



NEA-15

Operations Manual



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NCAGE: L00J5

Rifle Information

Model: _____

Serial no. _____

Purchased From: _____

Date Purchased: _____ / _____ / _____
Day Month Year

Please print and complete this page for your records, and store in a secure location should it be needed in the event of fire, theft or must be returned to your dealer or the manufacturer for service or repair.

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WARRANTY INFO

This NEA firearm carries a *lifetime warranty* to the original purchaser and covers all defects in material and workmanship. Any unauthorized, repair, misuse, abuse, modifications or alterations of this product is not covered by this warranty. This warranty does not include normal and expected wear of components, exterior finishes and appearance through use.

THIS WARRANTY WILL ONLY BE HONORED UPON THE COMPLETION AND SUBMISSION OF THE WARRANTY CARD INCLUDED WITH YOUR RIFLE, TO NEA WITHIN 30 DAYS OF PURCHASE. PLEASE INCLUDE A COPY OF THE DATED SALES RECEIPT FROM YOUR RETAILER.

All domestic and international returns and warranty work will be handled direct through NEA. Please contact us for a RMR authorization prior to sending your rifle to us or an authorized repair center. Any product submitted with no warranty issue discovered or no Warranty Card on file will be charged at our normal shop rate as well as return shipping. Any product requiring warranty work will be repaired/replaced free of charge and return shipping covered.



NOTICE

NEA has no control over the use of your firearm, and shall not be held responsible for injury, death, or damage to property resulting from either intentional or accidental discharge of this firearm. In addition, NEA shall not be responsible for proper function of the firearm when it is used for purposes or subjected to treatment for which it was not intended. NEA will not honor claims which may result from careless or improper handling, unauthorized adjustments or parts replacement, corrosion, neglect, use of the wrong type or caliber of ammunition, or the use of ammunition other than original, high quality commercially manufactured ammunition in good condition or any combination thereof.

Due to quality and maintenance concerns, NEA recommends against using any Steel-Cased or Laquored ammunition in your NEA-15



ALWAYS keep the gun pointed in a safe direction.



ALWAYS keep your finger off the trigger until ready to shoot.



ALWAYS keep the gun unloaded until ready to use.



ALWAYS know your target and what is beyond.



WARNING

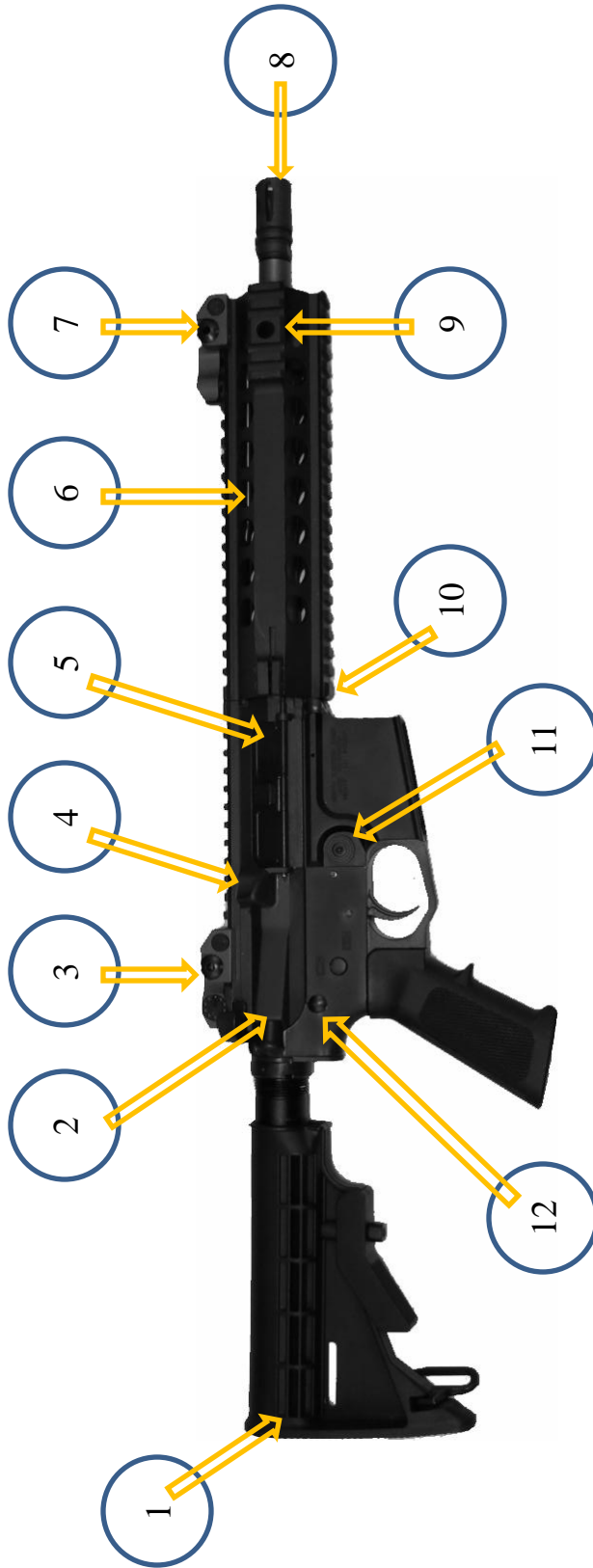
- To avoid accidental firing, **BE SURE WEAPON IS CLEAR**. Failure to do so could result in serious injury or death.
- Be sure the cam pin is installed in the bolt group. If it isn't, your rifle can still fire and will explode causing injury or death.
- **DO NOT** exchange or switch bolt assemblies from one rifle to another. It could cause damage to both you and the rifle.
- **DON'T OVERHEAT YOUR NEA-15 RIFLE BARREL**. Sustained firing of the NEA-15 Rifle will rapidly raise the temperature of the barrel to a critical point. Firing 140 rounds, rapidly and continuously, will raise the temperature of the barrel to the **COOKOFF POINT**. At this temperature, any live round remaining in the chamber for any reason may cook off (detonate) in as short a period as 10 seconds. If the cookoff point (or temperature) is felt possible, weapon should be immediately cleared and allowed to cool.
- Sustained rate of fire for the NEA-15 Rifle is 12-15 rounds per minute. This is the actual rate of fire that a weapon can continue to deliver for an indefinite length of time without serious overheating. Sustained rate of fire should never be exceeded except under circumstances of extreme urgency.
- If your bolt fails to unlock and you try to free it by banging the buttstock on the ground, keep clear of the muzzle.
- If there's water in the barrel, don't fire the rifle. It could explode.
- If you experience a noticeable difference in sound or recoil, **STOP FIRING**. Either condition could indicate an incomplete propellant burn and a bullet still in the bore. Retract bolt slowly and remove fired cartridge case. Clear weapon and check for unburned powder grains in the receiver or bore and for a bullet in the bore. Remove unburned propellant or bullet from bore before resuming firing or barrel could explode. If bullet is lodged in bore, turn in rifle to your unit armorer or a certified gunsmith.
- If rifle stops firing with a live round in the chamber of a hot barrel, remove the round immediately. However, during training, if you cannot remove it within 10 seconds, wait 15 minutes with the rifle pointing in a safe direction. This way you won't get hurt by a possible ammunition cookoff, which could happen 1 seconds after contact with a hot chamber. Clear rifle.
- Use only high quality commercially manufactured ammunition in good condition.

