



XM15-E2S[®]

SAFETY+ OPERATING MANUAL

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BUSHMASTER.COM
@BUSHMASTER_OFFICIAL

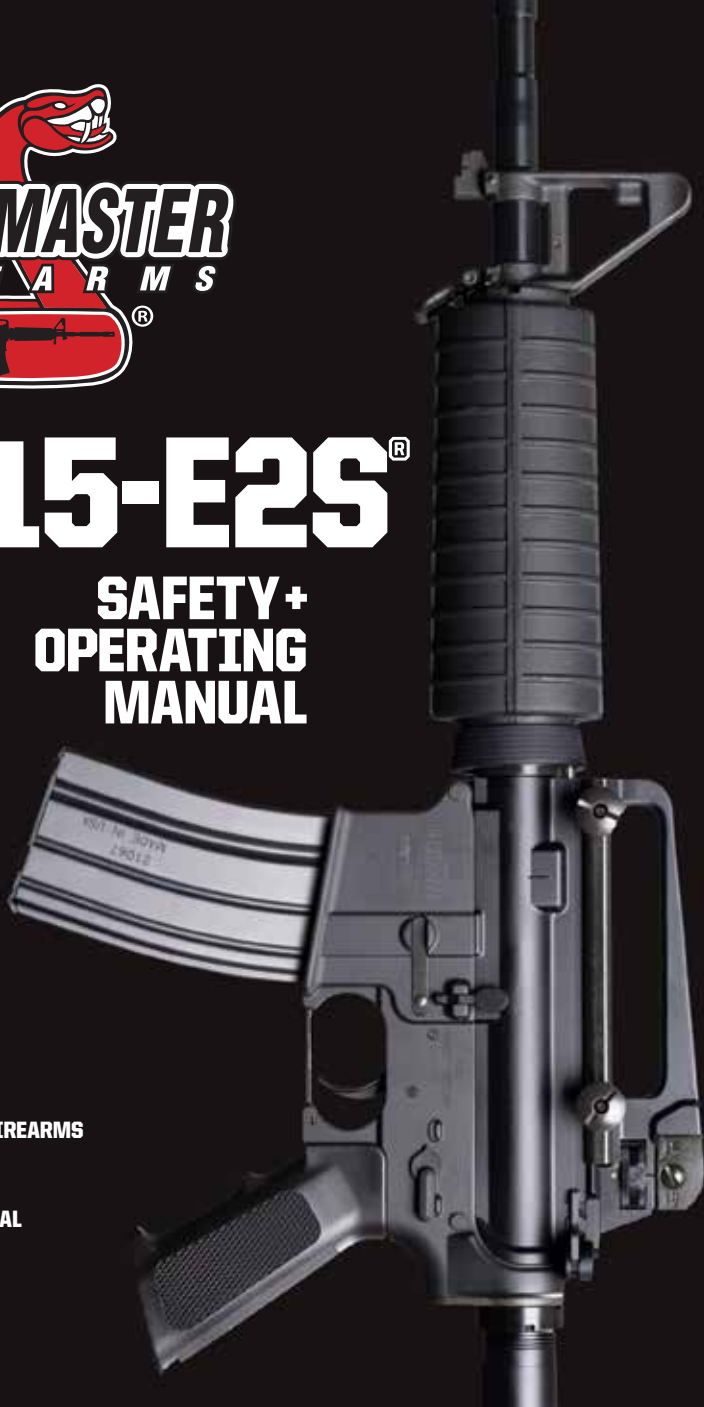




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AMERICA'S RIFLE.

Thank you for purchasing a firearm from Bushmaster Firearms International.™

Driven by the spirit of innovation that began over 50 years ago, the Bushmaster® name is one of quality, craftsmanship, and legacy. The new Bushmaster® is dedicated to bringing back not only the rifles we all remember but also the quality of the original Bushmaster® name.

While keeping up with the changing technology of today and tomorrow, we are striving to refine our engineering and manufacturing operations to continue building on the high-quality craftsmanship Bushmaster® has been known for.

With this safety and operating manual, we are providing the basic information necessary to safely own and operate your Bushmaster® firearm.

