



SAFETY AND INSTRUCTION MANUAL

# KE-15 SEMI-AUTOMATIC RIFLES AND CARBINES

**WARNING:**

BEFORE USING THIS FIREARM, READ AND FOLLOW THESE INSTRUCTIONS. IF THERE IS ANYTHING YOU DO NOT UNDERSTAND, SEEK ASSISTANCE FROM A QUALIFIED FIREARM SAFETY INSTRUCTOR

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©2015 KE ARMS. THIS INSTRUCTION MANUAL SHOULD ALWAYS ACCOMPANY THIS FIREARM. WHEN YOU LEND, GIVE OR SELL THIS FIREARM, BE SURE THIS MANUAL GOES WITH IT.



## WARNING

- > ALWAYS BE SURE TO CLEAR THE FIREARM, DO NOT SQUEEZE THE TRIGGER UNTIL THE FIREARM HAS BEEN CLEARED. INSPECT THE CHAMBER TO ENSURE NO SOURCE OF AMMUNITION IS PRESENT TO BE CHAMBERED.
- > TO BE CONSIDERED SAFE BEFORE DISASSEMBLY, CLEANING, INSPECTING, TRANSPORTING, OR STORING, THE FIREARM MUST BE CLEARED.
- > WITH THE BOLT CARRIER ASSEMBLY LOCKED TO THE REAR OR IN ITS FORWARD POSITION, IF THE FIREARM IS DROPPED OR JARRED WITH A LOADED MAGAZINE IN PLACE, IT COULD CHAMBER A ROUND.
- > WHEN YOUR FIREARM IS LOADED, ENSURE IT IS POINTED IN A SAFE DIRECTION. DO NOT LOAD WITH A HOT CHAMBER. IF YOUR FIREARM STOPS FIRING WITH A LIVE ROUND IN THE CHAMBER OF A HOT BARREL, REMOVE THE ROUND FAST. HOWEVER, IF YOU CANNOT REMOVE IT WITHIN 10 SECONDS, REMOVE MAGAZINE AND WAIT 15 MINUTES WITH THE FIREARM POINTING IN A SAFE DIRECTION. THIS WAY YOU WON'T GET HURT BY POSSIBLE ROUND COOKING OFF. REGARDLESS, KEEP YOUR FACE AWAY FROM THE EJECTION PORT WHILE CLEARING A HOT CHAMBER.

## DON'T OVERHEAT BARRELS

SUSTAINED FIRING OF THE FIREARM WILL RAPIDLY RAISE THE TEMPERATURE OF THE BARREL TO A CRITICAL POINT

## DO NOT FIRE:

- > SERIOUSLY CORRODED AMMUNITION.
- > DENTED CARTRIDGES.
- > CARTRIDGES WITH LOOSE BULLETS.
- > CARTRIDGES EXPOSED TO EXTREME HEAT (135°) UNTIL THEY HAVE COOLED.
- > CARTRIDGES WITH THE BULLET PUSHED IN (SHORT ROUNDS).
- > MAKE SURE YOUR FIREARM IS CLEAR AND ON "SAFE" BEFORE MOVING DOWN RANGE.

## READ AND UNDERSTAND ALL THE FOLLOWING PRECAUTIONS BEFORE REMOVING THIS FIREARM FROM ITS PACKAGE.

This KE Arms product is classified by the Alcohol, Tobacco and Firearms Division of the IRS, U.S. Treasury Department, as a firearm or dangerous weapon, it is therefore potentially lethal!

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

**CAUTION: CAREFULLY READ THIS INSTRUCTION MANUAL PRIOR TO LOADING AND FIRING YOUR KE ARMS FIREARM.** Your safety and the safety of others (including your family) depends on your mature compliance with this manual, and your diligent application of safe firearm practices. If unfamiliar with firearms, seek further advice through safe handling courses run by your local gun clubs, NRA approved instructor, or similar qualified organizations.

