

Technical Support: 260-482-3670

INSTRUCTIONS - SINCLAIR/WILSON STAINLESS STEEL MICRO-ADJUST BULLET SEATER

***** WARNING *****

DO NOT DISASSEMBLE OR REMOVE THE MICRO-ADJUST CAP. SPRINGS AND BEARINGS INSIDE CAP ARE UNDER PRESSURE AND COULD CAUSE INJURY. DO NOT UNSCREW PAST 5 ON THE SCALE DOING SO WILL VOID YOUR WARRANTY AND YOU WILL NEED TO SEND YOUR DIE IN FOR REPAIR.

Step 1: Remove from packaging clean die with a rag and solvent inside and out.

Step 2: Take one of your empty prepared cases from your gun and test fit in the die. Your case should drop just below flush on the bottom of the die. If your case does not go all the way into the die, this indicates you have an oversized chamber and you will need to send in the die along with a few cases to us, so we may open it up for you. There is no charge for this service. We only ask that you include return shipping of \$9.50 with your package. We do not need you to send the cap, stem or base, just the die body.

Step 3: Once you have determined a good fit, it is now time to set up the seater to your desired seating depth. The best way to do this is to take a dummy round or a factory round to get close to the seating depth you want. Insert the dummy round by setting it on the Bullet Seater Base and then slide the die over the top. You will notice the cap will raise up as you slide the die over the round.

Step 4: Next, if the die is not set to .250 thousands on the scale, do this now. (NOTE: Never unscrew Micro-Adjust Cap past 5 on the scale, springs and bearings are under pressure and will project out.)

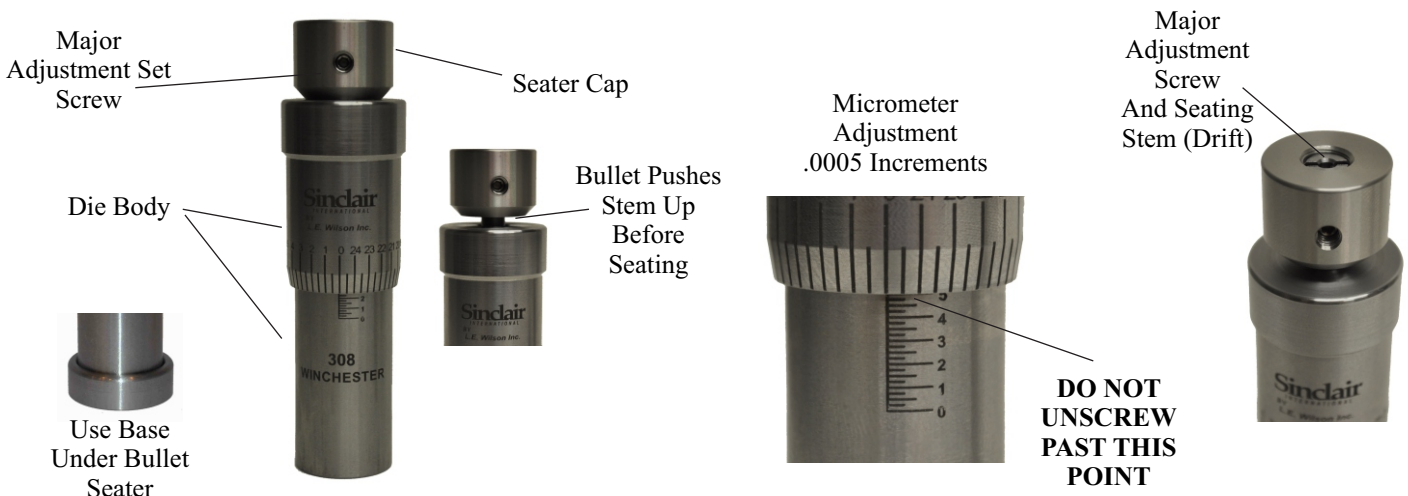
Step 5: Now it is time to adjust the major adjustment in the seating stem. This is done by loosening the set screw on the side of the bullet seater cap. This is a 3/32 (Included) hex set screw with a fiber pad between the stem and screw. Loosen now.

Step 6: Using a flat head screw driver, adjust the stem until the seater cap sits flat on the top of the Micro-Adjust cap. Snug the 3/32 hex setscrew back down (Do Not Over Tighten). If you screw the seating stem all the way to the top and there is still a gap between the Micro-Adjuster and the cap, then unscrew the Micro-Adjustment until the cap sits flush.

