M2 Precision .50 BMG Match FL Sizer

Thank you for purchasing the M2 Precision .50 BMG Match FL Sizer.

The M2 Precision .50 BMG Match FL Sizer 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 FL Sizer is used to resize .50 BMG cases. Safe operation is the responsibility of the user. Please follow the safety tips listed below:

1. NEVER resize a primed or loaded case.

2. After sizing, all case lube must be removed from the cases. This is a safety issue: A lubed case will cause higher bolt thrust.

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 FL Sizer is made of 416 stainless steel, heat-treated to RC42-44. 416 stainless allows cutting a precise chamber with little or no distortion during heat-treat. It is, however, softer than typical factory dies. Keep the cases very clean, and use plenty of case lube, and the .50 BMG Match FL Sizer will provide years of use.

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

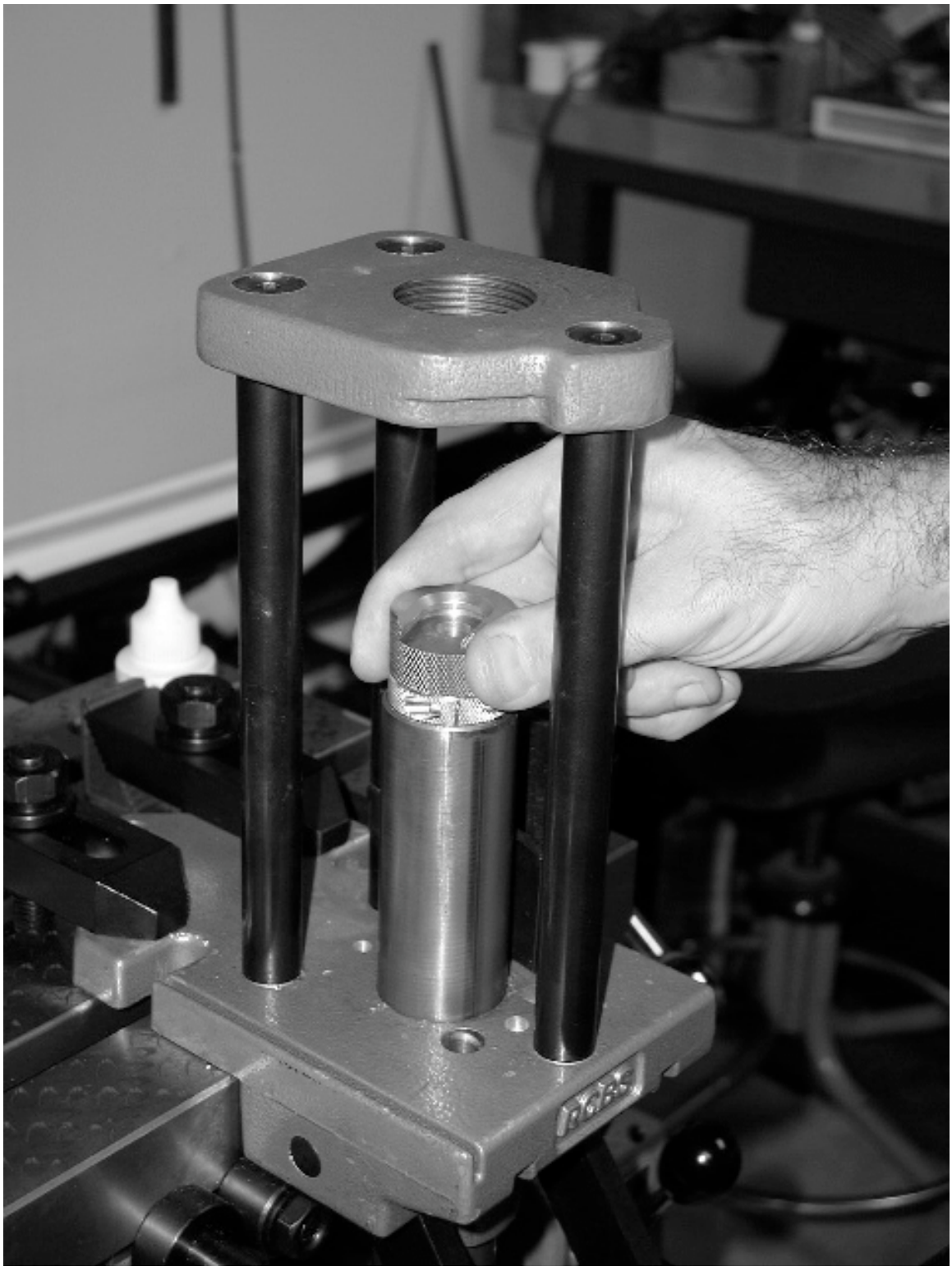
Headspace

The.50 BMG Match FL Sizer is cut, to exactly headspace on a GO GAGE., when used with a standard (.250" deep) .50 BMG shell holder.