NOTICE: KE Arms shall not be responsible for injury, death, or damage to property resulting from intentional or negligent discharge of this firearm, or when used for purposes for which it was not originally designed. KE Arms will not honor claims involving this firearm which result from careless or improper handling, unauthorized adjustment or parts replacement, corrosion, neglect, or the use of wrong caliber ammunition, or the use of ammunition other than original high quality commercially manufactured ammunition in good condition, or any combination thereof. KE Arms will not honor claims involving this firearm for any reason or cause when such claims are made by the second or subsequent owner.

## FIREARM SAFETY

### WARNING

> WHEN YOU SQUEEZE THE TRIGGER, YOU MUST EXPECT THE FIREARM TO FIRE, AND YOU ARE FULLY RESPONSIBLE FOR FIRING IT. YOUR CARE CAN AVOID ACCIDENTAL DISCHARGE, WHICH CAN PREVENT ACCIDENTAL INJURY OR DEATH. > THIS FIREARM MAY ACCIDENTALLY DISCHARGE WHEN A ROUND IS FED INTO THE CHAMBER, IF IT IS DROPPED, OR IF IT RECEIVES A BLOW TO THE MUZZLE OR FRONT OF THE GUN. (THIS CAN OCCUR REGARDLESS OF THE POSITION OF THE HAMMER OR ANY OF THE VARIOUS SAFETY DEVICES.) BECAUSE OF THIS, EXTRA CARE AND STRICT ADHERENCE TO THESE INSTRUCTIONS BY THE GUN USER IS MANDATORY FOR MINIMIZING THE RISK OF ACCIDENTS.

### GENERAL HANDLING CAUTIONS

- 1. ALWAYS HANDLE YOUR FIREARM AS IF IT WERE LOADED** in order to prevent unintentional firing when you think it is unloaded.
- 2. NEVER POINT YOUR FIREARM AT ANYTHING YOU DO NOT INTEND TO SHOOT** in order to prevent negligent, injury, death, or damage to property.
- 3. NEVER TRUST ANYONE'S WORD THAT A GUN IS UNLOADED.** Check for yourself with fingers off the trigger and the gun pointed in a safe direction in order to prevent accidental firing.
- 4. ALWAYS MAKE SURE YOUR FIREARM IS NOT LOADED AND BOLT IS LATCHED OPEN BEFORE LAYING IT DOWN OR HANDING IT TO ANOTHER PERSON** in order to prevent accidental firing when it is unsafe to do so. Do not let anyone stick their fingers in the ejection port.
- 5. ALWAYS KEEP AND CARRY YOUR FIREARM EMPTY, WITH THE SAFETY ON** except when you intend to shoot, so that your firearm cannot be fired accidentally.

**6. ALWAYS BE AWARE OF POSSIBLE RISK FROM DROPPING YOUR FIREARM.** Some parts of the mechanism could be damaged. Even though you may not see the damage, if it is severe, the firearm may discharge unexpectedly and cause injury, death, or damage to property. If your firearm has been dropped, have it examined by a competent gunsmith before using it.

**7. NEVER LEAVE A FIREARM COCKED READY TO FIRE.** This is extremely dangerous, and can lead to negligent discharge, causing injury, death, or damage to property.

**8. NEVER LEAVE A LOADED FIREARM UNATTENDED.** Someone may fire it and cause injury, death or damage to property.

**9. ALWAYS INSTRUCT CHILDREN AND OTHERS IN YOUR HOUSEHOLD TO RESPECT FIREARMS.** If you teach your children to shoot, have a qualified instructor train them to treat and use firearm property. Always supervise them closely, and always stress safety so that your children will not fire the firearm when it is unsafe to do so.

### LOADING CAUTIONS

**10. ALWAYS BE SURE BARREL BORE, CHAMBER, AND ACTION ARE CLEAN AND CLEAR OF OBSTRUCTIONS.** Immediately clean a wet or fouled firearm so that it will correctly function.

**11. ONLY USE CLEAN, DRY, COMMERCIALY MANUFACTURED AMMUNITION IN GOOD CONDITION WHICH IS APPROPRIATE TO THE CALIBER OF YOUR FIREARM.** Firearm and ammunition manufacturers design their products within exacting engineering standards. Handloads and re-manufactured ammunition can be outside those standards which can possibly blow up the chamber, damage the receiver and magazine, and cause injury or death.

