

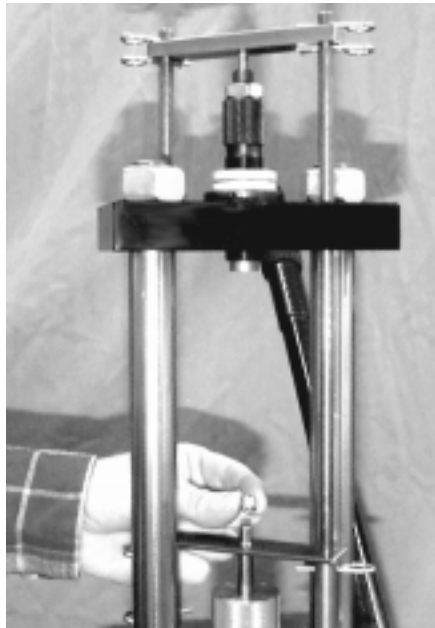


ET-1-H Jacket Trim Die

The Corbin ET-1-H Expand/Trim die fits the Corbin MegaMite, Hydro Junior, or Hydro Press. It trims jackets of a given caliber to precise, shorter lengths with a clean, even beveled mouth in one stroke.

The ET-1-H is best used with the optional Corbin SK-1-H Stripper Kit, which automatically strips the trimmed portion of the jacket from the punch, and ejects the jacket, on the down stroke of the press. The Stripper Kit is universal for all ET-1-H trimmer dies, with the exception of the stripper plate, which is different for each caliber. One stripper plate comes with the kit; others may be ordered for additional calibers of jacket trim dies.

- 1) Screw the punch into the press ram, and screw the die into the press head as shown.
- 2) Raise the ram of the press until it reaches the maximum upward travel. On Corbin hydraulic presses, raise the top sensor so that the ram is stopped by the drive cylinder limit, then lower the sensor so its LED just comes on at this position. Put the punch and the die into the press. It is very important not to force the punch into the die face; it must be pushed only so far as to pinch off the jacket. With the ram in the upmost position, adjust the die downward so the punch and the die just touch. Move the ram down for the next step.
- 3) Install the stripper kit, which has its own instruction sheet. The kit includes a heavy ejection bar and a thin stripper plate. The stripper plate goes over the punch. The ejection bar is locked in place by four spring pins, two per side, into the long rods of the stripper kit.



- 4) Get a small amount of Corbin Swage Lube on your fingertip and wipe the punch with it. Then put a jacket over the end of the punch, and raise the ram. The jacket should enter the die mouth. The portion of the jacket projecting from the die should be crushed and then gently nipped off by the pressure of the punch against the die face.

It is very important that the clearance be set properly; do not adjust the die any further down toward the ram than is necessary to just clip off the surplus jacket material. Otherwise you may destroy the punch or the die.

- 5) Lower the ram and the jacket will be ejected while the surplus material is pushed off the punch. You can catch the jacket in one hand, and then after the press stops moving, pick up the surplus trim and discard it. Repeat steps four and five until all the jackets are trimmed to the desired length.

Warning: The cut jacket edges are sharp. Be careful handling them. If the trimmed jacket material is too sharp to handle safely by hand, use a pair of needle nose pliers or tweezers to pull the remains off the punch.

Caution: Do not use the wrong punch with a given caliber of die. Each die and punch set is made for proper trimming of a certain caliber of jacket and may be damaged if used incorrectly.

Note: Do not attempt to trim jackets that are significantly thicker than the samples for which the set was built. If there is any doubt, send sample jackets to Corbin, along with your die and punch, so we can test them at our risk rather than yours. Do not grind, turn, polish, or attempt to modify the die or punch: if you feel there is a problem, call for an RMA number and return it with a clear explanation of the problem and samples of the jackets. Copper tubing, steel, brass, or jackets other than those for which the set was designed and tested should not be used with this tool. Doing so may destroy it and the warranty.

