

# Operation and Safety Manual



**Queen Creek Armory, LLC**

**Queen Creek, AZ**

**[Queencreekarmory.com](http://Queencreekarmory.com)**

**QC-15 Rifles and Pistols**

Multiple Calibers and Barrel Lengths

**WARNING: BEFORE USING THIS FIREARM,  
READ AND FOLLOW THESE INSTRUCTIONS**

## Safety

### 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 appropriate to the 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 fined and sent to prison.

Before this rifle left the factory, this firearm was tested, carefully inspected and packaged. Queen Creek Armory, 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.

### Safe Handling Procedures

- **Do NOT alter or modify your QC15 Model 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 personal 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 misfire has occurred, the round may 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!**

# About your Queen Creek Armory QC-15 Model Firearm

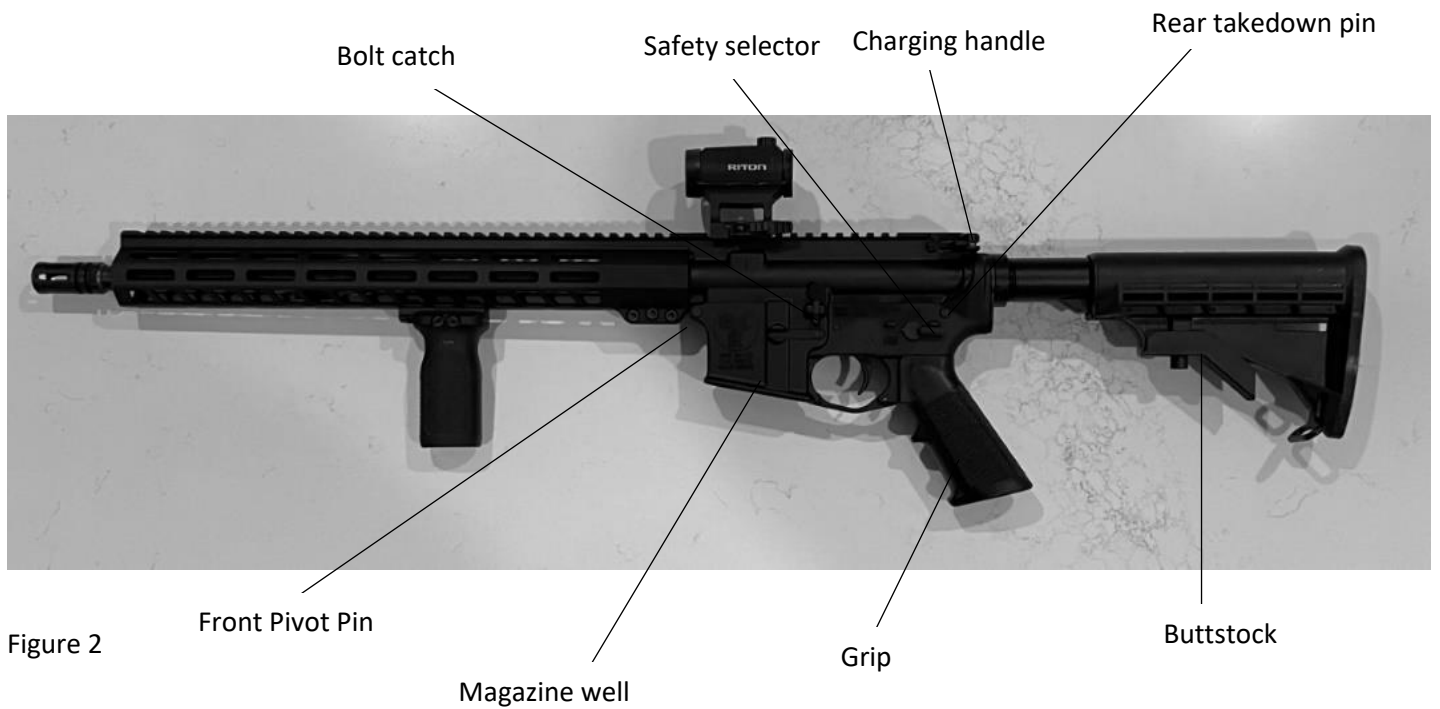
## Description

Your QC-15 Model rifle/pistol 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 or 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.

