

# Dillon Reloading Die Instructions

*These are simplified instructions for using the Dillon reloading dies. Refer to the Dillon Web site for complete die user instructions—[www.Dillonprecision.com](http://www.Dillonprecision.com)*

## DILLON PISTOL DIE INSTRUCTIONS

1. Dillon Pistol Reloading Dies are three die sets (Fig. A, B, C and D). All Dillon Pistol Size Dies incorporate a precision carbide sizing ring. Fired brass needs to be properly cleaned to preserve the interior surface finish of the carbide size die. Dillon recommends that pistol cases be lightly lubricated with Dillon Case lube for ease in sizing cases even with the carbide feature. The Pistol Depriming/Decapping Assembly in the Size Die incorporates a Floating-Spring-Loaded Stem with an easily replaceable hardened Depriming Pin. This Floating Spring-Loaded Assembly helps align the Depriming Pin and provides a "snap" action of the Primer Stem to minimize primer "draw-back." There is no adjustment of the Pistol Depriming Assembly.
2. **Install the Size Die** by cycling the reloading press Handle down so that the Toolhead and Shellplate are together in their sizing position. Screw the Pistol Size Die (clockwise) down until it just touches the Shellplate then back the Die up 1/16 of a turn or less. With a sized case fully up in the Size Die, tighten the Die Lock Ring with a 1" Dillon Bench Wrench using a 7/8" wrench to hold the Die Body for the best alignment of the Shellplate, Die, and Toolhead.
3. Check the sized case in a Dillon Pistol Case Gauge. The sized case, as well as the completed cartridge, should drop freely in and out of the Pistol Case Gauge.
4. The Pistol Seating Die has a removable double-ended Seating Stem. (Fig. C-6 and Fig. E). One end of the Seating Insert is for flat nose bullets and the other is for round nose bullets. Select the Seating Stem that matches the nose of the bullet. Disassemble/reassemble the Seat Die as shown in (Fig. C and E).
5. **Install the Seat Die** by threading it down/clockwise until the bottom of the Die is flush with the bottom of the Toolhead. Place a belled/flared case into the Shellplate Seating Station. Place a bullet on the belled case mouth and seat the bullet. Remove the cartridge and check the overall length of the cartridge with a digital or dial caliper. If the bullet is not seated deep enough, screw the Seating Die down 1/2 turn or less at a time. Replace the cartridge and repeat these steps until the correct cartridge overall length (COAL) is achieved (Fig. F).
6. The Dillon Pistol Crimp Die uses an easily removable Crimp Die Insert. This feature allows for quick cleaning without loss of the crimp setting. There are two types of crimps--roll crimp and taper crimp. Taper crimping is used for semi-auto rimless cartridges and roll crimping is used for revolvers with rimmed cartridges (Fig. G).
7. **Install the Crimp Die** by screwing the Crimp Die into the Crimp Station until it is flush with the bottom of the Toolhead. Place a cartridge with a properly seated bullet into the Crimp Station. Lower the Operating Handle and continue to screw the Crimp Die down until just it touches the cartridge. Raise the Operating Handle slightly and screw the Die down 1/8 of a turn or less and inspect the cartridge. If the bellying of the case mouth is still present, or the desired amount of crimp is not enough, continue making small adjustments until the desired amount of crimp is achieved. The crimp diameter should be only .001-.002" less than the outside diameter of the case mouth. Once the adjustment is complete, place the case back into the Crimp Station and lower the Operating Handle. Tighten the Crimp Die Lock Ring with the cartridge in place.
8. Cycle a case through the system producing a complete cartridge and verify that all the reloading parameters are correct.

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Note: Follow all safety precautions for reloading as outlined in the Dillon Reloading Manuals. For more complete user information refer to the Dillon Die Reloading Instruction Manual.

