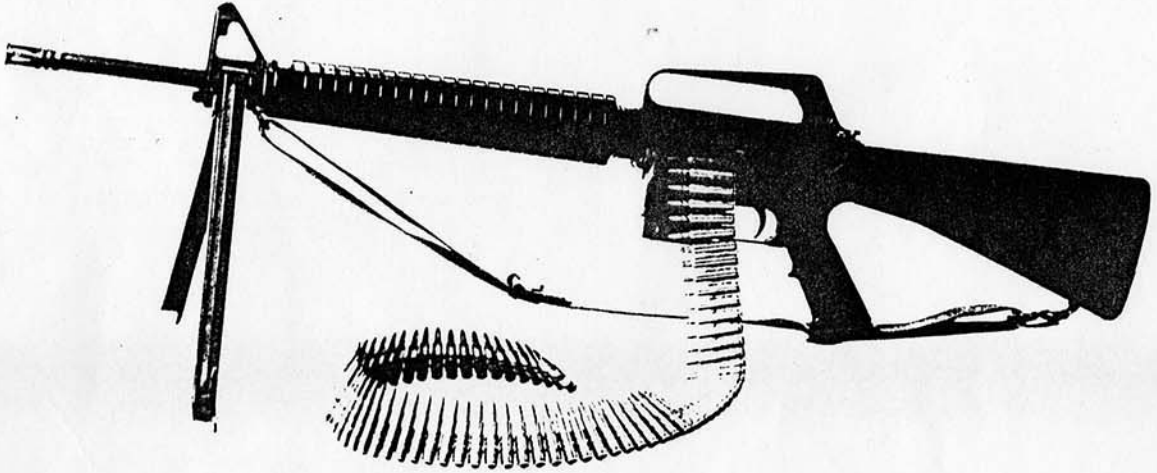


Jonathan Arthur Ciener

Class II Manufacturer



OPERATION AND MAINTENANCE OF THE BELT FEED AR15/M16 RIFLE AND CARBINE

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I. Introduction

The belt fed AR15/M16 is a light semi-automatic (AR15) or select fire (M16) belt or magazine feed firearm based on the highly successful and world renowned family of Colt M16 rifles, which have seen over 20 years of field and combat duty.

This belt fed conversion is partially based on the unit designed by Colt engineers over 25 years ago. It was field tested by our armed services but not adopted. Instead the M60 machine gun was accepted partly due to its larger cartridge (.308 win.) and longer effective range.

We have spent many hours thoroughly testing this firearm. It like any other machine is only as good as the operator. Please take the time to read and understand this manual.

II. ASSEMBLY OF THE BELT

The belt of your firearm is of the disintegrating link type. Each link has two loops - one holds and aligns the cartridge, the other hooks it loosely to the next cartridge/link combination.

To assemble a belt, lay the single finger of a link between the double fingers of another link. Push a new cartridge into the double finger loop from the tang end (note the small tang) until this tang snaps into the extraction groove at the base of the cartridge. Continue this process to assemble as long a belt as you want. **SPECIAL NOTE:** Belts of over 50 rounds need to be supported when fired if they are not being fed from the ammunition carrying/link catching box.

The specially designed double dummy cartridge/link assembly should be installed at the end of your belt. This is designed to eliminate jamming of the last round in the belt (see section VI, note 6), and easy clearing of the final links.

SPECIAL NOTE: The disintegrating link type belt is especially good for stopping a runaway gun (will not stop shooting when trigger is released). In the unlikely event of a runaway, you need only grasp the belt and twist. This will cause the belt to separate from itself causing the gun to run out of ammunition.

III. OPERATION

A. Loading the Firearm

Place the selector switch in the "safe" position.

Grasp and squeeze the charging handle and pull it fully to the rear. Reach with one finger between the belt feed rocker assembly and the left side of the receiver and pull the bolt hold open button away from the receiver. Allow the bolt to move forward and stop against the hold open.

VISUALLY VERIFY THAT THE CHAMBER IS EMPTY

With the belt turned cartridges up and the links facing down, insert the belt into the ammunition feed chute until you hear and feel it click in front of the upper feed arm. If you watch from the top as the belt enters you will see the upper feed arm click over and behind the first cartridge.

Now draw the charging handle to the rear and the bolt hold open will release. Release the charging handle abruptly from the FULL rearward position, then grasp and pull it ABRUPTLY to the rear again. This moves the first cartridge into the radii of the lower arm. Now release the charging handle from the FULL rearward position again. Releasing from the full rearward position abruptly and not "riding" it home is necessary to be sure the cartridge is fully stripped from the belt and there is enough energy to lock the bolt closed.

CAUTION: Do not try to use the hold open button to release the bolt. As the bolt moves forward the top of the rocker assembly oscillates abruptly toward the receiver and will pinch your finger rather seriously.

By rotating the ammunition box's catch on its right end, the box can be pulled out the left about 2-3 inches to allow up to 100 linked rounds to be carefully layered in the box. Slide it closed, set the latch and you are ready to fire.

B. Clearing the Belt from the Firearm

Put the selector switch on "safe". Grasp and pull the charging handle to the rear. This will eject the chambered cartridge. Reach in from the left and pull the bolt hold open lever out and ease the bolt down on it.

