

NEW DIMENSION™

*Match-Grade™
Dies*

*The highest
level of
reloading
precision.*



 **Hornady**

Accurate. Deadly. Dependable.

BEFORE USING DIES

Before using your new die, disassemble and carefully clean the inside surfaces. A rust preventative has been applied at the factory to protect the die during shipping and ***must be removed before reloading***. We recommend Hornady ONE SHOT Gun Cleaner and Dry Lube.

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 material 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 necked cases in a full length die require some lubrication. A small amount of lubrication on the case neck while using a neck size die will minimize stretching.

Little or no lubrication on necked cases in a full length die will result in a stuck case. Over-lubrication will cause dents in the shoulder, damaging the appearance. (If you do get a case stuck in a die, Hornady will remove the case without damaging the die and return it to you. Please enclose \$4.00 for postage and handling.)

DIE SETTINGS AND ADJUSTMENTS

BUSHING SIZE

Measure the outside diameter of your loaded cartridge. Subtract .002" to .003" from the neck diameter to determine bushing size. This allows for brass spring back and a bullet press fit of .001" to .002".

FULL LENGTH DIE ADJUSTMENT

1. Insert the bushing (large end down) into the die body.
2. Raise the ram of the press to its highest position.
3. Thread the die into the press until the end of the die touches the shell holder head.
4. Tighten the Lock Ring against the press and tighten the screw with the hex wrench.
5. Adjust the expander decap assembly to the proper height.

Note: *Firearm action types and chamber dimensions may vary, causing excess head-space. To eliminate the excess head-space, adjust the die upward.*

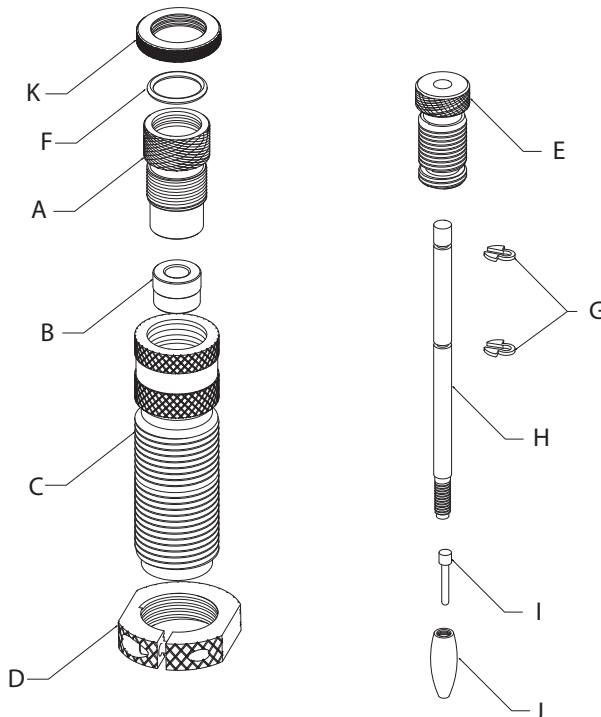
DECAPPING ADJUSTMENT

The decapping spindle assembly should be adjusted to remove spent primers, yet not contact the web of the cartridge case. If adjusted too low, damage can occur to the decapping assembly/ Slight tension of the Lock Nut and O-Ring will allow the decapping assembly while preventing accidental movement. *Adjust the height until the decapping pin is 1/8" to 3/16" below the end of the die.*

NECK-SIZE DIE ADJUSTMENT

1. Insert the bushing, large end down, into the die body.
2. Raise the ram of the press to its highest position.
3. For maximum setback, thread the die into the press until the end of the die touches the shell holder head.
4. To adjust to your chamber, back the die out accordingly.
5. Tighten the Lock Ring against the press and tighten the screw with the hex wrench.
6. Adjust the expander decap assembly to the proper height.

