



## **FR-15 SEMI-AUTOMATIC RIFLE INSTRUCTION MANUAL**

**READ THE INSTRUCTIONS AND WARNINGS  
IN THIS MANUAL CAREFULLY  
BEFORE USING THIS FIREARM**

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# OWNER'S MANUAL

## FR-15 SEMI-AUTOMATIC RIFLE INSTRUCTION MANUAL

### IMPORTANT “SAFETY WARNINGS”

Be certain this owner's manual is available for reference and is kept with this firearm if transferred to another party. If the manual is lost or misplaced, contact your "Product Service Center" for a free replacement copy, or download a copy from [www.fedarm.com](http://www.fedarm.com).

After performing any work on your firearm such as cleaning, adjustments, disassembly, or installation of any accessory, the firearm should be re-checked for proper functioning before firing live ammunition.

Firearms are complicated mechanisms. Any modification, alteration, or improper fitting of parts may result in a dangerous malfunction, damage to the firearm and injury to the shooter and others. The firearm's owner must accept full responsibility for the correct reassembly and functioning of the firearm after any disassembly or replacement of parts.

If you do not understand any of the material in this manual or have any questions, contact your dealer or a qualified gunsmith.

Do not attempt to load or use any firearm until you have read and understood the information contained in its owner's manual. Before handling your firearm, you should learn how it operates and how to maintain it. This includes knowing its basic parts, how the manual safety and other safety features operate, how to safely open and close the action, and how to safely load and unload ammunition from the firearm. Improper use and handling is dangerous and could cause serious injury or death to you or those around you. All users of the firearm must become thoroughly familiar with the instructions in this manual.

As the owner of a firearm, you must undertake the full-time responsibility of safe firearms handling for your own safety and the safety of those around you:

- Keep all firearms and ammunition out of the reach of children.
- Store your firearms and ammunition separately.
- Never store a loaded firearm.
- Never leave a loaded firearm unattended.
- Never transport a loaded firearm in a vehicle.
- Unload your firearm when you have stopped shooting and when you have to climb a tree, fence, cross a slippery surface or have to transport it in a vehicle.
- Do not load your firearm before you are in a place where it is safe to shoot, and keep your finger off the trigger until you are on target and have decided to fire.
- Never shoot at water, rocks or any hard surfaces. Shots may glance off such surfaces and cause injuries.
- Do not use alcohol or drugs before or while handling firearms.
- Do not touch the trigger while the safety button is being engaged or disengaged.

Always point the muzzle of your firearm in a safe direction, regardless of whether the firearm is loaded or unloaded. Always treat every firearm as if it were loaded. Give your firearm to someone with the action open (bolt fully rearward) and safety in the "ON" (SAFE) position, after you verify the firearm is unloaded. Insist on the same procedure when receiving a firearm from someone else. Learn the location of all the safety features of your firearm and how they operate. Wear eye and ear protection when shooting. Shooting without proper ear protection can cause hearing damage. The use of eye protection during any type of shooting is important to protect your eyesight. Due to the heavy recoil, maintain an adequate distance between the rear of the scope (if equipped) and your face at all times. Be certain the scope installation does not interfere with access to, or the proper functioning of the safety.

**WE SPECIFICALLY DISCLAIM ANY RESPONSIBILITY FOR DAMAGE OR INJURY WHATSOEVER OCCURRING IN CONNECTION WITH, OR AS A RESULT OF, THE USE OF FAULTY, OR "REMANUFACTURED," OR HAND-LOADED (RELOADED) AMMUNITION. ADDITIONALLY, WE DISCLAIM ANY RESPONSIBILITY FOR DAMAGE OR INJURY WHICH RESULTS FROM ANY MODIFICATIONS OR CHANGES THAT ARE NOT A PART OF THE FIREARM AS DELIVERED FROM THE FACTORY.**

Learn to clean your firearm thoroughly and make certain no oil, grease, or other materials are blocking the barrel. Obstructions of any kind can cause damage to the firearm, and may result in serious personal injury to the shooter and/or others nearby. Practice proper firearm maintenance and safety. Make sure all exposed metal surfaces are coated with a thin film of oil, especially after exposure to damp weather. (See proper section of this manual for cleaning instructions). Do not plug barrel or store in a fabric-lined case which will absorb lubricants from the firearm. Before using after storage, follow complete instructions stated in this manual for refamiliarization with the firearm. A thorough inspection should be performed before going into the field. Have your firearm periodically checked by a qualified gunsmith.

## Warnings and Notifications

**WARNING:** IF THIS FIREARM IS CARELESSLY OR IMPROPERLY HANDLED, UNINTENTIONAL DISCHARGE COULD RESULT AND COULD CAUSE INJURY, DEATH OR DAMAGE TO PROPERTY.

**CAUTION:** CAREFULLY READ THIS MANUAL PRIOR TO LOADING AND FIRING, FOLLOW ALL INSTRUCTIONS ON THE PROPER HANDLING AND SAFE USE OF THIS FIREARM – LIVES MAY DEPEND ON IT! If unfamiliar with firearms, seek further advise through safe handling courses run by your local gun clubs, NRA approved instructor or similar qualified organizations.

**CAUTION:** USE ONLY CLEAN, DRY, HIGH QUALITY COMMERCIALY MANUFACTURED AMMUNITION IN GOOD CONDITION which is the appropriate caliber of your firearm. We do not recommend the use of remanufactured or hand loaded ammunition because it may damage your rifle. Use of improper ammunition will void your warranty.

**WARNING:** THIS WEAPON COULD CHAMBER A ROUND if it is dropped or jarred with a loaded magazine in place – either with the Bolt Carrier Assembly to the rear, or in its forward position.

**WARNING:** CHILDREN ARE ATTRACTED TO AND CAN OPERATE FIREARMS THAT CAN CAUSE SEVERE INJURIES OR DEATH. Prevent child access by always keeping your firearm locked away and unloaded when not in use. If you keep a loaded firearm where a child obtains and improperly uses it, you may be fines and sent to prison.

Before this rifle left the factory, this firearm was tested, carefully inspected and packaged. Federal Armament LLC cannot control product handling after it leaves the factory, therefore please examine this firearm carefully at the time of purchase to ensure that it is unloaded and undamaged.

## Congratulations!

You are now the owner of the FR-15 semi-automatic rifle. Your rifle has an innovative design and is manufactured from high quality materials. With regularly performed maintenance and the use of proper ammunition it will provide you with many years of service.

