

CORE15[®]

OWNERS MANUAL

Table of Contents:

Safety Rules 1

Safety Selector..... 1

Loading the Magazine..... 2

Loading Magazine into Rifle..... 2

Chambering a Round..... 3

Chambering a Round (with Carrier in Battery) 3

Unloading the Rifle..... 4

Use of Bolt Catch 4

Locking Bolt Carrier to Rear..... 5

Forward Assist 5

Disassembly of Rifle..... 6

Removing Bolt and Carrier..... 6

Removing the Charging Handle 7

Gas Settings..... 7

Disassembly of Piston..... 8

Schematics..... 9–11

Cleaning Instructions..... 11–12

Contact Information..... Back Cover

Disclaimers:

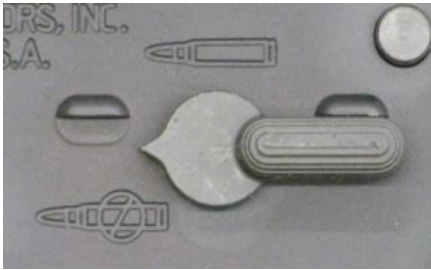
WARNING: CORE Rifle Systems can/will not be held responsible for damage, injury or death incurred by its firearms. User assumes full responsibility when using one of CORE's rifles.

WARNING: Misuse or carelessness may result in serious injury and/or death to the user or bystanders. CORE Rifle Systems, can and will in no way be responsible for misuse or careless use by the user of its firearms.

WARNING: Chambering, firing, or attempting to chamber or fire a round not intended for use in this firearm is extremely dangerous and can result in serious injury and/or death to the user or bystanders. Use only new ammunition, marked with the same markings as the firearm that it is intended to be used in.

Safety Rules

1. ALWAYS keep the gun pointed in a safe direction.
2. ALWAYS keep your finger off the trigger until ready to shoot.
3. ALWAYS keep the gun unloaded until ready to use.
4. ALWAYS assume every firearm is loaded.
5. ALWAYS know your target and what is behind it.
6. ALWAYS keep firearms and ammunition out of the reach of children.



Above picture shows "SAFE".



Above picture shows "FIRE".

Safety Selector:

Proper use of the safety selector is crucial to the safe use of the firearm. The safety selector is located on the left side of the gun, just above the pistol grip. To ensure the weapon is on "SAFE" the pointer on the safety selector will be pointed at the insignia showing a bullet with a circle and a line through it. To disengage the safety selector to allow the gun to fire, rotate the safety selector lever to the insignia with a bullet without a line through it. This will allow the gun to fire.

WARNING: NEVER take the weapon off "SAFE" until you are ready to shoot.

Loading The Magazine:

To load the magazine, insert ammunition one cartridge at a time vertically into the magazine. Ensure that each cartridge seats to the rear of the magazine, as cartridges that are not correctly seated may cause cartridges thereafter not to be depressed into the magazine. Once the magazine has been fully loaded, it will not readily allow more rounds to be inserted. Do not attempt to over load the magazine as this may bend/dent cartridges and pose a hazard to the user when attempting to fire the damaged cartridge.



Loading The Rifle:

To load the rifle, firmly insert a loaded magazine, with the bullets pointed towards the front of the firearm, into the magazine well located directly in front of the trigger. Make sure the magazine is completely seated by striking the bottom of the magazine with an upward motion with the palm of the hand.



Load magazine firmly into magazine well.

Chambering a Round:

(With the Bolt Carrier Locked in the Rear Position)

Once a loaded magazine has been inserted into the magazine well, depress the bolt catch located on the left side of the firearm. This will allow the bolt carrier to move forward into battery thereby loading the firearm.



Circled above is the Bolt Catch Release lever.

Chambering a Round:

(With the Bolt Carrier in Battery)

Once a loaded magazine has been inserted into the magazine well, use the charging handle located on the upper receiver to charge the weapon. To do this, grasp the charging handle with two fingers, one on each side of the upper, and pull charging handle to the rear. Once the handle has reached its full rearward travel, release, allowing the charging handle and bolt carrier to move back forward into battery, and thereby load the firearm.





Magazine Release Button



Pull Charging Handle To Rear

Unloading the Rifle:

Place the firearm on "SAFE".