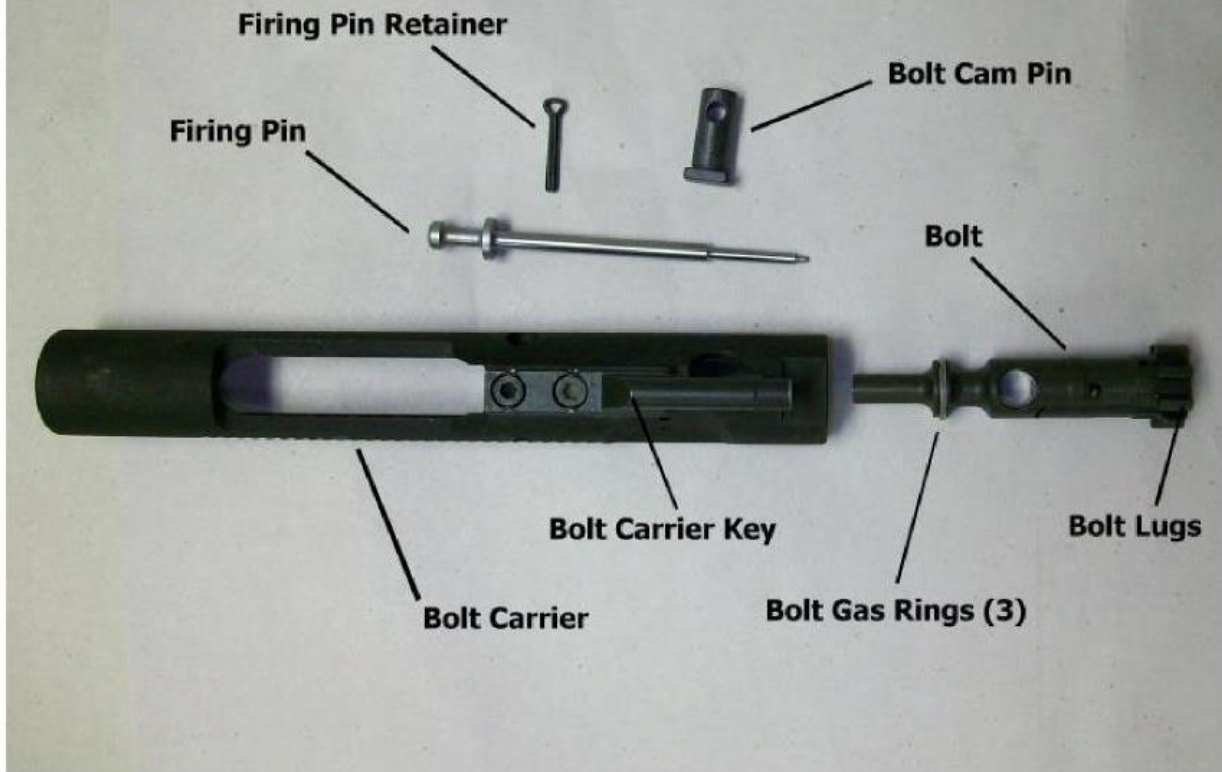
## Parts of your rifle/pistol

The orientations of Figures 1 and 2 below refer to the sides of your rifle when it is shouldered.

Insert Pics of rifle/pistol – left side/right side



# BOLT ASSEMBLY PARTS



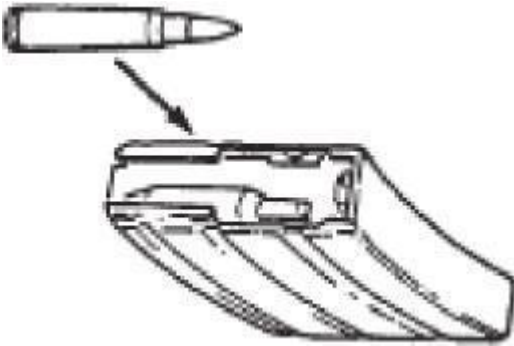
## Operating your QC-15 Model Firearm

### Safety Selector



The safety selector lever, located on the left of lower receiver, has two positions, "FIRE" (Bullet Pictogram) and "SAFE" (Bullet with an "X" Pictogram). When set to "FIRE" (the firearm will fire a single shot each time the trigger is pulled. When set too "SAFE" a cam bears upon the rear of the trigger, blocking trigger movement and preventing the hammer from being released.

