

# FULL LENGTH DIE INSTRUCTIONS

## BEFORE USING DIES

Before using your new dies disassemble and carefully clean the inside surface of the sizing and seating dies (and the expander die if a three-die set.) A rust preventive oil is applied at the factory to protect the dies during shipping and **must be removed before reloading.** Any commercial solvent or cleaner (like our ONE SHOT Gun Cleaner and Dry Lube) will suffice.

Inspect all cartridge cases and discard those with cracks, splits and other visible defects. Wipe cases clean with a soft cloth to remove grit and other foreign matter which may scratch the die. Before sizing, lubricate the cases with one of the case lubes available from Hornady (ONE SHOT Case Lube or UNIQUE, a hard paste.) No matter the method of lubrication, all rifle cases must be lubricated (**Hornady's Titanium Nitride three-die sets are lube-free.**) We don't recommend the use of oil-type lubes; they may contaminate the powder inside the case.

Little or no lube on rifle cases will result in a stuck case. Over-lubrication will cause dents in the shoulder, damaging appearance. (If you do get a case stuck in a die, we can remove the case without damaging the die and return it to you. Please send the die to our Customer Service Department with \$4 for postage & handling charges.)



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## ADJUSTING THE SIZE DIE

To adjust the expander/decap assembly:

1. Loosen the spindle lock.
2. Adjust the spindle so approximately 3/16" of the decap pin is below the end of the die (SEE PHOTO.)

*(NOTE: The new Zip Spindle is lightly threaded to provide a positive no-slip lock. In its free state, the Zip Spindle can be pulled up and down to make quick adjustments, or can be threaded for more precise adjustments.)*

3. Make sure the threads on the spindle and collet are engaged and tighten the spindle lock until the spindle no longer rotates.
4. Verify that the decap pin is only extended 3/16" below die.

*(Note: The new Hornady Zip Spindle comes with an easily replaceable headed decap pin. If during use or adjustment, the pin breaks, an extra decap pin has been provided. Remove the spindle assembly, unthread the expander/retainer, remove the decap pin head, and replace with the new decap pin.)*

To adjust the full-length size die, follow these steps:

1. Raise the press ram to highest position **without camming over.**
2. Thread the full-length die into the press until the base touches the shell holder head.
3. Tighten the lock ring against the press and tighten the set screw with the allen wrench.

*(Note: Firearm action types and chamber dimensions vary causing excess headspace. To eliminate the headspace, adjust the full-length die upward.)*

