

Choosing Neck expander mandrel >
1. Measure bullet diameter
2. Subtract neck interference fit you want
3. Add another .001 for spring back
4. This gives you your final Expander mandrel size

Be aware that all brass is not the same as there may be different spring back amounts from one brand to another. This is just a basic formula. Also some brass may complete it’s spring back instantly while others may have to sit overnight.

Calculator for figuring Expander Mandrel

Bullet Diameter	Subtract amount of Interference fit you want from bullet diameter)example: .002)	Result	Result with adding another .001 for spring back
0.2425	0.0020	(0.2405)	(0.2415)
		0.0000	(0.0010)
		0.0000	(0.0010)
		0.0000	(0.0010)
		0.0000	(0.0010)
		0.0000	(0.0010)
		0.0000	(0.0010)
		0.0000	(0.0010)

Choosing Neck/Shoulder bushing >
1. Brass neck wall thickness times 2
2. Bullet diameter
3. Total
4. Subtract another .005
5. Subtract another .001 for spring back
6. This gives you your final neck/shoulder bushing

Calculator for figuring Neck/Shoulder bushing

1. Neck wall thickness (times 2)	2. Bullet diameter	3. Total	4. Subtract .005	5. Subtract another .001 for spring back	Shoulder/Neck bushing size
0.0180	0.2425	0.2605	0.2555	0.2545	0.2545
		0.0000	(0.0050)	(0.0060)	(0.0060)
		0.0000	(0.0050)	(0.0060)	(0.0060)
		0.0000	(0.0050)	(0.0060)	(0.0060)
		0.0000	(0.0050)	(0.0060)	(0.0060)
		0.0000	(0.0050)	(0.0060)	(0.0060)
		0.0000	(0.0050)	(0.0060)	(0.0060)
		0.0000	(0.0050)	(0.0060)	(0.0060)