Fig. A. Dillon Pistol Three Die set

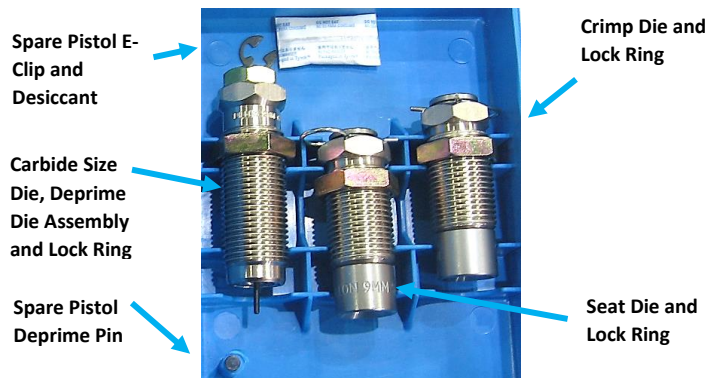


Fig. B. Size Die

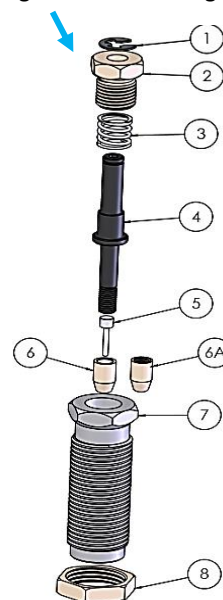


Fig. C. Seat Die

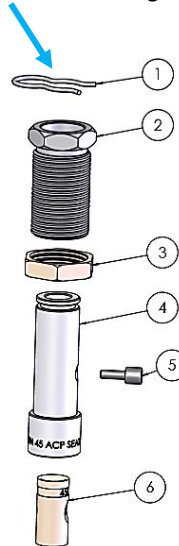
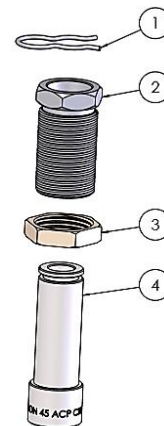


Fig. D. Crimp Die



ITEM	DESCRIPTION
1	14445_UNIVERSAL BODY CLIP
2	14444_UNIVERSAL DIE BODY
3	14067_DIE LOCK RING
4	CRIMP DIE INSERT*

\* = CALIBER SPECIFIC

ITEM	DESCRIPTION
1	13837_DECAP RETAINING CLIP
2	12866_DECAP STEM SCREW
3	13516_FLOATING DECAP SPRING
4	12800_FLOATING DECAP STEM
5	13753_PISTOL DECAP PIN
6	13429_DECAP NUT
6A	16665_32 ACP DECAP NUT
7	SIZE DIE BODY*
8	14067_DIE LOCK RING

\* = CALIBER SPECIFIC

ITEM	DESCRIPTION
1	14445_UNIVERSAL BODY CLIP
2	14444_UNIVERSAL DIE BODY
3	14067_DIE LOCK RING
4	SEAT DIE INSERT*
5	14434_SEATER STEM PIN
6	SEATER STEM*