I have measured brass spring-back of .0015 to .007 depending on the hardness of the brass and whether it has been annealed.

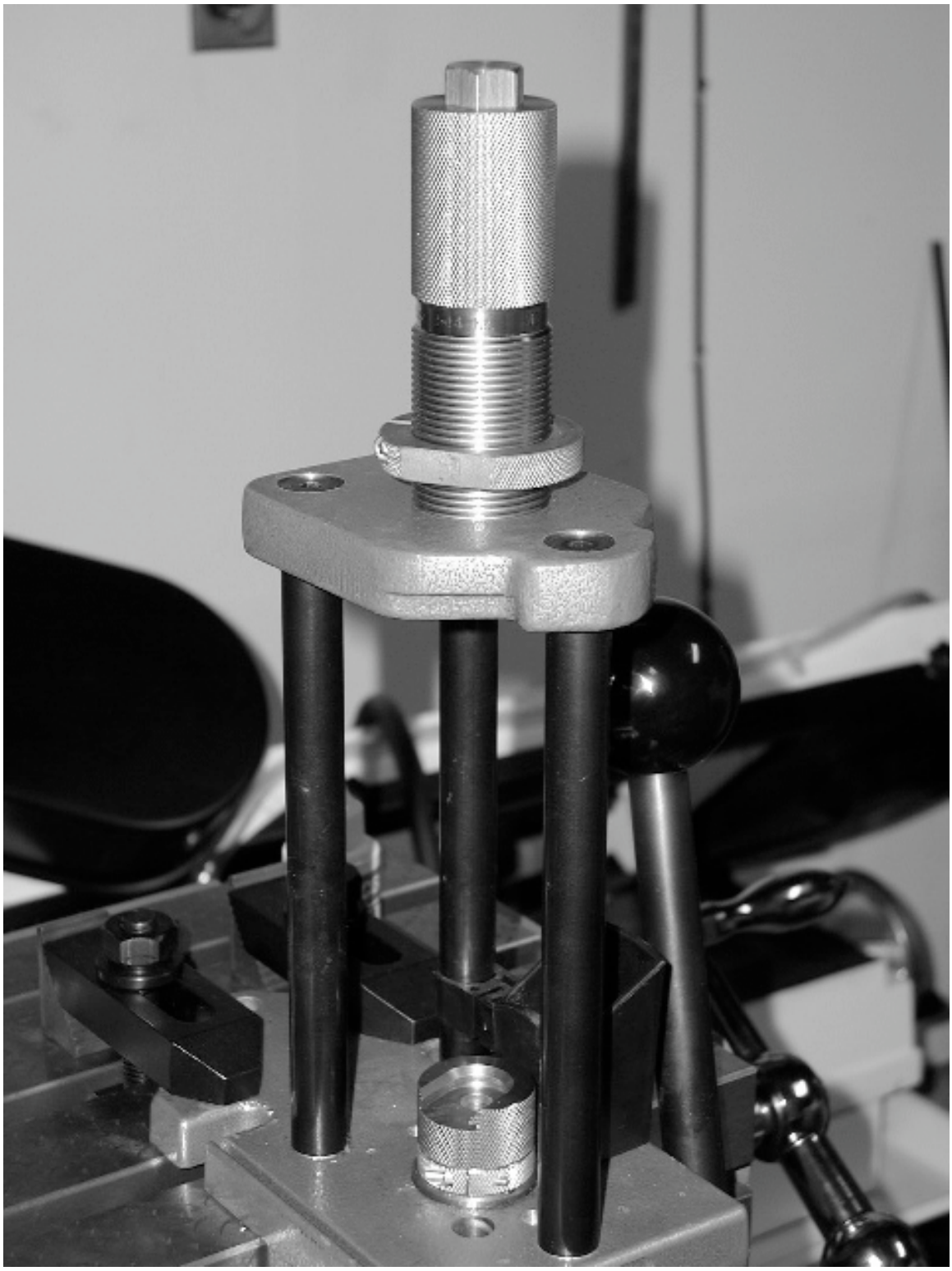
With this in mind, the.50 BMG Match FL Sizer, when used with a .250" deep shell holder will probably be close to the ideal setup of just bumping the shoulder back. Since each chamber is unique, custom depth shell holders are available. Please call or email for advice on selecting the correct shell holder.

