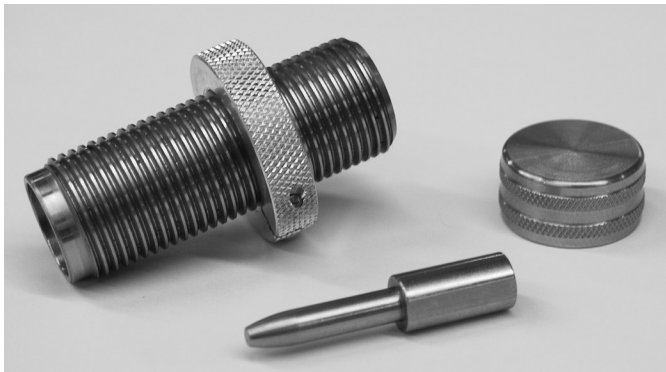




#749-011-715 Instructions For Generation II Expander Dies

200 South Front Street • Montezuma, IA 50171 • 800-717-8211
260-482-3670 • www.sinclairintl.com • support@sinclairintl.com



This tool is used primarily as a companion tool to our neck turning tools, but it can also be used to neck cartridges up to the next caliber for wildcatting, or to straighten out the dings, dents and flat spots found on the necks of new brass damaged during manufacturing and shipping. The Expander Die is designed to accept either our expander or neck turning mandrels (expander mandrels are .001" larger in diameter than our turning mandrels).

Instructions for use:

- 1) To use this die, remove the cap from the die body and drop one of our mandrels into the hole.

Note: You will notice that there is an o-ring inside of the cap. This o-ring seats the cap against the body of the die rather than the top of the mandrel. This results in a slight floating effect for the mandrel and permits the mandrel to find the true center of the case. If you prefer to lock your mandrel in place, the o-ring can be removed with a hook, pick or a small hex wrench.

- 2) Thread the cap back onto the body of the die and hand tighten, capturing the mandrel in the die body.

- 3) Thread the die into your reloading press. Unlike most reloading dies, do not thread this expander die until it touches the press shell-holder. Thread the expander die about one inch into the press.
- 4) Be sure to lube the inside of the case neck before running a piece of brass over the mandrel. This can be done with a cotton swab or by dipping the case mouth into the lube. We recommend using FP-10, any of the sizing die waxes, or any sizing lube (Redding, RCBS, Rooster, etc.).
- 5) The expander die is designed to allow the user to cam the press ram over with nearly all modern cartridges. To find the best location of the expander die in your press, slowly run a piece of brass up into the die, then thread the die in or out of the press to achieve the mandrel penetration into the case neck you desire. Do this slowly to prevent crushing the neck and ruining the piece of brass, using a culled piece of brass or one that is ready to be scraped is a good idea.
- 6) Once you've found the best location in the press for your expander die, thread the lock ring down to the top of the press and lock in place.

Other Sinclair Case Prep Tools:

#749-002-941	Sinclair Piloted Flash Hole Tool
See Chart	Sinclair Stainless Steel Pilots
#749-003-822	Sinclair Flash Hole Deburring Tool w/Handle
#749-006-477	Sinclair Neck Turning Tool
#749-006-615	Sinclair Deluxe Neck Turning Tool
#749-008-016	Sinclair Premium Neck Turning Tool
#749-002-109	Sinclair Case Holder Power Adapter
#749-002-xxx	Sinclair Case Holders
#749-011-486	Universal Case Holder Power Adapter

ITEM #	CALIBER
#749-001-044	.22
#749-001-037	6mm
#749-001-036	.25
#749-001-038	6.5mm
#749-000-999	.270
#749-001-039	7mm
#749-001-045	.30
#749-000-974	.312
#749-000-984	8mm
#749-001-019	.338
#749-000-975	.35 Rifle/9mm, 357, 38 Pistol
#749-008-926	9.3mm
#749-000-958	.375
#749-000-937	10mm/.40
#749-008-850	408 Cheytac
#749-000-946	.41/.416 cal.
#749-008-625	404 Jeffrey
#749-000-976	.44
#749-001-000	.45
#749-011-621	.50*