The new Lee Drive Key slug is a modern slug for modern components. The ability to use efficient, good sealing trap wads requires new load data. If you own a Load-All, you are ready to load—simply select the correct bushing. If you own other brands of reloading equipment — you're in luck. We've included a powder dipper.

- ★ You are responsible for the safety of your loads.
- ★ Be certain you completely understand the use of this data and your tool.
- ★ Be certain filler wad (if used) is placed under the slug.
- ★ Be certain you are using the correct bushing for the slug weight and powder type.
- ★ Be certain you are using the correct dipper. The included dipper is not usable with all the listed loads.
- ★ The dipper must be filled and struck level.
- ★ Be certain you weigh maximum charges and the components used exactly as listed, including shell, primer and wad brand. If you substitute components, reduce charge 10%.

If you can't find filler wads locally, contact Ballistic Products, Inc., 20015 75th Avenue North, Corcoran MN 55340 I-888-273-5623

SHELL TYPE	PRIMER TYPE	WADS	POWDER TYPE	MAX. WEIGHED CHARGE	7/8 OZ.SLUG	VELOCITY	LARGEST DIPPER	LARGEST LOAD-ALL BUSHING
FEDERAL GOLD MEDAL	FED 209A/WIN 209	ACTIV TG-30+.135 FILLER	ACCURATE #5	42.0 gr.	LEE 7/8 oz.	1638 f/s	2.5cc	.155
WIN AA	WIN 209	ACTIV TG-30	ACCURATE #5	40.0 gr.	LEE 7/8 oz.	1608 f/s	2.2cc	.148
ACTIV	WIN 209	ACTIV TG-30+.135 FILLER	ACCURATE #5	40.0 gr.	LEE 7/8 oz.	1593 f/s	2.2cc	.148
FEDERAL GOLD MEDAL	FED 209A	FED 12S0	HODGDON UNIVERSAL	30.0 gr.	LEE 7/8 oz.	1550 f/s	3.1cc	.198
FEDERAL GOLD MEDAL	FED 209A/WIN 209	FED 12S0	HODGDON HS6	42.0 gr.	LEE 7/8 oz.	1550 f/s	2.8cc	.180
REM PREMIER/NITRO 27	WIN 209	WAA 12L	HODGDON HS6	38.0 gr.	LEE 7/8 oz.	1550 f/s	2.5cc	.163
WIN AA	WIN 209	WAA 12	HODGDON HS6	38.0 gr.	LEE 7/8 oz.	1550 f/s	2.5cc	.163
FEDERAL GOLD MEDAL	WIN 209	ACTIV TG-30+.135 FILLER	ACC #2 IMP	25.5 gr.	LEE 7/8 oz.	1529 f/s	1.9cc	.128
ACTIV	WIN 209	ACTIV TG-30+.135 FILLER	ACC #2 IMP	25.5 gr.	LEE 7/8 oz.	1501 f/s	1.9cc	.128
WIN AA	WIN 209	ACTIV TG-30	ACC #2 IMP	25.0 gr.	LEE 7/8 oz.	1492 f/s	1.9cc	.128
REM PREMIER STS	WIN 209	ACTIV TG-30	ACC #2 IMP	22.5 gr	LEE 7/8 oz.	1466 f/s	1.6cc	.110
					1.0 OZ. SLUG			
FEDERAL GOLD MEDAL	FED 209A	WAA12	BLUE DOT	49.0 gr	LEE 1 oz.	1690 f/s	4.0 cc	none
REM PREMIER	WIN 209	WAA 12	BLUE DOT	49.0 gr	LEE 1 oz.	1673 f/s	4.0cc	none
WIN AA	WIN 209	WAA 12	HERCO	36.0 gr.	LEE 1 oz.	1587 f/s	4.0cc	none
ACTIV	WIN 209	ACTIV TG-30	ACCURATE #5	40.0 gr.	LEE 1 oz.	1553 f/s	2.2cc	.148
FEDERAL GOLD MEDAL	FED 209A	FED 12S3	HODGDON HS6	40.0 gr.	LEE 1 oz.	1550 f/s	2.8cc	.171
REM PREMIER / WIN AA	WIN 209	WAA 12SL	ACCURATE #5	38.5 gr.	LEE 1 oz.	1535 f/s	2.2cc	.141
FEDERAL GOLD MEDAL	FED 209A/WIN 209	WAA 12	HERCO	34.0 gr.	LEE 1 oz.	1538 f/s	3.7cc	none
FEDERAL GOLD MEDAL	WIN 209	FED 12S3	ACCURATE #5	41.5 gr.	LEE 1 oz.	1529 f/s	2.5cc	.155
REM PREMIER	FED 209A	WAA 12	HERCO	34.0 gr.	LEE 1 oz.	1522 f/s	3.7cc	none
WIN AA	WIN 209	WAA 12F 114	HODGDON HS6	36.0 gr.	LEE 1 oz.	1500 f/s	2.5cc	.155
FEDERAL GOLD MEDAL	WIN 209A	FED 12S3	HODGDON UNIVERSAL	28.0 gr.	LEE 1 oz.	1450 f/s	2.8cc	.180
REM PREMIER/NITRO 27	WIN 209	WAA 12SL	HODGDON HS6	36.0 gr.	LEE 1 oz.	1450 f/s	2.5cc	.155.