SAFETY FIRST!

- Treat every firearm as if it is loaded... AT ALL TIMES!
- Always keep the muzzle pointed in a safe direction.
- Never point your firearm at anything that you do not intend to shoot.
- Keep your finger off the trigger and out of the trigger guard until you are aiming at your target and ready to shoot.
- Always keep the safety in the “SAFE” position, especially when the firearm is loaded and cocked, until you are ready to fire.
- Always keep and carry your firearm with an empty chamber until you intend to shoot, so that your firearm cannot be fired unintentionally.
- Firearms should be unloaded when not actually in use.
- Be sure of your target and backstop before you shoot.
- Always wear hearing and eye protection when shooting.
- Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead, a substance known to be associated with birth defects, reproductive harm, and other serious injury. Have adequate ventilation at all times and wash hands after handling.
- Be sure that your barrel is clear of obstructions, including excessive oil, grease, cleaning patches, etc before shooting.
- Use only clean, high quality factory loaded ammunition in good condition. NEA cannot condone the use of handloaded ammunition. Any such use voids the NEA warranty.
- Do not alter or modify your firearm.
- Do not try to change your firearm’s trigger pull, because alterations of trigger pull can affect sear engagement and might cause accidental firing.
- Store firearms and ammunition separately, and beyond the reach of children.

NEA-15 Components

Right Side



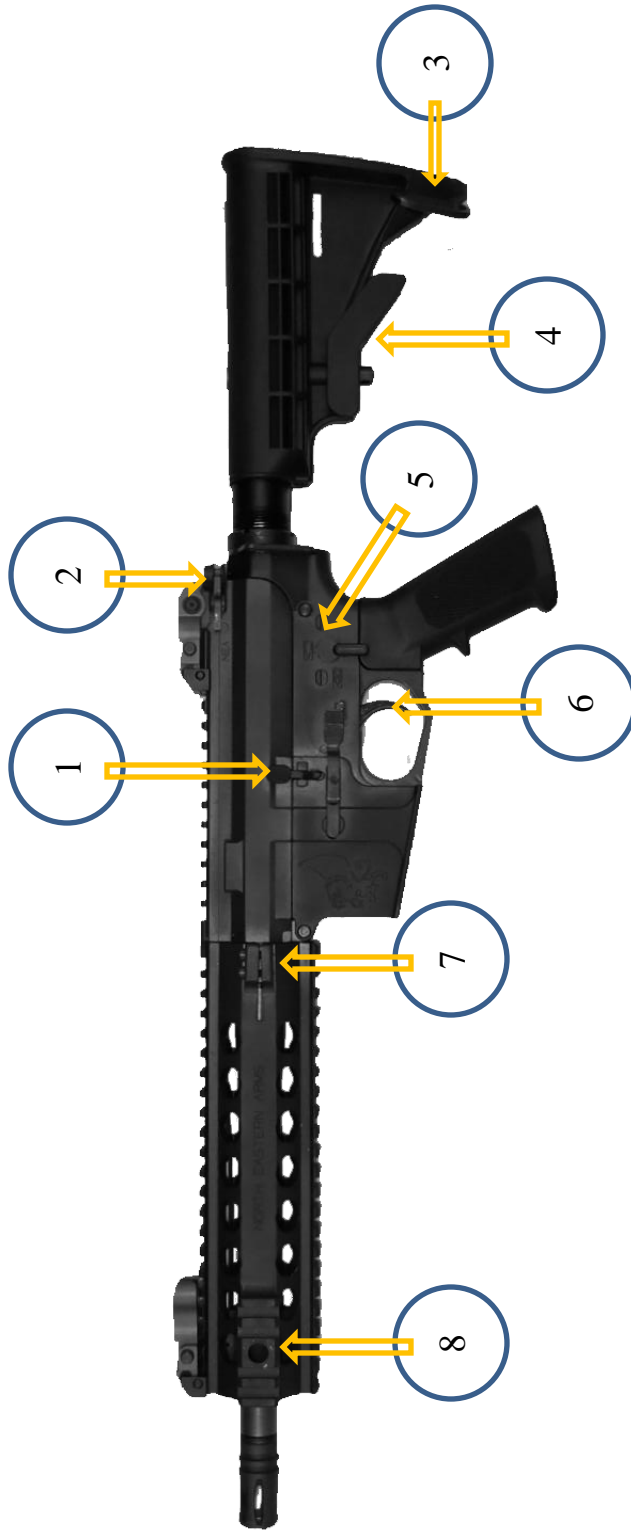
- (1) 6-Pos Carbine Stock Assy.
- (4) Deflector
- (7) Front BUIS (if installed)
- (10) Pivot Pin

- (2) Forward Assist
- (5) Ejection Port & Cover
- (8) Flash Suppressor
- (11) Magazine Release

- (3) Rear BUIS (if installed)
- (6) Free Float Handguard
- (9) Side Rail & QD Sling Point
- (12) Takedown Pin

NEA-15 Components

Left Side



(1) Bolt Catch/Release
(4) Stock Adjustment Catch
(7) Handguard Attachment Bolts

(2) Charging Handle
(5) Safety Switch
(8) Side Rail & QD Sling Point

(3) Rear Sling Point
(6) Trigger

Overview

The NEA-15 family of rifles are gas-operated, air-cooled, magazine-fed, semi-automatic or select fire, shoulder-fired weapons with a telescoping stock. A variant of the AR-15 design, the NEA-15 is available in several barrel lengths from 7.5" to 18", allowing the end user the widest range of mission-specific customization possible. Our quad rails free float the barrel to provide enhanced accuracy and ample space to mount weapons accessories. All NEA-15 rifles are built around our billet aluminum receivers. The upper is internally impregnated with a Dry-Film Lubricant to improve cycling in all weather environments. Our rifles feature medium profile barrel with polygonal rifling for enhanced accuracy, reliability and consistency. They are also built utilizing an 1:7 twist giving greater versatility in ammunition choices allowing heavier rounds to be used providing better range and terminal ballistics. Our barrels are treated inside and out with our proprietary ARC⁺ processing, an advanced form of Nitriding, further contributing to its longevity and corrosion resistance.