Setup

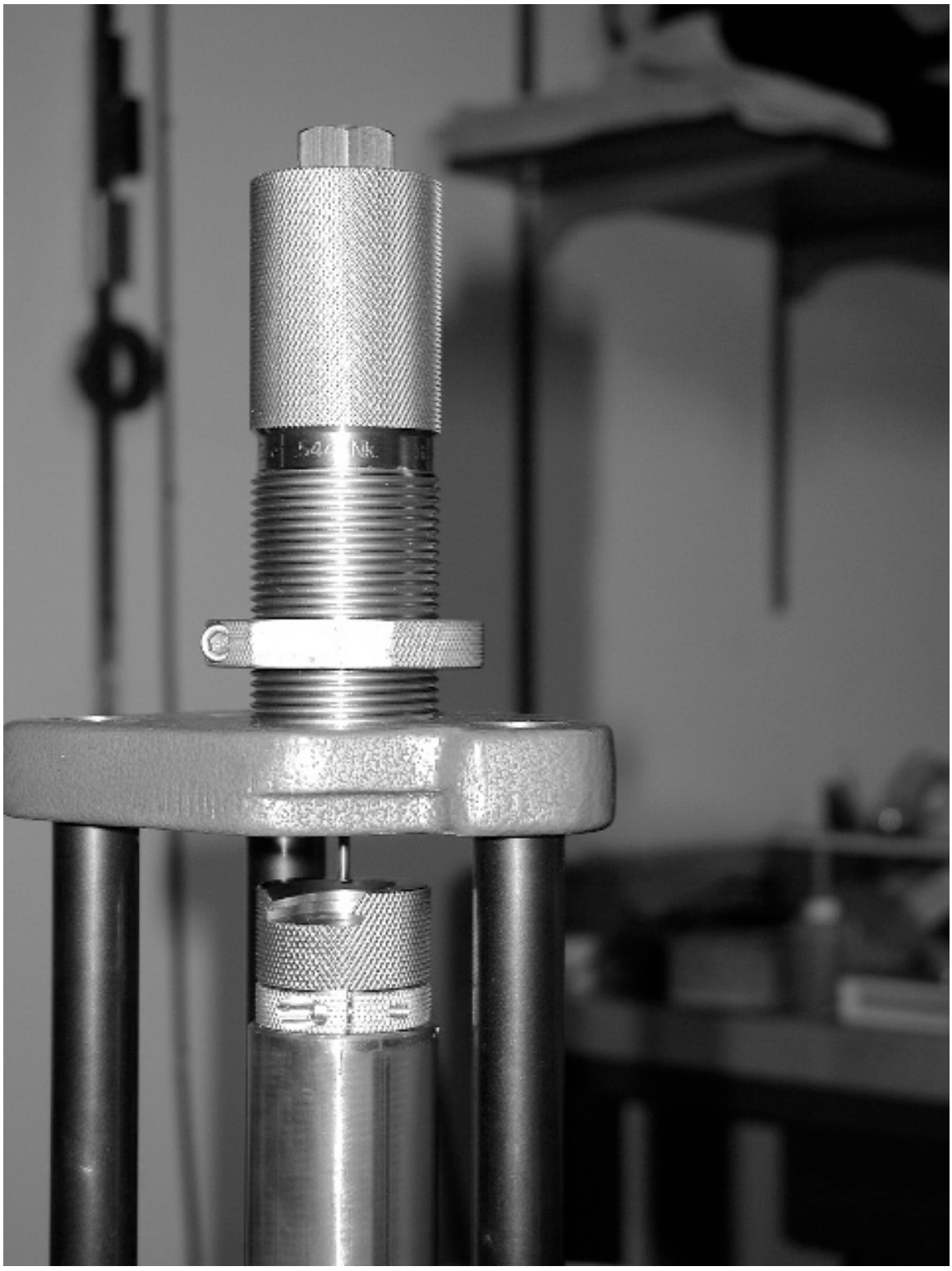


1. Put a .50 BMG shell holder in the press and lock it down.