In order to achieve the best performance and reliability from your rifle, please read and fully understand all of the instructions, safety guidelines, and warnings carefully in this manual. Your quality rifle is enormously reliable and safe unless it is handled in a careless or irresponsible manner.

**REMEMBER:** It is imperative that the firearm handler be fully educated and conscious of the importance of executing proper gun safety rules when operating any firearm.

Before using or firing with any live ammunition you should know and fully understand your rifle's parts, function, and operating mechanisms. So carefully read and fully understand all of the information about the parts and procedures of using the rifle safely and effectively.

# FIREARMS SAFETY

At FedArm, we believe that safe firearms handling is the most important consideration of anyone who uses firearms and ammunition. Please take a few minutes to thoroughly read and understand this instruction manual.

**ALL GUNS ARE NOT ALIKE.** Many makes and models of firearms may **LOOK** very similar. However, they differ widely in design and operation, and in the location and function of various controls.

You should completely understand this manual before you practice loading, unloading and firing with live ammunition.

Remember, firearms safety does depend on you!

**WARNING:** It is important for you to receive proper training from a competent firearms instructor or authority before beginning to shoot or when handling the firearm.

Failure to adhere to the rules of firearm safety can result in serious injury, death, or destruction of property

- 1) **Completely read and understand your owner's manual guidelines before using your firearm.** You should fully understand the function of all of the components and mechanics of the firearm. Before you remove the firearm out of the box thoroughly read the owner's manual on how to properly carry, handle, load, unload, and store your new firearm. Know the rules of proper gun safety and exercise them at all times because failure to do so may result in death or injury to yourself or others. Because it is impossible to list every firearm situation or scenario, be aware that certain circumstances may require additional safety rules unique to a particular situation. In these cases, we recommend that you use sound gun safety rules, judgment, and discretion.
- 2) **Always learn the specific mechanical and handling characteristics of your rifle.** All firearms are different thus it is important for you to understand how to properly carry, use, and handle each one according to its specific guidelines. Before using any firearm, one must completely familiarize themselves with the type of firearm and its specific safe handling procedures for loading, unloading, carrying, shooting, maintenance, and storing.

## **NEVER**

- Give the rifle to any person who has not thoroughly familiarized himself or herself with all of the information, safety rules, and warnings in the owner's manual.
- 3) **Always keep the firearm unloaded until ready to use.** Firearms should be kept unloaded when not in use. Whenever you pick up a firearm, immediately engage the safety device and remove the magazine to visually inspect the chamber and confirm that it is clear. Always unload all ammunition from the chamber and remove the magazine after:
    1. shooting
    2. before putting the firearm away,
    3. putting it into a holster,
    4. when not in use, and
    5. when handing it over to another person.

## NEVER

- Leave a loaded gun unattended, propped up against a surface, or out of your hands.
  - Assume a firearm is unloaded, even if you used it last. Always check to make sure that there is no ammunition and the chamber is clear.
  - Load a cartridge into the chamber until you are ready to fire.
  - Carry or transport your firearm with live ammunition in the chamber.
  - Pass a firearm to another person or accept a firearm from another person, until the cylinder or action is open and you have personally checked that the weapon is completely unloaded.
  - Haul a loaded firearm openly or in a carrying case.
  - Transfer or hand a loaded firearm to someone else.
- 4) **Always keep your finger off the trigger until you are ready to shoot.** When holding the firearm be sure to rest your finger on the trigger guard and along the side of the gun.

## NEVER

- Touch the trigger until you are ready to fire.
  - Engage in horseplay while handling a firearm.
  - Rely on the safety devices of the gun. Mechanical safeties are never foolproof and can wear out and malfunction over time. Remember to always handle all firearms using proper gun safety guidelines.
- 5) **Always keep the gun pointed in a safe direction.** A safe direction is one in which an accidental discharge cannot or would not cause injury or harm to yourself or others. Use extreme caution especially when loading and unloading your firearm. When handling any firearm always treat it as if it was loaded and ready to fire, even if you think it is empty. The recommended carrying position of your rifle is with the hammer in de-cocked position.

## NEVER

- Point your firearm at anything you don't intend to shoot.
  - Use a firearm under the influence of alcohol, drugs, or any other substances that may impair your judgment, skills, or physical abilities.
  - Target shoot or hunt with a firearm when you are fatigued or too tired to operate the firearm safely.
  - Use your firearm if you have an illness or disability that could compromise your judgment and the safety of yourself or others.
- 6) **Always use the correct ammunition.** All firearms are manufactured to use a certain caliber or gauge of ammunition. Only use ammunition that the manufacturer has recommended. Always verify before loading that you have the correct ammunition that matches the manufacturer's recommendations. Using improperly reloaded or incorrect ammunition can cause death and injury. This can also damage or destroy your firearm which will void any warranty.

## NEVER

- Shoot the gun unless you know you have the proper ammunition.
- Use hand loaded, non-standard or reloaded ammunition.
- Fire ammunition that exceeds industry standard pressure specifications.
- Use old, soiled, or damaged ammunition.
- Use ammunition which does not feed reliably in your particular firearm as it may malfunction at a critical juncture.

- 7) **Always store your firearm in a secured storage area to prevent unauthorized access or use from other individuals.** There are many types of firearm storage devices as well as locking devices that attach directly to the firearm itself. Each individual must consider their particular circumstances so that the firearm is stored and maintained for optimal safety and security. Metal gun safes are recommended over open racks or glass front cabinets. Mechanical safeties built into the firearm can fail and should not be used as a substitute for safe gun handling and adherence to all firearm safety rules. Additionally, always store your ammunition locked up and secured separately from any firearms.

**NEVER**

- Store or hide a loaded firearm
- Leave your firearms where unauthorized access from other individuals can occur.
- Allow access to individuals who do not understand or follow the rules of proper gun safety
- Leave an unsecured firearm in a bed, drawer, closet, or any other vehicle that could allow access to children or other unauthorized individuals
- Allow children under the age of 18 access to any firearms without close supervision and proper firearm safety training.

- 8) **Always comply with all local, state, and federal laws that govern the ownership, storage, carrying, and use of firearms.**

**NEVER**

- Vandalize any public or private property by using it as a target.
- Poach a game animal out of season
- Kill any animal you don't intend to eat.

- 9) **Always know your target and what is beyond.** Before you pull the trigger be sure of your target and what is behind it. Shoot only in areas that have approved backdrops such as a shooting range, or backstops such as a hillside or berm. Also, know how far your shot will travel in case you miss the target or the bullet ricochets.