It is important to ensure that your NEA-15 is properly maintained and serviced at all times so that it may provide the user with consistent function, reliability and accuracy throughout its life. The NEA-15 is a Direct Impingement (DI) operated rifle, and as such is prone to carbon buildup and fouling while shooting. Keeping your rifle free from carbon buildup and properly lubricated will help the rifle function without issue. There are several components in the NEA-15 rifle that are susceptible to wear and damage through normal use and will need to be inspected on a regular basis.

It is important to be aware of the basic Care & Cleaning procedures of your rifle.



NOTICE

- **Always clean and maintain your rifle in a safe and clean environment.**
- **Remember to always follow proper safety precautions any time that you are handling any firearm.**

Detailed Specifications

The NEA-15 weapons system is built around our NEA-15 Billet upper & lower receivers - featuring flared magwells and an enlarged integrated trigger guard. Also standard is an polygonal rifled barrel available in several lengths and calibers. Our barrels are finished with our proprietary ARC⁺ processing; an advanced form of Nitrocarburizing. It is this advanced treatment that allows us to provide an unparalleled Lifetime Warranty on our barrels (for non-military use). All rifles come with our Slab-Side free float quad rails and 6-position carbine stock.

Billet Upper Receiver

6061-T6 Billet Receiver
M4 Feed Ramps
Type III Hard Anodized
Laser engraved T-markings
Impregnated with Dry-Film Lubricant

Fore End

Available in 7", 9" and 12" Lengths
Slab Side Free Float Quad Rail
6061 T6 Aluminum
Type III hard anodized
Laser Engraved T-markings (upper rail)

Billet Lower Receiver

6061-T6 Billet Receiver
Type III Hard Anodized
Flared Magwell
Enlarged integrated trigger guard
Milspec Standard parts kit
Milspec Standard charging handle
A2 Grip
6-Position Carbine Stock (commercial)

Barrel

Length: 7.5", 10.5", 12.5", 14.5 and 18"
Calibers: .223REM, 5.56mm, .300 BLK
M4 Feed Ramps
4140 CMV
1:7" Twist
Button Cut Polygonal rifling
Barrel, Extension, Gas Port ARC⁺ Nitrided
Low-profile gas block ARC⁺ Nitrided then
Parkerized
A2 Flash Suppressor
High Pressure Tested (HPT)
Magnetic Particle Inspected (MPI)

Bolt Carrier Group

M16 Full Auto BCG
ARC⁺ Nitrided Carrier
High Pressure Tested (HPT)
Magnetic Particle Inspected (MPI)
Staked gas key

Clear Your Rifle

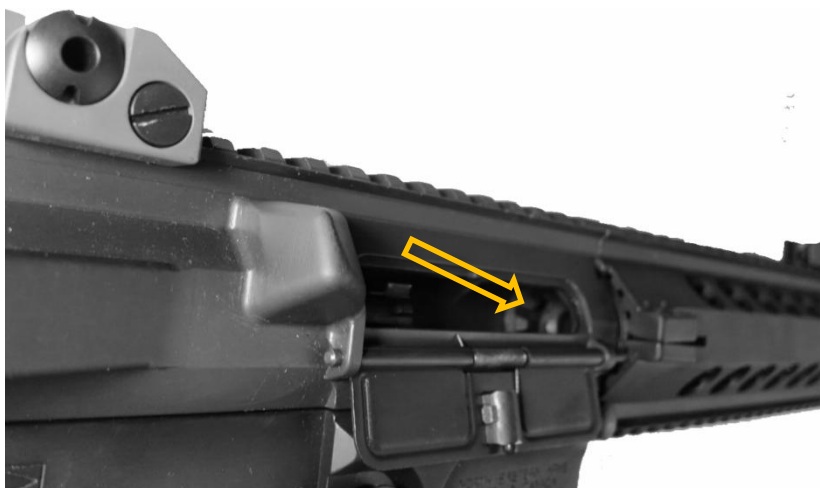


****BEFORE YOU BEGIN****

- **Verify the rifle is CLEAR**
- **Remove the magazine**
- **Lock the bolt to the rear**
- **Visually and physically inspect the chamber**
- **Point the muzzle in a safe direction, release the bolt and place the rifle on safe.**



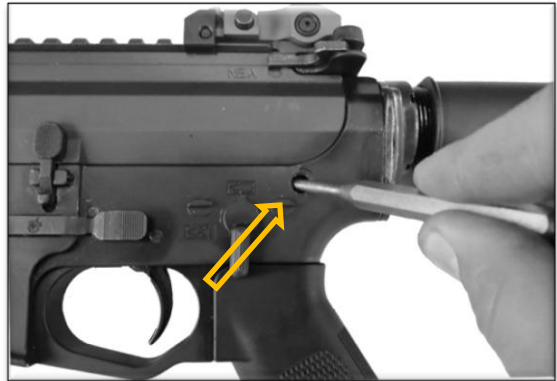
Pull the charging handle and lock the bolt to the rear.



Visually inspect the chamber. If there is round in the chamber, clear it.

Field Strip Your Rifle

Push in the rear takedown pin from left to right with your finger, or if tight, use a non-marring tool.



