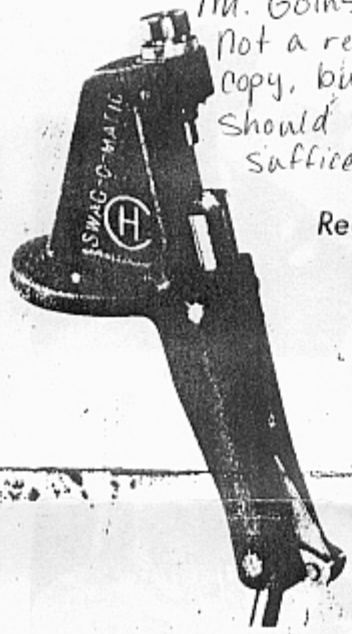


Mr. Goms,
Not a real good
copy, but
should
suffice.

INSTRUCTION SHEET FOR SWAG-O-MATIC

Read Instructions Completely Before Assembling Tool

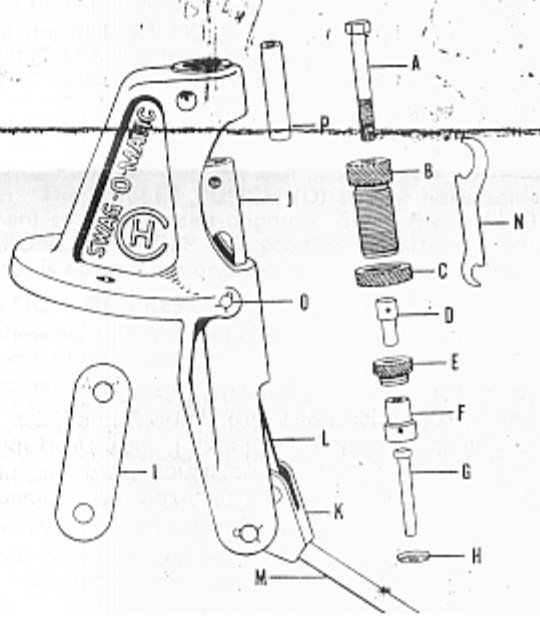


The operation of the SWAG-O-MATIC press is unique for it is the first tool specifically designed for the basic purpose of swaging bullets. The principal of swaging bullets has long been known, as well as have their superior qualities. The adaptation of swaging dies to a regular reloading press of 35 caliber and larger is not successful because of the tremendous pressure necessary to form bullets, and the reloading press, having been designed for a longer stroke than necessary for swaging, did not have either the strength nor the mechanical advantage necessary to easily and accurately form bullets. A press of heavier construction than the regular reloading press was required and one also producing a much greater leverage. The SWAG-O-MATIC was the answer and it embodies all these features.

Although it is possible to form bullets using standard gas checks, you lose much of the advantage gained by the tool and swaging itself. Special HALF-JACKETS were developed along with this tool so as to produce not only bullets of the most consistent and uniform weights, but bullets that will out-perform any type of similar projectile. These HALF-JACKETED bullets will allow you to obtain greater velocities, produce less leading and attain accuracy never before imagined, and also have pistol bullets that will expand perfectly through a wider range of velocities.

With the SWAG-O-MATIC press you can produce an infinite range of bullet weights by adjusting your tool accordingly. To change the bullet shape, an extra inexpensive nose punch is all that is necessary. For extra calibers, an inexpensive die set is all that is necessary. With bullets produced on the SWAG-O-MATIC press, you can compete with the finest marksmen in the world.

Your SWAG-O-MATIC press is assembled complete with the exception of the die set for forming the bullet and the items contained in the parts kit. The exploded drawing shows how the components should be placed together.



- A - Bullet Punch Lock Bolt
- B - Bullet Nose Punch Holder
- C - Lock Ring
- D - Bullet Nose Punch
- E - Locking Collar
- F - Die
- G - Ejector Punch
- H - Hardened Back-up Washer
- I - Support Plate
- J - Ram
- K - Toggle Joint
- L - Toggle Link
- M - Handle
- N - Spanner Wrench
- O - Ejector Actuating Pin
- P - Floating Spacer