\* = CALIBER SPECIFIC

Spare Pistol Deprime Assembly P/N21530



Fig. E interchangeable Seat Stems fit the nose of the bullet



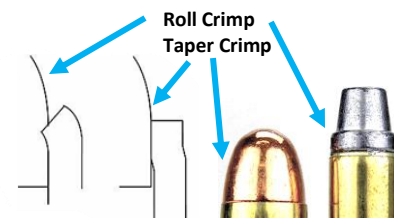
Clip holds Die Insert in Body

Pin holds Stem in Die Insert

Fig. F. COAL-Cartridge Overall Length



Fig. G. Roll and Taper Crimp



DILLON RIFLE DIE INSTRUCTIONS

9. Dillon Rifle Reloading Dies are three die sets (Fig. H, I, J and K). The Rifle Size Dies are available in steel or carbide. The Rifle Depriming Assembly is adjustable and incorporates a replaceable Depriming Pin and a Carbide Expander Ball. **Cases must be properly cleaned and MUST be lubricated with Dillon Case Lube when using either Steel or Carbide Size Dies to minimize the chance of a stuck case.** Dillon Steel Size Dies are shipped with an anti-corrosion protective coating that must be removed to prevent sticking a case in the Size Die. Remove the Depriming Assembly. Wet a paper towel with alcohol and "wind it" into the bottom of the Size Die up through the neck. Follow this with a paper towel dampened with Dillon Case Lube. The die is now ready to be used.
10. **Install the Size Die** by cycling the reloading press Handle down so that the Toolhead and Shellplate are together in their sizing position. Thread the Sizing Die into the Toolhead (clockwise) until it just touches the Shellplate and back it up two turns. Tighten the Die Lock Ring finger tight. Loosen the Rifle Decapping Assembly Locknut and raise the Depriming Assembly 3 turns. Insert a lubricated case into the sizing station. Size the case, remove it and verify it is properly sized and the headspace is correct using a Dillon Head Space Gauge. (Refer to usage of a headspace gauge in Dillon Reloading Press on-line Instruction Manuals.) Repeat the sizing adjustment until the case is properly sized. With the sized case in this station, screw the Decapping Assembly down while partially cycling the Handle up-and-down until the shoulder of the Decapping Pin just contacts the flash hole inside the case with the Handle down. Raise the Decapping Stem (Fig. I-1) 1½ turns from contact. Tighten the Die Lock Ring (Fig. I-7) and the Decap Lock Nut (Fig. I-3) with a sized case fully up in the Size Die for best alignment.
11. **Set up the Rifle Seat Die** by placing a sized and neck expanded case in the seating station. Screw the Seat Die down until it touches the case and back it up one turn. Lock the Die Lock ring in place with a 1" Dillon Bench Wrench while holding the Die with a 7/8" End Wrench. Loosen the 5/8" hex Seating Stem Lock Nut (Fig. J-2) and back the center 9/16" hex Adjustable Seating Stem (Fig. J-1) up 3 turns. Place a bullet in the case mouth. Carefully screw the 9/16" Seating Stem (Fig. J-1) down until it contacts the bullet plus 1/8 of a turn. Remove the cartridge and use a caliper to measure the COAL of the cartridge. If the bullet is not seated deep enough, screw the Seating Stem (Fig. J-1) down 1/8 turn at a time. Repeat these steps until the correct COAL is achieved (Fig. L). Tighten the Seating Stem 5/8" Lock Nut (Fig. J-2) while holding the 9/16" Seating Stem (Fig. J-1) from rotating with end wrenches with the assembled cartridge in the Seat Die.
12. **Install the single piece Rifle Crimp Die** (Fig. K) by screwing it into the Crimp Station in the Toolhead until it is flush with the bottom of the Toolhead. Place a cartridge with a properly seated bullet into the Crimp Station. Lower the Operating Handle all the way and screw the Crimp Die down until just it touches the seated bullet. Raise the Operating Handle slightly and screw the Die down 1/8 of a turn or less and inspect the cartridge. If the bellying of the case mouth is still present, or the desired amount of crimp is not enough, continue making small adjustments until the desired amount of crimp is achieved. The crimp diameter should be only .001-.002" less than the outside diameter of the case mouth (Fig. M). Once the adjustment is complete, place the crimped cartridge back in the Crimp Station and lower the Operating Handle. Tighten the Crimp Die lock ring (Fig. K-2) with the cartridge in place while holding the Crimp Die from moving.
13. Cycle a case through the system producing a complete cartridge and verify that all the reloading parameters are correct.
14. **If a case gets stuck in the Size Die**, the Rifle Depriming Assembly can be used to push the case out. With the Die in the Toolhead and Press, remove the Stem Clip (Fig. I-2 & Fig. N-1). Loosen and thread the 5/8" Jam Nut to the top of the Depriming Stem (Fig. I-3 & Fig. N-1). Use a 9/16" wrench to turn the Depriming Stem down, pushing the stuck case out the bottom of the die. (If the case does not readily move—STOP). Try to remove the Depriming Stem Assembly (Fig. N-3). a. If the Depriming Assembly **can be removed**, use a hammer and a pin punch that closely fits through the neck and contacts the inside base of the stuck case and carefully drive the case out of the die (Fig N-4). b. If the case is still hung up on the Expander Ball in the Die or the Depriming Assembly can't be removed, use a pair of vice grips to firmly grasp the bottom of the exposed case. Carefully hit down on the vise grips with a Hammer (Fig. N-2). This should free the case from the Die and Expander Ball. Clean and inspect the die. If all else fails use the Redding Stuck Case Removal Kit from Dillon PN12186.