## Loading the Magazine



- Use only quality ammunition suitable for your firearm.
- With the magazine facing forward as shown, 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.
- 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 number of rounds are achieved

## 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**

- Press in on the bottom of the Bolt Catch while pulling back the Charging Handle. This will cock the hammer and lock the Bolt Carrier to the rear.
- Return the Charging Handle fully forward until it locks in place and remove your finger from the Bolt Latch.
- Set the Selector to the "SAFE" position.
- 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.
- 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.
- The Ejection Port Cover (dust cover) can be closed and will open automatically when the first round is fired.
- Do not disengage the safety until the rifle is pointed in a safe direction and you are ready to fire.

## Firing your Rifle

- Always wear ear and eye protection when firing your weapon.
- Load firearm as previously described.
- 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.

- 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 Buttstock firmly into shoulder.
- 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.
- 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.
- This is a semi-automatic firearm and is immediately loaded and ready to fire after each shot until magazine is empty.
- If the Bolt fails to lock automatically fully forward, press the Forward Assist button to lock it into battery position. 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.
- 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 open 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.**

- Press the Magazine Release to remove the magazine from the rifle.
- Press in on the bottom of the Bolt Catch while pulling back the Charging Handle. This will cock the hammer and lock the Bolt Carrier to the rear.
- If there is a round or a spent cartridge in the chamber, it will be ejected.
- Return the Charging Handle fully forward until it locks in place and remove your finger from the Bolt Catch.
- Set the Selector to the "SAFE" position.
- Inspect the chamber making sure it is empty.
- With the rifle pointed in a safe direction, press in on the top of the Bolt Catch. This will release the Bolt Carrier.
- Close the Ejection Port Cover (dust cover)

### **Maintaining your QC15 Model Firearm**

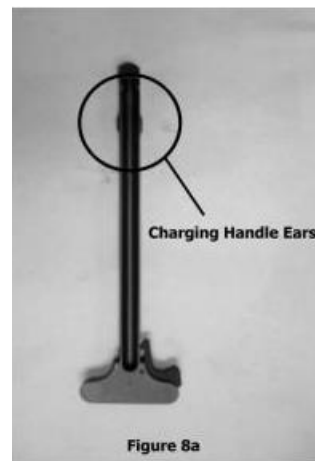
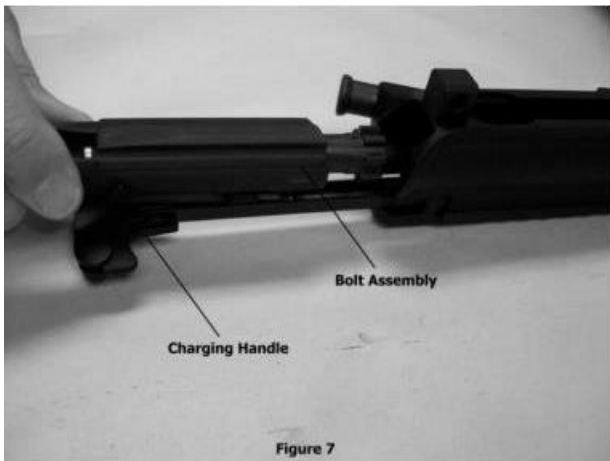
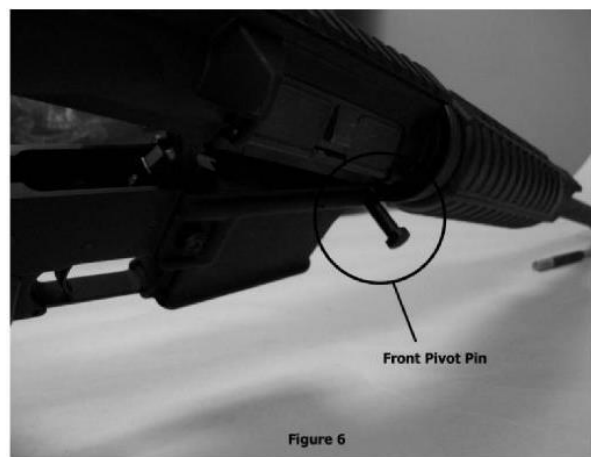
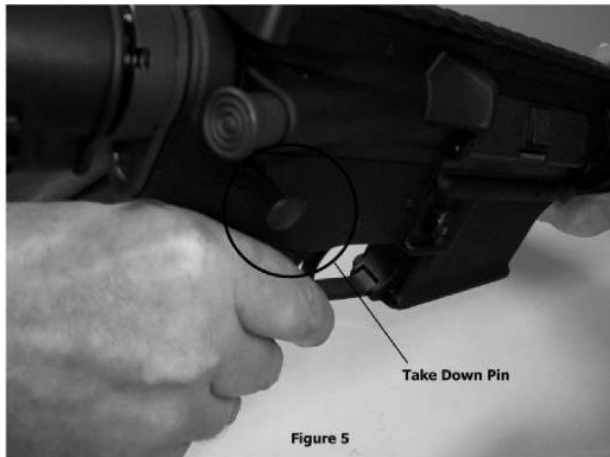
#### **Rifle Disassembly**

