

K&M CASE NECK EXPANDER

Instructions for Use

- NEVER use this tool in a cartridge with a live primer.
- F/L size your brass with the expander ball removed.
- For general neck turning when no doughnut is present run the mandrel through the neck/shoulder junction but stop before the case mouth touches the press adapter.
- For doughnut removal with the carbide cutting pilot stop the mandrel stroke just before the straight portion of the mandrel touches the doughnut.
- Adjust the stop screw to bottom on the case web for your intended final expansion position or use the Window Riser which allows the stop screw to be removed.
- If using a custom ground mandrel for setting final neck tension, first F/L size with no expander ball or select a sizing bushing that leaves the neck inside diameter 0.002"-0.003" smaller than the intended final size before expanding.



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