

FORSTER PRODUCTS

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User Instructions for the Bench Rest® Neck Sizing Die

1.0 GENERAL INFORMATION

The Bench Rest® Neck Sizing Die reduces the outside case neck diameter, removes the spent primer and expands the inside case neck diameter.

Each die has a precisely positioned hole that is partially drilled into the threaded or the recessed portion of the Die Body (C-10) for use in correct alignment of the Decapping/Expander Assembly (see Fig. 1).

Note: Complete die nomenclature is given in Figure 2 on the back page.

2.0 SAFETY INFORMATION

- Always wear safety glasses.
- Keep complete, chronological records of your reloads. This data is useful for future load development. Label each batch of cartridges with:

- | | |
|---|--|
| <input checked="" type="checkbox"/> Date loaded | <input checked="" type="checkbox"/> Powder type and weight |
| <input checked="" type="checkbox"/> Primer type | <input checked="" type="checkbox"/> Bullet type and weight |
| <input checked="" type="checkbox"/> Case type | |

- **Do not use on military brass with crimped primers.** Use a specially designed (decapping only) sizing die.
- The half-inch yellow square tab is an anti-rust agent. Keep this tab with the dies.

3.0 PREPARATION

3.1 Prepare the Cases

1. Inspect all cases. Dispose of those that are split or separated.
2. Clean cases.
3. Check case length and trim to length, if necessary.
4. If the case neck walls vary in thickness, turn the outside neck to a consistent thickness using a **Forster Outside Neck Turner** (part numbers OT1010 or HOT100).
5. Chamfer sharp corners of trimmed cases with a **Forster Deburring Tool**.
6. Lightly lubricate the case neck and shoulder with **Forster High Pressure Lube**. Do not over lubricate, as this may create pressure dents during sizing.
7. Apply a thin coat of dry lubricant to the inside of the case necks by pushing the cases down over the brushes of a **Forster Case Graphiter**.

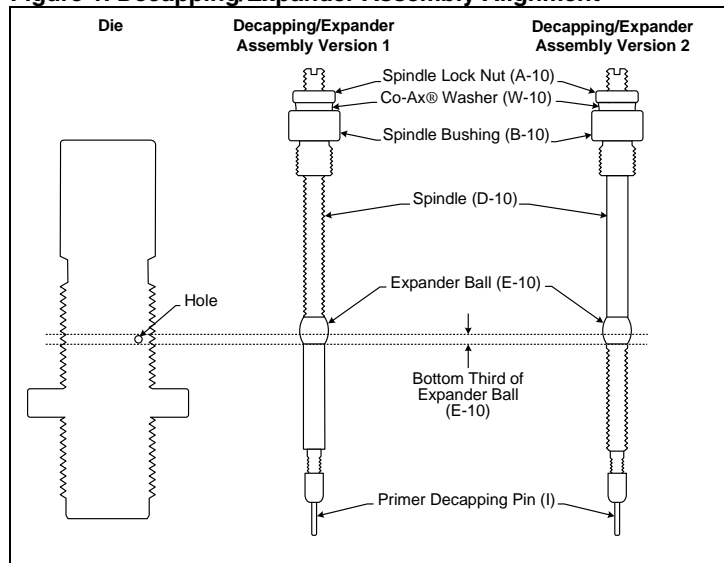
3.2 Prepare the Die as Follows:

3.21 Inspect the Die

Inspect the Decapping/Expander Assembly to ensure that shipping vibration did not change the critical, factory settings. The hole in the die should line up with the bottom third of the Expander Ball (E-10) as shown in Fig. 1.

- To check, remove the Decapping/Expander Assembly and place it next to the die.
- If adjustments are needed, position the Expander Ball (E-10) by setting the Spindle Lock Nut (A-10) and the Spindle Bushing (B-10). (Do not move the Expander Ball (E-10) itself. Ensure it remains at its factory-set position on the Spindle (D-10).)
- Ensure the Primer Decapping Pin (I) is centered at the bottom of the die.

Figure 1. Decapping/Expander Assembly Alignment



3.22 Clean the Die

Clean die inside surfaces using a cloth patch saturated with gun-cleaning solvent.

4.0 CASE SIZING PROCEDURE

1. Install the die into any standard 7/8-14 thread reloading press or **Forster's Co-Ax® Reloading Press** so that it makes contact with the shell holder when the ram is at its uppermost position.
2. Tighten the Cross Bolt Lock Ring (G-10) with a #2 Phillips screwdriver.
3. Insert a case into reloading press.
4. Size the case by actuating the reloading press. (Ensure the bottom of the die makes complete contact with the shell holder.) This operation reduces the outside diameter of the case neck only, removes the spent primer, and expands the inside of the case neck. It also may stretch the case neck, so check the overall case length and trim if necessary.
5. Remove the sized case from the die.
6. The case is now ready for priming and powder charge.