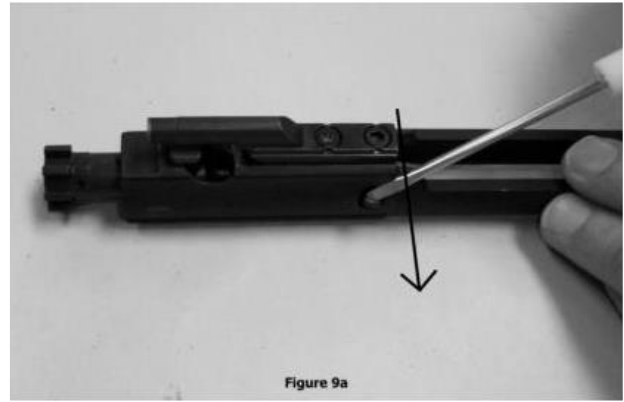
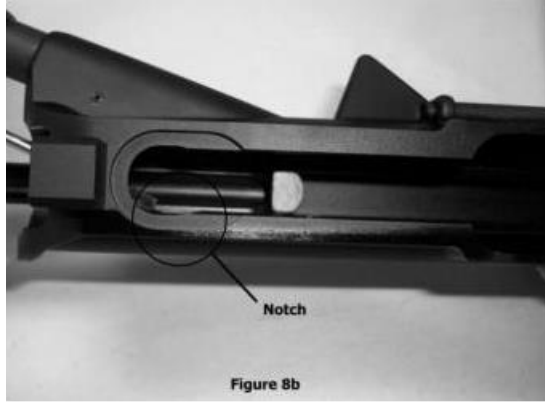


