M2 Precision .50 BMG Match Bullet Seater

Thank you for purchasing the M2 Precision .50 BMG Match Bullet Seater.
The M2 Precision .50 BMG Match Bullet Seater is a precision device that will help you produce the most consistent and accurate match ammunition. Please read and understand the following so that you can properly setup and use the tool.

Safety

The .50 BMG Match Bullet Seater is used to seat bullets in .50 BMG cases. Safe operation is the responsibility of the user. Please follow the safety tips listed below:

1. **The .50 BMG Match Bullet Seater is designed for use with neck-turned brass only. The loaded round must have a neck diameter less than .553". Failure to comply with this requirement can cause the loaded round to wedge in the die once the bullet is fully seated. If you don't wish to use neck-turned brass, contact the manufacturer for instructions or to return the die for a refund**.

2. Be sure of your load. Consult a reliable loading manual. Don't start at the maximum load, and note that some combinations of rifle and ammo will have safe maximums below what may be listed.

3. In general, treat all reloading tools with the same care and respect that you would give a firearm: Be safe.

The manufacturer and/or seller of this tool assumes no liability for any consequences of its use.

Please Note

The M2 Precision .50 BMG Match Bullet Seater is made of 416 stainless steel, with some parts heat-treated to RC42-44. Note that the chamber and bullet seater stem are matched to a tight tolerance. When disassembling the tool, use extreme care handling these parts.

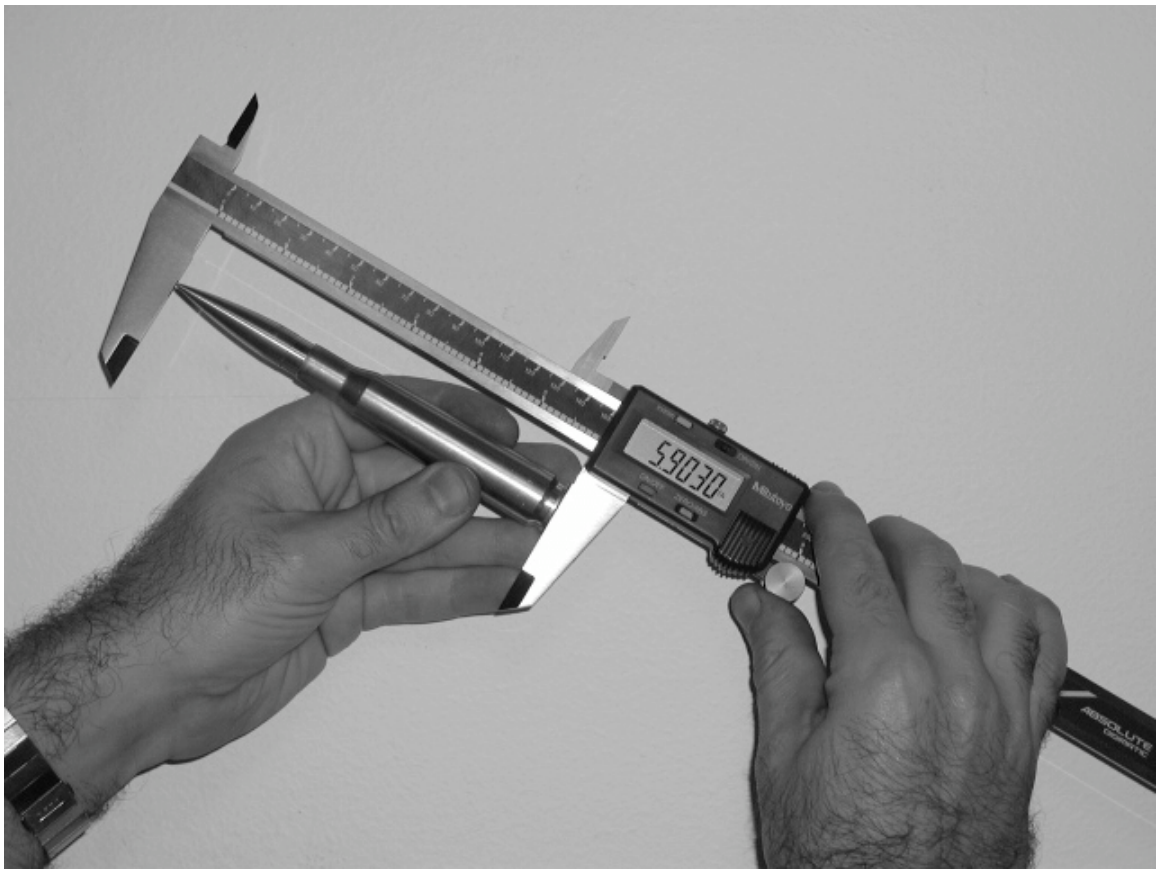
The .50 BMG Match Bullet Seater has precision-machined parts: don't use pliers, channel locks etc. on it.

