

Loading the Black Dog Machine LLC Drum

Hold the round drum body in the left hand with the body at a 45 degree position. With your left thumb pull the rotor counterclockwise enough to slip in 2-3 rounds with the right hand repeat until drum is full. **See Photo 1** To unload pull rotor slightly counter clockwise to relieve the tension. The rounds will fall out the front with short counterclockwise and clockwise pulls of the rotor.



PHOTO 1

Disassembly of Drum

Hold the drum and remove center screw with a 5/32 Allen wrench. Remove the two #4-40 Allen screws from top ears with a 3/32 Allen Wrench. Hold drum horizontal in the left hand with the nut side of the drum housing facing up (this is the back of the drum). **See Photo 2** Lift the back cover off while holding on to the front drum housing. Wind the rotor counterclockwise until the follower and dummy round stack comes out of tower. (Please note: dummy rounds apply to the AR15.22 and 10/22 drums only). Hold the pressure on the rotor and remove the dummy stack along with the follower. **See Photo 3** Gently let go of the rotor and remove it and the tower. **See Photo 4** The tower can be disassembled for cleaning or can be cleaned as a unit. There should be no need to remove the spring but it can be removed by taking off back plate. The spring is not under tension inside the rotor when not assembled and can be easily be removed.

Assembly of Drum



PHOTO 2

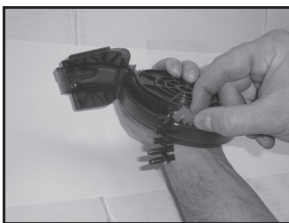


PHOTO 3



PHOTO 4

The rotor can be installed in 1/4 turn intervals using the drum housing's axle timing slots. The AR15.22 and Puma/PPS50 Drum has 1 1/2 turns from our factory. The tension can be decreased or increased; we recommend 1 1/2 minimum to 2 turns maximum. The turns is established by finding the follower hole on the outside of rotor. For two turns orientate this hole so it is straight up in line with the feed tower opening. **See Photo 5** For 1 1/2 turns orientate the hole so it is down and opposite the feed tower; for 1/4 turn intervals orientate the rotor hole in the 90 degree



PHOTO 5

Assembly of Drum - con't

position. Now line up the tail of the spring in the center with the nearest axle slot and push rotor in place. Tilt the rotor out at the top and insert the feed tower. **See Photo 6** Holding the drum housing and tower in the left hand count 1-3/4 full turns from the follower hole. Hold tension on rotor with left fingers and install follower and dummy rounds. **See Photo 7** Make sure dummy rounds go in nose first and that the rubber band is positioned in the center hole of each round. **See Photo 8** Start letting off the rotor tension while using a finger or thumb to guide the dummy stack and follower up into the tower. Be sure that the follower doesn't come out of hole, if it does it can be pushed back in with the Allen wrench or a finger. Install the cover, 2 ear screws, flat head bolt, and nut. A snug fit will work, no need to torque the bolt. Pull the rotor back out of the tower 2-3 times to line up the dummy round stack. The drum is now ready to load, enjoy!



PHOTO 6



PHOTO 7



PHOTO 8

Note: The power spring may relax over time. This is expected and is not a bad thing. To adjust, simply take the drum apart and reset your wind to 1 1/2 - 2 turns.

Sub-Assembly of Follower and Dummy Stack (AR15.22 only)

AR15 tower requires 10 dummy rounds, one follower, and one rubber band. To assemble dummy stack first feed the round end of the rubber band down through the hole in the follower and pull it through. Insert round end of band into the hole near the rim of the dummy round and snap it towards the hole in the middle of the round. Repeat for additional dummy rounds making sure that the pocket is pointed outward on the last dummy round; this accommodates a place for the round end of the band to rest. **See**

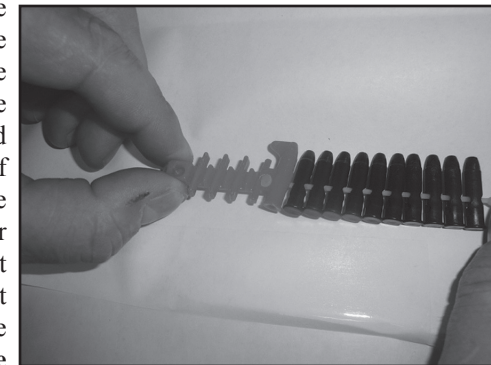


PHOTO 9

Photo 9

AR15.22 Replacement Drum Parts

AR Tower.....	\$17.00
AR Housing Front.....	\$11.00
AR Housing Back.....	\$11.00
Rotor.....	\$18.00
Rotor Cover Plate.....	\$2.00
Power Spring.....	\$8.00
Follower, 10 Dummy Rounds, & 2 Bands.....	\$11.00
Drum Hardware Set.....	\$6.00
1/4-20 Flat Head	
1/4 -20 Nut	
6 Cover Plate Screws	
2 #4-40 x 3/8 Screws	

Puma/PPS50 Replacement Drum Parts

Puma Tower and feed ramp.....	\$17.00
Puma Housing Front.....	\$11.00
Puma Housing Back.....	\$11.00
Rotor.....	\$18.00
Rotor Cover Plate.....	\$2.00
Power Spring.....	\$8.00
Follower.....	\$3.00
Drum Hardware Set.....	\$6.00
1/4-20 Flat Head	
1/4 -20 Nut	
6 Cover Plate Screws	
2 #4-40 x 3/8 Screws	

Limited Warranty

Black Dog Machine LLC warranties this product 100% against from manufacturer’s defects or failure. We will replace parts or entire unit at our discretion. This warranty does not cover damage caused by the consumer from abuse or misuse. Examples of abuse include: dropping, exposure to harsh chemicals or heat, etc. For additional information please see our website at www.blackdogmachinellc.net.

Polycarbonate Solvent Warning

Your drum is made with polycarbonate; it is also known as bullet-proof plastic. The polycarbonate used in this drum mag will last for years if treated properly. Like most other plastics it can be attacked by some common types of gun solvents like Hoppe’s #9™ or carb cleaner. Remove the drum before any use of solvents on your weapon. The drum itself can be cleaned with warm soapy water if needed.



Black Dog Machine, LLC .22 50 Round Drum

**Owner’s Manual
Patents Pending**

Black Dog Machine LLC

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