Use the magazine release button located on the right side of the firearm to release the magazine. Once the magazine has been removed, pull the charging handle to the rear of the firearm, bringing the charging handle to its full distance back. This will allow the cartridge chambered in the firearm to be extracted and ejected safely from the firearm.

Use of Bolt Catch:

When the magazine has been emptied, the bolt will lock in the rearward position. This will be done automatically by the bolt catch to visually show the user that the firearm is out of ammunition. To reload the weapon, ensure the firearm is on "SAFE". Then remove the empty magazine by utilizing the magazine release button on the right side of the gun in front of the trigger. Once the empty magazine has been removed, a loaded magazine can be inserted into the magazine well. With the full magazine firmly seated in the magazine well, push the bolt catch lever to release the bolt carrier, thereby chambering a round.



Bolt catch is Shown Above.

Locking Bolt Carrier to Rear:

The bolt carrier will lock to the rear position once the magazine is empty. This allows the user to visually verify that the rifle is indeed out of ammunition. In order to lock the bolt back without a magazine inserted, it is necessary to manipulate the bolt catch lever away from the upper while holding the bolt in the rearward position with the charging handle. At that point gently ease the charging handle forward ensuring the bolt caught on the catch.



Forward Assist:

If the bolt carrier fails to travel all the way forward, the Forward Assist can be used to seat the bolt completely. To use this feature, ensure that the rifle is on "SAFE", and remains pointed in a safe direction. Then swiftly strike the Forward Assist in a forward motion with the palm of the hand to push the carrier forward and completely into battery.

Forward Assist Shown Above

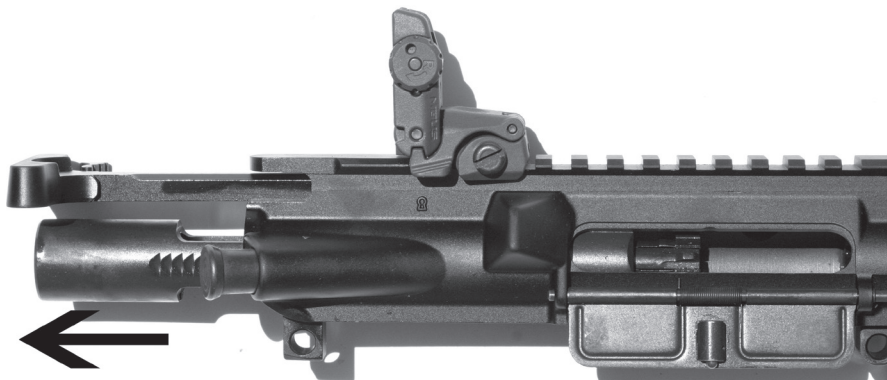
Disassembly of the Rifle:

To disassemble the rifle ensure that it is on "SAFE" and visually check to make sure the weapon is unloaded by pulling the charging handle to the rear of the weapon and visually inspecting the chamber to make sure the rifle is cleared of any cartridges. Allow the bolt carrier and charging handle to return to the forward position. Push the takedown pin to the right allowing the the upper receiver to pivot down exposing the trigger group and the back of the bolt carrier. To separate the upper receiver from the lower receiver, push the pivot pin, located in the front of the lower receiver, to the right. This will allow the upper receiver to be removed from the lower receiver.



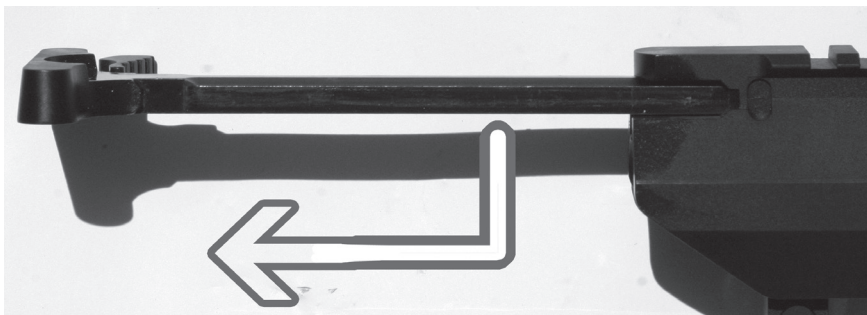
Removing Bolt and Carrier:

With the gun disassembled, pull the charging handle towards the rear just enough to unlock the charging handle lock. Grasp the rear of the bolt carrier and pull it towards the rear of the receiver. The bolt carrier should slide easily out the rear of the receiver.