Headspace

The.50 BMG Match Bullet Seater is cut to headspace .025" short on a GO GAUGE, when used with a standard (.250" deep) .50 BMG shell holder.

Setup

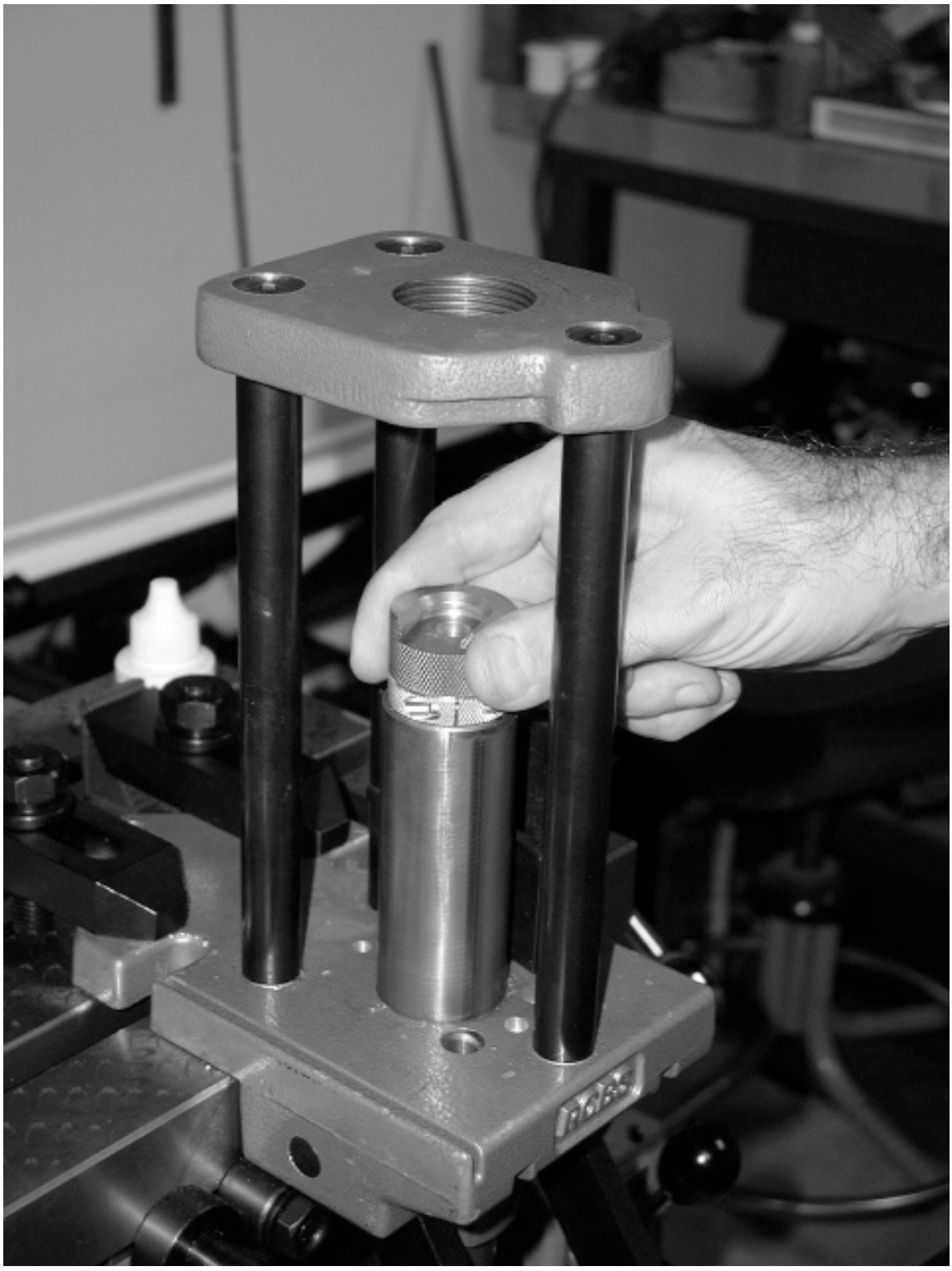
1. Measure the OAL of an unseated bullet (just resting inside the case mouth.



