights and types. Therefore, check the first reloaded cartridge for overall length with a factory-loaded cartridge. Or try it in the chamber of your gun. If the bullet of the reloaded cartridge seems to project into the lands or to be too long, seat the bullet a little deeper by loosening the small lock ring and adjusting the seater plug downward. Conversely, if the reloaded cartridge is too short, adjust the seater plug upward.

B. BULLET SEATING WITH CRIMPING

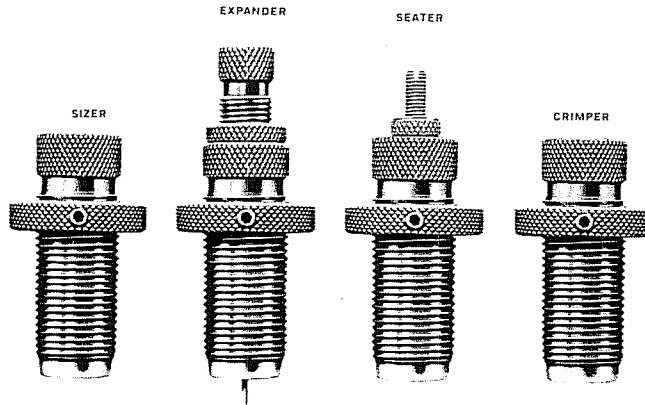
IMPORTANT: Cases must be trimmed to the same overall length before crimping.

If the bullet you are using has a definite cannelure or crimping groove, the bullet should be seated and crimped, using the following instructions. The crimping feature is machined into the Seater Die body—it is not a special attachment to the seater plug—so the Die must be moved up or down to obtain the proper crimp adjustment. Place a sized, primed and powder-charged case in the Shell Holder and run it to the top of the press stroke. Screw the Seater Die into the press until it is about $\frac{1}{8}$ " above the Shell Holder. Lower the case and insert the bullet in the case mouth. Now slowly run the case and bullet into the Seater Die. Check the bullet for proper seating depth. If the bullet is not seated properly, adjust the seater plug until the proper depth is obtained. Next, adjust the Die to crimp. While the uncrimped cartridge is still in the Seater Die, unscrew the seater plug several full turns. Then screw the Seater Die downward until you feel the built-in crimper touch the case mouth. Lower the reloaded cartridge and adjust the Seater Die down about $\frac{1}{4}$ th of a turn. Run the reload cartridge into the Die and check the crimp. If more crimp is desired, repeat the preceding step by adjusting the Die downward $\frac{1}{4}$ th of a turn at a time. After you are satisfied with the crimp, set the large lock ring and run the completed cartridge into the Seater Die and lower the Seater Plug until it touches the bullet. Then set the small lock ring. Once the Seater Die is properly adjusted, the bullet is seated and crimped in one operation!

RCBS 4 DIE SET

FOR STRAIGHT-WALL TYPE PISTOL CASES

Same as 3-Die Set shown on Pages 10 and 11
—except for addition of separate Crimper Die.



INSTRUCTIONS:

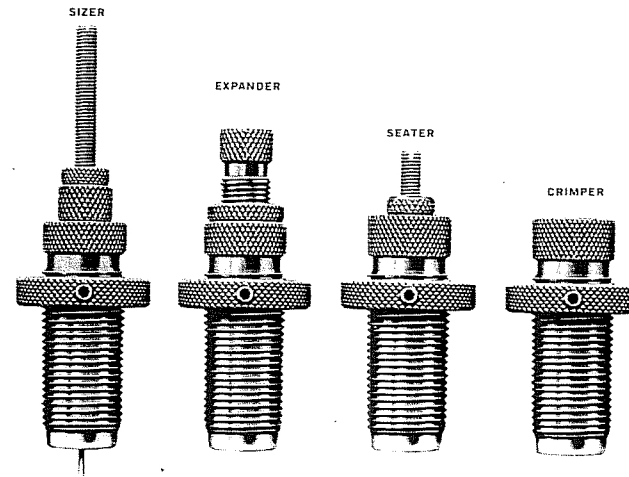
Follow the same instructions as for 3-Die Sets, beginning with Sizing (Page 14), Expanding (Page 15), Bullet Seating without Crimping (Page 16). Bullet Seating with Crimping is performed as follows: First, adjust the Crimper Die by inserting a reloaded cartridge, with bullet seated, into the Shell Holder. Then run the cartridge into the Die, and screw the Crimper Die into the Press until you feel the built-in

- 18 -

RCBS 4 DIE SET

FOR STRAIGHT-WALL TYPE PISTOL CASES

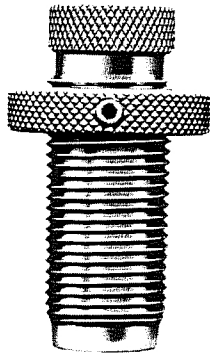
Same as 3-Die Set shown on Pages 12 and 13
—except for addition of separate Crimper Die.



Crimper touch the case mouth. Lower the reloaded cartridge out of the Die and adjust the Crimper Die down about $\frac{1}{8}$ th of a turn. Run the reloaded cartridge back into the Die and check the crimp. If more crimp is desired, repeat the preceding step by adjusting the Die downward $\frac{1}{8}$ th of a turn at a time. After you are satisfied with the crimp, set the large lock ring.

- 19 -

RCBS TUNGSTEN CARBIDE SIZER DIE



The Tungsten Carbide Sizer Die will give a lifetime of perfect service if properly cared for. However, the Die will not withstand severe impact, such as dropping. The Shell Holder should never strike the bottom of the Die.

RCBS Tungsten Carbide Sizer Dies are made to strict tolerances which have been found best for general use. The fired case size will vary with the size of the chamber and load. There are many different chamber sizes and many different case sizes all within the acceptable tolerances of a given caliber. Therefore a Sizer Die that is "normal" would oversize some cases and maybe

undersize others. It is impossible to make a custom Die that would give minimum or maximum sizing for all cases.

The .30 M-1 Carbine Tungsten Carbide Sizer Die is shipped from the factory for use with American commercial cases only. The wall thickness of some military and foreign cases is too thick and should not be used with this Die as damage to the Die and Shell Holder could result!

While it is not necessary to lubricate pistol straight-sided cases, the .30 M-1 Carbine case is heavy walled, tapered, and must have some lubrication. We recommend lightly lubricating every fourth or fifth case for best results. No lubrication will cause a damaged Shell Holder. See "Preparing the Cases" on Page 3.

With the exception of the .30 M-1 Carbine, do not start with the Tungsten Carbide Sizer Die adjusted down against the Shell Holder. Usually the Die should be set about the thickness of a nickel (about $\frac{3}{4}$ ") above the Shell Holder. All Tungsten Carbide Sizer Dies will leave an undesirable step or shoulder that could weaken the case if full length sized, as the Tungsten Carbide ring will size a case at the base the same amount as the case mouth. Therefore, adjust the Die to size the case mouth only enough to hold the bullet and go back into the chamber again.

Since the .30 M-1 Carbine case is tapered, set the Die down to where a page of this instruction booklet can be pulled between the bottom of the Die and the Shell Holder. If a step or shoulder is formed on the sized case, reduce the amount of sizing by backing the Die up a half turn at a time. If you are unable to eliminate the step or shoulder, the case wall is too thick and cannot be sized with the Tungsten Carbide Sizer Die.

Quality reloads begin with RCBS!