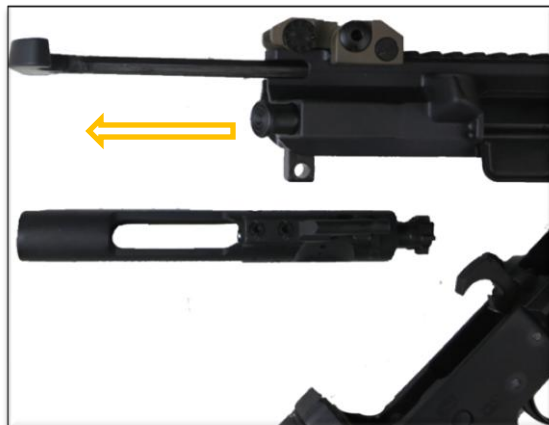
Rotate the lower down from the upper.



Pull the charging handle to the rear four inches.

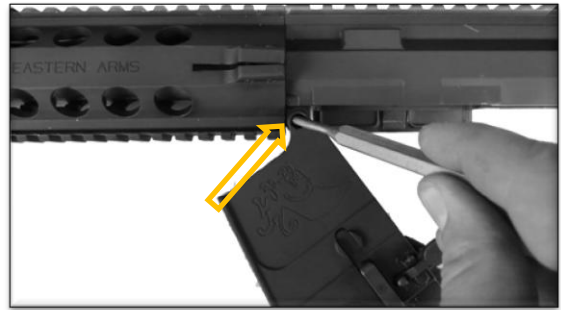


Pull the bolt carrier group to the rear and out of the back of the upper receiver. Remove the charging handle.

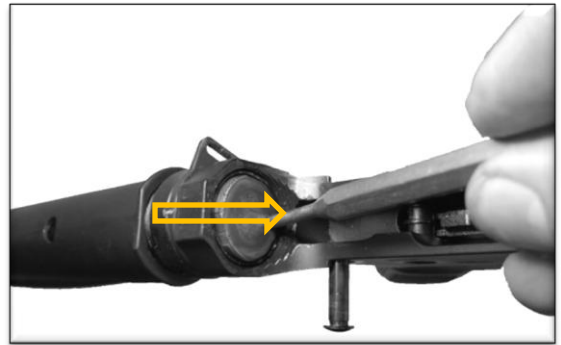


Field Strip Your Rifle (cont)

Push in the front takedown pin from left to right with your finger, or if tight, use a non-marring tool. Separate the upper and lower receivers.



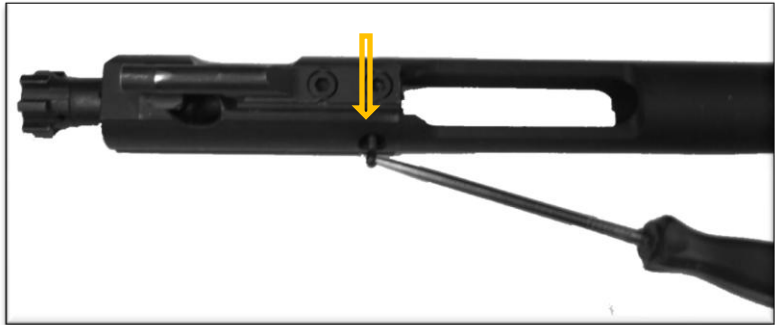
Ensure the hammer is in the cocked position and the safety is on. Depress the Buffer Retainer and allow the buffer and spring to exit the buffer tube.



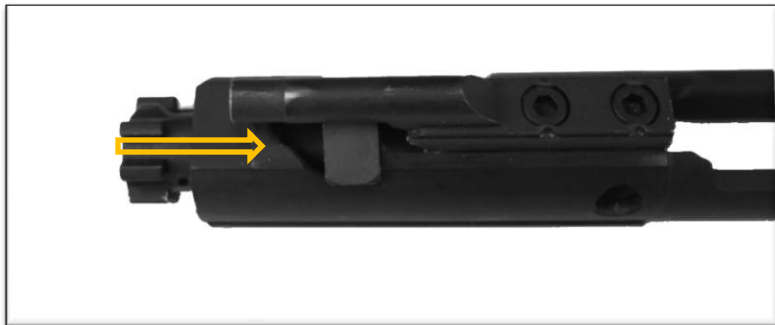
The NEA-15 Field Stripped.

Disassemble the Bolt Carrier Group

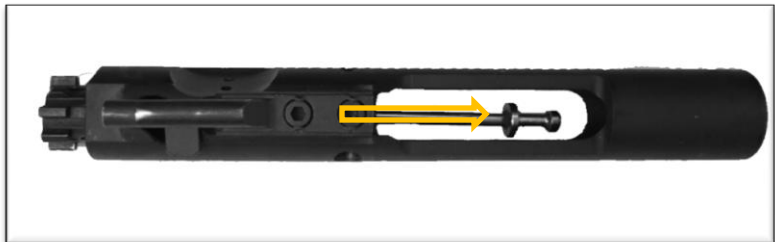
Remove the firing pin retaining pin.



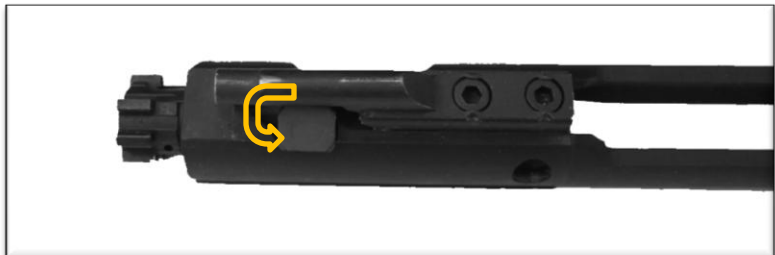
Push the bolt in to the locked position (into the carrier fully).



Invert the carrier and allow the firing pin to drop into your hand or onto a safe surface.



Rotate the bolt cam pin one-quarter turn and remove.

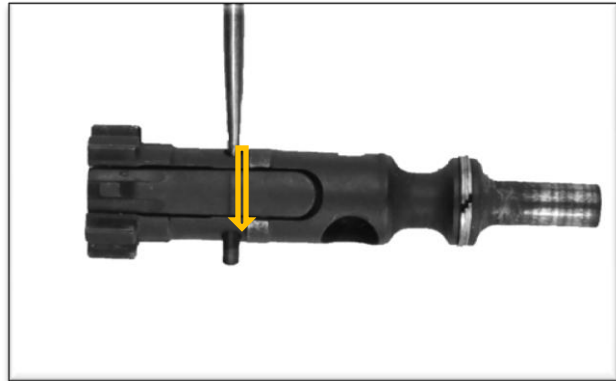


Pull the bolt out of the carrier.