Step 7: Now seat one of your rounds by placing your case on the bullet seater base. Then place the bullet on top of the case and slide the die over the top. This will force the seater cap up. Simply slide the die under your arbor press and press the cap down until it meets the top of the die body. Measure overall length and adjust the die as needed.

The most common error made by users of this type of seater is to remove the plunger and drop the bullet in from the top. This requires removing and replacing the plunger for each bullet seated, which causes excessive wear on the plunger and the bore that guides it. It can also permanently damage your die.

You are now ready to start using your die. Please see the reverse side for more information on you new bullet seater.



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When seating boat-tailed bullets the process is simple.

- A bullet with a tapered base will stand alone in the case mouth and we usually pick up a box of bullets and fill up the cases in the loading block.
- Pick up a case and bullet, lower the seater over the two, place the seater on its base and push the seater body clear down to its seat on the base. This will raise the plunger the amount the bullet lacks of being seated.
- Then force the plunger down with a small arbor press or soft-faced hammer. These hammers, usually with amber-colored plastic faces, are available at any good hardware store.
- Make major adjustments by screwing the plunger in and out of the seater cap. Make fine adjustments by turning the micrometer either way.

Much the same procedure is used in seating flat-based bullets.

- The exception being that such bullets won't stand alone but must be held in place on the case mouth with the fingers of one hand while the seater is started over the case and bullet with the other hand. With a little practice this will prove almost as fast as with boat-tailed bullets.
- Once the seater is started over the two, the bullet can't get out of line enough to prevent its being pushed up into the proper place and you will find the plunger being raised each time just the same as with the other type bullet. The plunger should be lightly oiled or greased and it should never be necessary to remove it during any seating operation.

With this type seater the case is completely supported before the seating operation begins. The case and bullet are shoved up into the chamber against a fixed plunger, the case can't be supported all around until it is clear up as far as it will go and then the seating operation is finished. This means that almost the entire seating operation is done with the case unsupported except at its base. For this reason you will usually find that bullets when seated with the chamber-type bullet seater will check truer with respect to the axis of the case than bullets seated without the type seater mentioned. The secret of the accuracy of the chamber-type seater does not lie in having the bore at the upper end of the seater a close fit with the bullet. If this were true only one size bullet could be seated with accuracy with any one seater. Thus a seater made for .2570" bullets wouldn't accept .2575." The important thing is that the plunger be a close fit in the bore and that the cone in the plunger, which aligns the bullet, be exactly centered in the plunger. We make the bore at the upper end of the seater usually about .002" larger than the standard bullets and oversize and undersize bullets can be seated with equal accuracy.

It is not necessary to have the cone in the seating plunger an exact fit on the ogive of the bullet. All that is required is a small contact and even a contact so small that it leaves a small ring mark on the bullet is okay. The important thing is that the bullet be precisely supported with reference to the bore of the seater and a full contact will accomplish no more toward that end than a line contact. With the addition of the VLD bullet we have recently added a new VLD stem. These stems will grip the VLD's a bit lower on the bullet than the standard seating stem and ensure correct alignment during the seating operation. Lead bullets would also be cause for a slightly modified plunger to fit the bullet contour. If this is the case call us to make sure we can make this modification, this may also require a modification of your seater as well.

The seating stem is adjustable for seating depth and the small set screw bears against a fiber disc so the treads on the plunger will not be damaged. One Full Turn on the seating stem adjustment = .042 Quarter Turn = .0105 Half Turn = .021

Please be sure to try an **UNLOADED** case in the seater, whether it be neck sized only or full length sized after the seater has been cleaned of its shipping oil. Push the case into the seater until it's flush with the bottom of the seater **(DO NOT FORCE IT)**. If it won't go flush, or is hard to remove with a small screwdriver under the rim or head, the seater needs to be opened up to fit your cases. Please send in 3 fired cases and the seater **WITHOUT THE SEATER STEM**. Seaters are made to SAAMI specs for max cartridge. Many chambers are larger than that. Not all chamber reamers are created equal. The same applies to neck sizing dies; push the case into the die without the bushing in it. We do not charge to open up the die, but we do have a minimum \$9.50 shipping and handling charge.

PLEASE NOTE: While bullets can usually be seated after full-length resizing without any problems, for more uniform seating we do recommend that the necks have an expander run through them first. This can be done in a regular reloading press at the same time the case is de-capped and primed.