



**Hornady**  
*Accurate. Deadly. Dependable.*

# BULLET FEED DIE

## INSTRUCTIONS

### Bullet Feed Die Set Up

Disassemble the die and lay the parts out on a flat surface.

Degrease every part of the die.

Reassemble the die as you took it apart.

Collet "A" goes in first with the open slots facing the bottom of the die.

Collet "B" goes in next with the open slots facing the bottom of the die.

Thread the Lock Ring back onto the Adjustment Screw until the Lock Ring is near the top end of the Adjustment Screw.

Place the O-Ring over the threads of the Adjustment Screw until it is close to the Lock Ring.

Screw the Adjustment Screw into the die. Screw it down until the end of the Adjustment Screw is just touching "Collet B".

With the Adjustment Screw touching the top Collet, back the Adjustment Screw off ½ turn and lock down the Lock Ring against the top of the Die Body.

At this time you should be able to shake the die and hear the two Collets move up and down just a little bit. If you hear this, the die is set up correctly.



## Die Adjustment Lock-N-Load® AP™

Screw on the Lock Ring to the outside threads of the Die Body.

Screw on the Lock-N-Load® Bushing to the outside threads of the Die Body.

Place the die into the top of the press and inserting it into the Lock-N-Load® Bushing in the Press Body.

## Die Adjustment for a NON Lock-N-Load® AP™

Place a Flared Case for your set up in the previous station. Case mouths should be flared to the approximate dimensions listed below.

380/9MM .....	.385"
38/357.....	.387"
40 S&W/10MM.....	.430"
44 SPL/44 MAG.....	.460"
.451/.452.....	.481"

Raise the ram to the top of the stroke.

Screw the Die Body down until it touches the top of the case.

Lower the ram to the bottom of the stroke.

Screw the Die Body down ½ turn and lock down the Lock Ring.

At this time the die should be set.

Place 5 or 6 bullets base first into the top of the die.

Place the case into the Shell Plate in the station before the Bullet Feeder Die so when the press rotates, the Flared Case will be inserting into the Bullet Feeder Die. Continue to raise the Ram to the top of the stroke. You will not be able to see or hear anything at this time.

Lower the Ram slowly.

You should be able to see a bullet that dropped on top of the case mouth. If the bullet dropped onto the case mouth and you can see it, you should have been able to hear a little noise coming from the collets. This is a correct sound, it will do this every time that the collets work correctly.

If the collets didn't drop a bullet, lower the Die Body approximately 1/16" turn and repeat the previous 3 steps. Repeat these steps until you get a bullet to fall onto the case every time.