Squeeze the two small levers on the rocker assembly together. This will pull the upper and lower feed arms away from the cartridges in the feed chute and allow you to gently pull the belt from the gun.

Be sure to check the chamber and feed area to ensure that no cartridges or links remain behind.

C. Firing from the Standard Magazine

To fire the firearm from the standard magazine, follow the feed mechanism removal instructions in the field strip

section of this manual.

After removing the feed assembly, close the firearm upper to the lower, and push the rear cross pin in. You can now insert the regular magazine and fire as a regular AR15/M16.

The slider will remain in the upper and move up and down harmlessly as the firearm is fired.

Note that the holes in the upper and lower receiver necessary for the feed mechanism are now closed by the standard magazine.

IV. FIELD STRIPPING THE FIREARM

The firearm field strips the same as the regular AR15/M16 rifle except for the feed system and the slider on the upper receiver.

When opening the upper receiver from the lower push the spring loaded lever on the rocker assembly forward and fully clear of the slider on the upper receiver while the two are together and before attempting to open them (If not done while they are closed, the pin is drawn up by the slider and if pushed it will hit the bolt hold open protrusion on the receiver, keeping it from pushing clear of the slider).

With this done the upper will tilt up and forward after the rear frame pin is pushed fully to the right to its detente position.

Grasping the feed assembly from the top, push the magazine release button and the feed assembly can be removed upward from the magazine well.

Re-assembly of the firearm is done in the exact opposite steps. It will be of assistance for you to depress the bolt hold open button when initially inserting the feed in the magazine well.

When inserting the bolt/bolt carrier take care that the slider is in its full up position and locate its pin in the bolt carrier's guide slot.

CAUTION : Be sure the ejection port cover is closed when closing the upper receiver to the lower. Be sure to depress the rocker drive pin to assure it is not bent when engaged by the slider.

If your firearm is select fire, remember that the upper will not close fully with the lower if the selector is in the auto position.

V. CLEANING AND MAINTENANCE

No additional cleaning beyond that of the standard AR15/M16 is required on the basic firearm.

The feed mechanism and related parts are cleaned easiest by submerging the entire assemble in solvent and brushing with a fine soft tooth brush type gun cleaning brush and blown dry.

Contrary to the stories you have doubtlessly heard the AR15/M16 as well as the belt feed mechanism work best with a liberal amount of light lubricant.

VI. DO'S AND DON'TS

Here is a listing of "Do's and Don'ts" that you should fully familiarize yourself with and always practice when operating this firearm;

1. Only use new commercial manufactured full charge .223 cal. (5.56 mm) ammunition. The use of reloads and most foreign ammunition is highly discouraged. Ammunition that works great in a regular AR15/M16 may not have sufficient energy to drive the feed mechanism.
2. Never use any .223 (5.56mm) links that do not have the guide slot cut in them. The gun will malfunction immediately as the unslotted links will not feed past the guide bar in the link ejection shoot.
3. Always field strip, clean, and lubricate the firearm after every use.
4. Never use force in assembly, disassembly, or trouble shooting. Any use of force may damage the delicate parts of the feed and voids all warranties.
5. Your ammunition belt must be clean. Remember that unlike ammunition protected in a box type magazine, belted ammo is much more susceptible to contamination.
6. Always stop firing the weapon before attempting to chamber the last live round. This will jam a cartridge in the feed that may be hard to clear. Remove the last 2 or 3 cartridges following the instructions in section V B. You may disregard this note when using the double dummy cartridge/link assembly at the end of your belt.
7. Never close the upper of the firearm to the lower receiver with the ejection port cover open.
8. Never insert the ammunition carrying box unless the ejection port cover is closed.
9. Never fire the firearm with the ammunition carrying box without the cross pin in place.
10. Be sure to support belts over 50 rounds if not fed from the ammunition/link catch box.

VII. WARRANTY STATEMENT

Jonathan Arthur Ciener, Inc. will replace or adjust to its commercial standard any unit returned prepaid to the factory, along with sales receipt, and found by us to be defective in either materials or workmanship. Such service will be made free of charge for one year from the date of purchase. This service shall apply ONLY to the original retail purchaser or end user. ANY unauthorized adjustments, alterations or modifications immediately voids this warranty.

STATEMENT OF LIABILITY

This Belt Feed Conversion is classified as a FIREARM ACCESSORY and is surrendered by us with the express understanding that we assume NO LIABILITY for its re-sale or safe handling under local laws and regulations. JONATHAN ARTHUR CIENER, INC. assumes no responsibility for physical injury or property damage resulting from either intentional or accidental discharge, or the function of any unit subjected to influences beyond their control, and will honor no claims which may result from careless handling, unauthorized adjustment, alterations, modifications, defective or improper ammunition, corrosion, or neglect.

This warranty and statement of liability supersedes all previous warranties and commitments.

JONATHAN ARTHUR CIENER, INC.

has long been the foremost manufacturer of fine quality sound suppressed firearms and silencers. We specialize in the expert conversion of certain semi-automatic firearms to select fire. For more information about our other products and services and information about the legal ownership of Automatic Firearms and Noise Suppressors, send \$4.00 for our informative illustrated catalog or \$12.00 for our catalog and distinctive logo T-shirt or Baseball Cap. State size for T-shirt orders and color preference for either T-shirt or Cap. Colors are red, white, blue, tan, or gold.