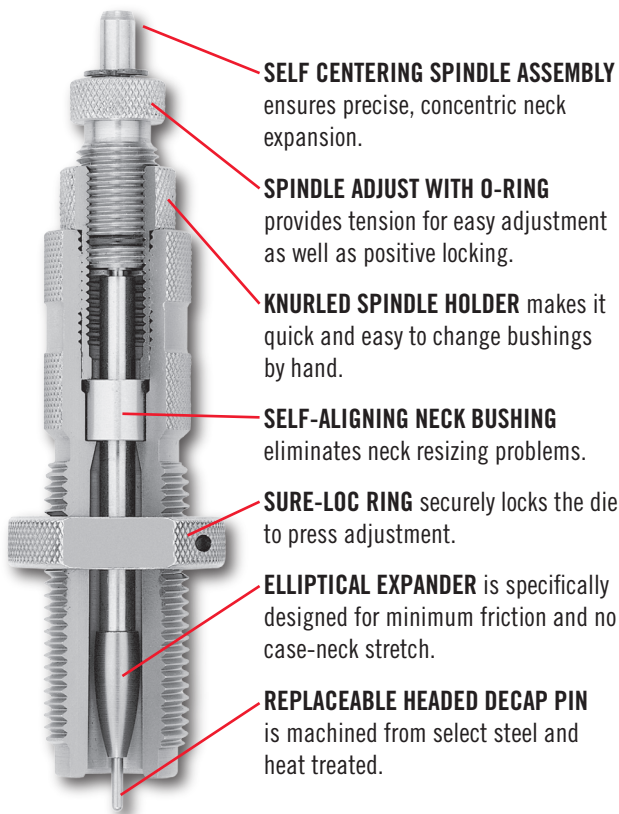
PARTS LIST



Key	Description	Part No.
A	Bushing Cap	*
B	Neck Size Bushing	*
C	Size Die Body	*
D	Sure-Loc Ring	044000
E	Large Spindle Retainer	396615
	Small Spindle Retainer	396616
F	O-Ring	396470
G	Large E-Clip (2)	396622
	Small E-Clip (2)	396621
H	Large Decap Spindle	396619
	Small Decap Spindle	396617
I	Decap Pin	390222
J	Elliptical Expander	*
K	Lock Nut	392764

* Caliber specific part numbers are assigned to these items.

FEATURES



SELF CENTERING SPINDLE ASSEMBLY ensures precise, concentric neck expansion.

SPINDLE ADJUST WITH O-RING provides tension for easy adjustment as well as positive locking.

KNURLED SPINDLE HOLDER makes it quick and easy to change bushings by hand.

SELF-ALIGNING NECK BUSHING eliminates neck resizing problems.

SURE-LOC RING securely locks the die to press adjustment.

ELLIPTICAL EXPANDER is specifically designed for minimum friction and no case-neck stretch.

REPLACEABLE HEADED DECAP PIN is machined from select steel and heat treated.

AVAILABLE DIES & BUSHINGS

CARTRIDGE	Full-Length Die	Neck-Size Die	Primer Punch Size	Shell Holder	Trimmer Pilot	Bullet Puller Collet
223 Rem.	544229	544227	Small	#16	#1	#2
22-250 Rem.	544221	544231	Large	#1	#1	#2
6MM PPC	544255	544253	Small	#6	#3	#3
6MM BR	544251	544259	Small	#1	#3	#3
243 Win.	544245	544243	Large	#1	#3	#3
308 Win.	544359	544357	Large	#1	#9	#7

These dies allow you to select the bushing of your choice. Please select the bushing your cartridge and firearm require.

.22 Cal. Bushings		6MM Bushings		.30 Cal. Bushings	
.242 Bushing	No. 594242	.260 Bushing	No. 594260	.332 Bushing	No. 594332
.244 Bushing	No. 594244	.262 Bushing	No. 594262	.334 Bushing	No. 594334
.246 Bushing	No. 594246	.264 Bushing	No. 594264	.336 Bushing	No. 594336
.248 Bushing	No. 594248	.266 Bushing	No. 594266	.338 Bushing	No. 594338

LEAD WARNING: Discharging firearms in poorly ventilated areas, cleaning firearms or handling ammunition may result in exposure to lead and other substances known to cause birth defects, reproductive harm and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure.
AVERTISSEMENT PLOMB: Décharger des armes dans des endroits peu ou mal ventilés, nettoyer des armes ou manipuler des munitions peut mener à une exposition au plomb ou à d'autres substances reconnues pour causer des malformations infantiles, des troubles de reproduction et d'autres blessures physiques sérieuses. Avoir une ventilation adéquate en tout temps. Laver ses mains minutieusement après l'exposition.



P.O. Box 1848 • Grand Island, NE 68802-1848
 (308) 382-1390 • www.hornady.com

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