An assortment of good load data is provided. Most of the loads can be assembled with little fuss. Some of the 7/8 oz. loads do require a filler. If you are using other slug data, be sure to reduce the charge. Modern trap wads and shells will generate higher pressures than with the old nitro card and fiber wads. Some experimentation may be required to find the perfect combination of components that will give a good crimp. The object is to find a combination of powder and wad that puts the loaded slug at about 7/16 of an inch from the end of the uncrimped shell.

If the slug is pushed too far in the shell, the crimp will be concave with a hole in the middle. The fix is a longer wad, bulkier powder or a paper filler wad. A small amount of hole is acceptable provided the slug is tight in the shell and the crimp stays closed.

If the slug is not deep enough, the crimp will open up. The fix is a shorter wad or denser powder.

The important length to consider in a wad is the distance from the base of the wad to bottom of the shot cup—not overall length.

Mark loaded shell "slug" to prevent mixing with shot loads.

Guarantee

LEE RELOADING PRODUCTS are guaranteed not to wear out or break from normal use for two full years or they will be repaired or replaced at no charge if returned to the factory. Any Lee product of current manufacture, regardless of age or condition, will be reconditioned to new, including a new guarantee, if returned to the factory with payment equal to half the current retail price.

SM3529

LEE PRECISION, INC.
4275 Hwy U · Hartford WI 53027
www.leeprecision.com

COMPLETE INSTRUCTIONS

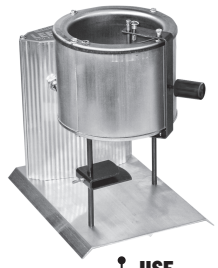
LEE SLUG MOLD

The Lee Slug Mold incorporates the exclusive "Drive Key" (patent rights reserved). The Drive Key doubles as an internal support for the wad. This eliminates the need to fill the base of the slug or require nitro cards in the shot cup. The Drive Key assures positive rotation of the slug in rifled barrels.

The slug was extensively tested with a wide variety of components. All the components tested produced safe results, usually always more accurate than factory loaded rifled slugs. We did find that the wad has a great effect on accuracy. Mediocre loads were transformed into spectacular loads by simply changing the wad.

Slugs MUST be cast from PURE LEAD. Other alloys, like wheel weights, will stick to the core pin and are nearly impossible to remove. Pure lead assures proper weight and good expansion.

HELPFUL HINTS



Always drop cast bullets onto a soft cloth of several thicknesses to prevent damage to the hot, relatively soft bullets.

Never drop bullet directly from the mold into the lead pot. Metal will splash onto the mold faces and prevent complete closure.

CAUTION Be extremely careful not to get any water into the molten lead. Even a small drop will explode into steam and violently spatter hot lead a surprising distance.

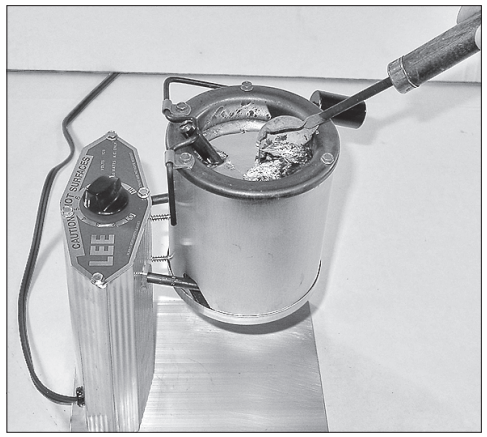
Glasses and gloves are recommended when handling molten metal.