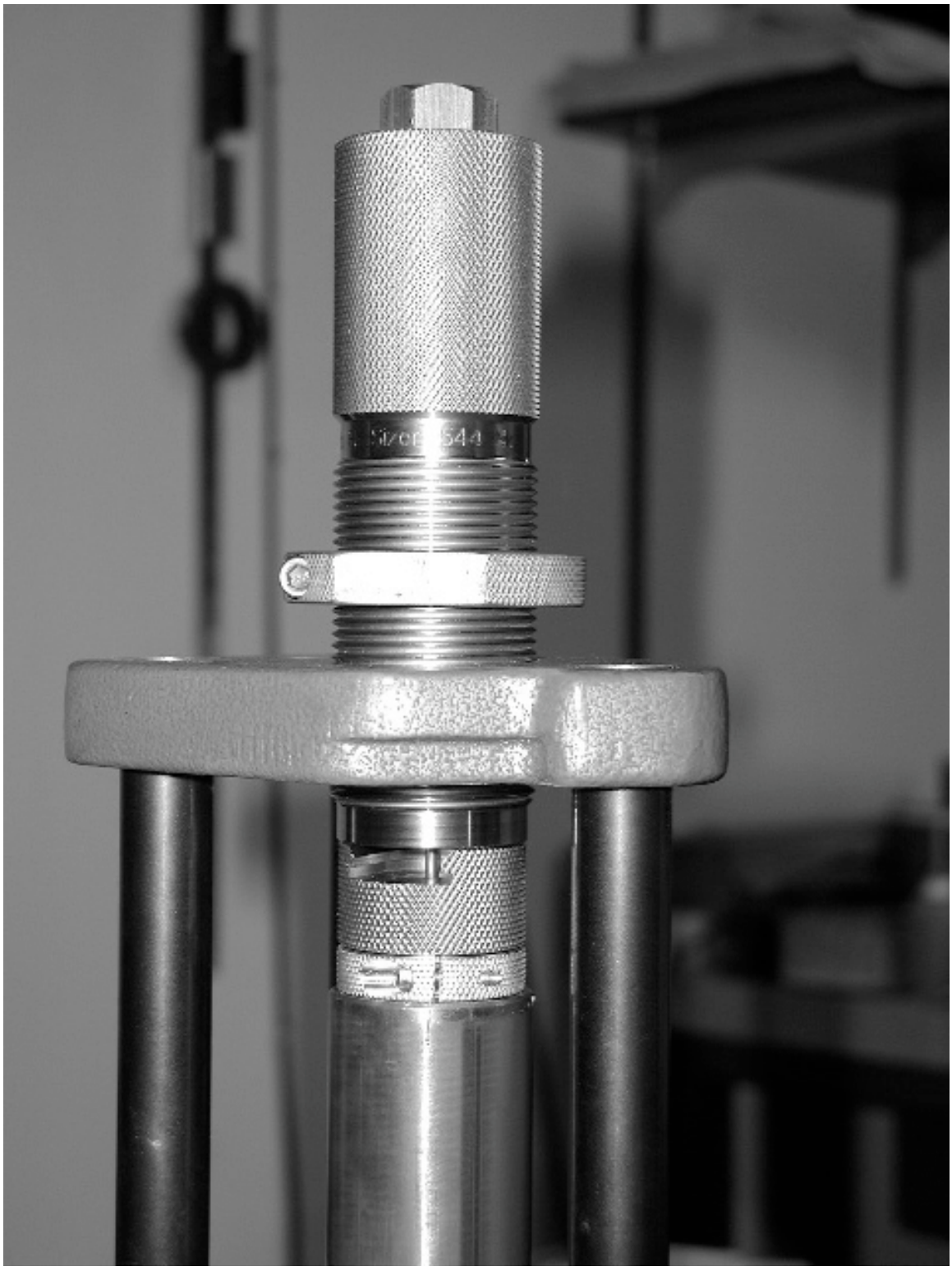
2. Install a lock ring on the .50 BMG Match FL Sizer, but don't lock it down yet.