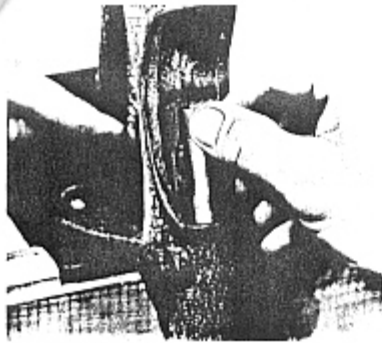


ILLUSTRATION 1

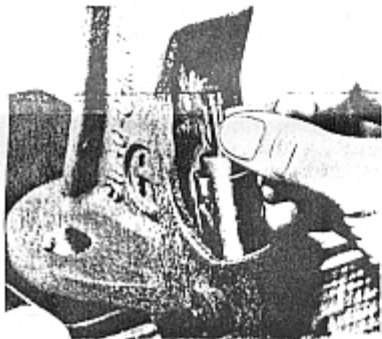


ILLUSTRATION 2



ILLUSTRATION 3

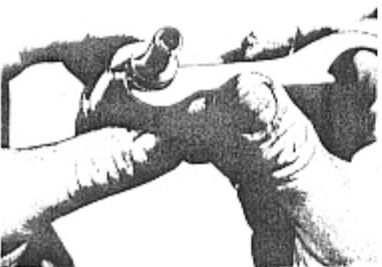


ILLUSTRATION 4

MOUNTING INSTRUCTIONS

Select a strong bench and drill two holes that correspond to the holes in the base of your SWAG-O-MATIC press. You will note that there is a SUPPORT PLATE (I) provided with your parts kit that has two holes that correspond to the holes in the base of your tool. Place this plate on the bottom of your bench and tighten the nuts firmly against the plate. (A 3/8" machine bolt of the correct length will work fine). Do not use lag screws or any type of wood screws to hold down your press for they will usually loosen.

ASSEMBLY INSTRUCTIONS

Screw the handle firmly into the toggle joint, making sure that it will not loosen during normal operation of the tool, for if the handle becomes loose, it will possibly be damaged or broken.

Open the box containing the die set; this consists of the DIE (F), EJECTOR PUNCH (G), BULLET NOSE FORMING PUNCH (D).

Remove the LOCKING COLLAR (E) and the HARDENED BACK-UP WASHER (H) from the small envelope included with your tool. You will also find a double end SPANNER WRENCH (N) enclosed in the same envelope. This wrench is used to lock the LOCKING COLLAR in place and lock the BULLET NOSE PUNCH (D) into position.

Place the HARDENED BACK-UP WASHER (H) into the opening in the top of the RAM (J) with the chamfered end down. Insert a pin into the vent hole in the DIE (F) to make sure there are no obstructions in the hole. Insert the larger end of the DIE (F) into the top of the RAM (Illustration #1) and place the EJECTOR PUNCH (G) from the die set into the DIE (Illustration #2). Align the bleed hole in the DIE to the hole in the RAM and tighten the LOCKING COLLAR (E) with the large end of the SPANNER WRENCH (N) (Illustration #3), making sure that it is firmly in place.

Remove the BULLET NOSE PUNCH HOLDER (B), and FLOATING SPACER from their box and fasten the BULLET NOSE PUNCH (D) with the BOLT (A) provided with the holder (Illustration #4). Make sure the 5/16" washer is placed on the bolt before the floating spacer is placed on the bolt. Using the small end of the SPANNER WRENCH (N), lock the BULLET PUNCH (D) into position. The BULLET PUNCH (D) should have some movement so as to be self-aligning. Screw the BULLET NOSE PUNCH HOLDER into position (Illustration #5). Your tool is now set up and ready for final adjustment.

OPERATION OF PRESS

The following tips and suggestions will enhance your enjoyment of this tool.

For best results, do not use HALF-JACKETS that are any longer than the sizes noted here, ie; 30 Cal. - .322; 38 Cal. - .242; 44 Cal. - .302; 45 Cal. - .275.

Make sure your lead wire is reasonably clean and there is no foreign material attached to the wire that could obstruct the vent hole.

Select the weight of bullet you wish and cut the core so that both core and cup will weigh one to three grains over the desired weight. Lead wire that is about 1/16

of an inch smaller in diameter than the finished size of bullet will generally work out the best for forming. (Example: .300 wire is easiest for forming 38 caliber bullets. Finish formed size for 38 caliber is generally .358). Place the core into the HALF JACKET (Illustration #6) and insert them both into the tool with the HALF-JACKET on the bottom. Adjust the BULLET NOSE PUNCH while actuating the handle until the bullet is formed completely. Weigh your bullet and make whatever minor adjustment is necessary to obtain the exact weight desired. Note that it is necessary to run the bullet quickly into the die **TWICE** to insure a perfect bullet. The first forming operation forms the bullet roughly to size and weight and bleeds the air from the NOSE PUNCH, thereby allowing the bullet to form out perfectly and be of uniform weight. Make sure that your bullet is ejected at least to the shoulder (Illustration #8) after the first forming operation or the air will not be bled from the NOSE PUNCH and your bullets will not form perfectly.

The nearer you cut the cores to the exact weight, the easier and more uniformly your bullets will form.

Use only pure lead wire for best results. Tin and antimonial wire will not form out as satisfactorily and they require many times greater force than does the pure lead. The harder tin and antimonial alloys will not expand well and there is some chance that you will damage either your gun or SWAG-O-MATIC by using these alloys.

Do not allow any liquid lubricant to get into the NOSE PUNCH. Oil cannot be compressed and, as a result, the bullets will not form satisfactorily. At regular intervals it is desirable to lubricate the moving parts of the tool with heavy grease such as wheel bearing grease.

HANDY TIPS

The new floating holder (Patent Pending) insures perfect alignment between the NOSE PUNCH and the forming die and will minimize wear to the NOSE PUNCH.