**12. ALWAYS CHECK THAT AMMUNITION IS CLEAN AND UNDAMAGED BEFORE USING THE FORWARD ASSIST.** Forcing damaged ammunition into the chamber could damage your rifle and lead to injury, death, or damage to property.

## SHOOTING CAUTIONS

**13. NEVER DRINK ALCOHOL OR TAKE DRUGS BEFORE OR DURING SHOOTING.** These substances can impair your vision and judgment leading to unsafe gun handling.

**14. ALWAYS SEEK A DOCTOR'S ADVICE IF YOU ARE TAKING MEDICATION** to be sure you are fit to shoot and handle your firearm safely.

**15. ALWAYS WEAR EAR PROTECTION WHEN SHOOTING** on a range. Without ear protection, the noise from your firearm and other guns close to you could leave a temporary "ringing" in the ears, and the cumulative long term effect of regular exposure to such loud noises could be permanent hearing loss.

**16. ALWAYS WEAR PROTECTIVE GLASSES WHILE SHOOTING.** Without protective glasses, flying particles or casings could damage eyes and cause blindness.

**17. ALWAYS KEEP SELECTOR LEVER SET TO "SAFE" WHEN FIREARM IS LOADED AND COCKED** until you are aiming at a target and intend to fire. This will minimize the chance of negligent discharge of the firearm.

**18. ALWAYS KEEP CLEAR AND KEEP OTHERS CLEAR OF THE EJECTION PORT.** Spent cartridges are ejected with strong force and can lead to injury. Never place your fingers in ejection port, they could be burned by hot metal or injured by the bolt moving forward.

**19. NEVER SQUEEZE THE TRIGGER OR PUT YOUR FINGER IN THE TRIGGER GUARD UNTIL YOU ARE AIMING AT A TARGET AND READY TO SHOOT.** This will prevent you from firing the gun when it is pointing in an unsafe direction.

**20. ALWAYS BE ABSOLUTELY SURE OF YOUR TARGET AND THE AREA BEHIND IT BEFORE FIRING.** A bullet could travel through or past your target up to three miles.

**21. NEVER ATTEMPT TO FIRE IF WATER IS IN THE BARREL.** Water can accumulate if your firearm is exposed to heavy rain or fog. Open the bolt and allow water to drain before firing. Clean a wet firearm as soon as possible.

**22. NEVER SHOOT AT HARD SURFACES SUCH AS ROCK OR LIQUID SURFACES SUCH AS WATER.** A bullet may ricochet and travel in any direction to strike you, or an object you cannot see, causing injury, death or damage to property.

**23. NEVER DISCHARGE A FIREARM NEAR FLAMMABLE MATERIAL.** Flame and sparks erupt from the firearm when discharged. They could trigger a fire or cause flammable liquids and gases to explode.

**24. NEVER FIRE YOUR FIREARM NEAR AN ANIMAL** unless it is trained to accept the loud noise. An animal's startled reaction could cause injury to you or the animal.

**25. NEVER JOKE AROUND WHILE HOLDING YOUR FIREARM.** You may negligently discharge which can lead to injury, death, or damage to property.

**26. NEVER WALK, CLIMB OR FOLLOW A COMPANION WITH YOUR FIREARM COCKED READY TO FIRE (IN BATTERY)** to eliminate risk of negligent discharge. When hunting, always control the direction of the muzzle and keep selector lever set to "SAFE."

## RANGE CAUTIONS

**27. ALWAYS BE SURE YOUR BACKSTOP IS ADEQUATE** to stop and contain bullets before beginning target practice. This will ensure that you do not hit anything outside the shooting area.

**28. ALWAYS PUT A KNOWLEDGEABLE AND RESPONSIBLE PERSON IN CHARGE OF MAINTAINING SAFETY CONTROL WHEN A GROUP IS FIRING ON A RANGE.** Follow his commands so that order is maintained and the likelihood of accidents is reduced.