2. Measure the OAL of the loaded round.

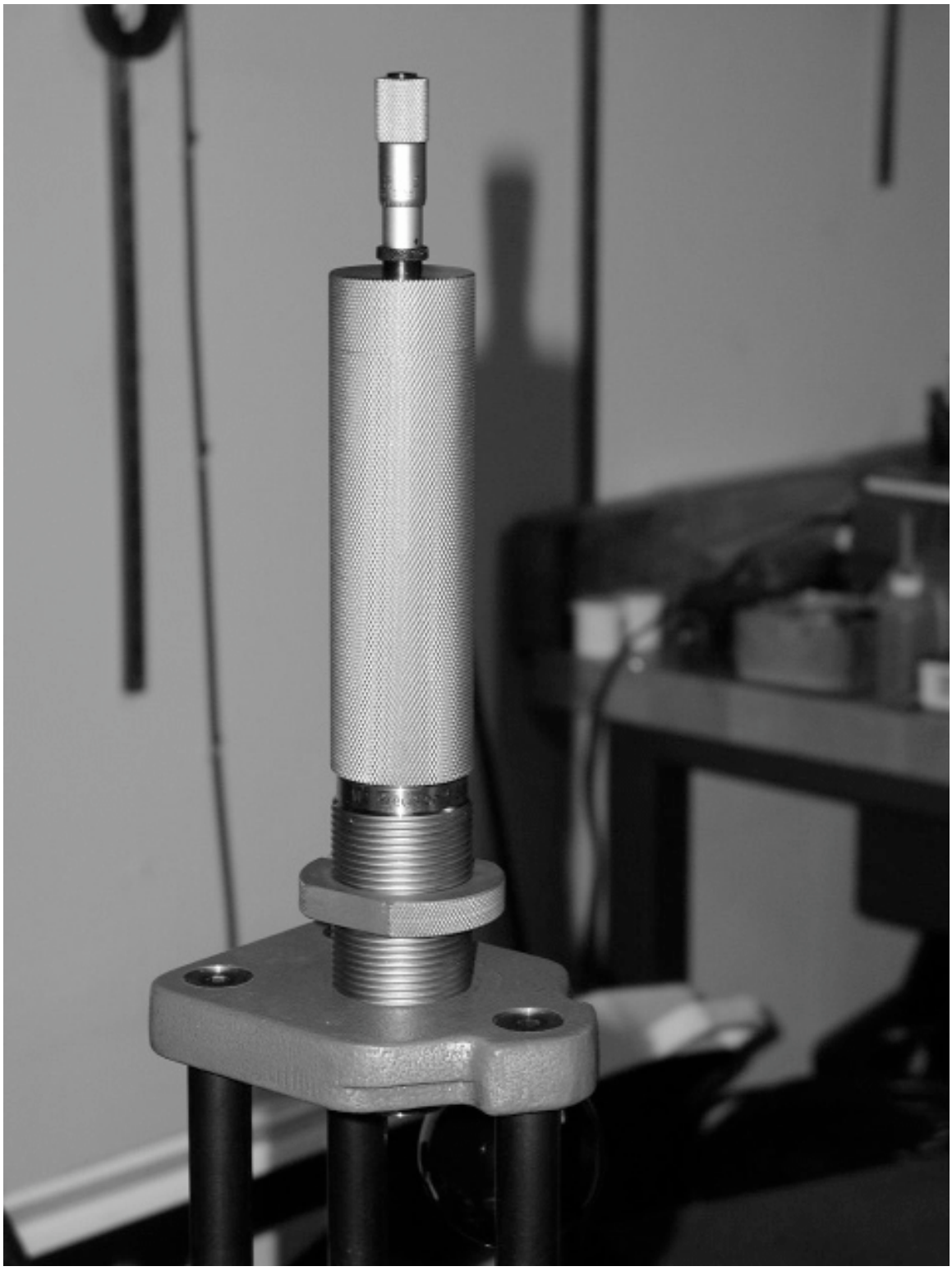
3. Subtract the measurement in step 2 from step 1.
Example: 6.2700 – 5.903 = .367 (be sure to use your numbers here).