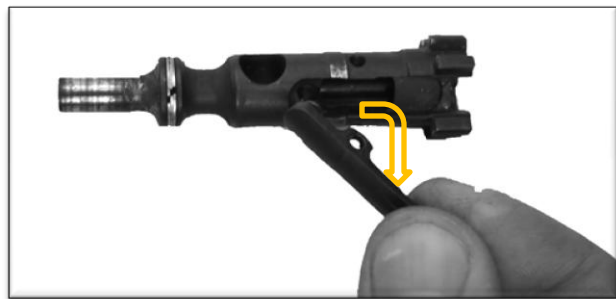


Disassemble the Bolt Carrier Group (cont)

Remove the extractor pin. If you use the firing pin, ensure not damage the tip of the firing pin.



Lift out the extractor and spring. Do not remove the spring from the extractor. The extractor needs to be cleaned only when damaged or extremely dirty.



The Bolt Carrier Group is now stripped.

Clean and Lubricate your Rifle

Recoil Spring & Buffer

- Use a dry cloth to wipe carbon, oil or dirt off of the spring and buffer.
- Apply a very light coat of oil to the spring & buffer. If in an arid/dusty environment leave dry.
- Inspect for damage.

Lower Receiver

- Use a dry cloth and soft cleaning brush to clean the internal surfaces and components of the lower receiver.
- Apply a small amount of lubricant to the operating and bearing surfaces of the fire control components; trigger/hammer pins, springs, and trigger/hammer polished contact surfaces.

Upper Receiver

- Use a dry cloth to clean the internal surfaces of the upper receiver. Avoid using abrasive products in the upper receiver as it may remove the applied Dry Film Lubricant.
- Pay particular attention as to not damage or bend the gas tube.
- Use a chamber brush to clean the chamber and barrel extension.
- Clean the bore with a .22cal/ 5.56m bore brush and swabs with an approved Cleaner, Lubricant, Preservative (CLP). Clean until a barrel patch pulls through clean.
- Wipe down the internal and external surfaces with a light coat of oil.
- Wipe down and lubricate the charging handle.
- Inspect all parts for signs of cracking or peening.
- Inspect the gas tube and gas block and ensure that the gas system is secure and in the upright position. Check the set screws in the gas block for security.

Bolt Carrier

- Wipe down surfaces with CLP.
- Using a carbon scraper or brass brush, remove carbon buildup.
- Place two drops of CLP into the gas key.
- Inspect gas key screws for security.
- Check for cracks or battered/peened surfaces.

Firing Pin

- Inspect for cracks, chips, bent or damaged tip.
- Apply a thin film of lubricant.

Cam Pin

- Use a dry cloth to wipe carbon, oil or dirt.
- Inspect for cracks and damage.
- Apply a thin coat of grease to the cam pin.

Clean and Lubricate your Rifle (cont)

Firing Pin Retainer

- Wipe clean & apply a thin coat of CLP.
- Inspect for damage and cracks. If damaged replace with an proper firing pin retainer, not a standard cotter pin.

Bolt

- Using a carbon scraper or brass brush, remove carbon buildup.
- Inspect the bolt face. Ensure that firing pin hole is round. Inspect the lugs for chips/breaks.
- Inspect the gas rings. **Replace gas rings every 3000 rounds.**
- Clean the extractor, lubricate and check the extractor for wear.
- Apply a light coat of lubricant to all surfaces. Apply a light coat of grease to the gas rings and cam pin hole.

Gas Ring Fit Test

- Check bolt assembly for proper fit with bolt cam pin removed.
- Insert bolt into the bolt carrier.
- Invert the bolt carrier group and suspend so the bolt assembly is pointed down.
- The bolt assembly should not drop free.



NOTICE

The bolt assembly must not drop out of the carrier when doing the gas ring fit test. If the weight of bolt assembly allows it to drop out of the bolt carrier assembly, replace the bolt gas rings.

New Rifle Break-in Procedure

Before firing your new rifle for the first time, take a moment to prepare your rifle for use. The NEA-15 rifle is shipped from the factory with very little lubricant to ensure that the rifle provides a blank slate for the environment being used. Before initial use your rifle should be well oiled and wiped clean both inside and out. The initial appearance of the rifles receivers and handguard may differ in color due to the anodizing and preparation processes. Applying a coat of lubricant to the external of these parts will help bring out the finish of the material. Clean your bore thoroughly before firing for the first time.

Your NEA-15 has a short 200-500 round break-in period to allow the newly machined and treated surfaces to smooth out and mesh properly. During this time use high quality commercially manufactured ammunition, military issue or surplus ammunition. During the break-in period you may experience a tight fit in many areas such as the takedown and pivot pin, charging handle, bolt carrier, selector, and trigger. The lower receiver springs perform out of the box at 8lbs (avg) and may settle in to 5-7lbs after break in.

Your barrel features polygonal rifling and has a very short break-in period. During the break-in period, clean your barrel every 5 rounds for 20 rounds and then every 25 rounds for 100 rounds. Doing so will help your barrel perform consistently over its lifespan.

During your break in procedure inspect your rifle every 100 rounds. Pay particular attention to ensure that the gas block set screws are tight and secure and the gas block is aligned and tighten as necessary. Check that the four handguard clamp screws are tight and there is no movement in the handguard. Inspect your bolt for signs of wear.

Care Under Unusual or Extreme Conditions

Extreme Cold

1. Clean and lubricate rifle using a recognized cold weather gun lubricant. Wipe excess lubricant off of operating surfaces.
2. Keep rifle moisture free.
3. Avoid exposing your weapon to extreme temperature shifts . Doing so can lead to precipitation forming on/in your rifle causing freeze-up.
4. Operate the controls through their entire range at regular intervals to keep them from freezing up.

Tropical, Maritime or Coastal Climates.

1. Inspect rifle more frequently, especially the hidden surfaces of the bolt assembly, gas system and lower receiver components. Ensure the rifle is kept well lubricated, inside and out.
2. When exposed to moisture or humidity, ensure the rifle is wiped dry, as moisture could cause corrosion. After drying, lubricate with lubricant.

Hot, Dry Climates.