**29. ALWAYS CARRY YOUR FIREARM EMPTY WITH BOLT LATCHED WHILE ON A RANGE** until preparing to fire. Keep it pointed towards the backstop when loading, firing, and unloading.

## MALFUNCTION CAUTIONS

**30. FAILURE TO FIRE: ALWAYS HOLD THE FIREARM, KEEPING IT POINTING TOWARDS THE TARGET OR A SAFE OPEN AREA AND WAIT 30 SECONDS AFTER IT FAILS TO FIRE.** If a hangfire (slow ignition) has occurred, round will fire within 30 seconds. If round does not fire, open cylinder, eject round and examine primer, if firing pin indent on primer is light, off center, or non existent, have firearm examined by gunsmith before firing again. If firing pin indent on primer appears normal (compared to similar previously fired rounds,) assume faulty ammunition, segregate misfired round from other live ammunition and empty cases, reload and carry on firing.

NOTE 1: It is normal for a light firing pin indent to appear on the primer of cartridges which have been fed into the chamber of the gun but not fired.

NOTE 2: Dispose of misfired rounds in accordance with ammunition manufacturer's instructions.

**31. NEVER USE YOUR FIREARM IF IT FAILS TO FUNCTION PROPERLY, AND NEVER FORCE A JAMMED ACTION** which can cause a round to explode leading to serious injury, possible death, or severe damage to your firearm.

## CLEANING AND STORAGE CAUTIONS

**32. ALWAYS MAKE SURE YOUR FIREARM IS NOT LOADED BEFORE CLEANING AND STORING** so that it cannot be fired when it is unsafe to do so.

**33. ALWAYS KEEP AND STORE YOUR FIREARM AND AMMUNITION IN SEPARATE LOCKED RECEPTACLES OUT OF REACH AND SIGHT OF CHILDREN AND UNTRAINED PEOPLE** to prevent unsafe use and firing of your firearm.

## GUN ABUSE CAUTION

**34. NEVER ABUSE YOUR FIREARM** by using it for any purpose other than shooting.

**35. NEVER DRY FIRE WHEN THE RECEIVERS ARE OPEN** as the safety level could be reduced.

**36. NEVER ALTER PARTS** as the level of safety could be reduced.

NOTE: Please note that we have chosen to use the word "SQUEEZE" in this instruction manual instead of "PULL" or "PRESS" when trigger movement is described, this is simply to remind you of the need for a gentle squeezing action to achieve accuracy.

## GENERAL INFORMATION

### EQUIPMENT DESCRIPTION

\*Some specifications may vary based on model.

#### MECHANICAL FEATURES:

Caliber ..... 5.56 mm / .223 Rem  
Rifling ..... (See Barrel Markings)  
Gas Operated Direct Impingement  
Integral accessory mounting rail  
Buttstock has six positions

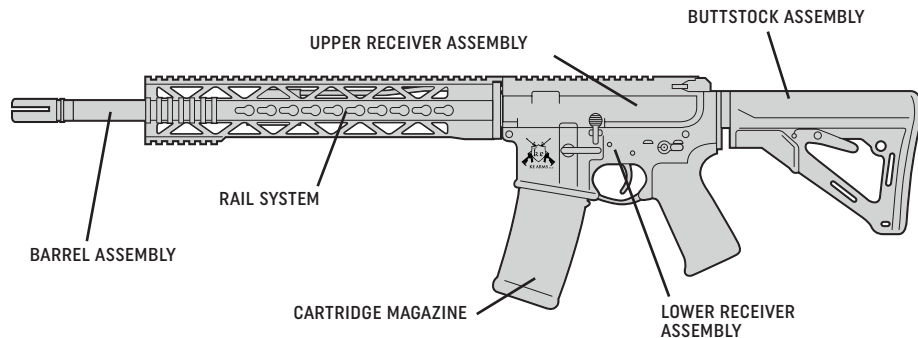
#### FIRING CHARACTERISTICS:

Fire Selector ..... SAFE-SEMI

#### MAX EFFECTIVE RATE OF FIRE:

Semi ..... 45rpm  
Sustained Rate of Fire 12/15 rpm  
Max Effective Range 500 meters (individual/point targets)  
600 meters (area targets)  
Max Range 3600 meters

## LOCATION AND DESCRIPTION OF MAJOR COMPONENTS

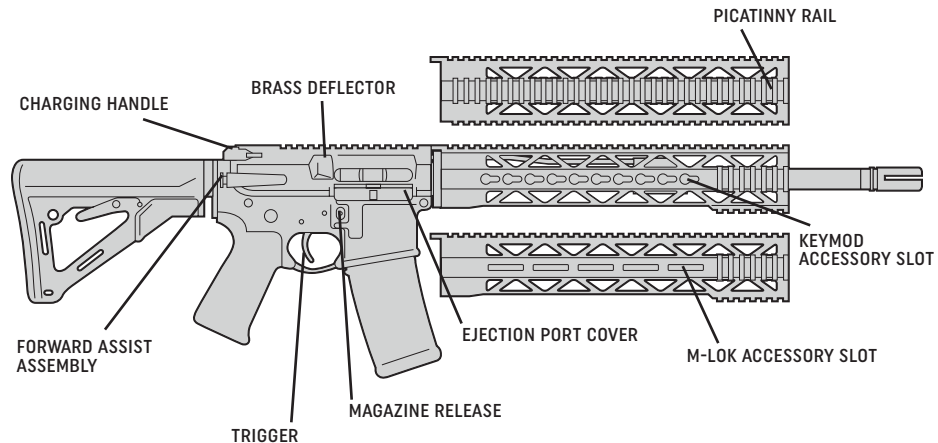


- 1. UPPER RECEIVER ASSEMBLY.** Contains bolt carrier group.
- 2. LOWER RECEIVER ASSEMBLY.** Contains fire control.
- 3. BARREL ASSEMBLY.** Provides support for the bolt carrier assembly. The barrel chambers the cartridge for firing and directs the projectile.
- 4. BUTTSTOCK ASSEMBLY.** Provides firing control for the firearm.
- 5. CARTRIDGE MAGAZINE.** Holds cartridges ready for feeding and provides a guide for positioning cartridges for stripping. Provides quick reload capabilities for sustained firing.
- 6. FREE FLOAT RAIL SYSTEM.** Increase accuracy and allow for mounting of accessories.

## DESCRIPTION AND USE OF CONTROLS AND FEATURES

- 1. BRASS DEFLECTOR.** Prevents ejected cartridge case from striking operator.
- 2. SIGHTS.** May be attached to upper and rail system.
- 3. EJECTION PORT COVER.** Closes over ejection port to prevent sand, dust, etc., from entering chamber. Should remain closed when not firing the firearm.
- 4. MAGAZINE RELEASE.** Holds magazine in place in magazine well and allows operator to release magazine and remove it from firearm.
- 5. TRIGGER.** When activated by operator, initiates firing sequence.
- 6. FORWARD ASSIST ASSEMBLY.** Ensures that the bolt is fully closed and locked.
- 7. CHARGING HANDLE.** Allows the operator to chamber a round and cock or clean the firearm.
- 8. RAIL SYSTEM.** M-1913 Picatinny, M-LOK or Keymod rail system. Visit [www.KEARms.com](http://www.KEARms.com) for details.