Removing the Charging Handle:

Once the bolt and bolt carrier has been removed from the weapon, pull the charging handle to the rear of the receiver, once rear motion has stopped, allow the charging handle to drop down into the receiver, then remove it from the receiver.



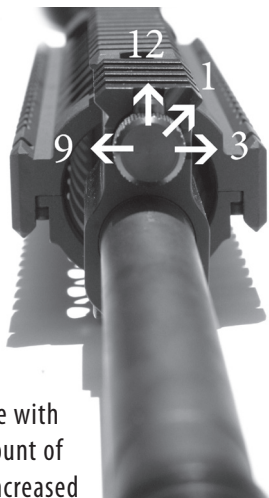
Gas Settings:

Our rifle's piston system comes with a gas block that has a four position adjustable gas plug, which allows the shooter to adjust the amount of gas pressure allowed to cycle the system and access the drive rod for cleaning and maintenance. The four settings are positioned at the 9 o'clock, 12 o'clock, 1 o'clock and 3 o'clock positions while facing the front of the gas block, and are called "Removal", "High", "Low", and "Off".

The 9 o'clock, or "Removal", positions unlocks the gas plug from the gas block. This position will allow you to remove the gas plug and drive rod for cleaning and maintenance. Once done, replace the gas plug and drive rod into the gas block at the 9 o'clock position. Depress the detent button and rotate to the desired gas setting for firing.

The 12 o'clock, or "High", position opens the gas plug completely, allowing the firearm to use the total amount of gas pressure. With this position, you may fire semi-automatic as the rifle was originally designed to. If the firearm is functioning correctly, you will be expelling empty casings between the 2 and 4 o'clock positions (roughly around the right shoulder) from the receiver consistently.

The 1 o'clock, or "Low", setting is recommended for use with the sound suppressor. A suppressor increases the amount of backpressure from the round exiting the barrel. This increased



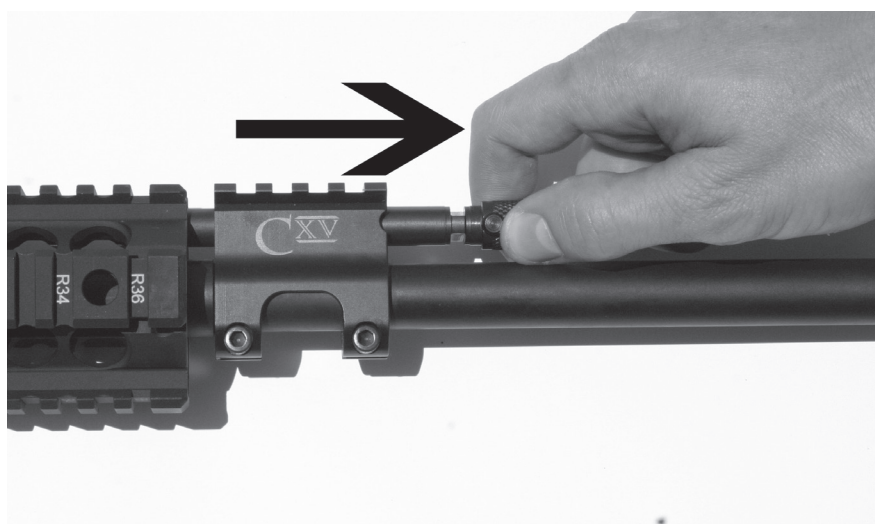
pressure causes an increase in the rate of fire. By turning the gas plug to the 1 o'clock position, the increased amount of backpressure will not enter into the piston chamber, allowing the AR to function at the rate of fire it was designed to have.

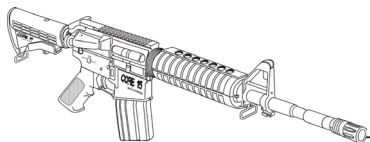
The last position is the 3 o'clock, or "Off", position. This effectively stops the firearm from cycling its action. While the round in the chamber will still fire, all the gases are vented out the front of the piston chamber and will require the shooter to manually work the action of the AR by pulling back on the charging handle. Essentially, this turns the AR into a bolt-action gun. This position is used mostly those with suppressors that do not want the sound of the action overpowering the sounds suppressed by the suppressor. It is also used with a .22LR conversion kit by removing the drive rod and turning the gas plug to the off position.