**NEVER**

- Fire in the direction in which there are people.
- Fire at a sound, movement, or a flash of color.
- Shoot directly upwards or at a high angle of elevation. Firing at or into the air can have enough energy to travel long distances and accidentally injure or kill someone.
- Shoot across a highway or other roadway.

- 10) **Always wear eye/ear/body protection.** Gases and debris can cause injury so it is very important that one wears protective gear to preserve their hearing and eyesight. Also, while in the field wear at least 1000 square inches or more of blaze orange so that you can be visible by others.

**NEVER**

- Discharge a firearm in a poorly ventilated area.

**WARNING:** Possible lead exposure can occur when discharging firearms in a poorly ventilated area, cleaning the firearm, or handling ammunition. Lead and its components is a substance known to cause birth defects, reproductive destruction/impairment, cancer, or other serious health conditions and injury. Always have adequate ventilation at all times and wash your hands and other contact areas thoroughly after each exposure.



- 11) **Always handle with extreme care if your gun fails to fire when the trigger is pulled.** If the ammunition doesn't fire when you pull the trigger, **STOP!** and remember to always keep the firearm pointed in a safe direction. Keep your face away from the breech, then put the safety on, carefully open the action, unload the firearm and dispose of the cartridge safely. Always keep in mind that anytime there is a shell in the chamber, your firearm is **LOADED** and ready to fire. Even if you tried to shoot and the firearm did not fire, always treat it as if it could still discharge.
- 12) **Always treat the firearm as if it was loaded, even if the safety is positioned correctly and keep your fingers away from the trigger when loading and unloading.** A gun is a mechanical device and is not foolproof and is subject to wear and tear over time. Always keep your fingers away from the trigger when you are loading and unloading. If the manual safety proves to be ineffective for any reason, danger of an unintentional discharge exists. The weapon is then to be immediately unloaded and restricted from further use. Contact FedArm so that the gun can be inspected and repaired by an authorized gunsmith.

**REMEMBER:** Any firearm safety mechanisms can fail, even if the safety is engaged. You should always assume that a firearm is loaded when handling it.

#### **NEVER**

- Risk an accidental discharge by walking with a loaded firearm when going through or climbing obstacles such as a fence or other obstructive barriers.
  - Rely on your gun's safety mechanisms.
  - Sleep with a loaded firearm in your possession.
- 13) **Always keep your rifle in the same mechanical and structural configuration as it was when it was manufactured.** This rifle was produced under specific manufacturer guidelines and should not be altered or changed under **ANY** circumstances. Performing conversions by altering the trigger, mechanical components, safety mechanisms, or using any other products other than those provided in the original box is **NOT RECOMMENDED** by the manufacturer, and could result in death, bodily harm, or compromising your safety or the safety of others. Any alteration made to the firearm also voids the factory warranty. Like any mechanical device it is subject to normal wear and tear from use. In order to maintain optimal safety and performance it should be periodically serviced. You must regularly clean and lubricate your firearm to maintain its functionality, accuracy, safety, and reliability. Always before cleaning or lubricating any firearm make sure that you perform a safety check to make sure that the firearm is completely unloaded prior to performing any routine maintenance. If for some reason your firearm does require repairing, you must contact the U. S. importer for an approved service provider. Using unauthorized personnel to repair your firearm will void your manufacturer's warranty.

#### **NEVER**

- Alter, convert, or change your firearm from its original manufacturer's configuration.
- 14) **Always make sure the barrel is clear of any obstructions before shooting.** Before loading always perform a safety check to make sure that there is no ammunition in the chamber or magazine. Examine the barrel for any obstructions or debris such as excess lubricant, dirt, or grease. If the bore is obstructed, it can cause increased pressure causing the barrel to bulge or burst during use. Always use a cleaning rod and patch to remove any residues or obstructions in the barrel. Be familiar with your firearm. If the noise or recoil seems muffled or weak then **STOP!** And proceed to unload your firearm and check to make sure nothing is lodged in the barrel.

#### **NEVER**

- Try to shoot out an obstruction by loading another shell and firing.

## Safe Handling Procedures

- Do **NOT** alter or modify your FR-15 firearm!
- **ALWAYS HANDLE YOUR FIREARM AS IF IT IS LOADED!**
- **NEVER** point your firearm at anything you don't intend to shoot.
- Always make sure your firearm is not loaded and the bolt is latched open and to the rear before laying it down or handing it to someone else.
- **NEVER LEAVE A LOADED FIREARM UNATTENDED!**
- Always be sure the bore, muzzle, chamber and action are clear of obstruction.
- Always check that ammunition is clean and undamaged.
- Never drink alcoholic beverages or use drugs before or during shooting.
- Always wear ear and eye protection when shooting.
- Always keep the safety on "SAFE" when the firearm is loaded and a round is chambered until you are ready to shoot.
- NEVER attempt to fire if water is in the bore.
- NEVER indulge in horseplay when holding your firearm.

**ALWAYS PRACTICE SAFE FIREARMS HANDLING!**

## Dangerous Procedures

- Be sure the cam pin is installed in the bolt assembly. If it isn't, your rifle can still fire but it could possibly explode, causing you person injury or death
- Do NOT exchange or switch bolt assemblies from one rifle to another. It could cause harm to you and others and damage your rifle
- If your firearm fails to fire, hold it, keep it pointed towards the target and wait 30 seconds. If a hang fire has occurred, the round will fire within 30 seconds. If the round does not fire (misfire), remove magazine, eject round and examine the primer. If firing pin indent is light, misaligned or non-existent, have your firearm examined by a certified armorer. If firing pin indent on primer appears normal (in comparison to previously fired rounds) assume faulty ammunition; appropriately dispose of misfired round from other live ammunition, reload and resume firing.
- If your bolt fails to unlock and you try to free it by banging the buttstock on the ground, keep yourself clear of the muzzle!
- If there is water in the barrel, do NOT fire the rifle, it could explode!
- If you notice a difference in sound and recoil, STOP FIRING. Either condition could indicate an incomplete powder burn and/or a bullet stuck in the bore.