The lead that continues to bleed out of the die in the first forming operation is a result of the air trapped at extremely high pressure in the NOSE PUNCH. You will note that lead will continue to bleed for almost a minute and the longer this bleeds the greater will be the variation in weight of the bullet. A quick operation of the handle on the first and second operation will insure bullets that are as consistent as possible.

Blank NOSE PUNCHES are available so that the experimenter can design his own bullet shapes.

SEATING STEMS

It is necessary to use SEATING STEMS with reloading dies that reasonably conform to the bullet shape. The ROUND NOSE bullet requires the ROUND NOSE SEATING STEMS. The WADCUTTER and CUP POINT bullet, work best with the WADCUTTER SEATING STEM. The SPIRE POINT bullet requires a special SPIRE POINT SEATING STEM. The SEMI-WADCUTTER and SEMI-WADCUTTER HOLLOW POINT require the SEMI-WADCUTTER SEATING STEM. If the correct SEATING STEMS are not used, you will note distortion of the bullets when seating them in your case.



ILLUSTRATION 5

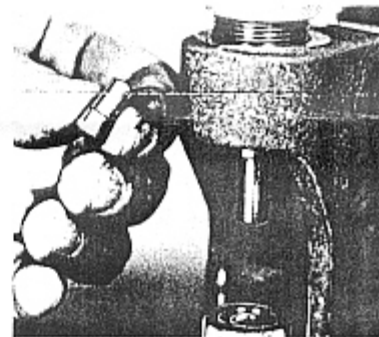


ILLUSTRATION 6

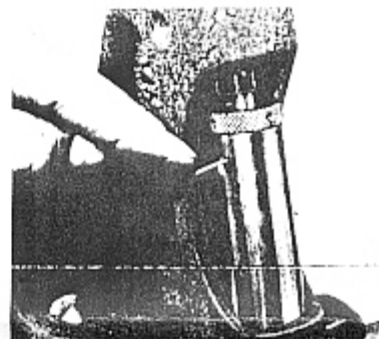


ILLUSTRATION 7

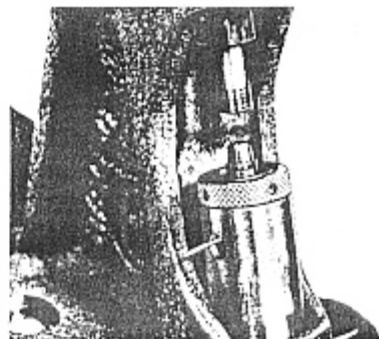


ILLUSTRATION 8

With pure lead bullets, you will find some distortion in seating, if not done in two separate operations. It is best to seat the bullet to depth in the first operation without crimping and then remove the seating stem and crimp only in the second operation.

Note: If the bullets have a tendency to stick in the nose punch, use a small amount of either graphite or other dry lubricant on several bullets. The bullets should not stick after they have been lubricated in this manner.

CAUTION ! USE NO LUBE OIL OF ANY KIND TO LUBRICATE DIES OR NOSE PUNCH.

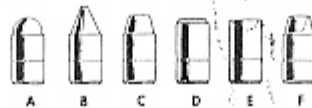
The HALF-JACKETED bullets produced on your SWAG-O-MATIC dies are the most uniform bullets available today. You can drive these bullets faster and obtain better controlled expansion than ever before (Illustration #9 showing typical expanded bullet). These bullets will expand like high velocity rifle bullets. The SWAG-O-MATIC HALF-JACKETED bullets have now made the handgun into an effective field weapon, both for accuracy and hitting power.



C H SWAG-O-MATIC PRICE LIST

Press Complete for 1 Caliber and 1 Bullet	Support Plate (I).....	.50
 Nose (Without Hollow Point Punch) \$33.00	Ram (J).....	\$10.00
 With Hollow Point Punch..... 35.50	Toggle Joint (K).....	2.50
Press, Toggle and Handle..... 24.00	Toggle Link (L).....	1.50
Bullet Nose Lock Bolt (A)..... .50	Handle (M).....	2.00
Bullet Nose Punch Holder (B)..... 1.00	Spanner Wrench (N).....	1.00
Lock Nut (C)..... 1.00	Hardened Ejector Actuating Pin (O)....	1.00
Nose Punch (D)..... 5.00	Floating Spacer (P).....	.50
Hollow Point Nose Punch (D)..... 7.50	Large Spring Clip.....	.15
Die Lock Collar (E)..... 1.75	Small Spring Clip.....	.10
Bullet Die (F)..... 5.00	Die Set Complete (Ejector,	
Ejector Punch (G)..... 5.00	 Die and Punch).....	9.00
Hardened Back-up Plate (H)..... .75	C H LEAD CORE CUTTER.....	7.50

The bullet shapes available for your tool are illustrated below. When ordering bullet nose punches, specify caliber and bullet style. Example: 38 cal. — Semiwadcutter.



- A. Round Nose
- B. Spire Point
- C. Semi-Wad-Cutter
- D. Wadcutter
- E. Cup Point
- F. Semi-Wadcutter Hollow Point

* All nose punches are \$5.00 each except hollow point. This style is \$7.50.

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