USE PURE LEAD

WARNING

Melting lead and casting lead objects will expose you and others in the area to lead, which is known to cause birth defects, other reproductive harm and cancer.

11.11.14	Lee Precision, Inc.	4511	CHECKED BY
	BULLET MOLD BMI206		myh



Promptly and properly dispose the dross or oxides skimmed off the molten metal.

THE MELTER

The **Lee Pro Pot IV** (pictured) is the best method of melting your metal. Heat control is simple and the bottom pour spout is convenient and efficient for pouring.

REDUCING EXPOSURE

Lead contamination in the air, in dust, and on your skin is invisible. **Keep children and pregnant women away** during use and until clean up is complete. Risk can be reduced, but not eliminated with strong ventilation, washing hands immediately after use of these products before eating or smoking; and careful cleaning of surfaces and floors with disposable wipes after lead dust has had a chance to settle. Use a lead-specific cleaning agent with EDTA, or a high-phosphate detergent (like those for electric dishwashers) and bag wipes for disposal.

TAKE CARE OF YOUR MOLD

Your bullet mold is a precision-made tool. To preserve this built-in accuracy, it's necessary to lubricate it properly. Beeswax or Permatex® anti-seize lubricant, or equivalent must be applied to the mid-alignment pins and sprue pivot point screws. Lack of lubrication will cause the sprue plate to gall and blocks to mismatch. Damage could be irreparable. When storing for long periods, lightly oil steel parts to prevent rust.

PREPARING YOUR METAL

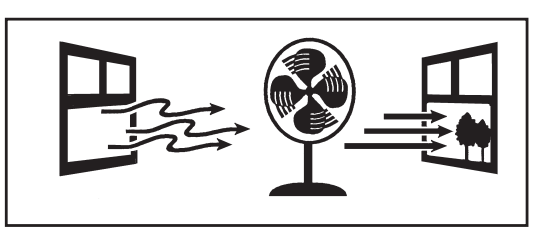
USE PURE LEAD. Wear safety glasses and gloves. After the metal has melted, it will have a grey scum on the top. Flux the metal. Do this by placing a small piece (size of a pea) of beeswax or paraffin into the molten metal and stir with ladle until there is nothing but dark grey powder floating on the metal. This should be removed with small ladle. Always flux the metal after adding to the pot, or if it needs it.

The smoke caused by fluxing your metal can be ignited with a match. This will keep your work area smoke-free.

IF THE SLUG STICKS TO THE CORE PIN

Look for nicks or burrs along the edge of the slot in the core pin. Lightly sanding with 150 grit (or finer) to dull the edge will help.

CAUTION Your bullet mold will be damaged and your bullets will be of poor quality unless lubricated as in STEP #4.



Use strong ventilation

IMPORTANT USE PURE LEAD

IMPORTANT

TO PREVENT DAMAGE TO YOUR MOLD OR POOR QUALITY BULLETS, FOLLOW THESE INSTRUCTIONS EXACTLY.

1 REMOVE ALL TRACES of oil. Wash mold block in white gas, lacquer thinner or strong detergent and water.

2 HOLD THE FLAME from a match in contact with the bullet cavity so it deposits a thin film of carbon in the cavity. This is important to eliminate the wrinkles.

3 PREHEAT MOLD. Dip corner of mold into molten metal and hold there for 30 seconds. If the lead solidifies on the mold block, it's an indication the mold is not hot enough.

HELPFUL HINTS

NEVER DROP BULLETS DIRECTLY from the mold into the lead pot. Metal will splash onto the mold faces and prevent complete closure.

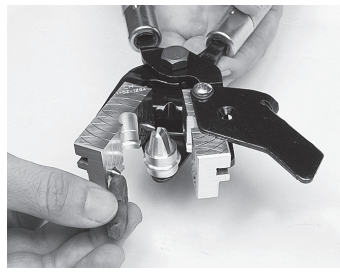
BE EXTREMELY CAREFUL not to get any water into the molten lead. Even a small drop will explode into steam and violently spatter hot lead a surprising distance.

