

4. Finish the draw. If you have a .224 jacket maker, the punch is one straight piece and will go through the die. If you have a .243 jacket maker, the punch is made with two diameters, and will NOT go through the die. To finish a .224 jacket, you must push it all the way through the die and out the top. To do this, lower the ram and see if the jacket comes of in the die, or stays with the punch. If the jacket stays with the punch, it will be ejected by the tube and disk assembly on the down stroke, and you can push it through later with a second operation. If it stays in the die, you can put the push rod into the jacket, and shove on the end of this short (1-inch) rod to push the jacket all the way through the ring die insert. It may not come out the top yet, but it is drawn. The next jackets will lift it out. Catch the push rod so it doesn't drop on the floor when you lower the ram. If you have a .243 set, you can use the knock out rod and a small mallet or block of wood to tap the jacket back out of the die (or, it may come back with the punch and be ejected automatically).

The .243 jackets are actually a kind of "pre-form" jacket. They are not brought to .243 caliber in this operation. The mouth is flared by pressing over the punch angle joining the two punch diameters, so that it will seal the bore of the core seating die and hold the lead pressure during core seating, which will expand the entire jacket to the correct diameter (just like blowing up a balloon, but with thousands of pounds of pressure). Corbin Swage Lube is recommended to increase die and punch life and lower the force required to draw the jackets.

Discard any cases which are bulged from oversized chambers, which have bad firing pin cuts or split mouths, or have bad corrosion. Sort your jackets to that your groups are fired using the same headstamps, and you will probably find the accuracy is improved! The thin rimfire cases require a slightly larger core seating punch than a commercial jacket. They are very explosive and make excellent varmint bullets. Accuracy is best if the velocity is kept under about 3,200 fps with most rifles. Because the jackets are very thin, they don't like being fired at higher speeds! However, with reasonable velocities, the .22 rimfire case jacket can give you a virtually unlimited supply of free bullets—just add scrap lead, swage them into quality bullets using Corbin swage dies, and you can avoid the cost of commercial bullets forever!

**World Leader in Bullet Swaging Technology Since 1975!**

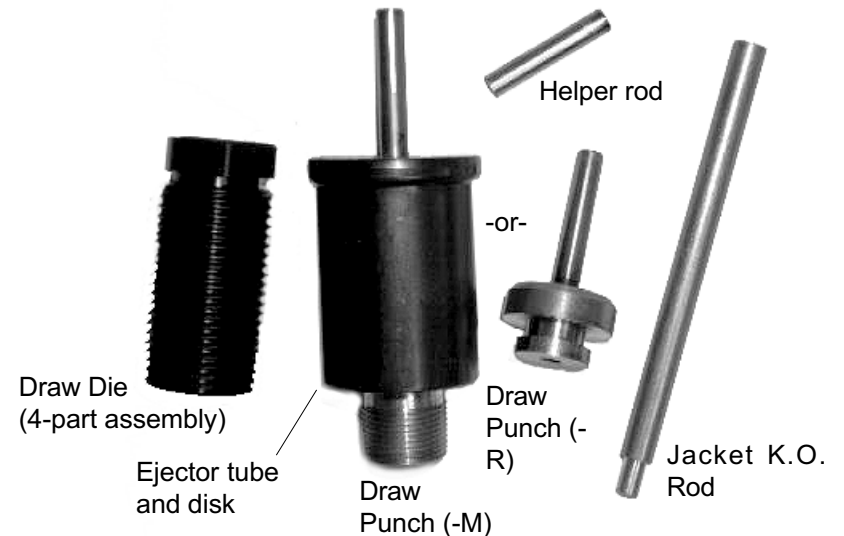


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# CORBIN<sup>®</sup>

## Rimfire Case Jacket Maker Kit

Quality .224 or 6mm jackets using fired .22 cases!  
Easy on the bore! Accurate! Free materials!



- RFJM-22R 22LR to 224 caliber (5.56mm) for use in a reloading press...
- RFJM-22M 22LR to 224 caliber (5.56mm) for use in Corbin Swage presses
- RFJM-6MR 22LR to 243 caliber (6mm) for use in a reloading press...
- RFJM-6MM 22LR to 243 caliber (6mm) for use in Corbin Swage presses

## The Corbin RFJM-22M Rimfire Jacket-Maker Die:

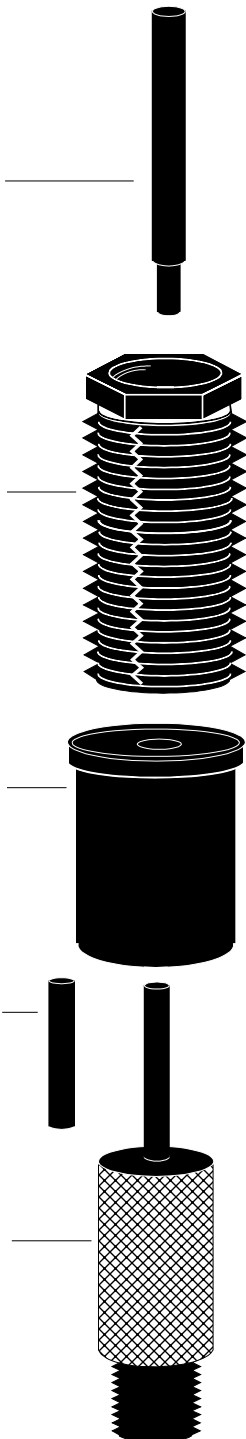
K.O. Punch (used to push a jacket out of the die, when needed to push out a jacket).