1. Dust and sand will get into the rifle and will cause malfunctions and excessive wear on component working surfaces through abrasive action during the firing operations. Clean and lubricate more often.
2. Lubricate internal working surfaces only with a small amount of lubricant. Do not lubricate external parts of the rifle. Do not lubricate internal components of the magazines.

Dusty and Sandy Areas.

1. Clean and oil rifle more frequently with lubricant.
2. Keep sand and dust out of parts when inspecting, lubricating, or assembling rifle. Apply only a very light amount of lubrication on outside of rifle. Using too much lubricant can attract dust and sand.

Assembly & Function Check

*** Assemble your firearm in the reverse order as it was disassembled. ***

CAUTION

When reassembling your Bolt Carrier Group, **ENSURE** that your bolt cam pin is reinstalled. The rifle will operate with this component removed, the action **WILL** explode if the rifle is fired without a bolt cam pin installed.

Notice: A function check should be performed each and every time the rifle is reassembled or any time there is a doubt as to whether the selector or rifle are functioning properly.

1. Pull the charging handle to the rear and release.
2. Place the selector on SAFE. Pull the trigger, and the hammer should not fall.
3. Place the selector on SEMI. Pull the trigger and hold to the rear. The hammer should fall.
4. Continue to hold the trigger to the rear, pull the charging handle to the rear, and release it.
5. Release the trigger with a slow, smooth motion until the trigger is fully forward. The hammer should not fall.
6. Pull the trigger. The hammer should fall.

Principals of Operation

- Feeding
- Chambering
- Locking
- Firing
- Unlocking
- Extracting
- Ejecting
- Cocking

1. Place selector lever on SAFE.
2. Insert loaded magazine in the magazine well and chamber a round.
3. Face the target, move the selector lever from SAFE to SEMI or AUTO, and place the rifle to your shoulder.
4. Align the front and rear sight with the target and squeeze the trigger.
5. Squeezing the trigger releases the firing pin and allows it to impact the primer on the round.
6. The primer ignites the propellant in the round.
7. Gas from the burning propellant pushes the projectile along the barrel of the rifle.
8. The rifling in the barrel causes the projectile to rotate which provides stability during flight to the target.
9. When round reaches approximate end of barrel, expanding gases from burning propellant pass out through gas port and into gas tube. Gas goes into bolt carrier assembly, ejects old cartridge, and chambers a new round.

NEA-15 Operation

Load the magazine

1. Use only ammunition for which your firearm is chambered.
2. With front of magazine forward, place a round between the lips of the magazine with the bullet forward. Press the round down until it is retained by the magazine lips. Place the next round on top of the last and repeat until the desired number of rounds are loaded.

Load the Rifle

1. With the rifle pointing in a SAFE direction, pull charging handle assembly rearward, lock bolt, and release charging handle. Place selector lever on SAFE.
2. Pull charging handle assembly rearward and check to see that chamber is clear.
3. Release charging handle assembly.
4. Push upward on the magazine until magazine catch engages and holds the magazine.
5. Tap upward to make sure cartridge magazine is seated correctly.

Chambering and firing a round

Rifle with bolt assembly to the rear;

1. Depress upper portion of bolt catch to release the bolt.
2. Tap forward assist assembly (if equipped) to ensure bolt is fully forward and locked.
3. Move selector lever to SEMI or AUTO.
4. Squeeze the trigger and fire. **NOTE** - This is a semi-automatic firearm and is immediately loaded and ready to fire after each shot until magazine is empty.



CAUTION

- **NEVER** load a cartridge into the chamber until you are ready to fire the rifle.
- **Do NOT** disengage the safety until the rifle is pointed in a safe direction and you are ready to fire.

NEA-15 Operation (cont)

Chambering and firing a round

Rifle with bolt assembly to the front;

1. Place the selector lever on SEMI or AUTO.
2. Pull charging handle assembly all the way back.
3. Release the charging handle assembly.
4. Never "ride" the charging handle assembly . Let it go on its own.
5. Tap forward assist assembly (if equipped) to ensure bolt is fully forward and locked.
6. Squeeze the trigger and fire. **NOTE** - This is a semi-automatic firearm and is immediately loaded and ready to fire after each shot until magazine is empty.

CAUTION

Always check that ammunition is clean and undamaged before using the forward assist. Forcing damaged ammunition into the chamber could result in personal injury or death to you and others and damage your rifle and property. The use of reloaded, hand-loaded or high pressure ammunition can be dangerous and will void the warranty.

CAUTION

Make sure the rifle is pointed in a safe direction and the safety is engaged at all times while loading the rifle. NEVER allow your fingers or other objects to contact the trigger while loading or unloading the rifle. Do NOT disengage the safety until you are ready to fire and have the rifle pointed safely downrange.

WARNING

If an audible "POP" or reduced RECOIL is experienced during firing, IMMEDIATELY CEASE FIRE, remove the magazine, lock the bolt to the rear, and place the selector lever on the SAFE position. Visually inspect and/or insert a cleaning rod into the bore to ensure there is not a projectile lodged in the bore.

NEA-15 Operation (cont)

Unload the rifle

1. Set selector to “SAFE” position.
2. Press magazine catch button and remove magazine.
3. Pull charging handle to rear and push in lower portion of bolt catch. If a round had been in the chamber it should have been ejected. If last round in magazine had been fired and if the magazine was in place, bolt and carrier should already be held to the rear.



WARNING

To avoid accidental firing, always look into chamber after clearing your weapon to make sure it does not contain a round.

CLEAR YOUR RIFLE

1. Place the selector lever on SAFE. *NOTE - If weapon is not cocked, lever cannot be pointed toward SAFE.*
2. Remove cartridge magazine by depressing magazine catch button and pulling the magazine down.
3. To lock the bolt open, pull charging handle assembly rearward, press bottom of bolt catch, and allow the bolt to move forward until it engages bolt catch. Return charging handle assembly forward. *NOTE - Ensure that selector lever is on SAFE.*
4. Check receiver and chamber to ensure these areas contain no ammunition.
5. With selector lever pointing toward SAFE, allow bolt to go forward by pressing upper portion of bolt catch. *NOTE - If weapon is to be stored, it should be dry fired to release tension on hammer spring.*
6. Place selector lever on SEMI and squeeze trigger to release tension on hammer spring.