Fig. H. Dillon Rifle Three Die Set

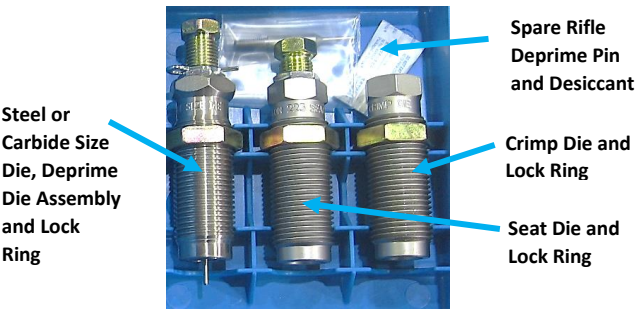
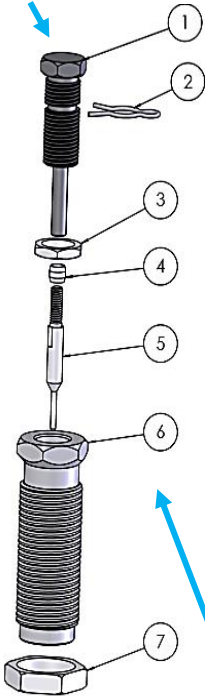


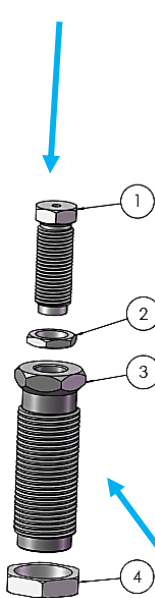
Fig. I. Size Die



ITEM	DESCRIPTION
1	RIFLE DECAPPING STEM*
2	13906_RIFLE DECAP STEM CLIP
3	12577_SEAT DECAP NUT
4	CARBIDE EXPANDER RING*
5	DECAP PIN*
6	SIZE DIE BODY*
7	14067_DIE LOCK RING

\*=CALIBER SPECIFIC

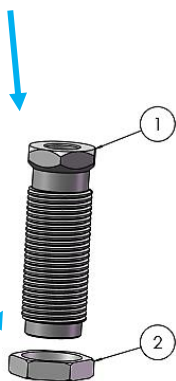
Fig. J. Seat Die



ITEM	DESCRIPTION
1	SEAT STEM*
2	12577_SEAT STEM DECAP NUT
3	SEAT DIE BODY*
4	14067_DIE LOCK RING

\* = CALIBER SPECIFIC

Fig. K. Crimp Die



ITEM	DESCRIPTION
1	CRIMP DIE BODY*
2	14067_DIE LOCK RING

\* = CALIBER SPECIFIC

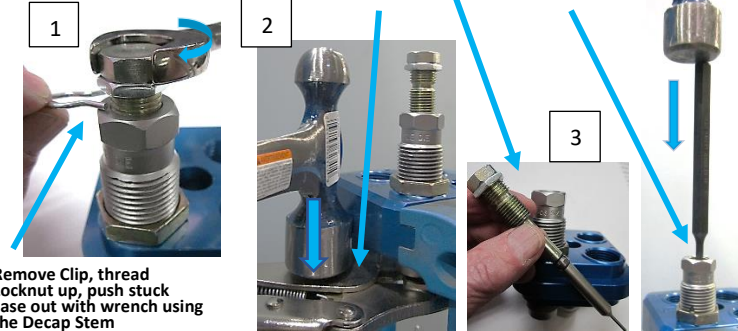
Fig. M. Measuring Crimp



Fig. L. Cartridge Overall Length (COAL)



Fig. N. Removing a Stuck Case



Remove Clip, thread Locknut up, push stuck case out with wrench using the Decap Stem

Use a hammer and vice grips to remove case and free the Decap Assembly

Use a hammer and pin punch contacting the inside case base to remove case