**WARNING:**

**BEFORE DISASSEMBLY, REMOVE THE MAGAZINE, CLEAR THE CHAMBER AND MAKE SURE THE FIREARM IS IN THE "SAFE" POSITION.**

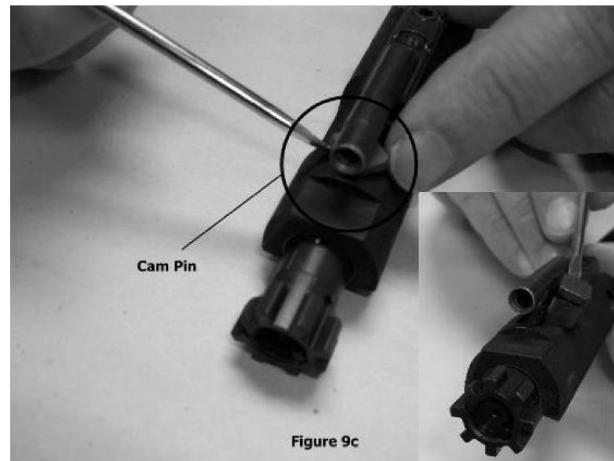
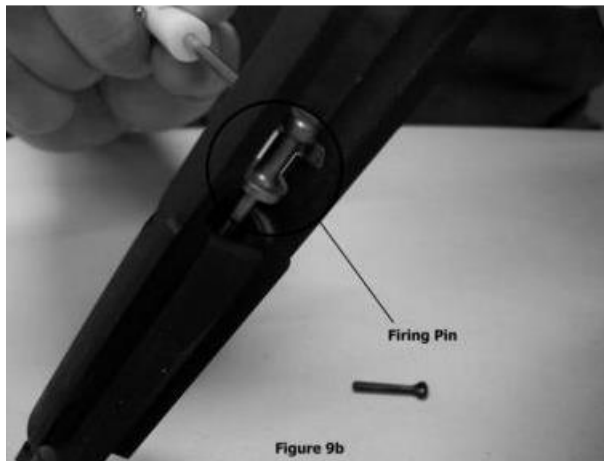
- Make sure the Bolt Assembly is in the forward (battery) position.
- Slide the Take Down Pin out, the firearm's upper receiver will now pivot forward. (see Figure 5)
- To completely separate the Lower Receiver from the Upper Receiver, slide the Front Pivot Pin out. (see Figure 6)
- To disengage and remove the Bolt Assembly, pull the Charging Handle back and remove the Bolt Assembly. (see Figure 7)
- Align the ears of the Charging Handle with the notch in the Upper Receiver to remove the Charging Handle Assembly. (see Figures 8a and 8b)

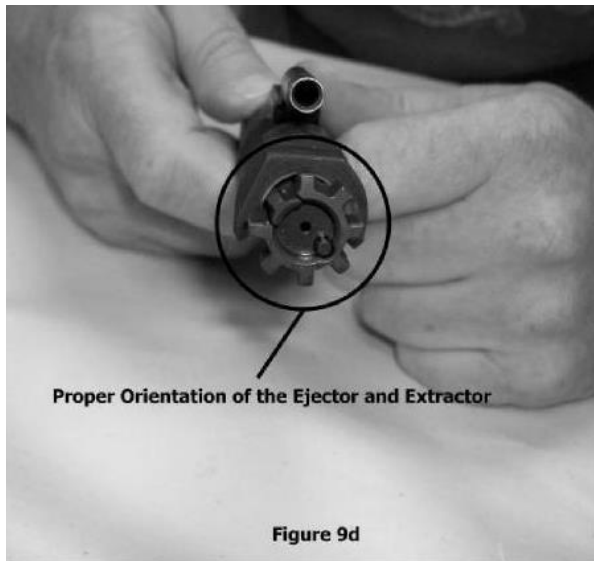




### Disassembling the Bolt Assembly

- Remove the Firing Pin Retainer. (see Figure 9a)
- Remove the Firing Pin. (see Figure 9b)
- To remove the Bolt Cam Pin, extend the Bolt completely, turn the Cam Pin 90° (1/4" turn either direction), push bolt back into the Carrier so that Cam Pin clears the Bolt Carrier Key, then slide the Cam Pin up and out. (see Figure 9c)
- Inspect the Cam Pin for wear.
- Before removing the Bolt from the Bolt Carrier, note the orientation of the Extractor and Ejector. (see Figure 9d)
- 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.
- Inspect the Bolt Carrier Key to ensure that it is tight, if loose, take to a certified armorer for repair.





**STOP:  
FURTHER DISASSEMBLY IS NOT RECOMMENDED**

### **Cleaning and Lubricating your Firearm**

Cleaning the Barrel Bore (using a standard multi-piece rod cleaning kit):  
ALWAYS CLEAN FROM THE CHAMBER TOWARD THE MUZZLE.