**ALWAYS PRACTICE SAFE FIREARMS HANDLING!**

## Disclaimer

The firearm in which these safety rules apply is sold under the expressed conditions that the manufacturer accepts no liability in part or whole for bodily injury, death, or property damage from:

- Improperly or carelessly handling the firearm.
- Using defective, improper caliber, hand-loaded, or reloaded ammunition.
- Inadequate maintenance of the rifle resulting in corrosion or damage.
- Negligence of malfunctions.
- Resale in contradiction of any applicable laws or regulations.
- Altering or converting the firearm's original aesthetic, functioning mechanisms, accessories, or mechanical configuration.
- Discharging with criminal intent or negligence.
- Failure to understand, adhere to, and follow the rules of firearm safety when using or handling the firearm.
- Any other circumstances outside the manufacturer's direct or immediate control.

## Serial Number of the Firearm

The serial number is located on various parts of the firearm. Each serial number is specific to that firearm and is used for identification and registration. It is recommended that you record your serial number in your manual and keep the information in a secured location.

# INTRODUCTION TO FEDARM SPORTING ARMS

We at FedArm thank you for the privilege of delivering a quality product to you that will provide you with years of pleasurable use.

## About Your FR-15 Semi-Automatic Rifle

Your FR-15 model rifle is a lightweight, gas operated, air-cooled, magazine-fed, shoulder-fired weapon that is fired in a semi-automatic mode. The upper and lower receivers are easily opened for cleaning and inspection. The bolt assembly and barrel extension are designed with locking lugs that lock the bolt assembly to the barrel extension. The forged and billet upper and lower receivers reduce the weight of the rifle. Muzzle velocity is approximately 3260 feet per second at a chamber pressure of 52,000 psi. The maximum effective rate of fire is 45 rounds per minute in semi-automatic mode. The maximum effective range is 550 meters for individual and point targets, and 800 meters for area targets. Maximum range is 3534 meters.

## Parts of Your Rifle

The orientations shown in Figures 1 and 2, refer to the sides of your rifle when it is shouldered. Figure 3 displays the upper and lower receivers, and figure 4 details the bolt assembly parts.



Figure 1. Right side view

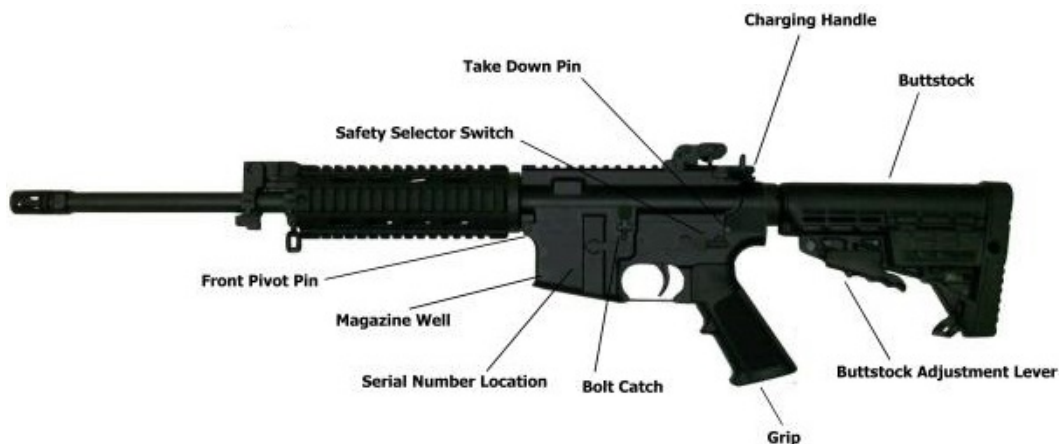
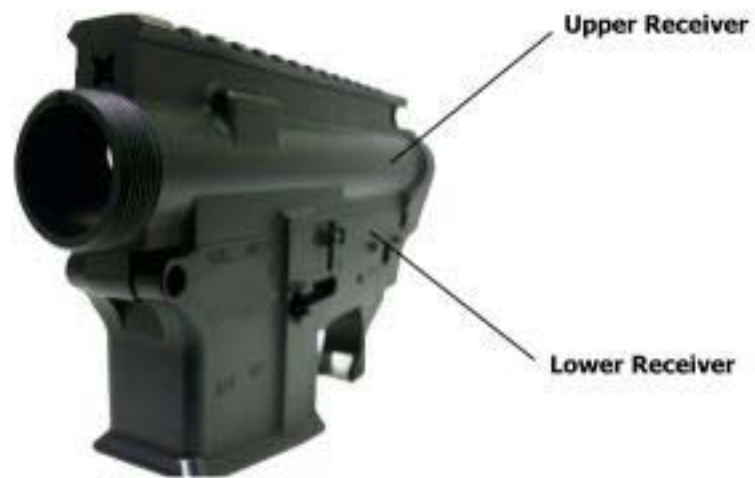
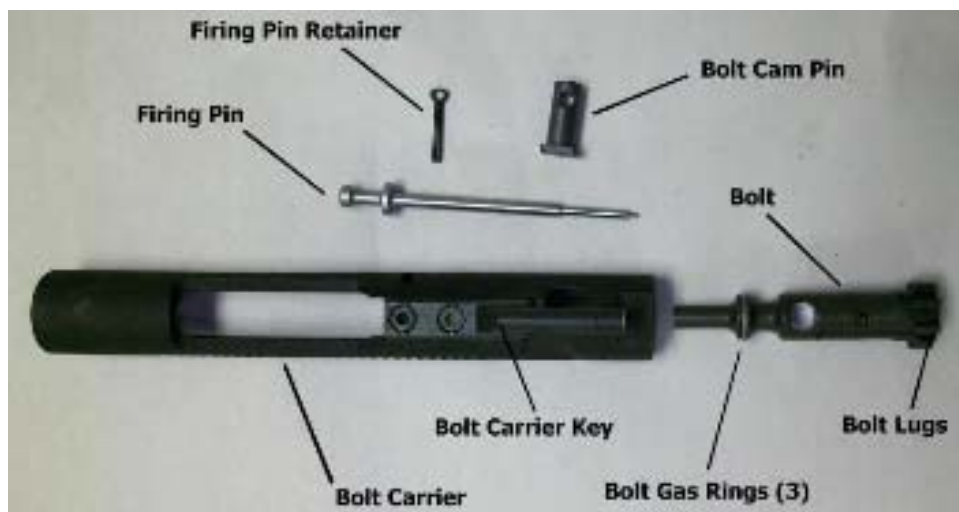


Figure 2. Left side view



**Figure 3. Upper and lower receivers**



**Figure 4. Bolt assembly parts**

# OPERATING YOUR FR-15 FIREARM

## Safety Selector

The selector lever, located on the left of lower receiver, has two positions, "FIRE" (figure 5) and "SAFE" (figure 6). When set to "FIRE" the firearm will fire a single shot each time the trigger is pulled. When set to "SAFE" a cam bears upon the rear of the trigger, blocking movements and preventing the hammer from being released.