Before operating your firearm, please do the following:

- Read the entire Safety & Operating Manual before using your weapon.
- Practice handling your weapon without ammunition.
- If you have any questions or do not understand something written in this manual, seek professional support or call Bushmaster™ for clarification.
- **Always follow the Universal Firearm Safety Rules (see page 6 for complete list).**
 1. Always keep firearm pointed in a safe direction.
 2. Treat all guns as though they are loaded.
 3. Keep your finger off the trigger until you are ready to shoot.
 4. Always be sure of your target and what's beyond it.



**100% AMERICAN MADE.
100% AMERICAN DESIGNED.
100% AMERICAN BUILT.
100% BUSHMASTER.®**



State Warnings

Warnings Specified by State:

The following warnings and disclosures are required by the laws of the various states identified below. These warnings do not represent the entirety of laws regulating firearms in those states. It is your responsibility to know and understand the federal, state, and local laws and regulations that apply in your jurisdiction. If you do not know or understand the laws relating to firearms, we recommend that you contact a lawyer before acquiring, possessing, or handling any firearm.

California:



WARNING

Children are attracted to and can operate firearms that can cause severe injuries or death. Prevent child access by always keeping guns 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 or sent to prison.



ADVERTENCIA

A los niños los atraen las armas de fuego y las pueden hacer funcionar. Ellos pueden causarse lesiones graves y la muerte. Evite que los niños tengan acceso a las armas de fuego guardándolas siempre con llave y descargadas cuando no las esté utilizando. Si usted tiene un arma de fuego cargada en un lugar en que un niño tiene acceso a ella y la usa indebidamente, le pueden dar una multa o enviarlo a la cárcel.



WARNING

Firearms must be handled responsibly and securely stored to prevent access by children and other unauthorized users. California has strict laws pertaining to firearms, and you may be fined or imprisoned if you fail to comply with them. Visit the website of the California Attorney General at <https://oag.ca.gov/firearms> for information on firearm laws applicable to you and how you can comply.

Prevent child access by always keeping guns 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 or sent to prison.

If you or someone you know is contemplating suicide, please call the national suicide prevention lifeline at 1-800-273-TALK (tel:1-800-273-TALK) (8255).



ADVERTENCIA

Las armas de fuego deben manejarse de manera responsable y almacenarlas de manera segura para evitar el acceso de los niños y otros usuarios no autorizados. California tiene leyes estrictas relativas a las armas de fuego, y puede ser multado o encarcelado si no cumple con ellas. Visite el sitio web del Procurador General de California en <https://oag.ca.gov/firearms> para obtener información sobre las leyes de armas de fuego aplicables a usted y cómo puede cumplirlas. Evite el acceso de los niños manteniendo siempre las armas almacenadas y descargadas cuando no estén en uso.

Si mantiene un arma de fuego cargada donde un niño la puede obtener y usarla incorrectamente, puede recibir una multa o ser enviado a prisión. Si usted o alguien que conoce está contemplando el suicidio, llame a la línea nacional de prevención de suicidio al 1-800-273-TALK (8255).

Warning:

This product can expose you to chemicals including lead, which are known to the State of California to cause cancer and birth defects or other reproductive harm. For more information, go to - www.P65Warnings.ca.gov.

Connecticut:

"Unlawful storage of a loaded firearm may result in imprisonment or fine."

Florida:

"It is unlawful, and punishable by imprisonment and fine, for any adult to store or leave a firearm in any place within the reach or easy access of a minor under 18 years of age or to knowingly sell or otherwise transfer ownership or possession of a firearm to a minor or a person of unsound mind."

Maine:

"Endangering the welfare of a child is a crime if you leave a firearm and ammunition within easy access of a child, you may be subject to fine, imprisonment, or both. Keep firearms and ammunition separate. Keep firearms and ammunition locked up. Use trigger locks."

SAFETY & OPERATING MANUAL

Maryland:

“Warning:

Children can operate firearms which may cause death or serious injury. It is a crime to store or leave a loaded firearm in any location where an individual knew or should have known that an unsupervised minor would gain access to the firearm. Store your firearms responsibly!”

Massachusetts:

“Warning from the Massachusetts attorney general: This handgun is not equipped with a device that fully blocks use by unauthorized users. More than 200,000 firearms like this one are stolen from their owners every year in the United States. In addition, there are more than a thousand suicides each year by younger children and teenagers who get access to firearms. Hundreds more die from accidental discharge. It is likely that many more children sustain serious wounds, or inflict such wounds accidentally on others. In order to limit the chance of such misuse, it is imperative that you keep this weapon locked in a secure place and take other steps necessary to limit the possibility of theft or accident. Failure to take reasonable preventive steps may result in innocent lives being lost, and in some circumstances may result in your liability for these deaths.”