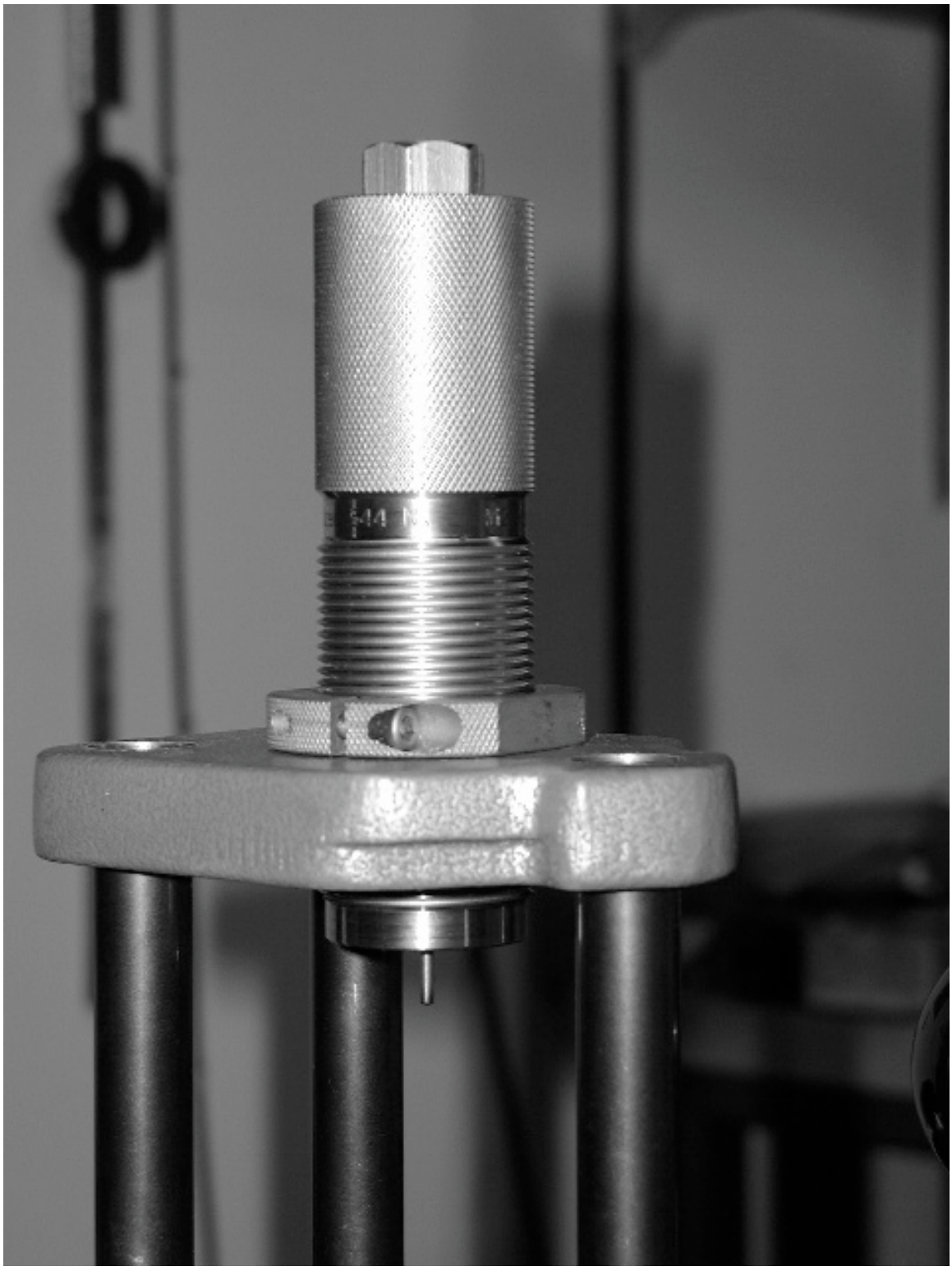
3. Thread the .50 BMG Match FL Sizer into the press part way.



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



5. Screw the .50 BMG Match FL Sizer into the press until it just contacts the shell holder.



6. Lower the press ram, screw the primer seater in 1/8 additional turn and secure the lock ring.

Note that the.50 BMG Match FL Sizer is designed for the shell holder to make firm contact, when the press's ram is at the full upward travel.

When adjusted properly, you should need about 25 pounds of force, on the press handle, to make the press cam over at the top.

Adjusting the .50 BMG Match FL Sizer so that it is backed off of the shell holder is not recommended. This will not give uniform results, as there is too much flex and slop in most presses. If you need to bump the shoulder more or less, do it with my custom shell holders.

Usage

It's now time to use the tool.

1. Make sure that all of your cases are cleaned and free of all dirt and grit. Walnut or corncob media in a large vibratory tumbler works well. Roll the tumbled cases on a clean towel to remove any media dust.

2. Use plenty of case lube. RCSB case lube works well, applied either with a lube pad, or by applying lube, directly from the bottle, and rolling the case around in your fingers.

Either way, make sure to apply lube to the outside of the neck. Note that there is no need to lube the inside of the neck.

If you aren't getting hydraulic dents, you aren't using too much lube.

3. Size the case. Pull the handle slowly and smoothly. One full second from start to end, is about the right speed. This allows the case lube to flow. If you get hydraulic dents, try a little less lube and/or pull the press handle slower.

4. Be sure to clean all of the case lube off before loading and shooting.

Care

1. It is designed with extremely tight tolerances. Treat it with care. Don't use pliers, channel locks, vice grips etc. on it as these may damage precision fit parts.

2. Use plenty of case lube.

3. Some brass may buildup inside the die. This is usually due to insufficient case lube. The brass buildup can be removed with a copper solvent on a patch (don't use a brush). Use the same care you would use on your match quality barrel. After cleaning, remove the solvent completely and oil the inside of the die to prevent corrosion from the solvent.