- 1.) Attach three Rod Sections together but leave each one about two turns short of being tight. Attach the Patch Holder but leave it two turns short of tight also.
- 2.) Point Muzzle down. Hold the Upper Receiver in one hand while inserting the end of the Rod with Patch Holder attached into the Chamber. Guide the Rod carefully through the Bore. CAUTION: Do not let the Rod or its threaded end scratch the Chrome Lining of the Bore or Firing Chamber. About 2 - 3 inches of the Rod should protrude out of the Muzzle.
- 3.) Attach the Handle Section of the Cleaning Rod to the end of the Rod sticking out of the Muzzle, and swab out the Bore with a patch moistened with "CLP" (Cleaner Lubricant & Protectant).
- 4.) Remove Patch Holder and attach Bore Brush (leaving it two turns short of tight).
- 5.) Pull the Brush through the Bore and out the Muzzle. You should be able to see the Rod twisting as you pull it - this is the Brush "tracking" in the rifling.
- 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.) Pull a patch through the Bore occasionally to help clean out the crud that the brush is getting loose. Just replace the Bore Brush with the Patch Holder and a wet patch. If you leave the rods loose again, the patch will "track" in the rifling as before. But remember;

always have the Bore wet with cleaner before trying to pull a brush through. NEVER reverse the direction of the Bore Brush while it is in the Bore.

### **Cleaning the Upper Receiver, Bolt, Carrier and Components:**

NOTE: Check to ensure that there is no looseness between the Barrel and the Upper Receiver - if you detect any movement by twisting with your hands, the Barrel Nut must be retorqued. Bring the Rifle to a Certified Armorer.

- 1.) Using a "CLP" type product, clean all areas (inside and out) of Powder Fouling, Corrosion and Dirt. Never use a wire brush or any type of abrasive to clean the Aluminum Upper Receiver - you'll scratch and damage the finish. A Toothbrush is good for loosening any dirt buildup, and won't scratch the Receiver.
- 2.) Clean the Firing Chamber - dip the larger Chamber Brush in CLP and use at least 5 plunge strokes and 3 - 360° clockwise rotations. Then swab out the Bore as described previously to remove contaminated solution or loosened crud.
- 3.) Use the Bore Brush - wet with CLP - to clean carbon and powder residue from around the Gas Tube. Run a Pipe Cleaner into the Gas Tube, clean the Bolt Locking Lugs, Bolt Rings, Firing Pin, Bolt Cam Pin, lip of the Extractor, and inside the Bolt Carrier from both front and rear. Clean out the Gas Key on top of the Bolt Carrier with a Q-Tip or a Pipe Cleaner. Also clean out any carbon/powder residue from vent holes in the Bolt Carrier. Clean and inspect Bolt, Cam Pin, Firing Pin and Firing Pin Retaining Pin thoroughly
- 4.) Wipe all components clean and dry, and inspect for excessive wear, corrosion or mechanical damage. Have your Armorer replace any worn or defective parts before firing.

### **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 Trigger Mechanism. Carefully clean the Magazine Release Button and the cavity for the Magazine Catch on the left side of the Receiver. Also inspect and clean the Bolt Catch Mechanism and Receiver's Takedown and Pivot Pins. Clean the Buffer, Action Spring, and inside the Lower Receiver Extension (the Buffer Tube). A piece of rag attached to the Cleaning Rod and Patch Holder can be used to wipe inside the Buffer Tube.
- 3.) If rifle has been used in very dirty/muddy conditions, the Vent Hole in the Tealstock Receiver Extension may need to be cleaned out. Use a Pipe Cleaner or piece of wire to ensure that Vent Hole is clear.
- 4.) Buttstocks may require cleaning as necessary. Telescoping Stock Latch can be pulled down to remove Stock. Clean the 6 Position Lock Holes, and lightly lube the Receiver Extension and Latch Mechanism to ensure proper telescoping action.

### **Lubricating the BCG (Bolt Carrier Group):**

Firing Pin: Lightly lubricate the Firing Pin with CLP - also the Firing Pin recess in the Bolt.

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.

Bolt: Generously lubricate the Bolt, its Cam Pin area, the Bolt 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.

Carrier Key: The inside of the Carrier Key on the Bolt Carrier should be dried with a Q-Tip or Pipe Cleaner – then place one drop of CLP inside.

### **Lubricating the Upper and Lower Receivers: 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 Front Sight, and surfaces under the Handguards. Be sure you lubricate in and around all the Locking Lugs. The Forward Assist should also be lightly lubed inside the Receiver and checked for function.

