



Sinclair Bump Gages

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Congratulations on your purchase of another fine Sinclair reloading product. Please take a few moments to read over these instructions before using your new Sinclair Bump Gage.

Proper headspace and minimizing the amount of sizing performed on your fired cases extends brass life, enhances accuracy and ensures the safety of your reloaded rounds. Sinclair Bump Gages are designed to aid in the set up of full length sizing dies. They are machined with a taper to accurately duplicate the shoulder of your brass.

Installing Bump Gage to Calipers

- 1) Select the proper Bump Gage/Bullet Comparator Body to be used. If you are setting up a full length die, either body will work well for you. For checking the headspace of loaded ammunition for sorting purposes, you will need to use the extended length model (blue).
- 2) Select the proper Sinclair Bump Gage (bump gages are engraved with the shoulder angle, consult the chart below or the cartridge drawing in a loading manual to determine the proper insert) and insert it into the body. Secure the insert in place using a 5/64 hex wrench.
- 3) Install the Sinclair Bump Gage/Bullet Comparator Body to one of the blades of your calipers by slipping the slot over the caliper blade and lightly tightening the thumb screw.
- 4) Select a case or loaded round you wish to measure, insert the case (mouth or bullet first) into the Bump Gage with the case head against the opposite caliper blade.
- 5) Lightly squeeze the case in the calipers. While doing this, loosen the thumb screw and let the insert body find its center with the calipers. Re-tighten the thumb screw, securing the Insert Body to the caliper blade. This procedure aligns the insert body to the caliper blades. You are now ready to measure.

Setting Up Full Length Dies

Note: Always make sure fired cases are either de-primed or have primers that do not protrude from the case head. Primers that protrude from the case head will give a false reading of "headspace".

- 1) Measure a good sampling of your fired cases. This should be between 10 and 20 pieces. Make note of the shortest measured length. For bolt action rifles, this measurement should vary less than .001" (one thousandth of an inch). For AR type rifles and other semi-automatics, this variance could be quite a bit more.
- 2) Run one case into your sizing die and measure, in the same manner as you measured your fired cases. Adjust your die accordingly, checking the cases after they are sized.

Note: For bolt action rifles set your full length die such that it bumps the shoulder on sized cases so that they measure .001" to .002" less than the length you made note of in step 1. For hunting rounds or rounds to be used out of the magazine (such is the case with reloads to be used in NRA High Power "Across the Course") you may wish to set your full length die to size your brass .003" less than your measured case in step For AR type rifles or other semi-automatics most shooters will find setting the full length die to size brass .003" to .005" less than your measured case in step 1.

- 3) Check your final setting by measuring 2 or 3 sized cases.

ITEM #	SHOULDER		CARTRIDGE LIST
	ANGLE		
#749-011-476	17°		30-06 Family
#749-011-477	20°		308 Family
#749-011-478	20°		338 Lapua
#749-011-471	21°		220 Swift
#749-011-473	23°		223 Family (222 Rem, 17 Rem, etc.)
#749-011-480	23°		6.8 SPC
#749-011-485	25°		Most Standard Magnums
#749-011-474	26°		6mm Rem
#749-011-472	28°		22-250, 223/243 WSSM, Some Ackley Improved
#749-011-484	30°		17 Fireball, 22/6mm PPC and BR, 204 Ruger
#749-011-481	30°		7mm & 30 BR, Remington Ultra Mags Up To 338 cal
#749-011-475	35°		284 Family, WSM Family
#749-011-482	40°		Ackley Improved Up To 6mm
#749-011-483	40°		Ackley Improved Cartridges Up To 338 cal
#749-011-479	45°		Wildcat Cartridges w/45° Shoulder