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Lee Precision MOLD DC C277-135-RF

Lee Precision Reloading Mold DC C277-135-RF User Manual

Model: MOLD DC C277-135-RF (Part No. 90454)
Brand: Lee Precision

Introduction

This manual provides comprehensive instructions for the safe and effective use of your Lee Precision Double Cavity Reloading Mold, model C277-135-RF. This mold is designed to produce .277 diameter, 135 grain gas-checked bullets with a flat nose, suitable for various reloading applications. Please read this manual thoroughly before operating the mold to ensure proper function and safety.

Safety Information

WARNING: Casting lead can expose you to lead, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warnings.ca.gov.

- Always wear appropriate personal protective equipment (PPE), including heat-resistant gloves, eye protection, and a respirator, when handling molten lead.
- Work in a well-ventilated area to minimize exposure to lead fumes.
- Keep children and pets away from the casting area.
- Ensure your casting pot and mold are stable and on a non-flammable surface.
- Never add water to molten lead.
- Allow the mold and cast bullets to cool completely before handling without gloves.

Product Overview

The Lee Precision Double Cavity Mold C277-135-RF is a precision tool for bullet casting. It features two cavities, allowing for efficient production of bullets. The mold is constructed for durability and includes handles for ease of use.



Figure 1: Lee Precision Double Cavity Reloading Mold (Model C277-135-RF). This image shows the aluminum mold block with two bullet cavities, attached to a steel sprue plate and wooden handles. The handles provide a comfortable grip for manipulating the mold during casting.



Figure 2: Example of a Cast Bullet. This image displays a detailed rendering of the .277 diameter, 135 grain bullet produced by this mold, featuring a flat nose and grooves for a gas check at the base.

Setup

1. **Clean the Mold:** Before first use, thoroughly clean the mold cavities and sprue plate with a degreaser (e.g., brake cleaner or rubbing alcohol) to remove any manufacturing oils or residues. Allow to dry completely.
2. **Prepare Lead Alloy:** Use a clean, appropriate lead alloy for casting bullets. Ensure the lead is free of impurities and moisture.
3. **Heat the Mold:** It is crucial to pre-heat the mold before casting. This can be done by placing it on a hot plate, in a dedicated mold oven, or by dipping it into the molten lead for a few minutes. A properly heated mold will produce shiny, well-formed bullets.
4. **Set up Casting Area:** Ensure your casting area is well-ventilated, stable, and free from flammable materials. Have a suitable container (e.g., a bucket of water or a damp cloth) ready for cooling cast bullets, if desired.

Operating Instructions

1. **Fill the Mold:** With the mold closed and the sprue plate in position, carefully pour molten lead into the sprue hole

until both cavities are completely filled and a small puddle forms on top of the sprue plate.

2. **Allow to Solidify:** Wait a few seconds for the lead to solidify in the mold cavities. The sprue puddle will dull as it cools.
3. **Cut the Sprue:** Once the lead has solidified, firmly and quickly open the sprue plate by striking the sprue plate handle with a wooden dowel or a soft hammer. The sprue should cleanly shear off.
4. **Open the Mold:** Open the mold handles to release the cast bullets. The bullets should drop freely from the cavities. If they stick, the mold may not be hot enough, or there might be a burr in the cavity.
5. **Cool the Bullets:** Allow the cast bullets to cool. They can be dropped into a bucket of water for rapid cooling (water dropping) or allowed to air cool on a heat-resistant surface.
6. **Repeat:** Close the mold, reposition the sprue plate, and repeat the process for subsequent bullets.

Maintenance

- **Cleaning:** After each casting session, allow the mold to cool. Clean any lead residue or carbon buildup from the mold cavities and sprue plate using a soft brush (e.g., a toothbrush) or a wooden pick. Avoid using steel brushes or abrasive materials that could damage the mold surface.
- **Lubrication:** Occasionally, apply a very thin coat of high-temperature lubricant (e.g., a dry film lubricant like graphite or a specialized mold release agent) to the sprue plate pivot and screw to ensure smooth operation. Avoid getting lubricant in the bullet cavities.
- **Storage:** Store the mold in a dry place to prevent rust or corrosion. A light coat of rust preventative oil on steel components (like the sprue plate screw) is recommended for long-term storage.
- **Inspection:** Periodically inspect the mold for any signs of wear, damage, or lead buildup that could affect bullet quality.

Troubleshooting

Problem	Possible Cause	Solution
Wrinkled or frosty bullets	Mold is too cold; lead is too cold.	Pre-heat mold more thoroughly; increase lead pot temperature.
Bullets sticking in cavities	Mold is too cold; cavities are dirty; burrs in cavities.	Heat mold; clean cavities; inspect for and carefully remove burrs.
Incomplete fill (rounded bases, missing details)	Lead is too cold; pouring too slowly; air trapped in cavities.	Increase lead temperature; pour faster and consistently; ensure mold vents are clear.
Sprue not cutting cleanly	Sprue plate too loose/tight; lead not fully solidified; sprue plate dirty.	Adjust sprue plate screw; wait longer for solidification; clean sprue plate.

Specifications

- **Model Name:** MOLD DC C277-135-RF
- **Part Number:** 90454
- **Bullet Diameter:** .277 inches
- **Bullet Weight:** 135 grains
- **Bullet Type:** Gas Checked, Round Flat Nose

- **Cavities:** Double Cavity
- **Included Components:** Mold block, sprue plate, handles
- **Material:** Aluminum mold block, steel sprue plate, wooden handles
- **Approximate Item Dimensions (LxWxH):** 10.63 x 2.56 x 2 inches
- **Approximate Package Weight:** 0.39 Kilograms (0.86 lbs)
- **Manufacturer:** ACK LLC (for Lee Precision)
- **Country of Origin:** Made in USA

Warranty and Support

Specific warranty information for this product is not provided in the available documentation. For warranty claims, technical support, or replacement parts, please contact Lee Precision directly through their official website or authorized dealers.

Lee Precision Contact Information: Please refer to the official Lee Precision website for the most current contact details and support resources.

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