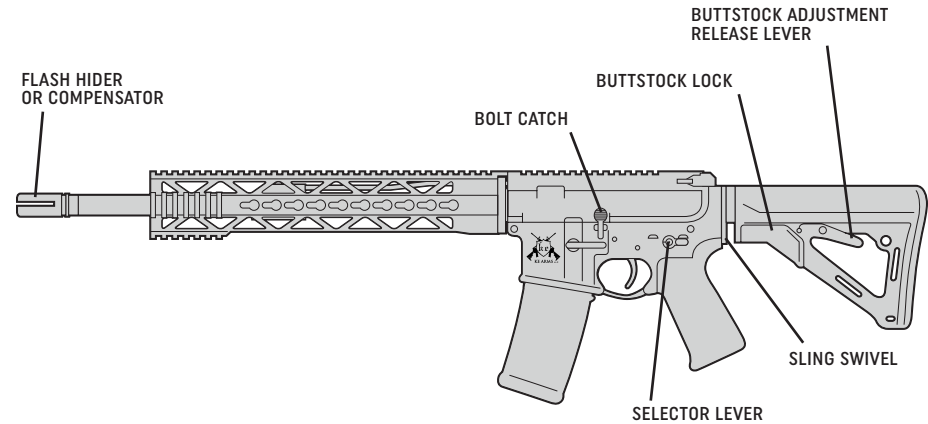
## RIGHT VIEW



## DESCRIPTION AND USE OF CONTROLS AND FEATURES

- 1. FLASH HIDER.** Hides flash of discharge.  
**COMPENSATOR.** Reduces muzzle climb.
- 2. BOLT CATCH.** Holds the bolt assembly to rear when last round is fired.
- 3. BUTTSTOCK ADJUSTMENT RELEASE LEVER.** Releases lock to adjust stock positions.
- 4. SLING SWIVEL.** Allows operator to attach sling to the firearm.
- 5. SELECTOR LEVER.** Allows the operator to select the mode of fire and place firearm on safe.

## LEFT VIEW

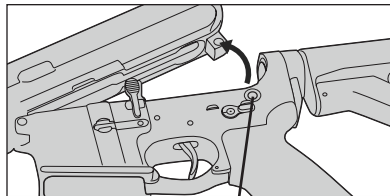




## MAINTENANCE

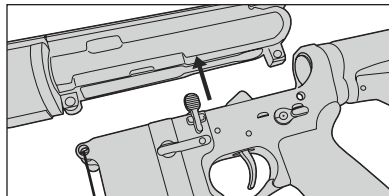
### DISASSEMBLY INSTRUCTION

1. Clear your firearm
2. Remove sling
3. Push rear take down pin as far as it will go pivot upper receiver from lower receiver



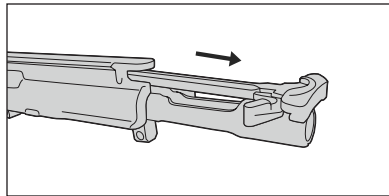
REAR TAKE DOWN PIN

4. Push front receiver pivot pin as far as it will go.
5. Separate upper and lower receiver

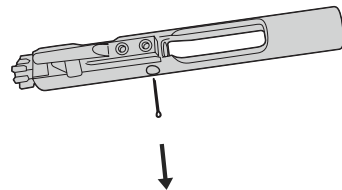


FRONT RECEIVER PIVOT PIN

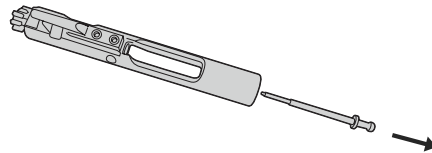
6. Pull back charging handle and bolt carrier



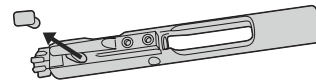
7. Remove bolt carrier and bolt
8. Remove charging handle
9. Remove firing pin retaining pin



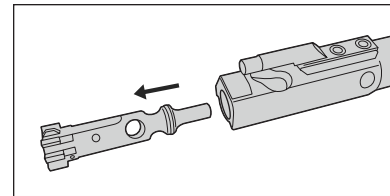
10. Push in bolt assembly to locked position
11. Drop firing pin out rear of bolt carrier



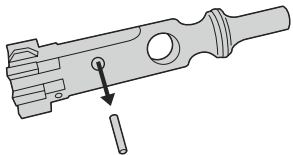
12. Remove bolt cam pin



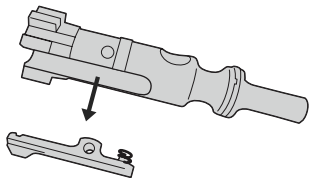
13. Remove bolt assembly



14. Remove extractor pin

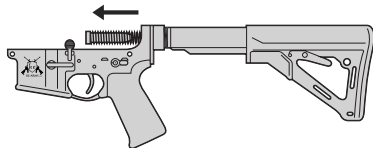


15. Remove extractor and spring assembly



16. Press in buffer, depress retainer, and release buffer

17. Remove buffer and action spring



## CLEANING INSTRUCTIONS

With the firearm disassembled, thoroughly clean, wipe dry and lube.