Figure 5. Safety selector – "FIRE"



Figure 6. Safety selector – "SAFE"

## Loading the Magazine

1. Use only quality ammunition suitable for your firearm.
2. With the magazine facing forward (figure 7), place a round between the lips of the magazine with the bullet tip forward. Push the round down until it is held by the magazine lips.
3. If necessary, slightly push the round backward to seat it against the back edge of the magazine lips. Place the next round on top of the previous round and repeat steps until the desired amount of rounds is achieved.

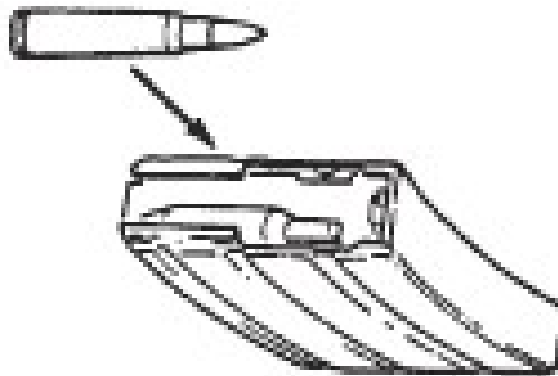


Figure 7. Magazine loading

## Loading your Rifle

**WARNING: 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 YOUR RIFLE. DO NOT DISENGAGE THE SAFETY UNTIL YOU ARE READY TO FIRE AND HAVE THE RIFLE POINTED SAFELY DOWNRANGE**

1. Press in on the bottom of the bolt catch while pulling back the charging handle. This will cock the hammer which positions the bolt carrier to the rear.
2. Return the charging handle fully forward until it locks in place and remove your finger from the bolt latch.
3. Set the selector to the "SAFE" position.
4. With the bullets pointing forward, insert the loaded magazine into the magazine well and push it up until it stops and is retained by the magazine catch.
5. With the rifle pointed in a safe direction, press in on the top of the bolt catch. This will release the bolt carrier and move a round into the chamber. The rifle is now loaded with a round in the chamber and the hammer cocked.
6. The ejection port cover (dust cover) can be closed and will open when automatically when the first round is fired.
7. Do not disengage the safety until the rifle is pointed in a safe direction and you are ready to fire.

## Firing your Rifle

1. Always wear ear and eye protection when firing your weapon.
2. Load firearm as previously described.
3. Before firing your rifle, practice your stance, aim, rhythm and breathing for steady aim with your firearm unloaded. Practice firing on a range before going hunting or using your firearm for any other type of shooting.
4. Grasp firearm with one hand on the handguard and other hand on pistol grip with trigger finger resting alongside of trigger guard. Raise firearm and pull the buttstock firmly into shoulder.
5. Keeping steady aim, place trigger finger on the trigger and squeeze gently until the trigger releases the hammer. Do not jerk the trigger as you will disturb your aim and ruin your accuracy.
6. To fire the next round and subsequent rounds, all that is necessary is to release the trigger and squeeze it again after every shot until the magazine is emptied.
7. This is a semi-automatic firearm and is immediately loaded and ready to fire after each shot until magazine is empty.
8. If the bolt fails to lock automatically, press the forward assist button to lock it in. If this action is necessary, it is usually a sign that your rifle needs to be cleaned, especially in the lug area of the upper receiver.
9. Once the magazine is emptied, release the trigger, remove finger from trigger, and set selector lever to "SAFE". If you have fired the last round from magazine, the bolt carrier will be held to the rear so that you can quickly reload by replacing the magazine or the chamber can be checked to ensure it is empty.

## Clearing the Chamber (Unloading)

**WARNING:** 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 YOUR RIFLE.

1. Press the magazine release to remove the magazine from the rifle.
2. Press in on the bottom of the bolt catch while pulling back the charging handle. This will cock the hammer which positions the bolt carrier to the rear.
3. If there is a round or a spent cartridge in the chamber, it will be ejected.
4. Return the charging handle fully forward until it locks in place and remove your finger from the bolt latch.
5. Set the selector to the “safe” position.
6. Inspect the chamber making sure it is empty.
7. With the rifle pointed in a safe direction, press in on the top of the bolt catch. This will release the bolt carrier.
8. Close the ejection port cover (dust cover).



# MAINTAINING YOUR FR-15 FIREARM

## Rifle Disassembly

**WARNING:** BEFORE DISASSEMBLY, REMOVE THE MAGAZINE, CLEAR THE CHAMBER AND MAKE SURE THE FIREARM IS IN THE “SAFE” POSITION.

1. Make sure the bolt assembly is in the forward (battery) position.
2. Slide the take down pin out, the firearm will now pivot forward (figure 8).
3. To completely separate the lower receiver from the upper receiver, slide the front pivot pin out (figure 9)
4. To disengage and remove the bolt assembly, pull the charging handle back and remove the bolt assembly (figure 10).
5. Align the ears of the charging handle with the notch in the upper receiver to remove the charging
6. Handle assembly (figures 11a and 11b).