4. Divide the result in step 3, by .0833.
Example: .367 / .0833 = 4.405 (once again use your numbers here).
This result is the number of additional turns the .50 BMG Match Bullet Seater will need in step 10.

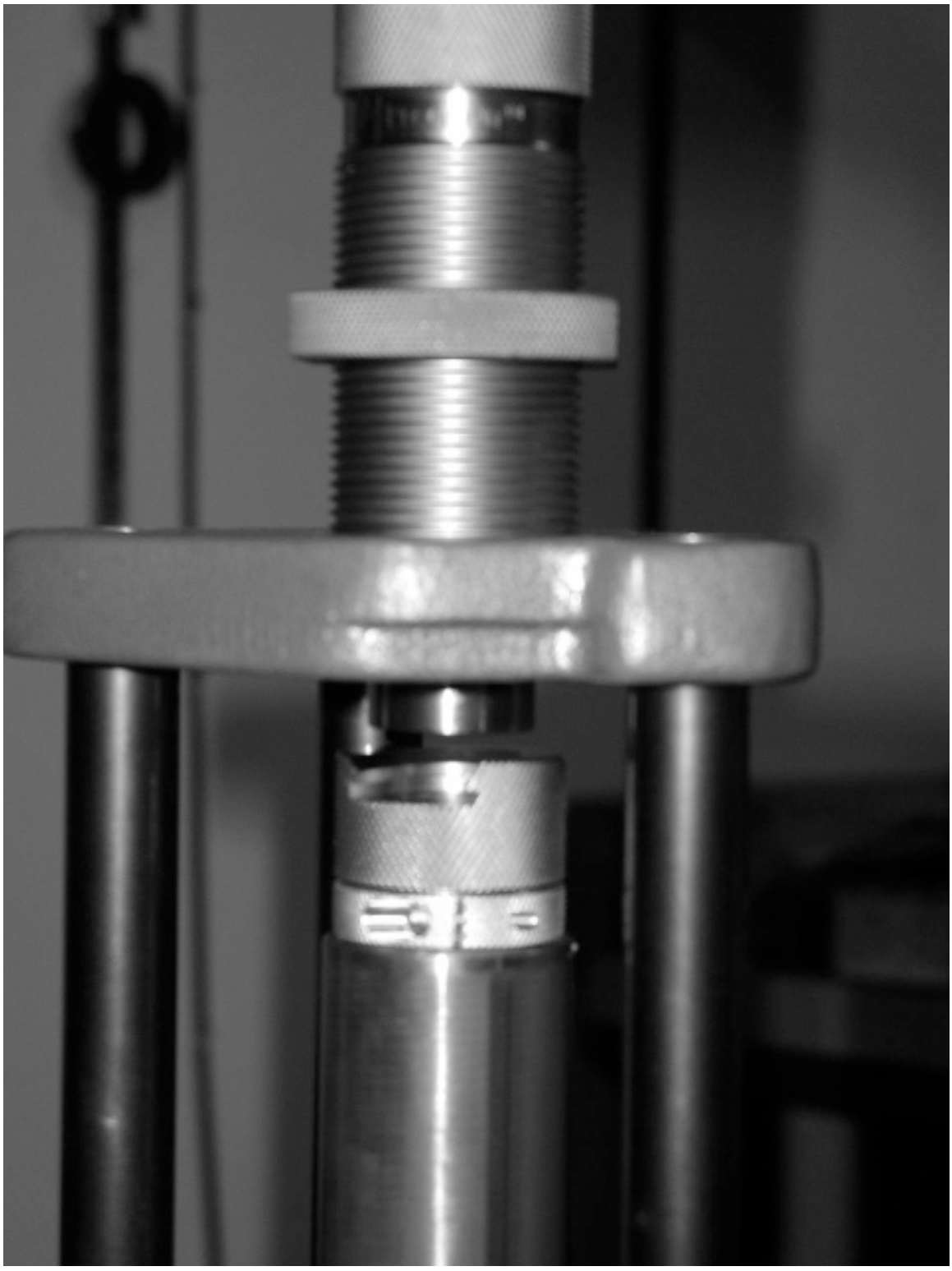


5. Put a .50 BMG shell holder in the press and lock it down.

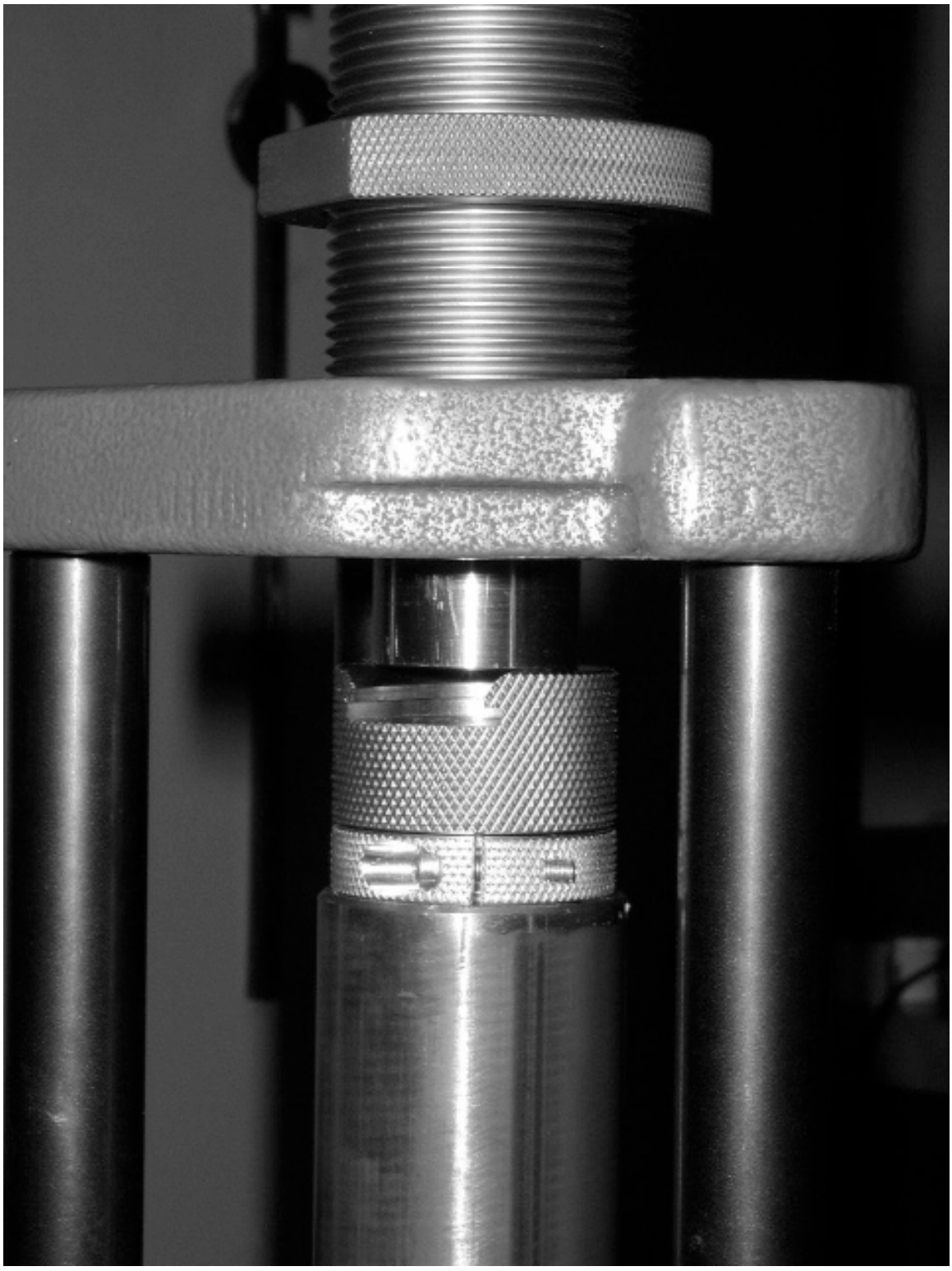
6. Install a lock ring on the .50 BMG Match Bullet Seater, but don't lock it down yet.