Front Sight Detent (if equipped): Depress and apply two or three drops of CLP to it. Depress the detent several times to work the lubricant down into the Spring.

### **Lower Receiver:**

Generously lubricate ALL MOVING PARTS INSIDE THE LOWER RECEIVER including the Trigger, Hammer, Safety, Bolt Catch, Magazine Release, etc), and their various Pins and Detents. Don't forget the Takedown and Pivot Pins and their Detents. Use an oiled rag to wipe off any fingerprints on the exterior surfaces (they can start the corrosion process). A black cloth is best as it won't leave visible lint.

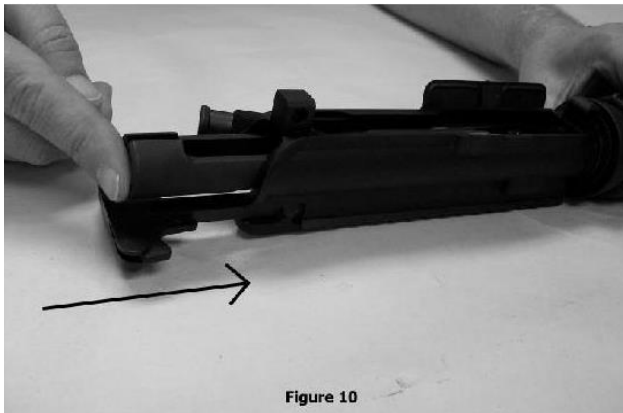
Lower Receiver Extension: Lightly lubricate inside the Lower Receiver Extension (Buffer Tube), the Buffer and the Action Spring. Also lightly lubricate the Telestock Latch and exterior of the Receiver Extension.

### **Reassembling the Bolt Assembly**

- Reinsert the Bolt into the Bolt Carrier, note the orientation of the Ejector and Extractor in Figure 9d.
- Reinsert the Cam Pin and rotate 90°, refer to Figure 9c.
- Reinsert the Firing Pin making sure it is seated completely forward towards the bolt face.
- Reinsert the Firing Pin Retainer.
- After assembly, make sure the Bolt moves freely and that the Firing Pin is captured correctly.

## Rifle Assembly

- 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 8a and 8b. Charging Handle must be seated at the bottom of the slot in the Upper Receiver. Slide the Charging Handle forward approximately 1/4".
- With the Bolt fully extended, reinstall the Bolt Assembly into the Upper Receiver using the slot in the Charging Handle as a guide. Refer to Figure 7.
- Slide the Bolt Assembly into the forward (battery) position, note that the Charging Handle moves with the Bolt Carrier. (see Figure 10 and Figure 11)



- Line up the Upper and Lower Receiver pivot pin holes and slide the Front Pivot Pin into the locked position. (see Figure 12 and Figure 13)
- Pivot the Receivers together and slide the Take Down Pin into the locked position. Refer to Figure 5.
- The firearm is now assembled



## Function Test

### WARNING:

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

- Pull the Charging Handle fully to the rear and release. Make sure the Bolt Assembly returns to the forward (battery) position.
- Move the Selector to the "SAFE" position.
- Pull the trigger to check that the Safety is working correctly.
- Move the Selector to the "FIRE" position.
- Pull the trigger to check that the Hammer is falling 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.**

- After clearing the chamber, check that the Bolt Assembly is in the forward (battery) position.
- Point the gun in a safe direction and pull the trigger so the hammer is in a fired state.
- Close the dust cover
- Store the rifle in a locked case in a safe area.
- If storing your rifle for an extended period of time, use lite oil in the barrel and chamber to prevent corrosion.

## Firearm Record

Make a copy of this operations manual and proof of purchase/sales record.

Maintain these items in a secure safe or fireproof container. These materials will be necessary if the firearm is damaged, stolen or returned to Queen Creek Armory for warranty or repair.

Model : \_\_\_\_\_

Serial Number : \_\_\_\_\_

Purchased From : \_\_\_\_\_

Purchase Date : \_\_\_\_\_

You may attach the Proof of Purchase or Receipt, or a copy of, to this page.

Keep this Operation and Safety Manual, or a copy of this manual, with your firearm at all times.