Figure 8. Bolt assembly in forward (battery) position

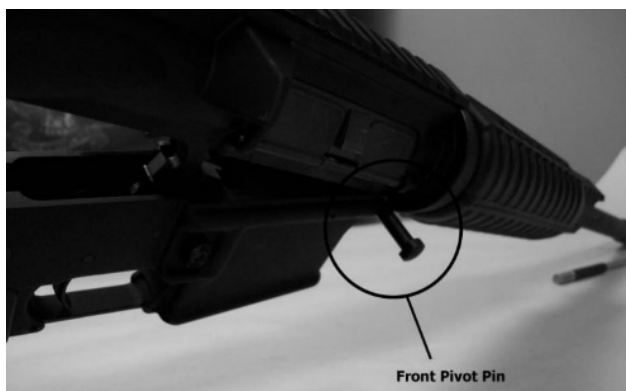


Figure 9. Removal of front pivot pin

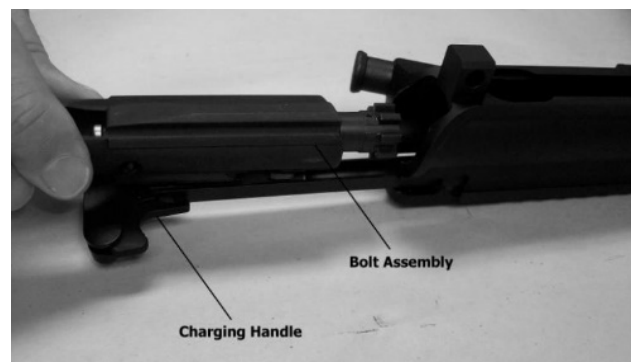


Figure 10. Remove bolt assembly

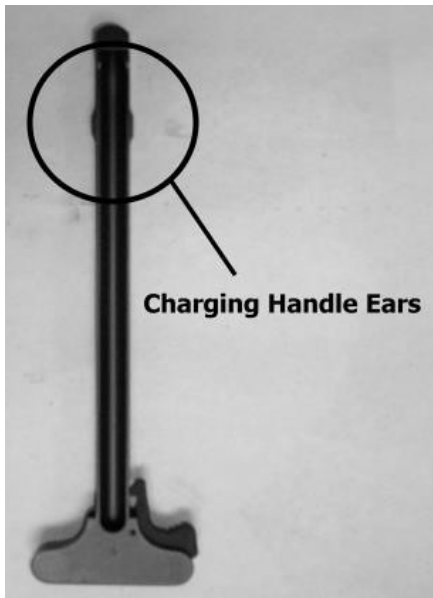


Figure 11a. Handle assembly

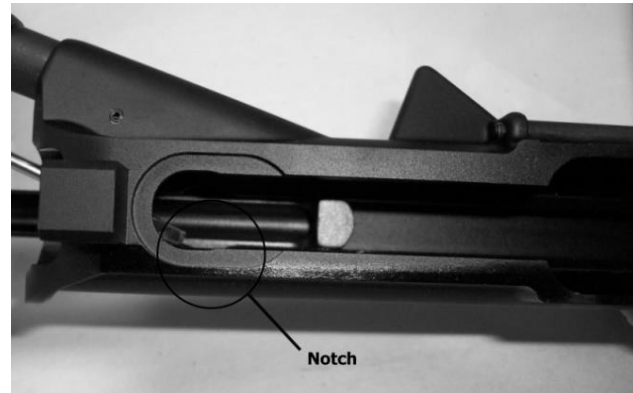


Figure 11b. Handle assembly

## Disassembling the Bolt Assembly

1. Remove the firing pin retainer (figure 12a)
2. Remove the firing pin (figure 12b)
3. To remove the bolt cam pin, extend the bolt completely, turn the cam pin 90° (1/4" turn), push bolt back into the carrier so that cam pin clears the gas key, then slide the cam pin out (figure 12c).
4. Inspect the cam pin for wear.
5. Before removing the bolt from the bolt carrier, note the orientation of the extractor and ejector (figure 12d).
6. Once the bolt is removed, inspect the gas rings and lugs for wear. If excessive wear is present, take parts to a certified armorer for replacement or repair.
7. Inspect the bolt key to ensure that it is tight, if loose, take to a certified armorer for repair.

**STOP! FURTHER DISASSEMBLY IS NOT RECOMMENDED**

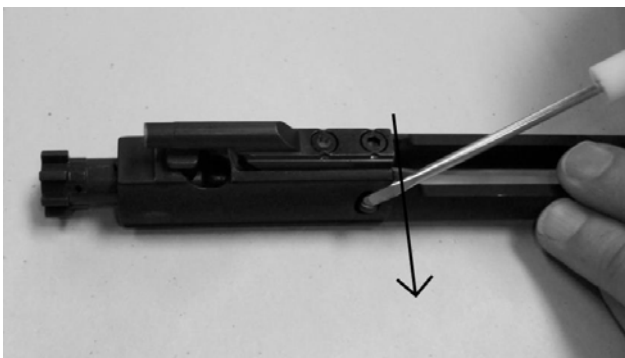


Figure 12a. Firing pin retainer removal

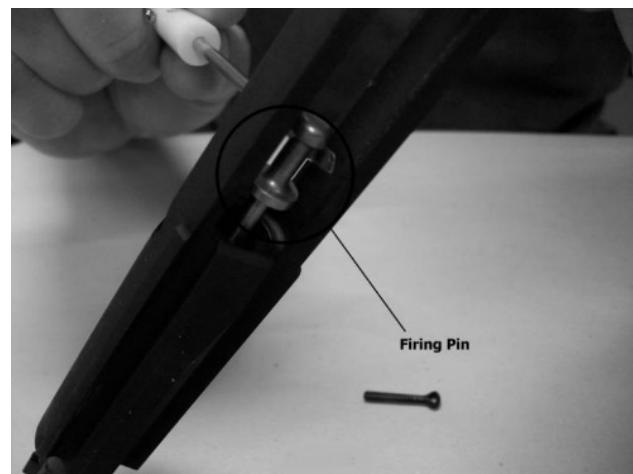
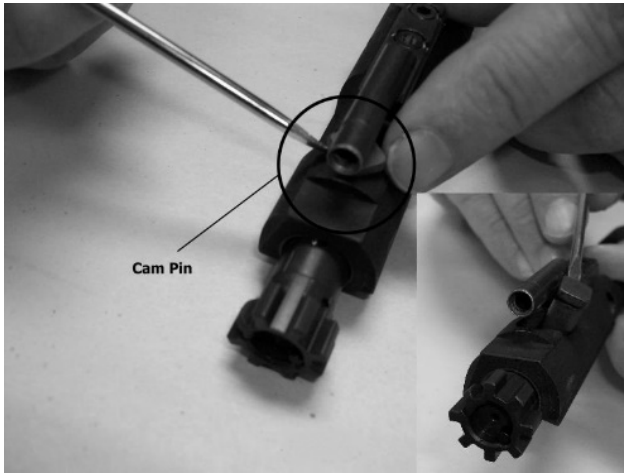
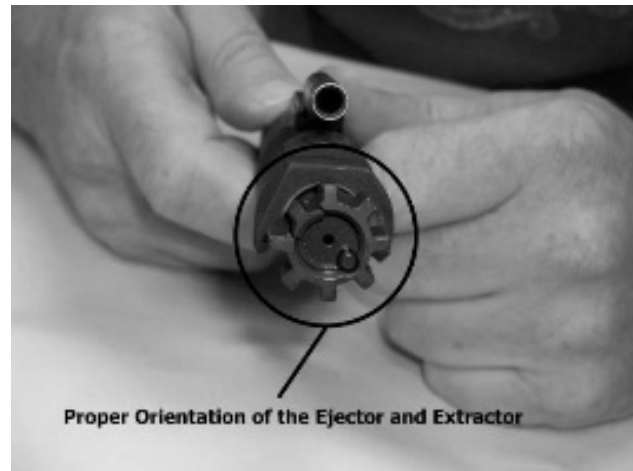


Figure 12b. Firing pin removal



**Figure 12c. Remove cam pin**



**Figure 12d. Extractor and ejector orientation**

## Cleaning your Firearm

Once the FR-15 rifle is field stripped, it can be properly cleaned. You will need a cleaning rod and bore brush appropriate for the caliber of your rifle as well as solvent and gun oil. You will also need some cloth cut into 1/2" square patches. You may use a bore snake, but it is not necessary.

Using the cleaning rod, run a cloth patch dipped in solvent down the bore of the barrel, preferably in the direction of fire, and follow it with clean cloth to absorb the majority of solvent. Dip the bore brush in solvent, and run it straight up and down through the barrel for several passes. Rotate the brush during the last pass to dislodge any particularly stubborn traces of metal. Do not "scrub" as this may damage the rifling. Pass clean cloth patches down the barrel until they emerge clean, or repeat the above steps if they continue to emerge dirty. When finished with the bore, wipe down the outside of the barrel with a lightly oiled cloth.

Using a clean cloth, wipe away any visible deposits of gunpowder residue, grime, dust, dirt, and other markings that may exist inside the upper receiver and around the lug area. You may use solvent for any stuck deposits, but be sure to wipe all solvent away afterwards. The bolt assembly parts and other difficult to clean parts can be soaked in soap (liquid detergent) and water for 5 minutes, but be sure to clean and dry them off immediately. Afterwards, use a clean cloth to wipe away any fingerprints and body oils built up from handling.

After assembly, wipe down the magazine, the receivers, and other exposed metal surfaces with a lightly oiled cloth. If the rifle will be in storage for an extended period of time, also apply a light coating of gun oil to the inside of the barrel and chamber to prevent corrosion. Make sure to store the rifle in a dry location.

**WARNING! BEFORE REASSEMBLING YOUR RIFLE, ALL PARTS MUST BE COMPLETELY DRY!**

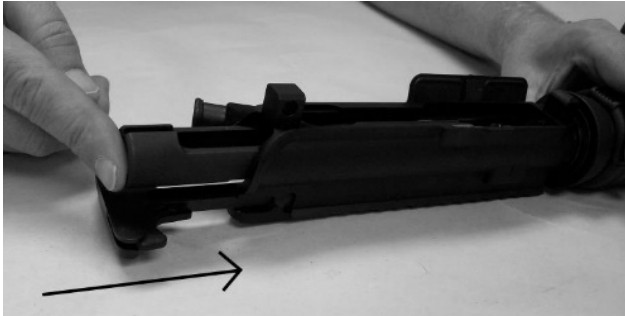
## Reassembling the Bolt Assembly

1. Reinsert the bolt into the bolt carrier, note the orientation of the lugs in figure 12d.
2. Reinsert the cam pin and rotate 90°, refer to figure 12c.
3. Reinsert the firing pin making sure it is seated completely back.

4. Reinsert the firing pin retainer
5. After assembly, make sure the bolt moves freely and that the firing pin is captured correctly.

## Rifle Assembly

1. Reinsert the charging handle into the upper receiver by aligning the ears of the charging handle with the notch in the upper receiver, refer to figures 11a and 11b. Charging handle must be seated at the bottom of the slot in the upper receiver. Slide the charging handle forward approximately 1/4".
2. With the bolt fully extended, reinstall the bolt assembly into the upper receiver using the slot in the charging handle as a guide. See figure 10.
3. Slide the bolt assembly into the forward (battery) position, note that the charging handle moves with the bolt carrier (figure 13 and figure 14).
4. Line up the upper and lower receiver pivot pin holes and slide the front pivot pin into the locked position (figure 15 and figure 16).
5. Pivot the receivers together and slide the take down pin into the locked position. Refer to figure 8.
6. The firearm is now assembled.



**Figure 13. Replacing bolt assembly**



**Figure 14. Replacing bolt assembly**



**Figure 15. Front pivot pin**



**Figure 16. Front pivot pin in locked position**

## Function Test

**WARNING: BEFORE PERFORMING A FUNCTION TEST, REMOVE THE MAGAZINE AND CLEAR THE CHAMBER AND KEEP THE FIREARM POINTED IN A SAFE DIRECTION.**

1. Pull the charging handle fully to the rear and release. Make sure the bolt assembly returns to the forward (battery) position.
2. Move the selector to the “SAFE” position.
3. Pull the trigger to check that the safety is working correctly.
4. Move the selector to the “FIRE” position.
5. Pull the trigger to check that the firing pin is working properly. Note that “dry firing” this rifle will not damage it in any way.

## Storing your Rifle

**WARNING: BEFORE STORING, REMOVE THE MAGAZINE AND CLEAR THE CHAMBER.**

1. After clearing the chamber, check that the bolt assembly is in the forward (battery) position.
2. Point the gun in a safe direction and check that the trigger is in a “fired” state
3. Close the dust cover
4. Store the rifle in its case in a safe area.
5. If storing your rifle for an extended period of time, use a lite oil in the barrel and chamber to prevent corrosion.

# TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Won't fire</b>	Selector lever on "safe"	Select "fire"
	Improper assembly of the firing pin.	Assemble correctly
	Defective ammunition	Remove and discard
	Too much carbon on firing pin or in the firing pin recess	Clean
<b>Bolt won't unlock</b>	Dirty or burred bolt	Clean or see a certified armorer
<b>Won't extract</b>	Broken extractor spring	See a certified armorer
	Dirty or corroded ammunition	Remove stuck round
	Carbon in the chamber	Clean the chamber
	Fouling or carbon in the extractor recess tip	Clean the extractor
<b>Won't feed</b>	Dirty or corroded ammunition	Clean
	Dirty magazine	Clean
	Defective magazine	Replace
	Too many rounds in magazine	Take out excess
	Magazine not fully seated	Adjust magazine catch
<b>Double feed</b>	Defective magazine	Replace
<b>Won't chamber</b>	Dirty or corroded ammunition	Clean
	Damaged ammunition	Replace
<b>Won't lock</b>	Dirt, corrosion or carbon buildup in the barrel locking lugs	Clean lugs
<b>Won't extract</b>	Frozen extractor	Remove and clean
	Restricted movement of the bolt carrier	Remove and clean
	Restricted buffer assembly	Remove and clean
<b>Short recoil</b>	Alignment of gaps of the bolt gas rings	See a certified armorer
	Carbon or dirt in the bolt key or on the outside of the gas tube	Clean the bolt key and the area around the gas tube
	Foreign object stuck in the bolt key	Clean if possible or see a certified armorer

PROBLEM	POSSIBLE CAUSE	SOLUTION
<b>Bolt fails to lock after the last round</b>	Dirty or corroded bolt latch	Clean the bolt latch, check for buffer endcap obstruction and check for full travel of the bolt carrier
<b>Selector lever binds</b>	Dirt or sand under the trigger	Clean
<b>Bolt carrier is hung up</b>	Round is jammed between the bolt and charging handle and/or double feed	<p>Remove the magazine, push in on the bottom of the bolt latch. While pulling down on the charging handle, bang the rifle butt on the magazine well. Ground. The bolt should lock to the rear. While the bolt is held to the rear, the round should fall through the magazine well</p> <p><b>WARNING! KEEP CLEAR OF THE MUZZLE. AFTER THE ROUND IS REMOVED, THE BOLT IS UNDER TENSION</b></p>

## Parts

To order parts, please be ready with the following information: Your name, address, telephone number, firearm serial number, make and model and payment information. Call the Federal Armament Service Department at 1-888-652-6660.

## Parts List

### Barrel Parts

Part Number	Description
FM-04	Barrel 16 Hbar 1-9 twist
FM-31	Flash hider
FM-71	Crush washer
FM-06	Barrel nut
FM-107	Front swing swivel
FM-106	Front swivel rivet
FM-105	Front sight base
FM-56 (OPTION)	Front sight post
FM-55	Front sight detent
FM-57	Front sight detent spring
FM-58	Front sight taper pin
FM-60 (CAR)	Gas tube, car
FM-61	Gas tube roll pin
FM-66 (CAR)	Handguard A2 carb.
FM-65-750	Handguard car, m4 notched .750
FM-32	Delta ring
FM-07	Snap ring
FM-101	Weldon spring

### Upper Receiver Parts

Part Number	Description
	Forged flat top upper receiver
FM-27	Charging handle body
FM-28	Charging handle latch
FM-30	Charging handle spring
FM-29	Charging handle roll pin
FM-35	Ejection port cover
FM-37	Ejection port cover rod
FM-36	Ejection port cover snap ring
FM-38	Ejection port cover spring
FM-47	Forward assist assembly
FM-53	Forward assist spring
FM-52	Forward assist pin



## Lower Receiver Parts

Part Number	Description
	Forged lower receiver
FM-23	Buttstock body assembly
FM-21	Mil-spec receiver tube
FM-26	Receiver tube nut
FM-02	Receiver end plate
FM-17 (CAR)	Car buffer
FM-20 (CAR)	Car buffer spring
FM-72	Pistol grip
FM-73	Pistol grip lock washer
FM-74	Pistol grip screw
FM-19	Buffer detent spring
FM-18	Buffer detent
FM-97	Trigger guard pin
FM-96	Trigger guard. Metal
FM-98	Trigger and hammer pin 2x .41 ea
FM-75	Front pivot pin
FM-94	Take down pin
FM-93	Take down detent spring 2x .12ea
FM-92	Take down detent 2x .15 ea
FM-68	Magazine catch
FM-69	Magazine catch button
FM-70	Magazine catch spring
FM-11	Bolt catch
FM-13	Bolt catch roll pin
FM-14	Bolt catch spring
FM-12	Bolt catch detent
FM-91	Selector spring
FM-90	Selector detent
FM-89	Selector
FM-34	Disconnect spring
FM-33	Disconnect
FM-99	Trigger spring
FM-95	Trigger
FM-64	Hammer spring
FM-62	Hammer
FM-103	30 round magazine 2x 12.37ea
FM-CABLK	Black hard case with foam padding

## Bolt Parts

Part Number	Description
FM-10	Bolt carrier, stripped
FM-16	Bolt carrier key
FM-16	Bolt carrier key screw
FM-09	Bolt cam pin
FM-59	Bolt gas rings, 3 per set
FM-08	Bolt, stripped
FM-42	Extractor
FM-43	Extractor pin
FM-44	Extractor spring and bumper
FM-39	Ejector
FM-40	Ejector roll pin
FM-41	Ejector spring and bumper pad
FM-45	Firing pin
FM-46	Firing pin retainer

## For Service:

Ship the firearm prepaid to:

Federal Armament LLC  
5701 South 73rd Place  
Fort Smith, AR 72903

## Thank You

Thank you for purchasing a FedArm rifle. We are sure this gun will bring you years of hunting and/or shooting pleasure. Your satisfaction is the key to our success. Please let us know if we can be of service and relay any observations about your gun's performance or appearance. For your questions or comments, please visit [www.fedarm.com](http://www.fedarm.com).

# SERVICE AGREEMENT AND LIMITED WARRANTY

FedArm agrees to service its products free of charge for defects in materials and workmanship in accordance with the service agreement listed below. The obligation of FedArm under this agreement is limited to the repair or replacement of unserviceable parts and does not cover any incidental or consequential damages. Other than the express warranty contained herein, FedArm makes no warranties, expressed or implied.

FedArm will repair or replace any unserviceable part(s) for one (1) year from the date of manufacture in accordance with the above warranty statement provided your firearm had not been altered, abused, willfully damaged, or damaged by overpressure ammunition. This agreement is not transferable.

To obtain service during the time this agreement is in effect, make sure your firearm is unloaded and send it to Federal Armament LLC with proof of purchase from a certified FedArm dealer.

This agreement and the warranties contained herein do not apply to OEM manufactured firearms, firearms sold without warranties, or some firearms sold by non-listed/certified FedArm dealers.

Please visit [www.fedarm.com](http://www.fedarm.com) to fill out and submit a warranty.

## Shipping

When returning your firearm for service, please take care in packing. Disassemble your gun, wrap in a safe manner and place it in its original box. (THIS BOX WILL PROTECT THE GUN BUT IS NOT DESIGNED FOR SHIPPING.) Wrap the original box in a cardboard box approved for interstate shipping. FedArm is not responsible for damages incurred during shipping.



**Federal Armament LLC**

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Fort Smith, AR 72903

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