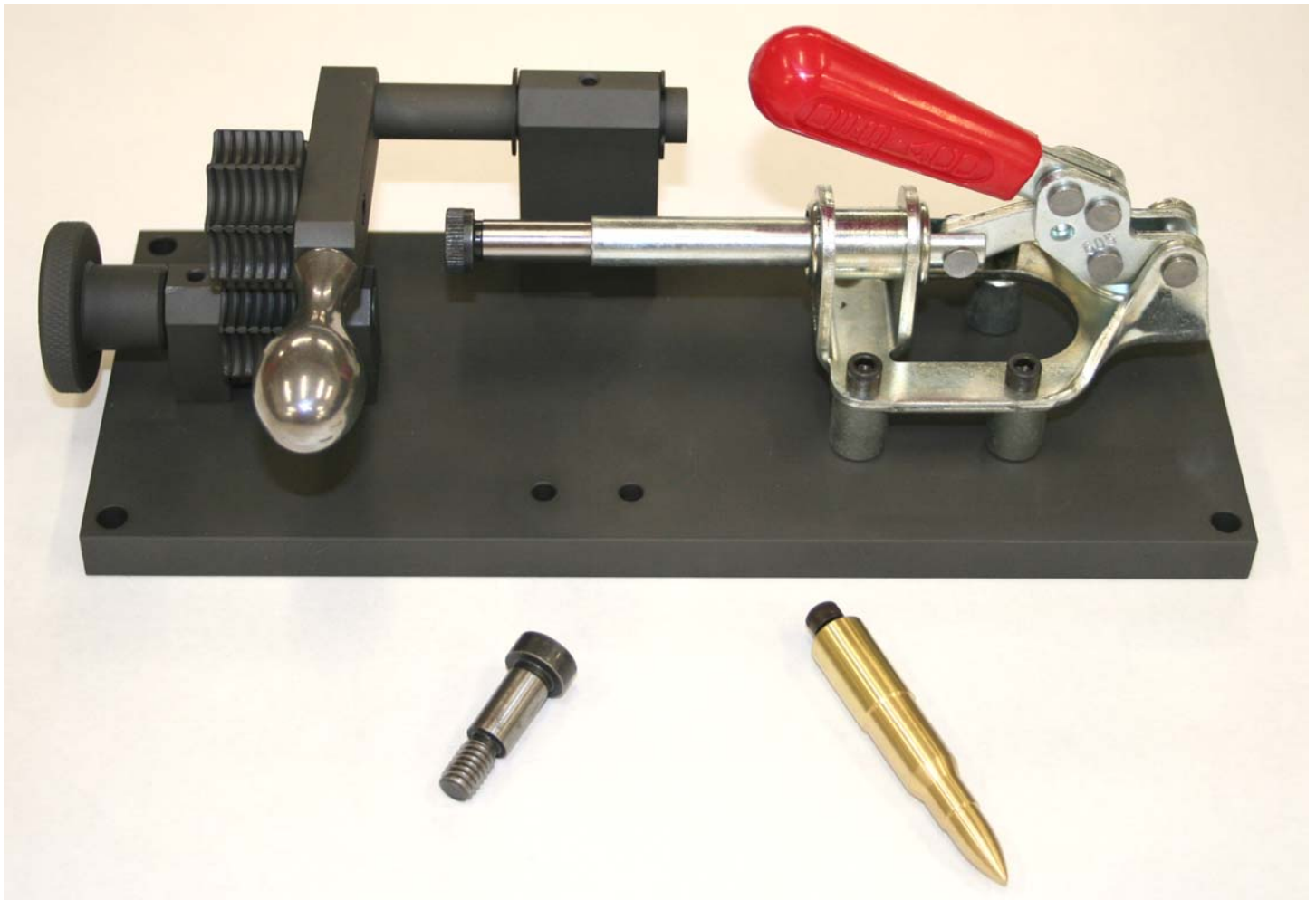




1919A4 Single Round Belt Loader



Thank you for your purchase of the JJ Custom, LLC Single Round Belt Loader.