**BORE** – The bore of your firearm has lands and grooves called rifling. Rifling makes the bullet spin very fast as it moves down the bore and down range. Because it twists so quickly, it is difficult to push a new, stiff bore brush through the bore. You will find it easier to pull your bore brush through the bore. Also, because the brush will clean better if the bristles follow the grooves (called tracking), you want the bore brush to be allowed to turn as you pull it through

## UPPER RECEIVER

1. All areas of Powder Fouling, Corrosion, Dirt, and Rust
2. Bore: Push cleaning brush from chamber to muzzle. Never reverse in barrel. Swab with patches or bore snake.
3. Locking Lugs
4. Gas Tube
5. Chamber: Install chamber brush on cleaning rod. Dip in solvent and insert in chamber and locking lugs. Clean by pushing and twisting cleaning rod.  
NOTE: Gas tubes will discolor from heat Do not attempt to remove discoloration. Use a worn out bore brush to perform the following step. This procedure ruins the bore brush.
6. Use a bore brush to clean outside surface of protruding gas tube (get sides and bottom from bottom of upper receiver).

## BOLT CARRIER ASSEMBLY

Clean with solvent

1. Clean carbon and oil from firing pin, firing pin recess and all surfaces of bolt/bolt carrier with dry swabs.
2. Clean bolt carrier key with worn brush.
3. Clean firing pin hole with pipe cleaner.
4. Carbon deposits and dirt from locking lugs
5. Areas behind bolt ring and under lip of extractor

## LOWER RECEIVER AND BUTTSTOCK ASSEMBLY.

**CAUTION:** Do not use wire brush or any type of abrasive material to clean aluminum surfaces.

1. Wipe dirt from trigger with a swab.
2. Use a swab dipped in CLEANING LUBRICATE OR SOLVENT and cleaning brush to clean powder fouling, corrosion, and dirt from outside parts of lower receiver and extension assembly.
3. Clean buffer assembly, spring, and inside lower receiver and buffer tube with swab dipped in CLEANING LUBRICATE OR SOLVENT. Wipe dry.

## EJECTOR

1. Place a few drops of CLEANING LUBRICATE OR SOLVENT around the ejector to form a puddle.
2. Take a fired or dummy case and place it under the lip of the tractor. With a rocking motion, 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. Replace the CLEANING LUBRICATE OR SOLVENT frequently. Once the spring action of the ejector is smooth and strong, dry off any excess.

## REASSEMBLY INSTRUCTIONS

Use Disassembly diagrams in reverse to reassemble.

1. Insert buffer spring and buffer.
2. The large end of extractor Spring assembly in the extractor and seat it by pushing and turning clockwise.
3. Insert extractor assembly into bolt
4. Install extractor pin.

NOTE: Stagger ring gaps to stop gas loss

5. Slide bolt into bolt carrier.

**WARNING:** Be sure the cam pin is installed in the bolt carrier assembly. If it isn't, your firearm can still fire and will explode.

6. Insert bolt cam pin
7. Drop in and seat firing pin

8. Pull bolt out.

9. Insert firing pin retaining pin.

NOTE: Firing pin should not fall out when bolt carrier assembly is turned upside down.

10. Insert charging handle part way.

11. Slide in bolt carrier assembly

12. Push charging handle and bolt carrier assembly together into upper receiver until fully seated.

13. Join upper and lower receivers.

14. Engage receiver pivot pin.

15. Close upper and lower receiver assembly. Push in takedown pin.

16. Install sling.



For more information about KE Arms and  
KE Arms firearm products, please visit  
[www.KEArms.com](http://www.KEArms.com)

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