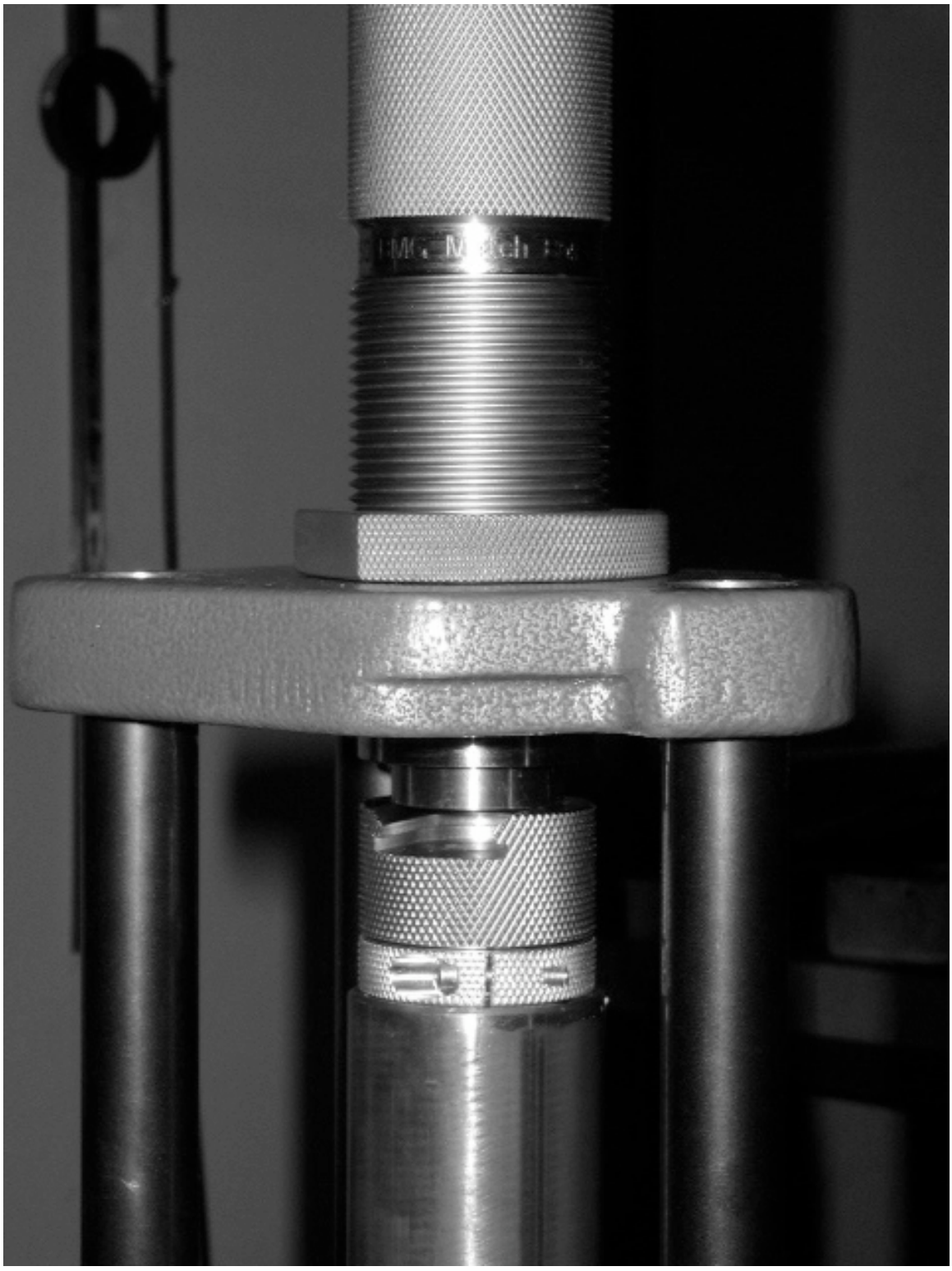
7. Thread the .50 BMG Match Bullet Seater into the press part way.