The loader was designed as an economical solution to load cloth belts for the 1917/1919A4/M37 series of guns. Original belt filling machines are hard to find and expensive. While this loader is not as simple to use as the original belt filling machine, it will accomplish the task of seating cartridges in cloth belts. Two shoulder bolts are included to allow loading of .308/7.62 NATO, .30-06 and 8mm cartridges. The block that supports the arm can be moved to the opposite side of the loader for loading from the other direction, as the user prefers. A military-type manganese phosphate finish is applied to all metal surfaces except the plated push arm.

The belt loader works by seating partially started cartridges using star wheels with serrations that grip the belt and a push arm which seats the cartridge. Detents are machined into the face of the bottom wheel that engage a spring-loaded ball so it indexes in the proper position. While applying downward force to the handle the top wheel provides pressure to grip the belt. This allows the ram to seat the cartridge into the belt. Turning the hand wheel advances the belt for the next cartridge to be seated. Additional rounds are started and the process is repeated until the belt is fully loaded.

The block that supports the arm as well as the two blocks that support the axle of the bottom star wheel have oil holes to eliminate the need to disassemble the loader for lubrication. A one-year warranty is included with the loader as well as this detailed instructions with pictures of its use.

JJ Custom, LLC warrants the loader to be free from defects in material and workmanship for a period of one year from the original date of purchase.

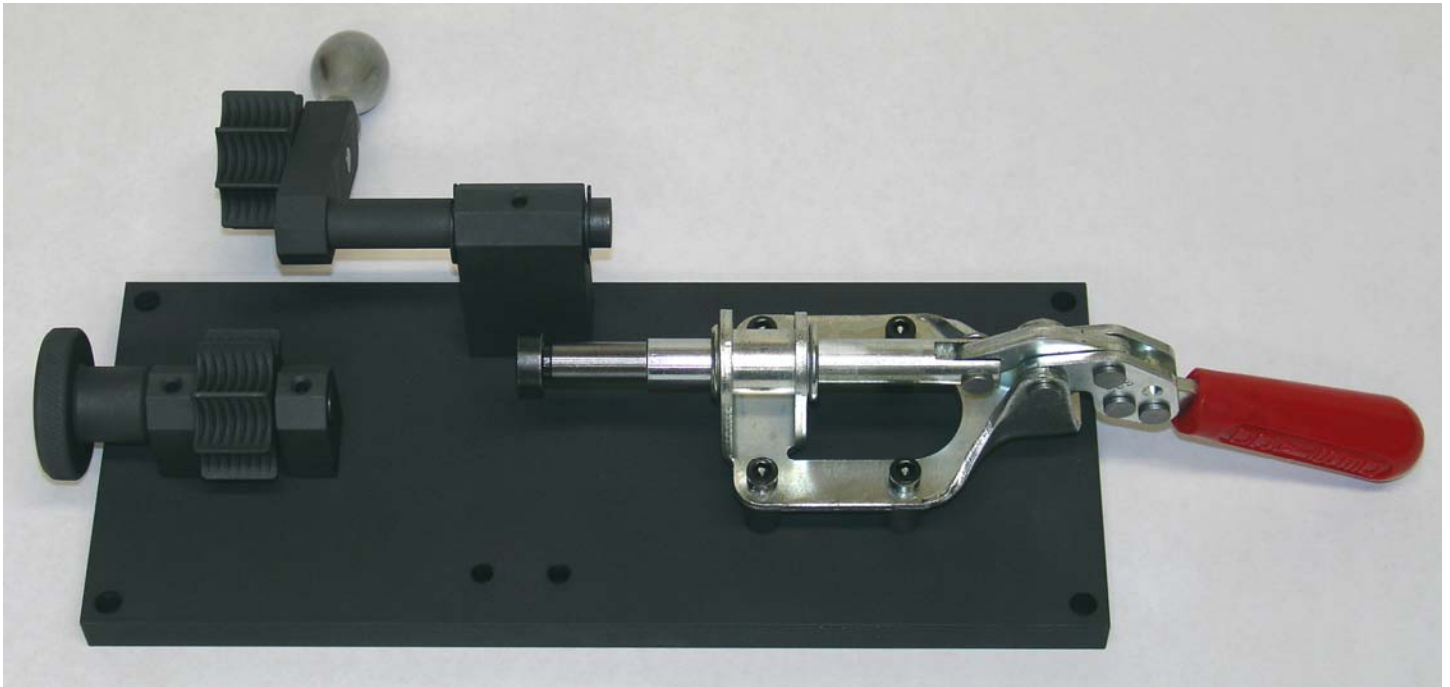
As with any operation which involves ammunition, wear safety glasses while using this loader. Never strike the rear of the cartridge and examine ammunition for primers that protrude beyond the face of the cartridge.