Disassembly of Piston:

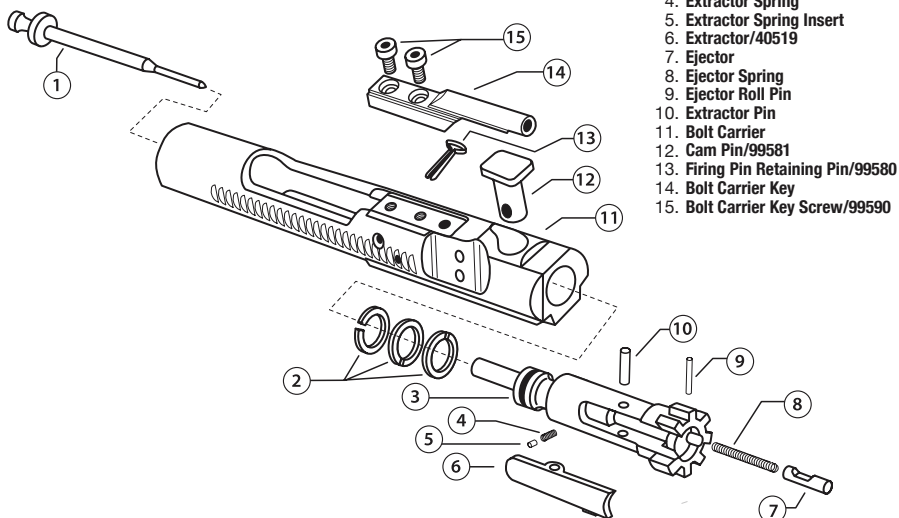
To disassemble the piston system for cleaning, ensure the gun is on "SAFE" and visually inspect to make sure the chamber is empty. Rotate the detent knob to the 9 O'clock position, and pull the piston and rod towards the end of the muzzle. This will remove the piston and rod from the gun.

WARNING: DO NOT remove the gas block from the barrel as the gas block is spaced, lined up, and torqued to precise tolerances. Removing and incorrectly reinstalling the gas block can cause serious damage to the rifle, and/or injury and in serious circumstances, death, to the user and/or bystanders.

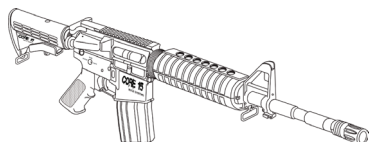




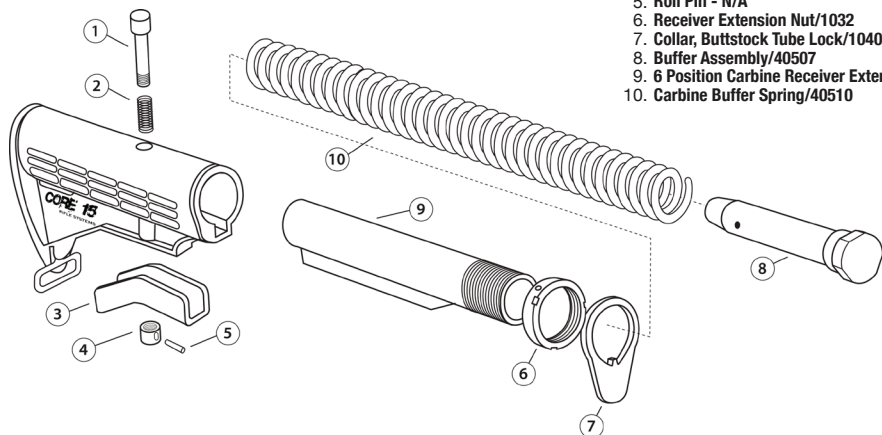
Upper Receiver, Bolt & Bolt Assembly / 99627