The Four Principals of Marksmanship

1. Steady Positioning.

Steady Positioning is when your rifle only moves with the natural pattern of your breathing in a gentle up and down motion. Hold your rifle along the grip and stock of the weapon firmly.

2. Use Breath Control. Breath control is the ability to breathe calmly and know the moment to fire. For the optimal chance of hitting your target, it is recommended to fire at the natural pause at the height of your inhale or the bottom of your exhale.

3. Maintain a Good Sight Picture. A Good Sight Picture will have your front sight post or assembly and your target clearly defined in your field of vision, the rear sight post or assembly somewhat blurry. Keep the top of the front sight post at roughly center-of-mass, in the middle of the chest for a human-sized target.

4. Squeeze the Trigger. Place the meat of your fingertip on the trigger and pull back with a smooth motion .

Troubleshooting

This manual cannot list all malfunctions that may occur, nor all tests or inspections and corrective actions. If a malfunction is not listed or is not corrected by listed corrective actions, notify organizational maintenance, or North Eastern Arms.

1. WEAPON WILL NOT FIRE.

- Step 1. Check to see if selector lever is in SAFE position. Place in SEMI or AUTO position.
- Step 2. Check for improper assembly of firing pin. Assemble correctly.
- Step 3. Check for too much oil in firing pin recess . Wipe off.
- Step 4. Check for defective ammunition. Remove and discard.
- Step 5. Check for too much carbon on firing pin. Clean.

2. BOLT WILL NOT UNLOCK.

- Step 1. Check for dirty bolt. Clean.
- Step 2. Check for burred bolt. Notify organizational maintenance

3. WEAPON WILL NOT EXTRACT.

- Step 1. Check for stuck cartridge or cartridge case in chamber. Remove stuck cartridge or cartridge case.
- Step 2. Check for broken cartridge extractor or extractor spring assembly. Replace bolt assembly.
- Step 3. Check for dirty or corroded ammunition.
 - a. Clean dirty ammunition with a dry cloth.
 - b. Corroded ammunition should be discarded in accordance with local laws.
- Step 4. Check for carbon in chamber. Clean.
- Step 5. Check for carbon in cartridge extractor opening on bolt assembly or cartridge extractor lip. Clean.

Troubleshooting (cont)

4. WEAPON WILL NOT EJECT CARTRIDGE CASE.

Step 1. Check for broken ejector spring. Replace spring.

Step 2. Bolt assembly is installed upside down. The bolt cam pin is worn or the bolt cam pin hole is defective and allows for improper assembly. Disassemble and assemble correctly. Replace worn cam pin.

5. WEAPON WILL NOT FEED.

Step 1. Check for dirty or corroded ammunition.

a. Clean dirty ammunition with dry cloth.

b. Corroded ammunition should be discarded in accordance with local laws.

Step 2. Check for dirty magazine. Clean

Step 3. Check for defective magazine. Replace.

Step 4. Check for too many rounds in magazine. Remove excess rounds.

Step 5. Check for restricted buffer assembly action. Remove and clean.

Step 6. Cartridge magazine not fully seated. Adjust magazine catch .

6. ROUND WILL NOT CHAMBER.

Step 1. Check for dirty or corroded ammunition.

a. Clean dirty ammunition with dry cloth.

b. Corroded ammunition should be discarded in accordance with local laws.

Step 2. Check for damaged ammunition. Replace .

Step 3. Check for carbon in chamber. Clean.

7. BOLT WILL NOT LOCK.

Step 1. Check for dirt, corrosion, or carbon buildup in barrel locking lugs. Clean.

Step 2. Check for frozen cartridge extractor. Remove and clean.

Step 3. Check for restricted buffer assembly action. Remove and clean.

Step 4. Restricted movement of bolt carrier assembly. Remove, clean, and lubricate.

Troubleshooting (cont)

8. WEAPON HAS SHORT RECOIL.

Step 1. Carbon or dirt in key and carrier assembly or on outside of gas tube. Clean.

Step 2. Gas rings worn. Inspect and replace if needed.

9. BOLT FAILS TO LOCK AFTER LAST ROUND.

Step 1. Check for dirty or corroded bolt catch. Clean.

Step 2. Check for faulty magazine. Replace.

10. SELECTOR LEVER BINDS.

Step 1. Check for not enough lubrication on selector lever. Lubricate.

11. BOLT CARRIER ASSEMBLY JAMMED.

Step 1. Check for round jammed between bolt and charging handle.