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Following is a brief description of the operation of the belt loader

Loading:

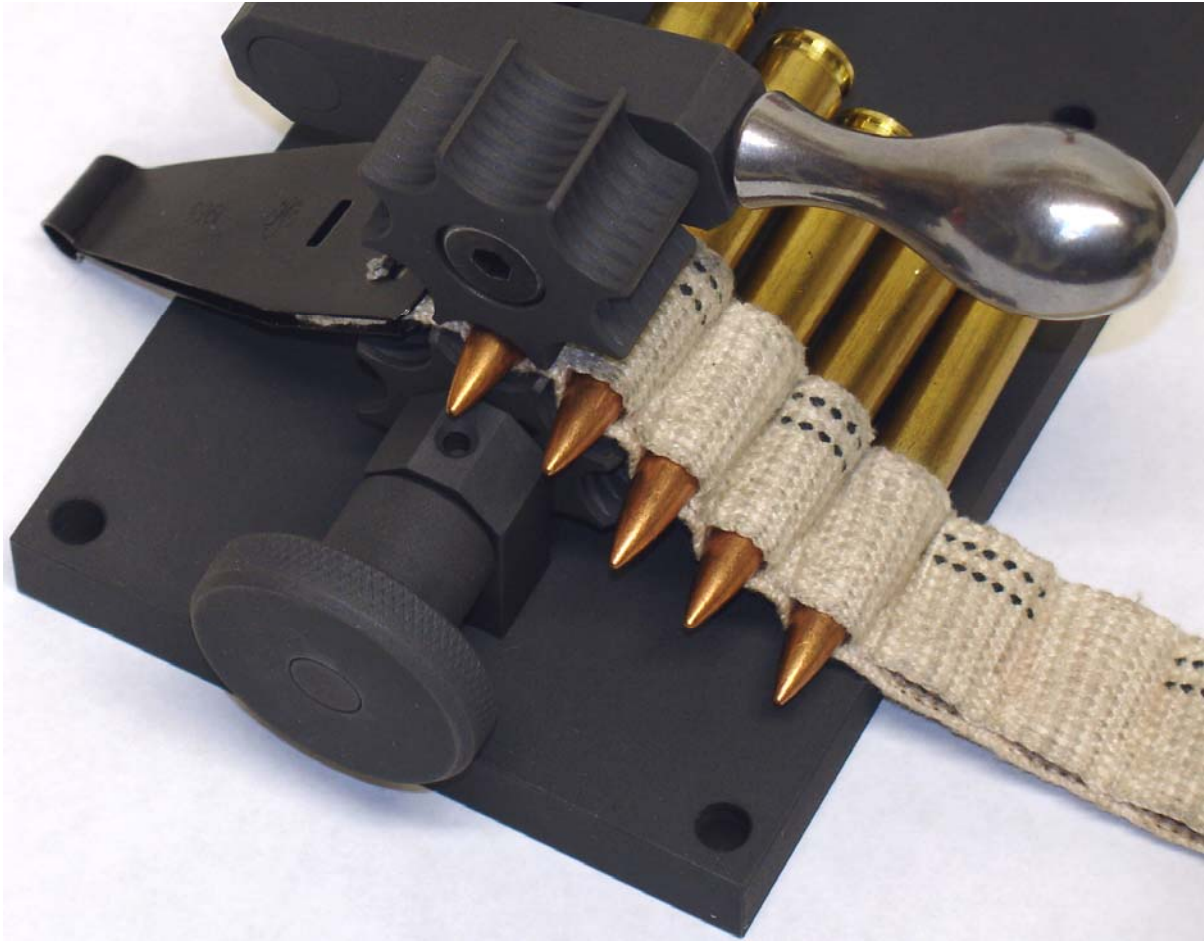
Swing the top arm up and away. Spin the hand wheel so that it is indexed in the aligned position. Swing ram handle to the rear:



Pre-feed the cartridges in the belt so they are started. Position first round in the top position of the wheel so that the front edge of the belt lines up with the front of the wheel:



Lower arm so that the cartridge is centered in the grooves of the wheels. Apply pressure to the handle while actuating the ram handle to push the ram forward thus pushing the round into the belt:



The cartridge is fully seated when the rim of the cartridge neck is even with the front of the belt.

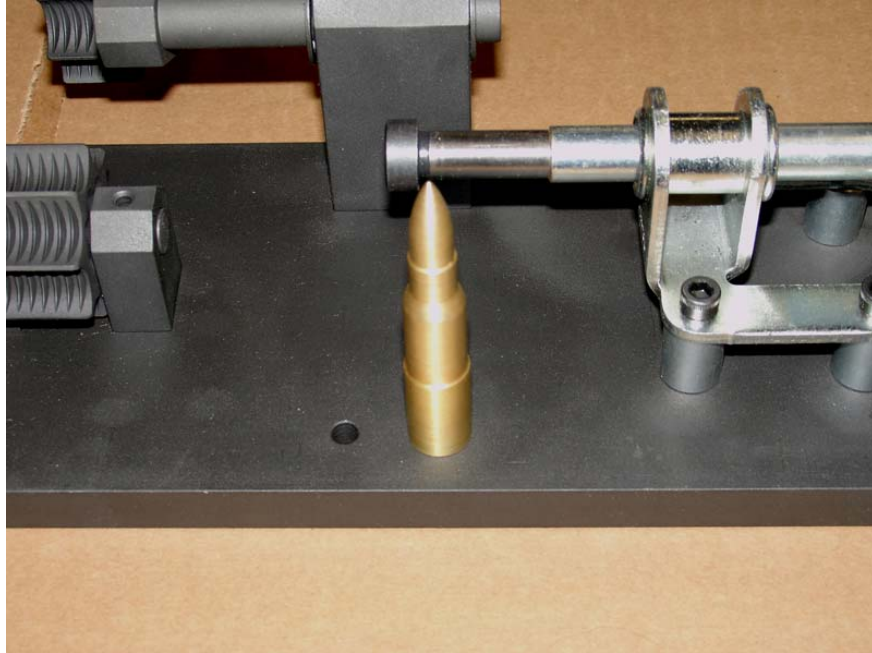


Swing ram handle to the rear position so it clears the base of the next cartridge to be loaded. While applying light pressure to the handle, rotate the hand wheel one position and continue to feed the remainder of the belt:

