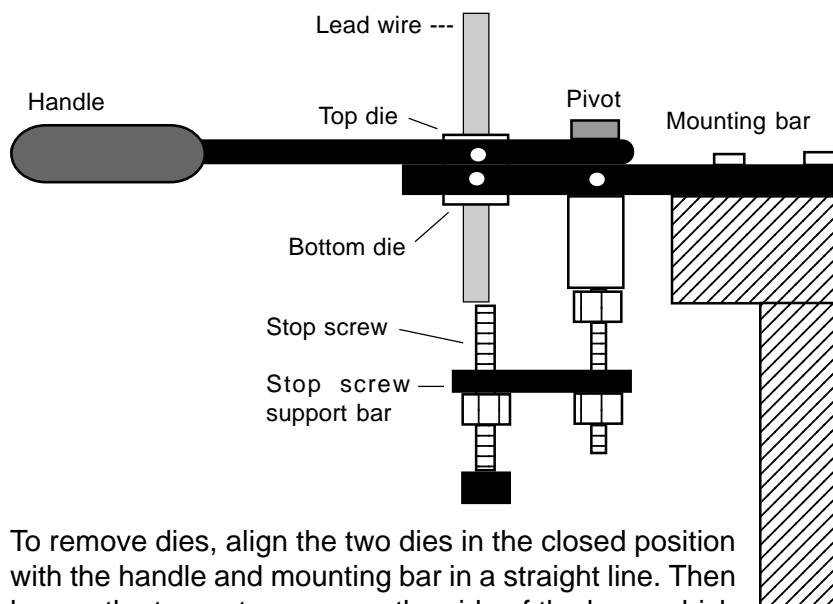


# CORBIN<sup>®</sup>

## PCS-1 Precision Core Cutter



To remove dies, align the two dies in the closed position with the handle and mounting bar in a straight line. Then loosen the two set screws on the side of the bars, which secure the dies. Push the dies out. If they do not move easily, you can use an old cartridge case as a drift pin to drive them out.

To install new dies, move the handle so about half the die hole is covered by the mounting bar (open position). Then, using the surface of the opposite bar as a stop, press the dies into place with the sharp edge of the die holes together, facing inward toward each other. One side of each die is chamfered. Make sure that the two chamfered edges of the die holes face away from each other, one pointed up and one pointed down. The two sharp edges do the cutting. While pressing firmly on the die, secure the set screw to hold it in place. Do this with both dies. If you install the dies with the handle and mounting bar in line, you may lock up the tool by allowing one die to slip past the junction and into the opposite die hole!

The PCS-1 core cutter is used for wire from .100 to .365 inch diameter, with standard dies of .185, .218, .247, .312, .340, and .365. The PCS-2 magnum core cutter can be used with sizes .185 to .500 inch. Custom dies are made for this tool. Standard sizes are .430, .390, .365, .340, and .312. The minimum core length is 1/2-inch.

Corbin Core Cutters are designed to mount to your loading bench, or to be fastened to a short piece of 2 X 4 wood, which can then be clamped in a vise on your bench. A length of lead wire can be fed down, through the top cutter die, through the bottom cutter die, and pressed against the adjustable stop screw to determine the length and thus the weight of cut cores.

For best results, the size of interchangeable die insert should be slightly larger than the wire, so that the lead wire can feed easily under its own weight. The assembly of the stop screw can be changed to increase the maximum length, or to decrease the minimum length, by positioning the locking nut on the opposite side of the stop screw support bar.



Large adjustments in length (and thus, weight) of the cores can be made by screwing the support bar up or down and then locking it in place by securing the locking nut against it. Fine adjustments are made by turning the stop screw.

The lower cutter die can be a size larger than the top one, for faster production. Lead wire always cuts with a slight shear angle, so there will be a slight variation in weight depending on where the angle on the end of the wire rests against the stop pin. Therefore, for easier operation, offset the stop pin slightly from center, so it is farther off center away from the direction that the cut lead piece will be moved. This way, the cut piece does not have to drag across the entire top of the stop screw when it is cut.