NOTICE

- As the case is sized, the Expander Ball (E-10) will be located near the neck of the case. When the case is withdrawn from the die, most of the neck is still in the neck sizing portion of the die, keeping the axis of the neck and case in alignment. You will barely feel the effort required to draw the Expander Ball (E-10) through the case neck.
- Do not position the Expander Ball (E-10) too high. This may crush the case neck and may damage the Decapping/Expander Assembly. Refer to Figure 1 for proper Expander Ball (E-10) positioning. This will ensure that the Expander Ball (E-10) is situated as co-axially as possible with the case neck.
- Snug up the Spindle Lock Nut (A-10) against the Washer (W-10). Tighten the Spindle Bushing (B-10) to the top of the Die Body (C-10).

5.0 AFTER USE

Oil the die with a good quality gun oil before storing die until the next use.

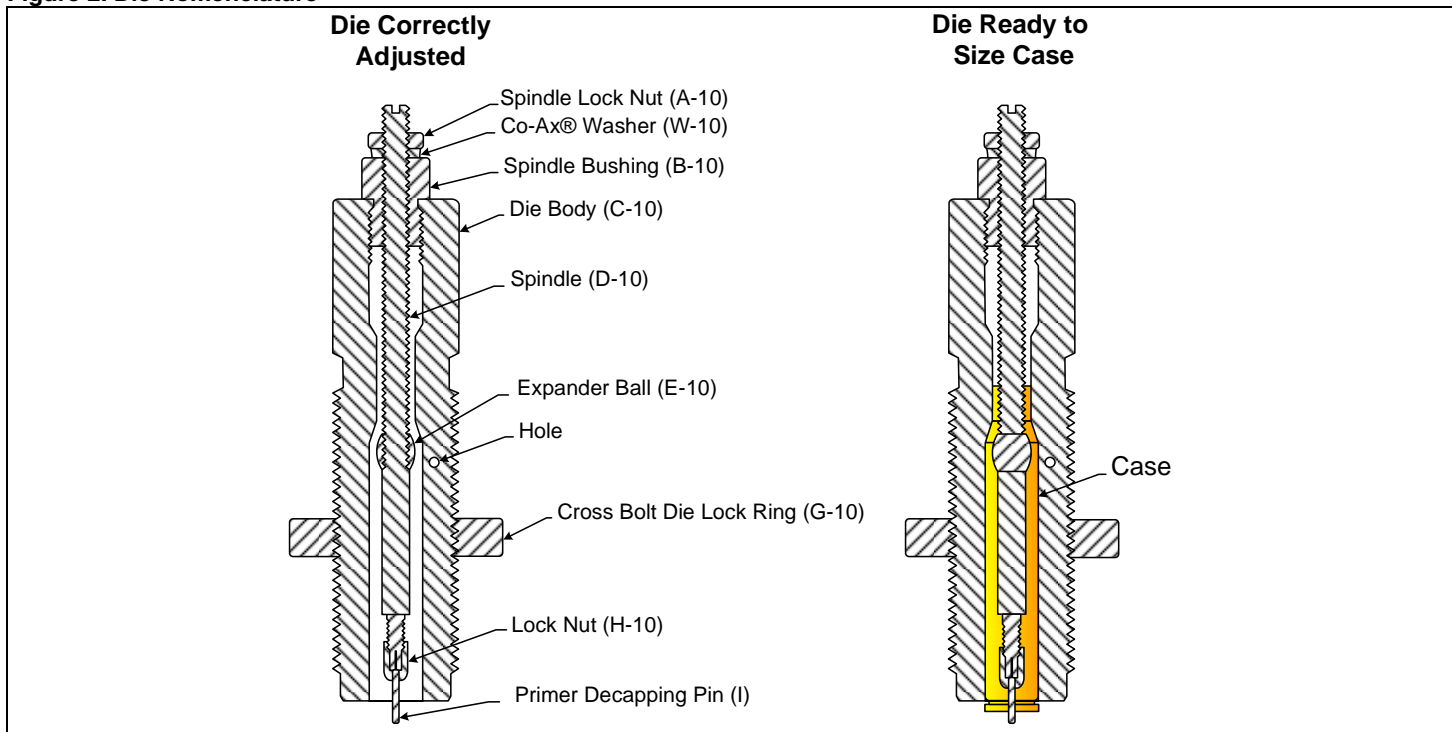
6.0 REPLACEMENT PARTS

The following replacement parts are available for a wide variety of calibers. See our Web site at www.forsterproducts.com for specific sizes.

- Spindle (D-10)
- Expander Ball (E-10)
- Primer Decapping Pin (I)

For best prices, contact your Forster dealer. Experienced dealers and wholesale jobbers are an integral part of the shooting sports. Please make frequent use of their knowledge and support them. If your dealer or wholesale jobber cannot supply you, please contact us by email, fax or phone.

Figure 2. Die Nomenclature



WARRANTY

All Forster Products are warranted against defects in materials and workmanship for the life of the product. Parts which, by nature of their function, are subject to normal wear (such as springs, pins, etc.) and parts which have been altered, abused or neglected, are excluded from the warranty. If the product is deemed defective by workmanship or materials, it will be repaired, reconditioned or replaced (at Forster's option). This warranty supersedes all other warranties for Forster Products whether written or oral.