GLASSES AND GLOVES ARE MANDATORY when handling molten metal.

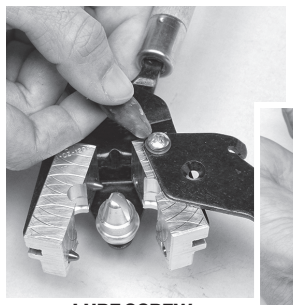
LOADS SHOULD NOT EXCEED 34000 PSI with plain base bullets. This means most pistol loads can be loaded without gas checks. **BULLETS FOR MODERN CARTRIDGES** will be stated size to plus .003 Most bullets from Lee molds can be used as cast. Sizing should not be considered as an absolute necessity. However, all cast bullets must be lubricated.

WHEN USING A HARD ALLOY like linotype multiply the listed bullet weight by .93 to obtain your approximate bullet weight.

4 LUBRICATE mold using beeswax or Permatex® anti-seize lubricant or equivalent. DO NOT USE Lee Liquid Alox as it will bake on the mold surface, preventing proper closure. Do not use paraffin wax as it does not provide adequate high temperature lube and tends to migrate to the cavities, causing wrinkled bullets.

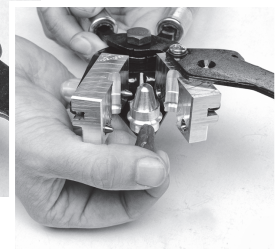


Lightly touch the preheated mold alignment pins and the sprue pivot point screw. It will instantly wick into the sprue plate pivot area and allow gall free operation of the sprue plate. As soon as you feel the sprue plate bind touch the now hot sprue pivot point with lube. **WARNING Do not start casting bullets until your mold has been lubricated.**

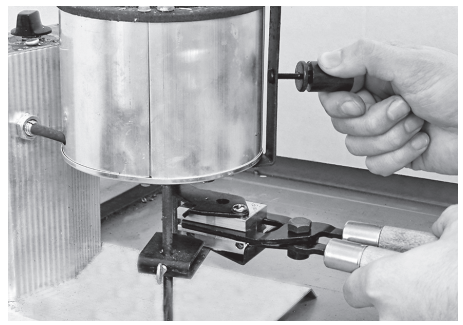


LUBE SCREW

LUBE CORE PIN

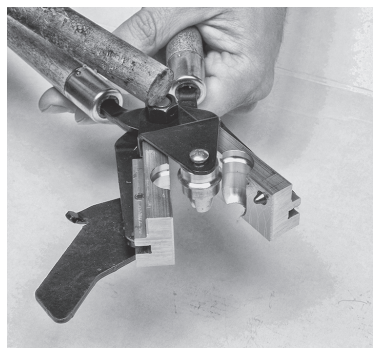


5 FILL MOLTEN METAL into mold block through sprue plate. Some bullet shapes tend to trap air at the nose. This can be eliminated by pouring the metal on the sprue plate chamfer instead of directly into the hole. This causes a swirling action that better fills the mold.



6 JUST BEFORE complete solidification of the metal in the sprue plate, strike the sprue plate with a wood dowel to cut the sprue. Move plate 90º to clear the base of the bullet.

7 OPEN HANDLES and tap handle hinge bolt to shake bullet onto soft cloth. If mold doesn't open easily, gently tap the aluminum block near the bottom while applying light pressure to open the blocks.



WARNING Do not strike core pin holder. If bullets do not drop free with a light tap on hinge bolt, heat corner of mold in molten metal

TROUBLESHOOTING

PROBLEM	REASON	REMEDY
Mold not filling out	Mold cold	Dip corner of mold in molten metal for 30 seconds
	Oil in mold	Wash blocks in solvent, white gas, lacquer thinner, etc.
	Metal not hot enough	Increase heat
	Metal needs fluxing	Flux the metal as per instructions
	Mold not smoked	See Step #2
Takes long for metal to solidify	Mold too hot	Touch mold to moistened cloth or sponge. **Caution:** Don't get water in the block or lead as it turns into steam instantly and the metal spatters with explosive force.
Mold does not line up or closes with difficulty	Needs lubrication	Lubricate your mold as in Step #4 above. Don't get any in the cavity
Mold does not release bullet	Burr at part line	Remove burr by scraping very lightly with a sharp knife inside the cavity