Die Assembly, consists of the threaded die holder body (7/8-14 TPI), which screws into the press head, the ring die insert which does the actual drawing, the spacer tube, and the retaining bushing (hexagon head, screws into the top of the die body and presses against the spacer tube, which in turn holds the ring die insert).

Ejection disk and tube assembly (press fit together, slips over the punch and strips the jackets off the punch on the down stroke of the press). Your press ram must fit inside this tube in order to use the die set on a reloading press.

Push rod, which can be used to finish pushing the jacket through the die, after using the punch alone to unfold the rim at the end of the stroke. The rod adds about an inch to the travel of the ram, sufficient to push the de-headed case through the ring die insert. In the 6mm version, the jacket is NOT pushed all the way through the die: it is ejected after unfolding the head and used at original diameter (it expands in the core seating operation).

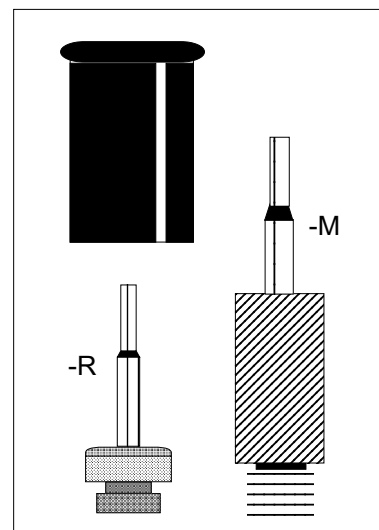
Punch, used to push the case into the die just far enough to draw out the rim into a straight section without folds or creases. This is done at the end of the press stroke. The push rod is put into the case and used to shove the case the rest of the way through the die (for .224 jackets only).



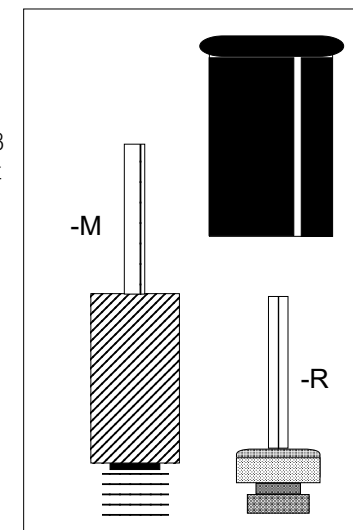
## How to use the jacket maker sets:

1. Clean and sort the cases. Separate them into groups by headstamp for the best accuracy. Throw away any that are punched through at the firing pin dent, or have been smashed flat. Boil the cases in hot water with detergent and a couple of tablespoons of vinegar to remove corrosion and dust. Rinse them in clean hot water and spread them out on an old towel to dry.
2. Draw the cases. Screw the die into the top of the press (hex nut faces away from the ram). Bottom of the die should be flush with the press frame to about 1/8-inch below it. Insert the punch into the press ram (screws into Corbin rams, slips sideways into regular loading press rams like a shell holder). Corbin CSP-1 press must be in the LONG STROKE or reloading position of the ram and toggle, not the short swaging stroke. With a film of Corbin Swage Lube on your fingers, touch a small amount of lube on the punch, and on the O.D. of the case. Put the case over the punch, and push it into the die about 1/4 inch (the press should run out of stroke at this point). Adjust the die so that the drawing is done at the END of the press stroke. Only about 1/4-inch of the case is drawn down in this operation.
3. Anneal the cases. The cases must be brought to a temperature sufficient to stress relieve and soften the brass, without burning it. Generally, if the cases are brought to a barely visible red glow in a dimly lit room, they were hot enough to avoid folding at the tip when you form the ogive later. A self-cleaning oven generally gets hot enough. Spread the cleaned cases out on an old cookie sheet and "bake" in the self-clean cycle of your electric range, or heat the cases by using a propane torch to quickly bring them to a red heat visible in dim light. Failure to anneal only means that the ogive may fold over instead of drawing smoothly to a point. Let them cool to room temperature.

6mm (.243)  
PUNCH-R, and PUNCH-M



.224 (5.56mm)  
PUNCH-M, and PUNCH-R



You can convert from .224 to .243 or vice versa just by obtaining the correct punch to fit your press ram! Type -R punches fit the reloading press, type -M fit Corbin presses.