

Casting Instructions



Use the following instructions:

- ✓ Clean and de-grease your bullet mould with a good solvent. An aerosol cleaner/degreaser such as Gun Scrubber from Birchwood Casey or an automotive brake and parts cleaner will work well. Completely remove all traces of oil or grease.
- ✓ Bullet moulds require adequate lubrication. Use a good mould prep or mould release containing graphite completely covering the mould inside and out, especially the cavity, and the top and bottom sprue plates. Lubricate the hinge of the sprue plates using a small amount of paraffin wax as you cast. Just a light touch of wax is all it takes. The use of mould prep (release agent) and wax lube in the single greatest asset in keeping your mould working correctly, without galling, and completely free of any build-up of lead deposits. An aerosol Moly lube also works well.
- ✓ The bullet mould must be hot enough to prevent immediate solidification of the molten alloy. The bullet mould must keep the sprue molten for 1 to 2 seconds. This allows the alloy to completely fill the bullet cavity, consistently from bullet to bullet.
- ✓ The alloy must be hot enough to flow well. A hot alloy will flow better than a cold alloy. This usually requires 700 to 800 degrees Fahrenheit for most alloys used for casting bullets.
- ✓ The alloy must be fluxed often and regularly to keep oxidized alloy to a minimum. The use of paraffin wax as a flux every 20 to 40 bullets will keep the alloy clean and flowing well.
- ✓ All bullet moulds are designed as gravity - fill moulds. For best results, fill the mould using a large capacity dipper such as made by RCBS.

In summary, the factors that contribute to casting high quality bullets consistently over a period of time are as follows:

- THE ALLOY MUST BE HOT ENOUGH AND CLEAN AND FREE OF IMPURITIES.
- THE MOULD MUST BE HOT ENOUGH, AND UNIFORMLY HEATED.
- THE MOULD MUST BE PROPERLY LUBRICATED.