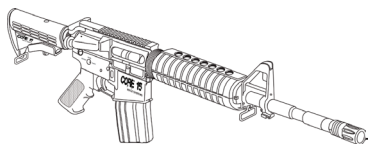
1. Firing Pin/99579
2. Bolt Gas Rings
3. Bolt
4. Extractor Spring
5. Extractor Spring Insert
6. Extractor/40519
7. Ejector
8. Ejector Spring
9. Ejector Roll Pin
10. Extractor Pin
11. Bolt Carrier
12. Cam Pin/99581
13. Firing Pin Retaining Pin/99580
14. Bolt Carrier Key
15. Bolt Carrier Key Screw/99590



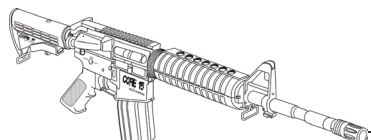
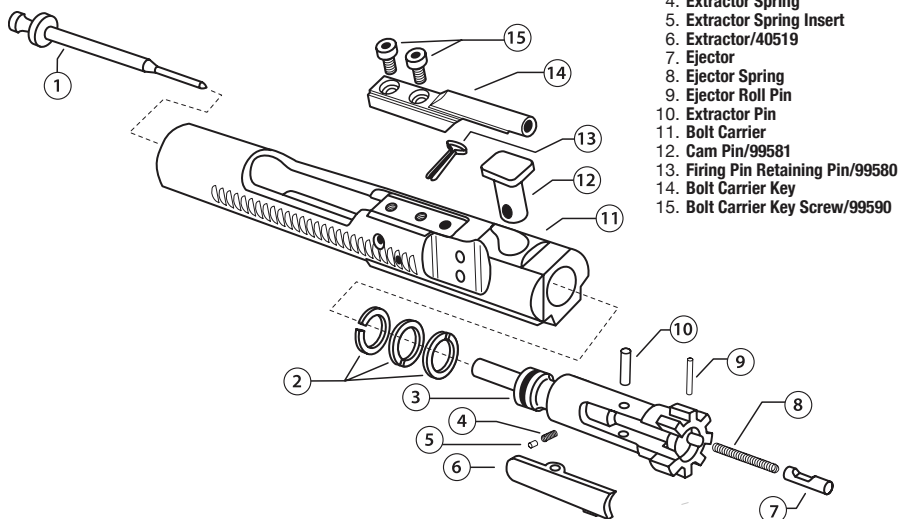
Buttstock Assembly



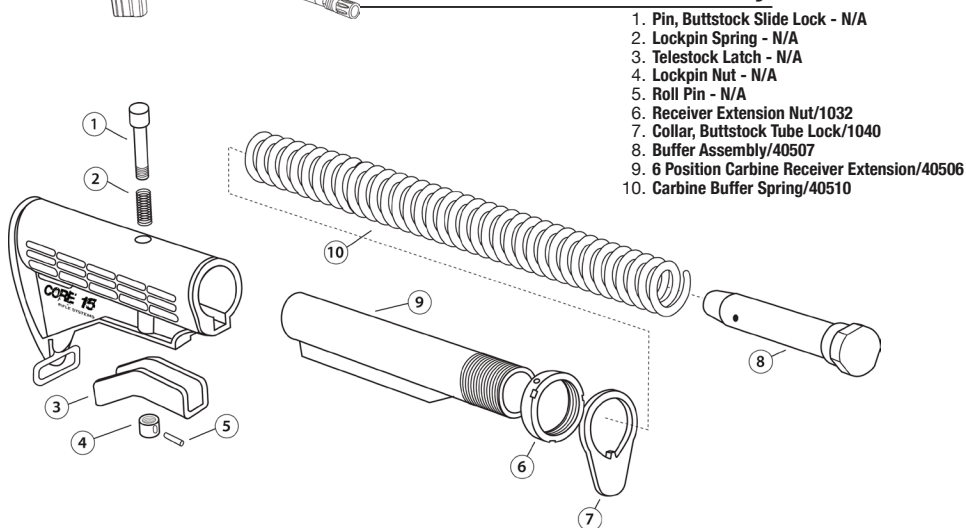
1. Pin, Buttstock Slide Lock - N/A
2. Lockpin Spring - N/A
3. Teletock Latch - N/A
4. Lockpin Nut - N/A
5. Roll Pin - N/A
6. Receiver Extension Nut/1032
7. Collar, Buttstock Tube Lock/1040
8. Buffer Assembly/40507
9. 6 Position Carbine Receiver Extension/40506
10. Carbine Buffer Spring/40510

