# INSTRUCTIONS FOR USING THE 22 FLASH DIES



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*Thank you for choosing a Silma product. The dies now in your possession represent the best that modern technology allows in the field of precision mechanics. These are machined parts, thermally and chemically treated to be anti-wear and anti-oxidation. They can be cleaned and lightly lubricated.*

*The first die, 22NECK, is used to resize the case neck; the second, 22SEATER, is to seat the bullet, completing the production cycle.*

**A PREMISE IS NEVERTHELESS NECESSARY**

Home assembly of ammunition requires caution and skill: the indications provided in this publication represent an aid, not a complete teaching tool. We therefore advise those who are undertaking this activity for the first time to prepare themselves adequately by attending specific courses and studying specialized publications, namely those referable to the manufacturers of the components used. Helpful can be the assistance of the National Proof House of Gardone V.T. (Banco Nazionale di Prova di Gardone V.T.), which is the reference body regarding the testing of weapon systems and ammunition, together with the consultation of C.I.P. documentation.

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ADJUSTMENT SEQUENCE 1st DIE (Neck - knurled finish)

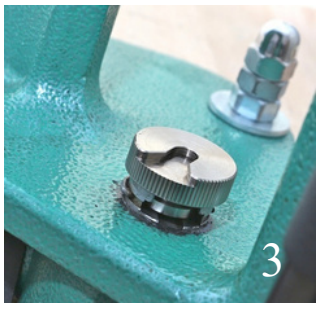
1. Insert the shell holder onto the sliding ram (fig. 3).
2. Retract the micro-adjustment set screw with a 5mm Allen key (fig. 5).
3. Loosen the lock nut (fig. 4) and position it at the top end of the die.
4. Raise the ram to the end-of-stroke position.
5. Lower the die until it makes contact with the shell holder.
6. Unscrew the die by a fraction of a turn* and lock it with the lock nut.
7. Lower the ram and insert an externally lubricated case into the shell holder.
8. Raise the ram.
9. Screw in the micro-adjustment set screw (fig. 5) until the desired working depth is reached (Recommended 2.5mm).

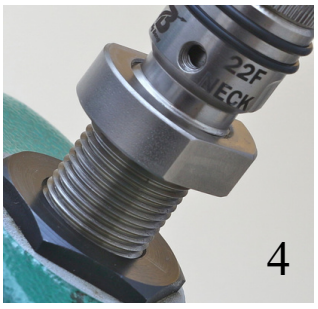
**Note**: Step n° 9 must be done gradually, performing tests.

ADJUSTMENT SEQUENCE 2nd DIE (SEATER - smooth finish)

1. Retract the micro-adjustment set screw by unscrewing it with a 5mm Allen key (fig. 5).
2. Loosen the lock nut (fig. 4) and position it at the top end of the die.
3. Raise the ram to the end-of-stroke position.
4. Lower the die until it makes contact with the shell holder.
5. Raise the die by a fraction of a turn* and lock it with the lock nut.
6. Insert the case, filled with propellant, into the shell holder.
7. Prepare the bullet in the case for seating with good accuracy.
8. Raise the ram to the end of its stroke.
9. Screw in the micro-adjustment set screw (fig. 5) gradually, until the desired seating depth is reached (O.A.L: 26.5 to 26.7mm).

**Note** 2: To perform the resizing accurately, it is good practice to perform multiple resizing operations on the same case, rotating it 90° around its longitudinal axis and keeping it in lateral contact with the shell holder. This circumstance is caused by the fact that industrially produced cal. 22LR cases often have orthogonality and concentricity problems. The case heads often have dimensional and flatness issues, therefore we recommend the use of special calipers or gauges to inspect and, consequently, select them. It is recommended to perform measurements as accurately and repeatedly as possible, to ensure compliance with the pre-established work plans.


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