8. Pull the press handle, raising the press ram to its full upright position.



9. Screw the .50 BMG Match Bullet Seater into the press until it just contacts the shell holder.



10. Lower the press ram, screw the .50 BMG Match Bullet Seater in at least the number of additional turns calculated in step 4, and secure the lock ring.

11. Unlock the micrometer lock ring (turn counter clockwise).

12. Raise the micrometer to the top.

13. Put a loaded sample round in the press. You may need to lift up on the chamber sleeve to clear the bullet.

14. Raise the press ram to the top. Note that there should be a nominal .025″ gap between the shell holder and the chamber sleeve.

15. Turn the micrometer until resistance is felt.

16. Lock the micrometer lock ring (turn clockwise). The micrometer setting, at this point, will be close to duplicating the OAL of the loaded sample round.

17. Remove the loaded round. Don't forget that you may need to lift up on the chamber sleeve to clear the bullet.

Usage

1. Place a primed and charged case in the shell holder. Set the bullet on top of the case.

2. Pull the press handle, seating the bullet.

3. Remove the loaded round. Don't forget that you may need to lift up on the chamber sleeve to clear the bullet.

Fine Tuning

Turn the micrometer clockwise to decrease the OAL, or counter clockwise to increase.

Important

When pulling the handle, the.50 BMG Match Bullet Seater must be adjusted (steps 1-10) so that the case headspaces in the chamber sleeve before the bullet begins to seat. Improper adjustment will cause excessive run-out.

An easy way to check this is to slowly pull the handle, noting when resistance is felt. If the .50 BMG Match Bullet Seater is properly adjusted, you will feel a slight resistance when the case headspaces in the chamber sleeve, followed by a greater resistance when the bullet begins to seat.

If your brass is insufficiently sized, it may not headspace properly on the shoulder. Check that you have a nominal .025" gap between the shell holder and the chamber sleeve when the ram is at the top.

Care

1. NEVER turn the micrometer when the press handle is pulled down.

2. Keep the .50 BMG Match Bullet Seater clean. If it gets sticky, take it apart and clean the chamber sleeve and bullet stem. If you use a solvent on these parts, dry them thoroughly, and don't oil them. Use compressed air to blow out any lint from the patch. Use extreme care with these two parts. Don't drop them or use excessive force on re-assembly.

3. When the chamber sleeve moves (either seating a bullet or pressing by hand), an air piston effect will make the seater stem move up and down. Listen for this sound as it indicates that the seater stem is moving freely. If you don't hear this sound, take the .50 BMG Match Bullet Seater apart and clean it.