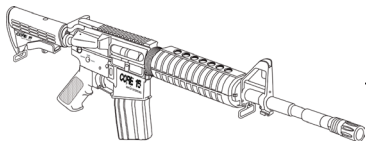


Upper Receiver, Bolt & Bolt Assembly / 99627

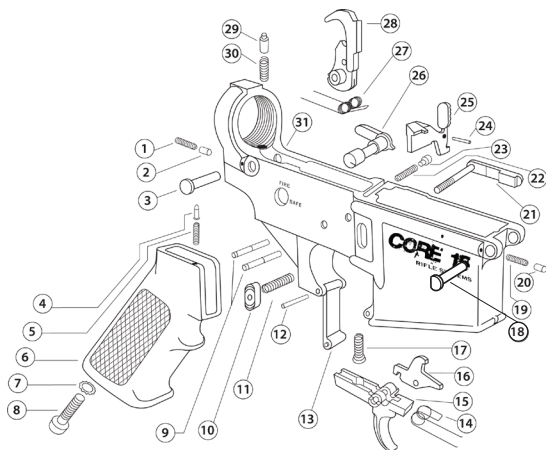


Buttstock Assembly





Core15 Semi-Auto Lower Receiver



1. Takedown Pin Spring
2. Takedown Pin Detent
3. Takedown Pin/99546
4. Safety Detent/99470
5. Safety Detent Spring/99462
6. Pistol Grip/99487
7. Lock Washer/99485
8. Pistol Grip Screw/99484
9. Hammer and Trigger Pins/99474
10. Magazine Catch Button/99123
11. Magazine Catch Spring/99127
12. Trigger Guard Pivot Roll Pin/99472
13. Trigger Guard Assembly/99582
14. Trigger Spring/99461
15. Trigger
16. Disconnecter/99469
17. Disconnecter Spring/99468
18. Pivot Pin/99589
19. Pivot Pin Spring
20. Pivot Pin Detent
21. Magazine Catch/99160
22. Bolt Catch Spring/99459
23. Bolt Catch Plunger/99561
24. Bolt Catch Roll Pin/99560
25. Bolt Catch/99562
26. Safety Selector Lever/99466
27. Hammer Spring/99460
28. Hammer with J Pin/99473
29. Buffer Retainer/99471
30. Buffer Retainer Spring/99541
31. Lower Receiver

Cleaning Instructions:

It is recommended to use Breach-to-Muzzle® gun cleaning products by Otis Technology for proper care and maintenance of CORE Rifles.

Prior to cleaning be sure the firearm is unloaded.

1. Run a patch with solvent: Using a patch, create the appropriate sized swab. Add a couple of drops of solvent and pull the patch from the breech to the muzzle. (continues next page)



Cleaning Instructions continued:

2. Run a brush: Run the appropriate sized brush from the breech to the muzzle to loosen and remove copper and lead deposits or other foiling.

3. Run a dry patch: Use a clean, dry patch and pull through from the breech to the muzzle to remove any fouling loosened by the brush.

4. Repeat as often as is necessary until clean.



For more information on Breech-to-Muzzle® cleaning with Otis Technology products, please visit www.otistec.com

Cleaning Upper Receiver, Bolt Carrier, & Charging Handle:

Wipe all areas that come in contact with the bolt carrier or charging handle down with a rag moistened with oil. This will clean and lubricate the receiver at one time. Use a small brush to brush away any powder residue that may be built up around the feed ramps of the barrel to ensure smooth feeding of ammunition from the magazine into the chamber. Wipe the bolt carrier down with an oil moistened rag to remove powder residue that has built up on it. Drip a drop of oil onto the back side of the firing pin to lubricate the movement of the firing pin and cam pin in the bolt carrier.

Cleaning the Lower Receiver:

To remove powder residue from the lower receiver, use a small brush or gun cleaning rag to remove residue from inside the lower receiver. Apply small drop of oil to trigger and hammer springs for smooth operation of both. Wipe out magazine well with an oil moistened rag to remove powder deposits.

Notes:_____

[illegible]

Contact Information:



CORE Rifle Systems

4600 W. Highway 326, Ocala, FL 34482

Email: Sales@core15rifles.com

Phone: (352)401-9070