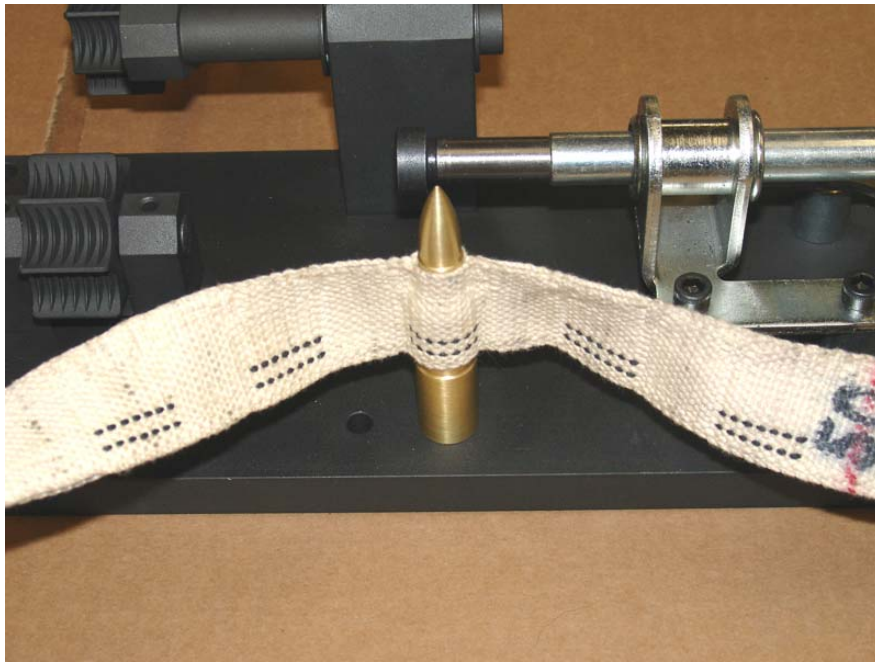


Loading of New Belts:

New belts are difficult to load, as the pockets are very tight. Attempting to load these belts may result in shifting or tearing. Prior to loading new belts, use the belt awl to stretch the pocket. The awl has the same dimensions as a 7.62 NATO cartridge and can be attached to the base of the loader using the supplied bolt. Insert the bolt through an unused arm pillar mount hole and tighten. Swing the ram handle back and the top wheel arm to the rear. This will allow room for working the belt.



Once attached, the belt can be work by alternatively pulling down on each side of the belt working it down onto the awl.



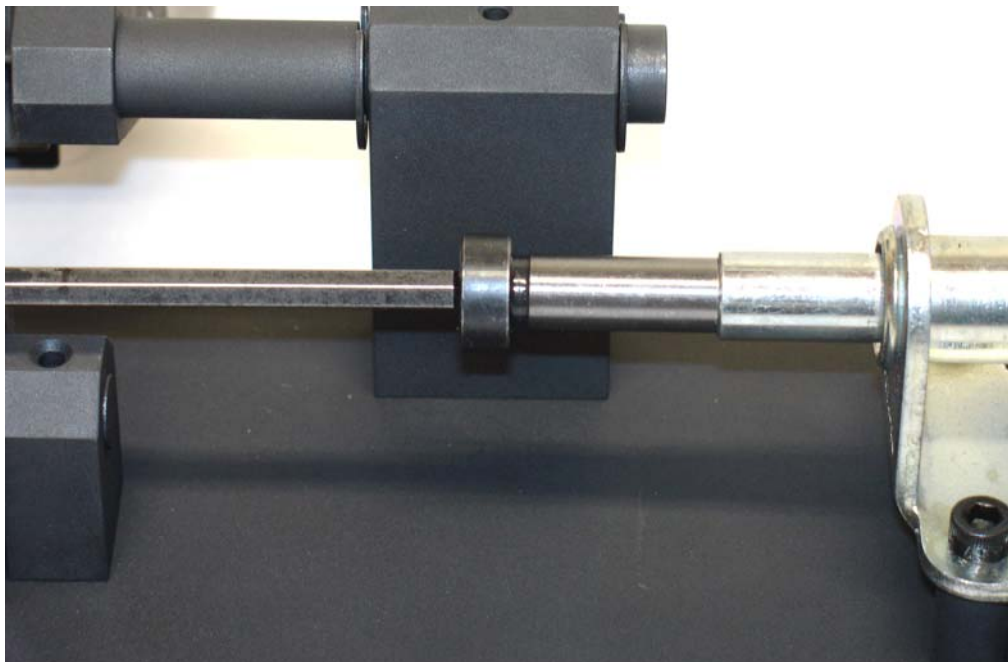
After the pocket has been stretched, moved to the next pocket until all pockets have been stretched. The belt can then be loaded as normal.

Changing Caliber:

Provided with the loader are two shoulder bolts to be installed on the ram. The $\frac{3}{4}$ " length bolt is for loading .30-06 and 8mm (**LEFT**). The 1" length bolt is for loading .308/7.62 NATO (**RIGHT**).