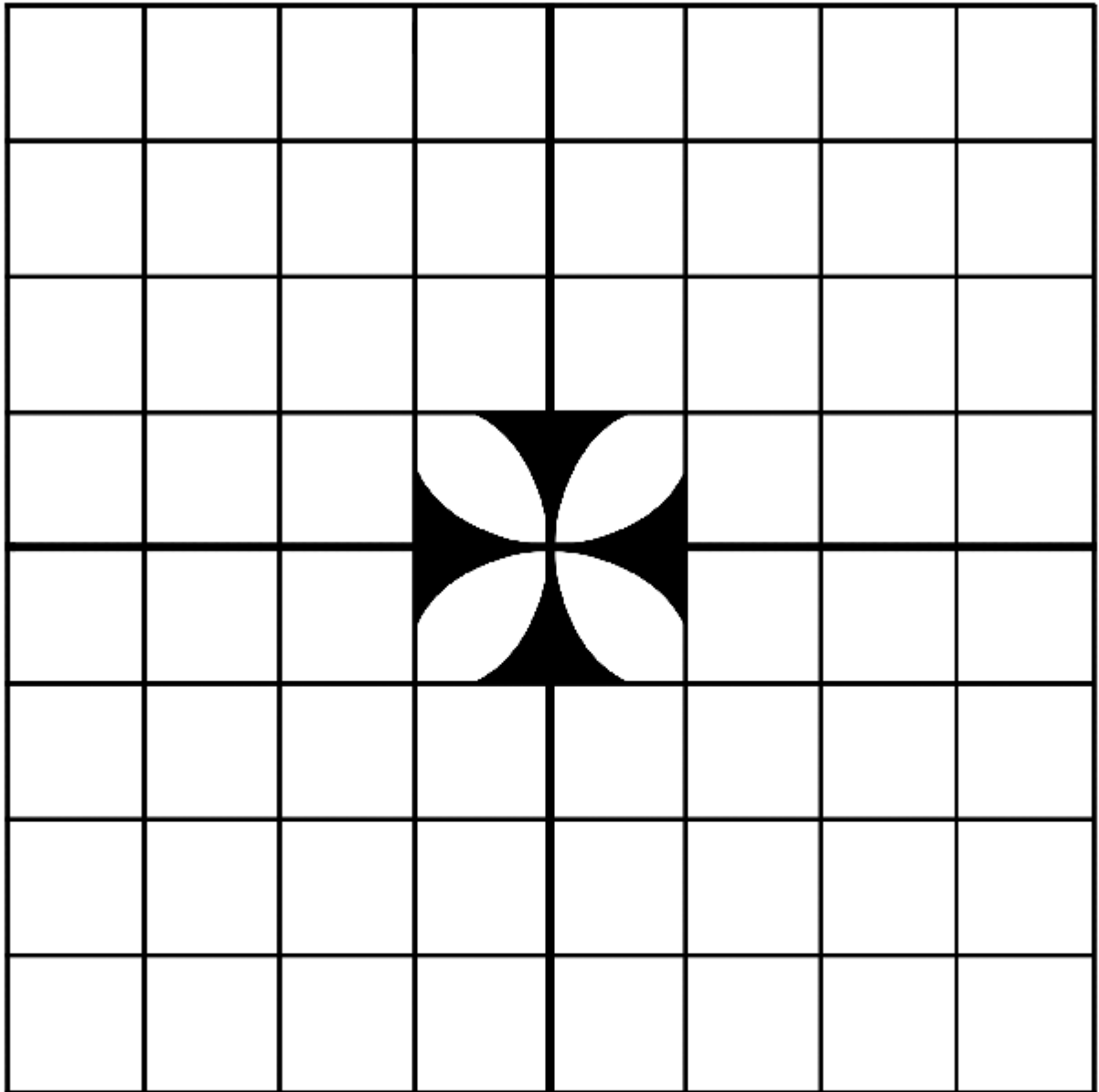
WARNING - Keep clear of muzzle.

a. Remove magazine.

CAUTION - After round is removed, bolt is under tension.

b. Hold charging handle assembly back and bang rifle buttstock on ground. If rifle has a collapsible stock, ensure that the stock is FULLY collapsed.

c. While bolt is held to rear, push charging handle assembly forward. Round should fall through magazine well.

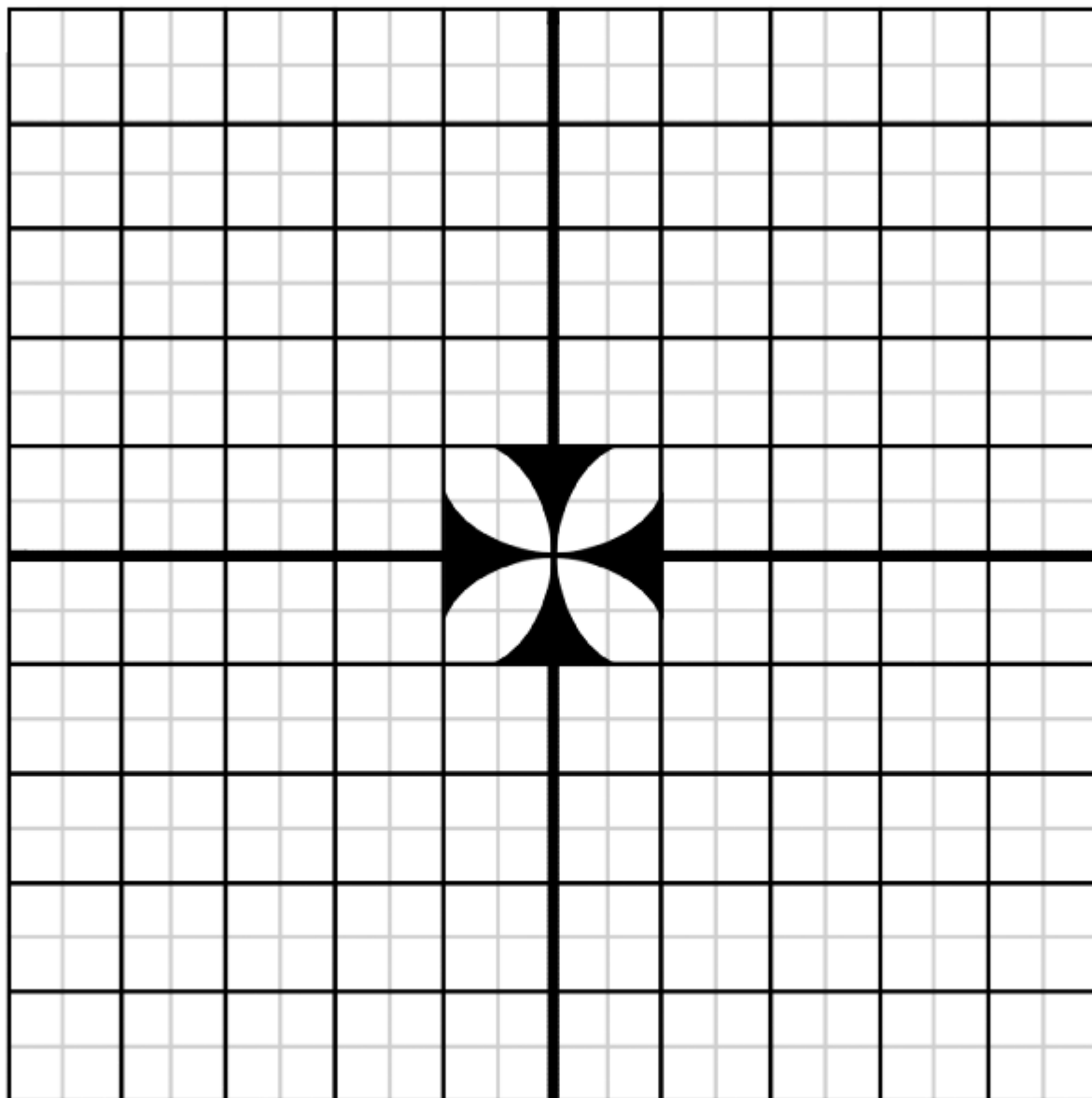


1 MOA = 1" @ 100 yards

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1 Mil RAD = 10 cm @ 100 m

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