



200 South Front Street
Montezuma, IA 50171
800-717-8211

WARNING!

This product contains lead, a chemical known to the State of California to cause cancer and birth defects and other reproductive harm.

We hope you found this Sinclair product to be of use to you in your reloading endeavors. We hope you turn to Sinclair International the next time you need reloading and shooting equipment. Thank you for your business.

Sinclair Chamber Length Gage Insert

#749-000-746 17 Cal.	#749-011-493 32 Cal.
#749-000-795 20 Cal	#749-000-752 338 Cal.
#749-000-811 22Cal.	#749-011-494 35 Cal.
#749-000-796 6mm	#749-011-503 9.3mm
#749-000-751 6mm	#749-011-495 375 Cal.
Tight Neck .262"	#749-011-497 408 Cheytac
#749-000-771 25 Cal	#749-011-498 416 Cal.
#749-000-783 6.5mm	#749-011-496 404 Jeffery
#749-000-772 270 Cal.	#749-011-499 44 Cal.
#749-000-784 7mm	#749-011-500 45 Cal.
#749-000-804 30 Cal.	#749-011-501 50 Cal.

This insert if used according to the following instructions will allow the experienced reloader to determine the length of his rifle's chamber. Length of chamber as discussed with this tool is defined as the distance from the bolt face of the bolt when closed to the end of the neck of the chamber. This tool is intended for use in bolt action centerfire rifles only. The inserts are made from leaded steel and will not scratch the chamber's surface.

Instructions For Use

STEP #1: Take a cartridge case of the correct size for your rifle's chamber. Completely full length size the case. Remove the primer at this time.

STEP #2: Trim the case length 0.100" shorter than the published trim length for the cartridge (see most reloading handbooks for this dimension). Chamfer the inside and outside of the case neck.

STEP #3: Using a drill bit, drill through the primer pocket into the case interior. **DO NOT ATTEMPT TO HOLD THE CASE IN YOUR HAND WHILE DRILLING.** Clamp the case in padded vise jaws while drilling. (This operation is necessary so the gage insert can be pushed out of the case and reused).

STEP #4: Insert the tapered end of the chamber length gage insert into the prepared case. Using a bullet seater for that cartridge, press the gage insert into the case until the overall length of the assembly measures approximately 0.100" **greater** than the published trim length for the cartridge you are working with.

STEP #5: Insert the dummy assembly into the rifle chamber, do not feed through the magazine, and close the bolt. The gage insert will stop at the end of the chamber's neck and be pushed back into the case neck as the bolt is closed.

STEP #6: Open the bolt slowly and remove the assembly being careful not to force the case length assembly into the side of the action damaging the insert.

STEP #7: Using an accurate dial caliper, measure the length of the assembly. This measurement is the true chamber length **for your rifle**.

STEP #8: To reuse the insert for a different cartridge of the same caliber, insert a punch through the hole that you drilled in Step #3, and push the gage insert from the case.

WARNING!

Excessive case length will cause dangerous chamber pressures resulting in personal injury. We do not recommend increasing case length beyond published SAAMI specifications. **DO SO AT YOUR OWN RISK! !** If you do increase your case length maintain the case length so that it is a minimum of .024" shorter than the chamber length.

This Chamber Length Gage must not be inserted into a chamber that has a neck diameter which is smaller than the largest diameter step on the gage insert. Chamber neck diameter can be determined approximately by measuring the case neck diameter of a fired case before resizing.