The bolt is replaced using a $\frac{3}{16}$ " allen wrench. Loosen and remove one shoulder bolt and install and tighten the replacement bolt:



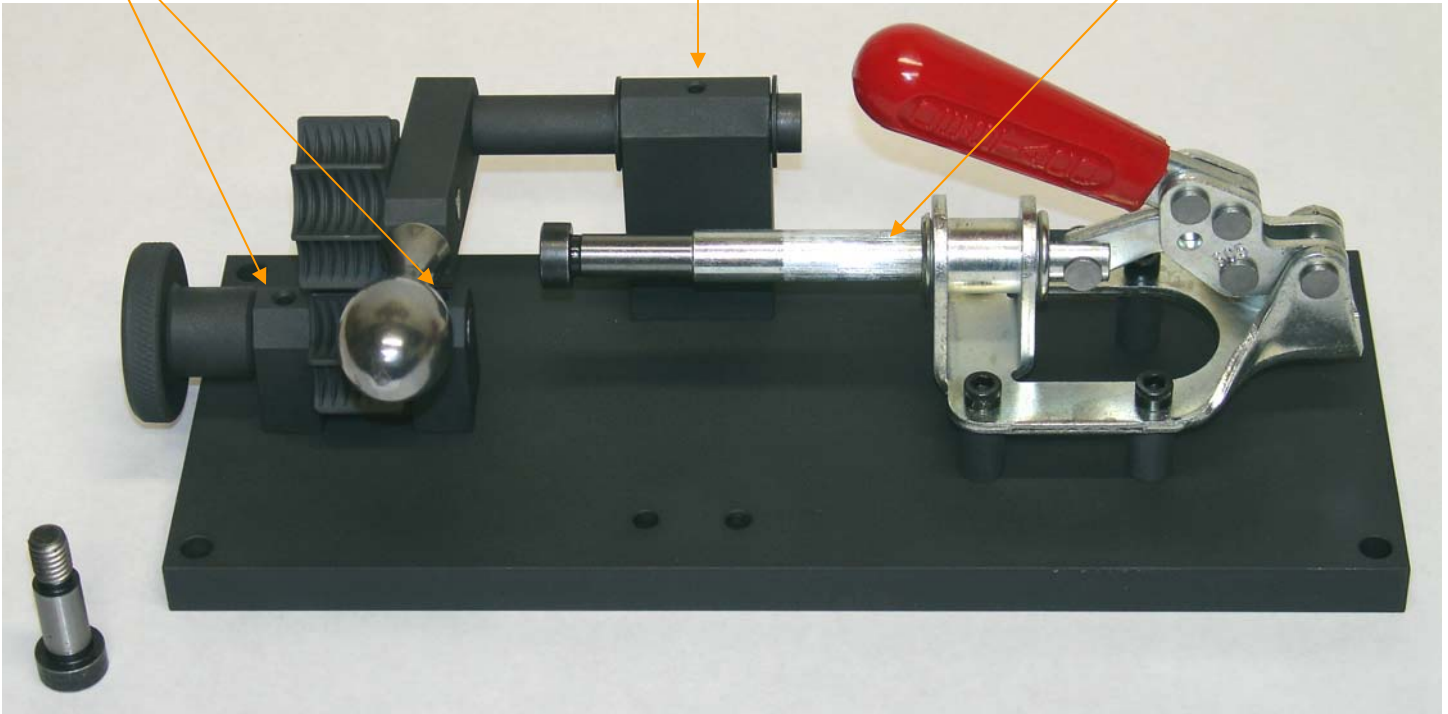
Care and maintenance:

The following points should be lubricated. Apply a light film of oil on the surface of the ram and grease for the axles through the lubrication holes. The loader ships with Tetra white grease applied to all axles.

Wheel Axles

Arm Axle

Ram



Addendum:

The star wheels have been redesigned to perform better at grabbing the belt and preventing slippage while seating the round. The new design is closer to the original 1918 Belt Filling Machine wheels:

