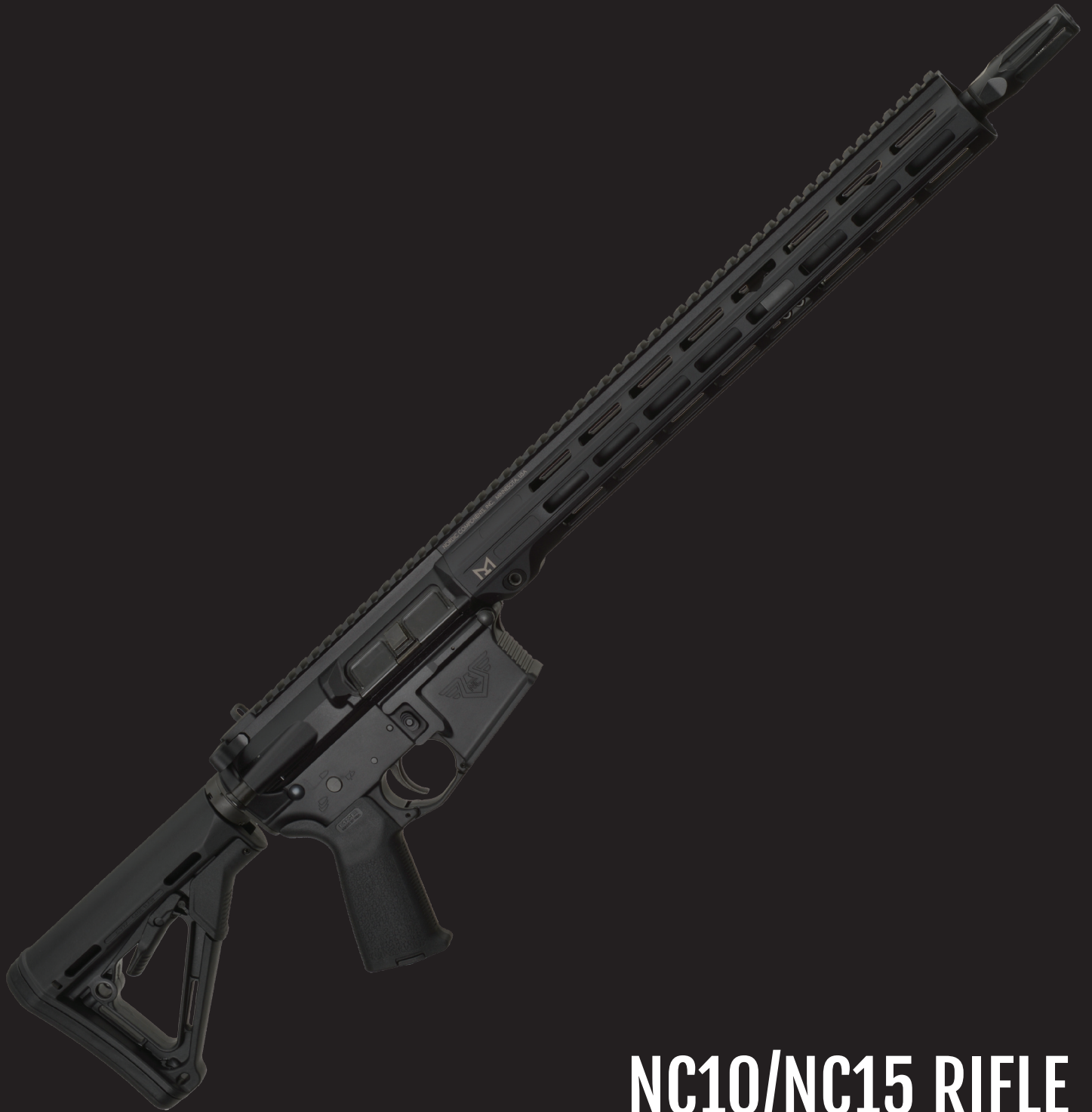




NORDIC COMPONENTS



**NC10/NC15 RIFLE
OWNER'S MANUAL**

Thank you for choosing Nordic Components!

Your new Nordic rifle is ready to use right out of the box, but before you get started, please carefully study and diligently practice the safety and operational procedures outlined in this instructional manual.

Doing so will ensure years of reliable service while maintaining a safe and enjoyable shooting experience for yourself and those around you.

LIMITATION OF LIABILITY

PRODUCTS ARE SOLD BY US WITH THE EXPRESS AND SPECIFIC UNDERSTANDING THAT NORDIC COMPONENTS, INC. IS NOT RESPONSIBLE IN ANY WAY FOR:

PHYSICAL INJURY, INCLUDING, BUT NOT LIMITED TO, HEARING LOSS OR EYE DAMAGE RESULTING FROM FAILURE TO TAKE ADEQUATE PRECAUTIONS WHILE SHOOTING

PROPERTY DAMAGE RESULTING IN WHOLE OR IN PART FROM CRIMINAL OR NEGLIGENT DISCHARGE

UNSAFE, IMPROPER USE, OR CARELESS HANDLING BY THE USER

UNAUTHORIZED MODIFICATIONS

DEFECTIVE, IMPROPER, RELOADED, HAND LOADED, OR NON-STANDARD AMMUNITION OR IMPROPER CALIBER USAGE

CORROSION, ABUSE OR NEGLECT

OR OTHER INFLUENCES BEYOND OUR DIRECT AND IMMEDIATE CONTROL.

PURCHASE AND USE OF THIS PRODUCT IMPLIES CONSENT TO THESE TERMS.



Warranty Information

NO WARRANTY CARD HAS BEEN INCLUDED WITH THIS NEW NORDIC COMPONENTS FIREARM

The Magnuson-Moss Act (Public Law 93-637) does not require any seller or manufacturer of a consumer product to give a written warranty. It does provide that if a written warranty is given, it must be designated as “limited” or as “full” and sets minimum standards for a “full” warranty. Nordic Components, Inc. has elected not to provide any written warranty, either “limited” or “full”, rather than to attempt to comply with the provisions of the Magnuson-Moss Act and the regulations issued thereunder. There are certain implied warranties under state law with respect to sales of consumer goods. As the extent and interpretation of these implied warranties varies from state to state, you should refer to your state’s law.

Local, State & Federal Restrictions

According to the NRA-ILA website; “There are estimated to be more than 20,000 gun laws in America at the federal, state and local levels and laws vary greatly from state to state and, in some states, from locality to locality. Since 1968 virtually every aspect of lawful firearms commerce from manufacture to retail sales has been strictly controlled and regulated by the federal government.” It is your responsibility to educate yourself on the laws pertaining to firearms ownership, transfer, transport, and storage in your area.

Questions/Concerns

If, at any time, you are unclear on any of the safety or operational procedures discussed in this manual or are having difficulties with your firearm, please contact Nordic Components, Inc. for assistance at 952-442-8900 or email sales@nordiccomp.com. Our customer service and technical support departments are available to you should you have any questions or concerns.

We make every effort to supply products in the best possible condition; however, issues can arise from time to time. If there is a problem with our product, or if a shipment was damaged in transit, call us immediately for assistance and instructions at **952-442-8900**. Remember that it is illegal to ship a firearm and ammunition in the same package. Ammunition must be shipped separately.



SAFETY IS CRITICAL TO PERFORMANCE

Your Nordic rifle is only as good as the hands that hold it. You can never be too careful. Frequently, firearms accidents are the result of carelessness or inattentiveness such as failing to control the direction of the muzzle, failing to properly engage the safety, leaving the rifle loaded or using improper ammunition. This carelessness can result in the destruction of life, limb or property. The principles of safe firearm handling and storage must be known before you unpackage your rifle; there are no do-overs.

Function and performance of your firearm depends on proper use and maintenance, so the information in this instruction book must be known and understood. Not all firearms are the same, and there can be new information for even the most experienced firearms owner. To handle your firearm safely, you must first learn the features and requirements of your new rifle.

The **Ten Commandments of Firearm Safety** should be etched in your memory forever and should dictate your action anytime you're involved with firearms -- in the field, on the range, or in your home. Take the time to review and understand these rules.

1st Commandment: Always keep the muzzle pointed in a safe direction

This is the most important firearm safety rule. A safe direction is one in which an accidental discharge will not cause injury to yourself or others. Never allow your firearm to point at anything you don't intend to shoot. Be especially careful when you're loading or unloading. Treat every firearm as if it were loaded. Make it a habit to know where the muzzle is pointed at all times, even when your firearm is unloaded. Even if you have a negligent or accidental discharge, as long as the muzzle is pointed in a safe direction, no one should be harmed.

2nd Commandment: Firearms should be unloaded when not actually in use

Load your firearm only when you're in the field or on the range and ready to fire. Never let a loaded firearm out of your sight or out of your hands. Unload it as soon as you're finished shooting. Remember, unloading your firearm means unloading it completely, so there is no ammunition in the chamber or in the magazine. Before handling a firearm or passing it to someone else, visually check the chamber, receiver and magazine to be certain they do not contain ammunition. Always keep the firearm's action open when not in use. Never assume a firearm is unloaded -- always check for yourself.



- Let common sense rule when you carry a loaded firearm. If you're in a situation that could risk accidental discharge - such as crossing a fence, wading through a stream or climbing a tree - always unload your firearm. Never pull or push a loaded firearm toward yourself or another person. Never carry a loaded firearm in a scabbard, detached holster or gun case.
- Certain firearms are equipped with internal security devices to prevent unauthorized use. In addition, some firearms owners use external devices, such as cable locks and trigger blocks, for the same purpose. Even if you use such a device, you should still keep your firearm unloaded when stored or not in use. Internal or external devices cannot substitute for securing your firearms and ammunition in a separate, locked location.
- Safe storage of firearms is just as critical as safe handling. Never store firearms loaded. Be sure to keep your firearms in a secure place where unauthorized persons cannot get their hands on them without your knowledge.
- Take special care if there are children around. Children are fascinated by firearms. It's a natural curiosity that can have tragic consequences when not properly supervised. Store your firearms in a locked gun safe or some other location that physically bars a child from gaining access.
- Ammunition should be stored and locked in a location separate from your firearm. Never leave an unsecured firearm or ammunition in a closet, dresser drawer or under the bed. Remember, it is your responsibility to make sure that children and others unfamiliar with firearms cannot get access to your firearm and ammunition.

3rd Commandment: Don't rely on your firearm's safety.

Treat every firearm as if it can fire at any time, whether or not there's pressure on the trigger. Your firearm has been carefully designed to maximize performance and safety. However, because a firearm's safety is a mechanical device, it can still fail. Human error is a more likely reason for a firearm safety to fail. By mistake, you may think the safety is on when it really isn't, or the safety may have been disengaged without your knowledge. You could think your firearm is unloaded when there's actually a cartridge or shell in it. A mechanical safety is not a substitute for common sense. It is only a supplemental mechanism to aid proper handling of a firearm by the operator.

Keep your fingers away from the trigger until you're ready to shoot, and when you're loading or unloading. Don't pull the trigger when the safety is engaged or positioned between safe and fire.



Before using your firearm, read this instruction book to understand the exact location and operation of your firearm's safety. Even when the safety is on, maintain control of your loaded firearm and control the direction of the muzzle. In other words, don't rely on your safety to justify careless handling. If your firearm's internal mechanisms are broken or have been altered, your firearm may fire even when the safety is on. Remember, you and your safe firearm handling practices are your firearm's best safety.

4th Commandment: Be sure of your target and what's beyond it.

Once you pull the trigger, you can never call that bullet back. Never fire unless you know exactly where your shot is going and what it will strike. Never fire at a sound, a movement or a patch of color. A hunter in camouflage can easily be mistaken for a target by an impulsive shooter.

Before you pull the trigger be absolutely sure of your target and what's behind it. Make sure the shot has a backstop such as a hillside or dense material like sand. Remember, bullets can travel great distances with tremendous velocity.

Be sure to know where your shot might go if you miss the target or if the bullet is not stopped by the target.

Be aware and mindful of the possibility of ricochets; never shoot at a hard surface or water.

Know how far your shot will go if you miss your target or the bullet ricochets.

5th Commandment: Use proper ammunition.

Each firearm is designed to use a certain caliber or gauge of ammunition. Using the wrong ammunition, mixing ammunition or using improperly reloaded ammunition can cause serious personal injury or death. It only takes one cartridge or shotshell of the incorrect caliber or gauge, or which has been improperly reloaded, to destroy your firearm. It's your responsibility to make sure the ammunition you use exactly matches the caliber or gauge of your firearm. Refer to this instruction book to find out the specific requirements of your firearm. Always read the instructions on ammunition boxes.

Mixing shells or cartridges can cause serious personal injury or death and destroy your firearm. Check your shells or cartridges closely and use only the precise caliber or gauge for your specific firearm.

Check all ammunition before you load it to make sure it matches your firearm's requirements. You'll find the caliber of your new Nordic Components firearm marked on the barrel.



6th Commandment: If your firearm fails to fire when the trigger is pulled, handle with care

If for some reason the ammunition doesn't fire when you pull the trigger, stop and remember the 1st Commandment of Firearm Safety - always keep the muzzle pointed in a safe direction. Keeping your face and hands away from the breech as much as possible, put the safety on, carefully open the action, unload the firearm and dispose of the cartridge safely. Anytime there's a shell in the chamber, your firearm is loaded and ready to use, and could still discharge.

7th Commandment: Always wear eye and ear protection when shooting

Your sight and hearing risk injury from shooting and should be protected at all times. Wear protective shooting glasses to guard against powder residue, ruptured cartridge cases, and debris in the field. Always wear eye protection when you're disassembling or cleaning a firearm so that tensioned parts and cleaning products don't come in contact with your eyes.

Unprotected exposure to shooting noise will permanently damage your hearing. On the range, be sure to use the maximum protection of a protective earmuffs. Learn to use ear protection at all times. Only discharge your firearm in well-ventilated areas.

8th Commandment: Be sure the barrel is clear of obstructions before shooting

Before loading your firearm, open the action and make sure the chamber and magazine are empty. Check the barrel for any obstructions or debris. Even a small amount of snow, mud, or excess lubricant or grease in the bore can dangerously increase pressure and cause the barrel to bulge or burst when firing. Use a cleaning rod and patch to wipe away anti-rust compounds or any other residues or obstructions in the barrel. Never try to shoot out an obstruction by loading another shell and firing!

When firing, rely on your instincts. If the noise or recoil of your firearm seems weak, unload your firearm and be sure nothing is lodged in the barrel. Always be sure you're using the correct ammunition in your firearm and that it's free of obstructions.

9th Commandment: Don't alter or modify your firearm and have it serviced regularly.

Your firearm has been designed to operate according to certain factory specifications. You'll jeopardize your safety and that of others around you by attempting to alter its trigger, mechanical safety or other mechanisms. Never alter or modify your firearm in any way.

Like any mechanical device, a firearm is subject to wear. It must be maintained and periodically serviced to assure safety and performance. Only a qualified service facility should service, repair or modify your Nordic Components firearm. Consult your instruction book for instructions on how to send your firearm to the factory.



Proper cleaning and lubrication are also important to firearm maintenance and are necessary to assure accuracy, safety and reliability. Before cleaning, always make sure that your firearm is completely unloaded. And always clean the barrel from the chamber end to the muzzle when possible.

Make it a practice to clean your bore every time you're going to shoot. Be sure to clean your entire firearm before and after long-term storage and no less than once a year. It's also important to clean your firearm whenever it's been exposed to adverse conditions such as rain, dirt, mud, snow, sleet or saltwater.

For safe and dependable operation of your firearm, all parts of your firearm must be properly cleaned and lubricated. Periodically inspect the internal workings of your firearm to be sure they're clean and free of rust, dirt, and debris.

Use recommended lubricants on your firearm and do not over-lubricate. Excessive use of a non-recommended lubricant could adversely affect the function and safe operation of your firearm. Failure to properly maintain your firearm cannot only damage your firearm, it can cause personal injury or death.

10th Commandment: Learn the mechanics and handling characteristics of your firearm.

Not all firearms are alike. They have different mechanical characteristics that dictate how you should carry and handle them. Anyone who plans to use a firearm should first become totally familiar with the type of firearm it is and the safe handling procedures for loading, unloading, carrying, shooting, and storing it.

Before you unpack your new Nordic Components rifle, read this instruction book from cover to cover and familiarize yourself with the different component parts of the firearm. Then read, understand and follow the Ten Commandments of Firearm Safety in this manual.

There's one other rule that must be followed when handling firearms. Respect for this rule is necessary in order to effectively practice the Ten Commandments of Firearm Safety. The rule is: **SHOOT SOBER!** Firearms and alcohol or drugs make a deadly combination. Never consume anything that would impair your judgment or physical coordination when you're using a firearm. A large number of the shooting accidents that occur involve alcohol or drugs. Be smart. Always shoot sober and stay alive.

LEAD WARNING

Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other chemicals known to cause birth defects, reproductive harm, cancer, and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure.



OPERATION OF THE NC10 AND NC15 RIFLE

Detailed instructions about loading, unloading, and operation of your NC10 or NC15.

Clearing Your Rifle

ALWAYS FOLLOW THE RULES OF SAFE GUN HANDLING. Assume the rifle is loaded, and then proceed according to the following steps to clear the rifle:

1. Point rifle in a safe direction.
2. Place safety selector lever on SAFE. Note: If the rifle is not cocked, the safety selector lever cannot be placed on SAFE.
3. Press magazine release button and remove magazine.



4. To lock bolt open, pull charging handle to rear. **VISUALLY INSPECT THE CHAMBER TO ENSURE IT IS EMPTY.**



5. Hold down the lower portion of bolt release and allow bolt to move forward until it engages bolt catch. Return charging handle to forward position. Make sure the safety selector lever is on SAFE.

Preventative Maintenance Checks & Services

1. With your rifle completely UNLOADED and the bolt locked open, check to see that there is no excessive oil in the bore. If there is, swab it out with a patch and the cleaning rod. Always clean a new rifle before firing. If the rifle is fired with oil, water, or other obstructions in the barrel, excessive pressure may be created causing the rifle to explode.

2. Retract the bolt to ensure free movement between bolt carrier and gas tube.

3. Perform safety function check to ensure that safety selector lever works properly.

Safety Function Check

1. Remove magazine. Pull charging handle completely to rear. Visually check to make sure the chamber is clear and empty, then release the bolt.

2. Place selector lever in SAFE position, point rifle in a safe direction, and pull trigger. THE HAMMER SHOULD NOT FALL.

3. Place safety selector lever in FIRE position. Pull the trigger. THE HAMMER SHOULD FALL.

4. Hold trigger to the rear, pull charging handle to the rear and release charging handle. Then release pressure on the trigger with a slow, smooth motion, without hesitations or stops, until the trigger is fully forward. AN AUDIBLE CLICK SHOULD BE HEARD - THE HAMMER SHOULD NOT FALL.

5. Repeat this safety function test FIVE TIMES. The rifle must not malfunction during any of these five tests. If the rifle malfunctions during any of these tests, stop using the rifle and have it serviced by a gunsmith or contact Nordic Components.



Loading a Magazine

1. Use only quality commercially manufactured ammunition and the caliber specified for use in your rifle. Examine your ammunition to confirm that the ammunition you are using matches the specified ammunition markings on the barrel of your rifle. Examine each cartridge - particularly around the primer. Look for dents, scratches, and other signs of damage. **DO NOT USE DAMAGED OR RELOADED AMMUNITION!**
2. With the magazine facing forward, place a round between the feed lips of the magazine with the bullet facing forward. Push the round down until it is held in place by the magazine feed lips.
3. If necessary, give the round a slight push backward to seat it against the inside back edge of the magazine feed lips. Place next round on top of the previous round and repeat steps until desired number of rounds are loaded in to magazine.

CAUTION: Safe firearms handling dictates that you ONLY LOAD LIVE AMMUNITION INTO YOUR RIFLE WHEN YOU ARE ABOUT TO SHOOT.

Loading Your Rifle

WARNING: ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION THROUGHOUT THE LOADING PROCESS!

1. Place safety selector on SAFE.
2. Pull charging handle completely to the rear and check the firing chamber. Make sure it is CLEAR.
3. Return charging handle to forward, locked position.



4. Push loaded magazine up into magazine well until magazine catch engages and holds the magazine in place.



5. Slap upwards on magazine bottom to make sure it is seated correctly.

NOTE: The magazine may be inserted into the rifle with the bolt assembly open or closed.

6. If the bolt is locked back, push upper portion of bolt release. The bolt should spring forward. This will chamber a round from the magazine into the chamber. If the bolt assembly is closed, pull the charging handle fully to the rear, then release the charging handle, allowing the bolt to spring forward. This will chamber the first round. Never "ride" or "push" the charging handle forward. Let it move forward on its own.



7. Tap the forward assist with the heel of your hand to ensure that the bolt is fully forward and locked. **RIFLE IS NOW READY TO BE AIMED AND FIRED!**



CONDITION: Rifle is now loaded, a round is chambered, and safety selector should be on SAFE.

NOTE: If rifle is not going to be fired right away, make sure the selector is still on SAFE.

WARNING: THE RIFLE CAN FIRE A CHAMBERED ROUND EVEN IF THE MAGAZINE HAS BEEN REMOVED.

WARNING: KEEP THE MUZZLE POINTED IN A SAFE DIRECTION.

Firing Your Rifle

1. Once a round is chambered and you are ready to commence firing, move the safety selector from SAFE to FIRE.
2. Aim at the target.
3. Squeeze the trigger. As the rifle fires, release the trigger.
5. The rifle will automatically eject the spent cartridge and chamber another in preparation for the next shot. The cycle of pulling the trigger to shoot, and the rifle automatically reloading, can be continued until the magazine and chamber are empty. If you stop firing before the chamber is empty, immediately place the safety selector in the SAFE position.

NOTE: After the last round is fired, the bolt carrier will lock to the rear. You can then push the magazine release button to drop the empty magazine, insert a fresh magazine, release the bolt catch, and a new round will be automatically chambered.

WARNING: IF A NOTICEABLE DIFFERENCE IN SOUND OR RECOIL IS EXPERIENCED, STOP FIRING IMMEDIATELY.

Either condition could indicate incomplete powder burn and/or a bullet stuck in the bore. Remove the magazine and retract the bolt to empty the chamber. Check for unburned powder grains in the receiver or bore and for a bullet stuck in the bore. Clean out any unburned powder before resuming firing. If a bullet is stuck in the bore, do not attempt to remove it. Take the rifle to a gunsmith for removal or contact Nordic Components.

WARNING: DO NOT LOAD WITH A HOT CHAMBER - A ROUND MAY "COOK OFF".
Cooking off means that a round may detonate from the heat of the rifle's chamber.

Unloading Your Rifle

WARNING: ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION THROUGHOUT THE LOADING PROCESS!

1. Place safety selector on SAFE.
2. Press magazine release button and remove magazine.
3. Pull charging handle to rear. Press lower portion of bolt release. Bolt should lock open. If a round was in the chamber, it should have been ejected.
4. Visually check chamber through ejection port to make sure chamber is empty.
5. With the magazine removed and the chamber empty, close the bolt by pushing the top of the bolt release to allow the bolt to return forward on the empty chamber.
6. Empty the magazine by sliding the remaining cartridges forward and out of the magazine.

CONDITION: The rifle and magazine are now completely unloaded. Securely store ammunition and rifle separately.



Remedial Actions

IF YOUR RIFLE STOPS FIRING, perform the following immediate actions:

1. Slap upward on magazine to ensure it is fully seated.
2. Pull charging handle all the way back. Observe the ejection of the case or cartridge. Check chamber for any obstruction.
3. If cartridge or case is ejected, or chamber is clear, release charging handle to feed a new round into the chamber. Don't "ride" the charging handle forward.
4. Tap forward assist to ensure bolt is locked.
5. Pull the trigger -- the rifle should fire..

NOTE: If pulling the charging handle fully to the rear does not extract and eject the chambered cartridge or case, then the cartridge or casing may be stuck in the chamber. If this occurs do the following:

1. Remove the magazine.
2. Lock the bolt open.
3. Open the receiver.
4. Remove the bolt Carrier and bolt.
5. Try to tap out cartridge or casing with a cleaning rod.

IF THE CARTRIDGE OR CASE CANNOT BE TAPPED OUT WITH THE CLEANING ROD, TAKE THE RIFLE TO A GUNSMITH OR CONTACT NORDIC COMPONENTS



Bullet Stuck in the Bore

WARNING: IF AN AUDIBLE “POP” OR REDUCED RECOIL IS EXPERIENCED DURING FIRING, IMMEDIATELY CEASE FIRING AND THEN PERFORM THE FOLLOWING STEPS:

1. Place the selector lever on SAFE.
2. Remove the magazine.
3. Lock the bolt to the rear.
4. Use a cleaning rod to check for a bullet in the bore.

WARNING

IF A BULLET IS STUCK IN THE BARREL, FOR REMOVAL, DO NOT TRY TO REMOVE IT. TAKE THE RIFLE TO A GUNSMITH OR CONTACT NORDIC COMPONENTS.

Disassembly

1. Clear the rifle as previously outlined.
2. Push in takedown pin (a punch may help) as far as it will go. Pivot upper receiver from lower receiver.
3. Push in pivot pin.
4. Pivot lower receiver down and away from upper receiver.
5. Remove bolt carrier and bolt.
6. Remove charging handle by pulling back and up until “ears” clear cutouts in receiver.
7. Remove firing pin retaining pin. A metal punch or pliers may help to remove it from the bolt carrier.

NOTE: Wear protective eyewear during disassembly to protect your eyes from spring loaded components.



8. Drop firing pin out of rear of bolt carrier.
9. Push bolt in to locked position.
10. Remove cam pin by rotating 1/4 turn and lifting out (**NC15 ONLY**).
11. Remove bolt assembly from bolt carrier by pulling straight out.

DISASSEMBLE USING STEPS 12 THRU 16 ONLY WHEN DIRTY.

NOTE: Before removing extractor pin, be prepared to stop movement of extractor spring.

12. Remove extractor pin by pushing out with a metal punch. NOTE: Press rear of extractor to check spring function.
13. Remove extractor with spring. CAUTION: Extractor spring may pop out and get lost.
14. With hammer cocked, depress buffer retainer with metal punch to release buffer and spring.

CAUTION: Maintain pressure on buffer as it is under tension from action spring.

NOTE: Hammer must be cocked to allow buffer and spring to clear receiver.

15. Pull out buffer and action spring for cleaning.

NORDIC COMPONENTS DOES NOT RECOMMEND ANY FURTHER DISASSEMBLY OF YOUR RIFLE.



Maintenance Overview

NOTE: DO NOT INTERCHANGE PARTS BETWEEN NC10 AND NC15 RIFLES.

Routine maintenance is critical to keeping your NC10 or NC15 firearm in top working order for years to come.

Inspection, Cleaning, and Lubrication

After firing your rifle, clean it as soon as possible to make the job easier and to avoid allowing the development of any corrosion.

When your firearm has not been fired, you should clean it once or twice a year if you live in a temperate climate, or as often as once a week in a tropical climate. If you get your firearm wet, clean it as soon as possible to avoid the onset of corrosion or rust.

After you have disassembled the rifle, thoroughly clean, inspect and lubricate all parts according to the techniques described below.

WARNING

NEVER CLEAN A LOADED FIREARM. BEFORE CLEANING, COMPLETELY UNLOAD THE RIFLE AND DISASSEMBLE AS NECESSARY.

Detailed Cleaning Techniques

Cleaning the Bore

The bore of your Nordic Components NC10/NC15 rifle has lands and grooves called rifling. Rifling makes the bullet spin as it moves down the bore and down range. It is difficult to push a new, stiff bore brush through the bore. You will find it much easier and more effective to pull the brush through the bore. Also, because the brush will clean better if the bristles follow the grooves, the brush should be allowed to turn as it travels through the bore. A high quality cleaning rod with a ball bearing handle which allows the rod to turn will assist in cleaning your rifle. Do not use a steel cleaning rod, as this can permanently damage the bore.

ALWAYS CLEAN FROM CHAMBER TOWARD THE MUZZLE.



Follow these steps:

1. Assemble your cleaning rod as necessary. Attach the patch holder to cleaning rod.
2. Pointing the muzzle down, hold the upper receiver in one hand while inserting the end of the rod with patch holder attached into the chamber. Carefully guide the rod through the bore.
CAUTION: Do not let the rod or its threaded end scratch the bore or chamber.
3. Moisten a patch with bore cleaner and run it through the bore.
4. Remove the patch holder and attach the bore brush.
5. Pull the brush through the bore and out the muzzle. The rod should turn as you pull it through - as described earlier, this is the brush "tracking" in the rifling. **NEVER** reverse the direction of the bore brush while it is in the bore.
6. After one pull, take off the handle section and repeat the process. After three or four pulls, the three rod sections and the bore brush may become screwed tightly together. Loosen them up and repeat the process.
7. Run a patch through the bore occasionally while using the brush to help clean out debris. Just replace the bore brush with the rod tip (patch holder) and a wet patch. Always have the bore wet with cleaner before trying to pull a brush through.

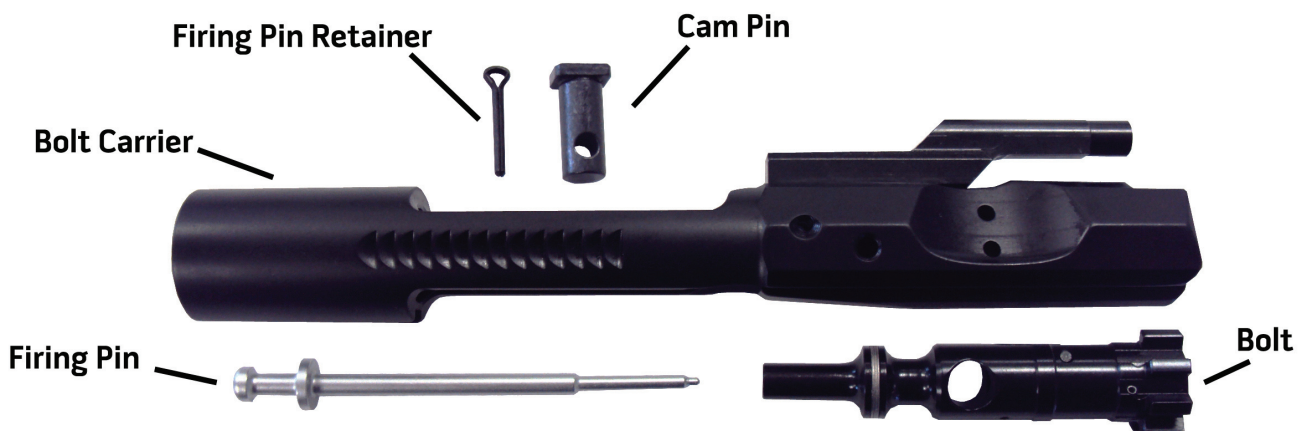


Cleaning the Upper Receiver

NOTE: Check to ensure that the fit between the barrel and the upper receiver is tight - if you detect any movement by twisting with your hands, the barrel nut must be retorqued. Take the rifle to a qualified gunsmith or contact Nordic Components for such maintenance.

1. Using a high quality cleaner, clean the inside and outside of the upper receiver of powder fouling, corrosion and dirt. NEVER use a wire brush or any type of abrasive to clean the aluminum upper receiver - you may damage the finish. A toothbrush or stiff-bristled nylon brush is good for loosening any dirt buildup, and won't scratch the receiver.
2. Clean the chamber. Dip a chamber brush in bore cleaner and use at least five plunge strokes and three 360° clockwise rotations. Swab out the bore as described previously to remove solvent and debris.
3. Use the damp bore brush to clean carbon and powder residue from around the gas tube. Run a pipe cleaner in to the gas tube. Clean the bolt locking lugs, gas rings, firing pin, bolt cam pin, lip of the extractor, and inside the bolt carrier from both front and rear.
4. Wipe all components clean and dry, and inspect for excessive wear, corrosion or mechanical damage. If you notice any excessive wear or damaged components, **DO NOT FIRE THE RIFLE**. Have the rifle inspected by a gunsmith or contact Nordic Components.

Bolt Carrier Group Components (NC15 shown)



Cleaning the Bolt, Bolt Carrier & Components

1. Clean out the gas key on top of the bolt carrier with a cotton swab or a pipe cleaner. Also clean out any carbon/ powder residue from vent holes in the bolt carrier.
2. Clean and inspect bolt, cam pin, firing pin and firing pin retaining pin thoroughly.

CHECK THE BOLT: Look for cracks, especially in the cam pin hole area. Inspect the bolt face. The bolt must be replaced if any cracks, pitting, or other significant damage is found.

CHECK THE CAM PIN: If it is cracked or chipped, it should be replaced. NOTE: cam pin can only be installed in bolt from one side, so ejector will be positioned correctly.

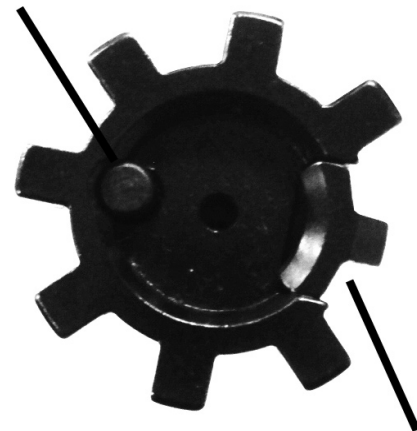
CHECK THE FIRING PIN: If it is bent, cracked, too blunted or too sharp, it should be replaced.

CHECK THE FIRING PIN RETAINING PIN: If it is bent or badly worn, it should be replaced. Never use a generic cotter pin as a substitute for a real firing pin retaining pin. Cotter pins are not made of heat treated spring steel and their round head shape will cause damage to the receiver.

WARNING: IF THE CAM PIN IS MISSING, DO NOT FIRE THE RIFLE - IT MAY EXPLODE!

CHECK THE EXTRACTOR/EXTRACTOR SPRING:
If the extractor is chipped or has broken edges in the area of the lip that engages the cartridge rim, it should be replaced. Check that the rubber insert is inside the extractor spring. Clean off any carbon buildup or powder residue.

Ejector



Extractor

Cleaning/Lubricating the Ejector

NOTE: The design of the ejector makes its disassembly for cleaning impractical - we do not recommend disassembly unless absolutely necessary. Make sure your rifle ejects empty cases efficiently by following these steps (more frequently if firing blanks).

1. With the bolt removed from the bolt carrier and the extractor installed, hold it with the bolt face upward and apply a few drops of oil around the ejector to form a puddle.
2. Take a fired or dummy case and place it under the lip of the extractor. Press the case down against the ejector. Since the ejector is spring loaded, some resistance will be felt. Press on the case until it stops against the bolt face. Ease off with your thumb slightly and press down again. Repeat several times, adding oil as needed. Once the spring action of the ejector is smooth and strong, dry off any excess lubricant.

Cleaning The Lower Receiver

1. Clean all areas of powder fouling, corrosion, dirt and rust. Again, never use a wire brush or any type of abrasive to clean the aluminum lower receiver.
2. Wipe any dirt from the fire control group. Carefully clean the magazine release button and the magazine catch on the left side of the receiver. Also inspect and clean the bolt catch and takedown/pivot pins. Clean the buffer, buffer spring, and inside the lower receiver extension.
3. Telescoping stocks may require cleaning occasionally. The stock latch can be pulled down to remove stock. Clean the six lock holes and lightly lube the receiver extension and latch mechanism.

Lubrication - Upper & Lower Receivers Upper Receiver

Upper Receiver

Lightly lubricate the inside of upper receiver, the bore and chamber (using the cleaning rod and a patch), the outer surfaces of the barrel, and surfaces under the handguards. Be sure you lubricate in and around all the bolt locking lugs. The forward assist should also be lightly lubed inside the receiver and checked for function.



Lower Receiver

Lower Receiver Extension: Lightly lubricate inside the receiver extension, the buffer and the buffer spring. Also lightly lubricate the stock latch and exterior of the receiver extension.

Lower Receiver: Generously lubricate **ALL MOVING PARTS INSIDE THE LOWER RECEIVER** with oil including the trigger, hammer, safety, bolt catch, magazine release, etc., and their pins and detents. Lubricate the takedown and pivot pins and their detents. Use an oiled rag to wipe off any fingerprints on the exterior surfaces.

Bolt Carrier Group

Firing Pin: Lightly lubricate the firing pin and firing pin channel in bolt with oil.

Bolt: Generously lubricate the bolt, its cam pin area, and the gas rings. A lighter application is good on the extractor and its pin.

Charging Handle: Lightly lubricate the charging handle and its latch and spring.

Bolt Carrier: Lightly lubricate the inner and outer surfaces of the bolt carrier. Generously lubricate the cam pin area and the slide rail areas of the bolt carrier where they contact the inside of the receiver.

Carrier Gas Key: The inside of the carrier gas key on the bolt carrier should be dried with a cotton swab or pipe cleaner and lightly oiled.

Reassembly

To reassemble the rifle, follow these steps:

1. Insert buffer spring and buffer (the spring will lock onto the buffer if you slide it on, then push and turn counterclockwise). Depress buffer detent and push buffer in past the detent, then release.
2. Insert extractor and spring. NOTE: Extractor assembly has a rubber insert within the spring. Be sure not to lose it. If the spring comes loose, put the large end of the spring in the extractor and seat it (a metal punch works well).



3. Push down on extractor to depress spring and reinsert extractor pin.
4. At the back end of the bolt, stagger the gas ring gaps to reduce gas loss. Position the three ring gaps 120° apart around the bolt. The rings will slide around in their groove by pushing them into position with a small sharp object.
5. Insert bolt into bolt carrier. Twist into position so cam pin can be inserted (remember that cam pin can only be installed in bolt from one side, so if it doesn't fit right away, twist the bolt 180° and try again).
6. Once cam pin is inserted, twist it 90° (**NC15 ONLY**).

WARNING: THE CAM PIN MUST BE INSTALLED IN THE BOLT GROUP. IF IT ISN'T, YOUR RIFLE CAN STILL FIRE AND MAY EXPLODE!

7. Drop in and seat the firing pin. Pull bolt forward in the carrier, then reinsert firing pin retaining pin.

NOTE: After inserting firing pin retaining pin, firing pin should not fall out when bolt carrier group is turned upside down.

CAUTION: NEVER INTERCHANGE BOLTS BETWEEN DIFFERENT RIFLES. DOING SO COULD RESULT IN DAMAGE, PERSONAL INJURY OR DEATH.

8. Insert charging handle into upper receiver and lower the ears at front end of handle into cutouts in receiver. Then slide the charging handle partially into receiver.
9. Lower complete bolt carrier assembly into upper receiver. Gas key will fit into groove in the charging handle. Bolt must be pulled to forward position in the carrier so cam pin will fit into the channel in the upper receiver.
10. Slide the bolt carrier assembly and charging handle all the way into the upper receiver until charging handle latch locks on the receiver.

NOTE: If ejection port door is closed, you will feel some resistance as you push the carrier and handle in until you pop the cover open. If cover is already open, the handle and carrier should slide in easily.



11. To join upper and lower receivers, position pivot pin lug of upper receiver into slot at front of lower receiver and push pivot pin into place.

CAUTION: ALWAYS place the safety selector lever on SAFE before pivoting the upper receiver to a closed position on the lower receiver.

12. After receivers are joined, push in takedown pin.

NOTE: Pivot pin and takedown pin are held captive in the lower receiver - meaning that they are held in by their detents and springs so they cannot fall out and get lost.

Magazine Disassembly/Reassembly

Your NC10 or NC15 rifle is shipped with a single Magpul PMAG® magazine. This is a high-quality magazine made of advanced polymers and may be disassembled for maintenance purposes.

1. To disassemble magazine, push up on the oblong gray button in the center of the floorplate.
2. Slide floorplate out of magazine body.
3. Remove magazine spring and follower out of magazine box body.

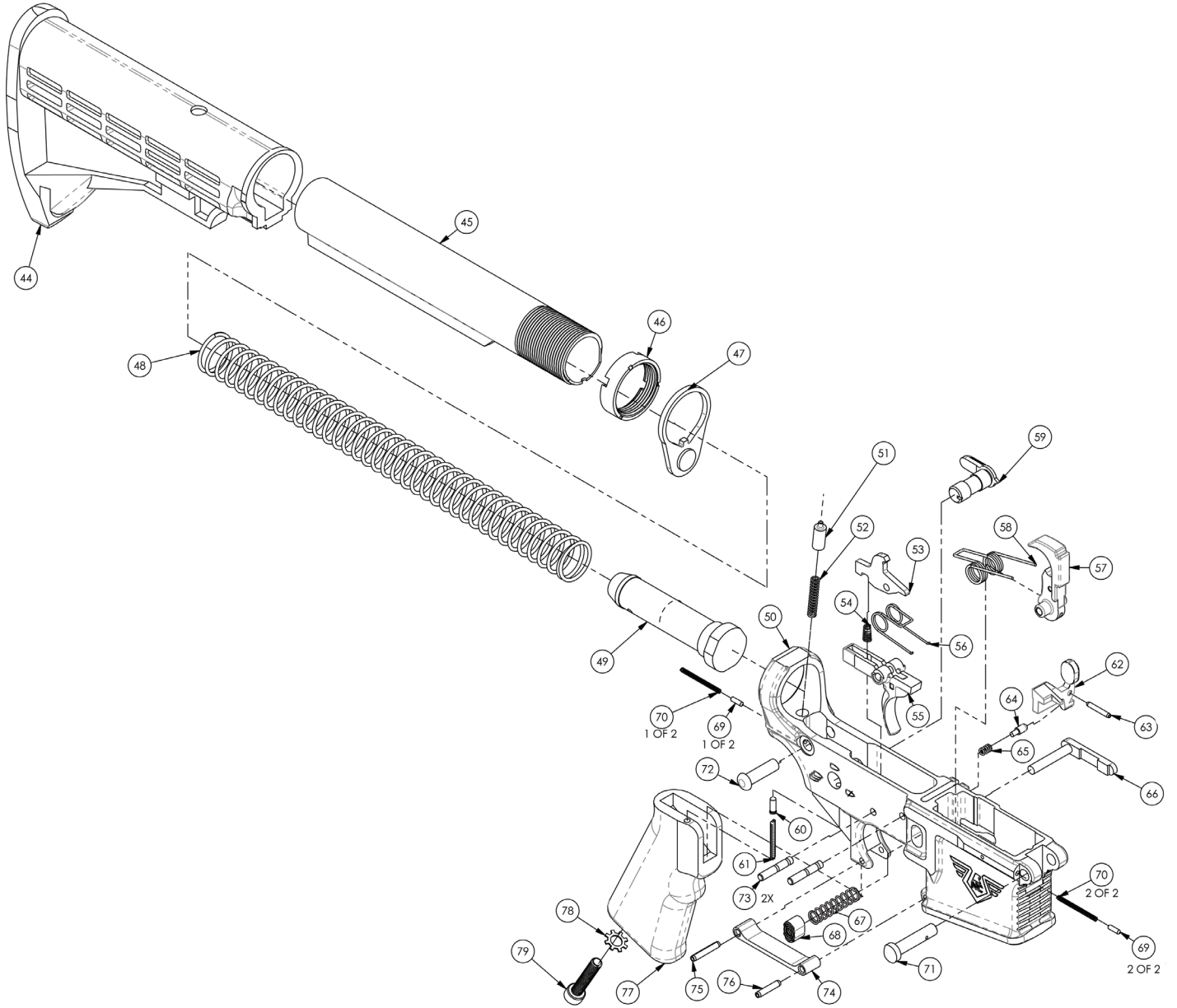
TO CLEAN AND LUBRICATE: Wipe dirt from the magazine body, spring, floorplate and follower. Lightly lubricate the spring.

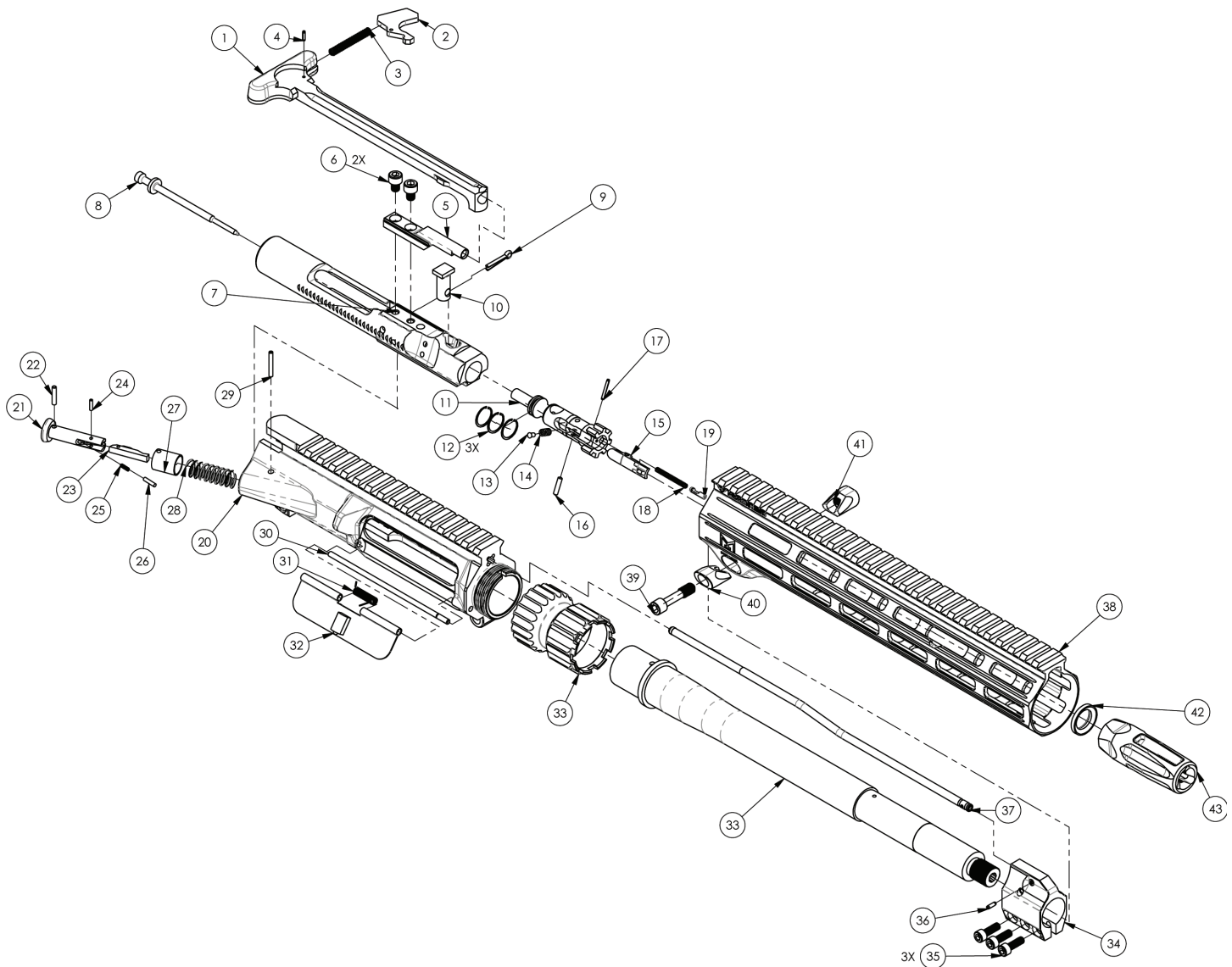
Reassembly procedure is the reverse of these steps. The gray floorplate retainer will automatically snap into place once the floorplate is slid on to the magazine body.



ITEM NO.	PART NUMBER	Upper/QT	ITEM NO.	PART NUMBER	QTY.
1	AR-15 Milled Charge Handle Forging from drw 8448647-master	1	44	STOCK	1
2	CHARGING HANDLE LATCH	1	45	BUFFER TUBE	1
3	CHARGING HANDLE LATCH SPRING	1	46	CASTLE NUT	1
4	CHARGING HANDLE LATCH PIN	1	47	ENDPLATE	1
5	GAS KEY	1	48	BUFFER SPRING	1
6	GAS KEY FASTENER	2	49	BUFFER	1
7	BOLT CARRIER	1	50	LOWER RECEIVER	1
8	FIRING PIN	1	51	BUFFER RETAINER	1
9	FIRING PIN RETAINER	1	52	BUFFER RETAINER SPRING	1
10	CAM PIN	1	53	DISCONNECTOR	1
11	BOLT	1	54	DISCONNECTOR SPRING	1
12	GAS RING	3	55	TRIGGER	1
13	EXTRACTOR SPRING BUFFER	1	56	TRIGGER SPRING	1
14	EXTRACTOR SPRING	1	57	HAMMER	1
15	EXTRACTOR	1	58	HAMMER SPRING	1
16	EXTRACTOR PIN	1	59	SELECTOR	1
17	EJECTOR PIN	1	60	SELECTOR DETENT	1
18	EJECTOR PIN	1	61	SELECTOR DETENT SPRING	1
19	EJECTOR	1	62	BOLT CATCH	1
20	UPPER RECEIVER	1	63	SPS 0.0938x0.625	1
21	FORWARD ASSIST BUTTON	1	64	BOLT CATCH PLUNGER	1
22	FORWARD ASSIST COLLAR PIN	1	65	BOLT CATCH SPRING	1
23	FORWARD ASSIST PAWL	1	66	MAGAZINE CATCH	1
24	FORWARD ASSIST PAWL PIN	1	67	MAGAZINE CATCH SPRING	1
25	FORWARD ASSIST PAWL SPRING	1	68	MAGAZINE RELEASE BUTTON	1
26	FORWARD ASSIST PAWL DETENT	1	69	TAKEDOWN/PIVOT PIN DETENT	1
27	FORWARD ASSIST COLLAR	1	70	TAKEDOWN/PIVOT PIN DETENT SPRING	2
28	FORWARD ASSIST SPRING	1	71	PIVOT PIN	1
29	FORWARD ASSIST PIN	1	72	TAKEDOWN PIN	1
30	EJECTION PORT ROD	1	73	TRIGGER/HAMMER PIN	2
31	EJECTION PORT COVER SPRING	1	74	TRIGGER GUARD	1
32	EJECTION PORT COVER	1	75	SPS 0.125x0.75	1
33	BARREL NUT	1	76	SPS 0.125x0.625	1
33	BARREL	1	77	PISTOL GRIP	1
34	GAS BLOCK	1	78	GRIP SCREW WASHER	1
35	GAS BLOCK FASTENER	3	79	GRIP SCREW	1
36	GAS TUBE PIN	1			
37	GAS TUBE	1			
38	HANDGUARD	1			
39	HANDGUARD FASTENER	1			
40	HANDGUARD INSERT (NON-THREADED)	1			
41	HANDGUARD INSERT (THREADED)	1			
42	CRUSH WASHER	1			
43	FLASH HIDER	1			







FOR SERVICE, TECHNICAL SUPPORT, OR WARRANTY ISSUES, CONTACT:

NORDIC COMPONENTS

79 E. 8TH ST.

WACONIA, MN 55387

SALES: 952.442.8908

TECHNICAL SUPPORT: 952.442.8915

SALES@NORDICCOMP.COM