“It is unlawful to store or keep a firearm, rifle, shotgun, or machine gun in any place unless that weapon is equipped with a tamper-resistant safety device or is stored or kept in a securely locked container.”

New Jersey:

“It is a criminal offense to leave a loaded firearm within easy access of a minor.”

New York City:

“The use of a locking device or safety lock is only one aspect of responsible firearms storage. For increased safety, firearms should be stored unloaded and locked in a location that is both separate from their ammunition and inaccessible to children and other unauthorized persons.”

North Carolina:

“It is unlawful to store or leave a firearm that can be discharged in a manner that a reasonable person should know is accessible to a minor.”

Texas:

“It is unlawful to store, transport, or abandon an unsecured firearm in a place where children are likely to be and obtain access to the firearm.”

Wisconsin:

“If you leave a loaded firearm within the reach or easy access of a child you may be fined or imprisoned or both if the child improperly discharges, possesses, or exhibits the firearm.”

Basic Rules Firearm Safety

1. Always keep firearm pointed in a safe direction.
2. Treat all guns as though they are loaded.
3. Keep your finger off the trigger until you are ready to shoot.
4. Always be sure of your target and what's beyond it..
5. Learn the mechanical and handling characteristics of the firearm you are using.
6. Be sure that the barrel is clear of any obstructions before shooting. Even excess oil or a spider web can cause a problem. Never fire with water in the barrel.
7. Always make sure everyone in the vicinity is wearing eye and ear protection suitable for firearm use prior to shooting.
8. Never use alcohol or drugs when shooting. If you are using prescription medication, contact your doctor to determine your fitness prior to using the firearm.
9. Keep yourself, all persons, obstructions and flammables away from the ejection port when firing as hot shell cases will be ejected with significant force
10. Never place your fingers in the ejection port except when physically checking the chamber to determine if the firearm is loaded. CAUTION: The carrier may slide forward under spring pressure and injure you if the firearm is used improperly.
11. Never climb a tree or fence with a loaded firearm.
12. Do not store, carry, drop, drive a vehicle, bicycle, walk or run with a live round in the chamber. A gun that is dropped, bumped, or jarred with a live round in the chamber might accidentally discharge, even with the safety on, causing injury to you or someone else.
13. Do not shoot at a hard surface or water; it may ricochet in an unsafe direction.
14. Never rely on your firearm's safety mechanism to justify careless handling.
15. Always keep your selector set to "safe" prior to target acquisition when the firearm is loaded.
16. Never discharge the weapon near flammable material. Muzzle flash may ignite a fire or cause gases or liquids to explode.
17. Never force a jammed action as the jammed round may cause the rifle to explode. Use of the forward assist should take minimal pressure. If a jammed action is not resolved with application of minimal pressure placed on the forward assist, it is likely that the firearm is in need of inspection and cleaning before additional use.

18. If your firearm failed to fire after the trigger was pulled, wait at least 1 minute before clearing. Continue to keep the firearm pointed in a safe direction. Water, oil, or other contaminants in the ammunition can cause a delayed fire.
19. If you notice a difference in sound or recoil while firing, stop immediately and clear the firearm. A “squib” or sub-standard round may have fired, and the bullet may be stuck in the bore. If another shot is fired with the bore obstructed, the barrel may bulge or burst, causing injury or even death to yourself and/or others in the vicinity.
20. Sustained fire will heat up the barrel and receiver to the point that it may cause burns when touched. Never shoot your firearm to the point that it is too hot to touch as it may, in rare occasions, also create an accidental discharge by “cooking off” ammunition in a hot chamber even though the trigger was never pulled. In addition, excessive rapid fire may cause premature wear of the barrel.
21. This firearm may discharge accidentally if it is dropped or struck with sufficient force while a live cartridge is in the chamber.
22. Do not shoot your firearm around animals unless they are trained accordingly. They may react to the sound of the discharge and can cause an accident, injury or death to yourself or others.
23. Always unload the magazine and chamber, lock the bolt back, and physically & visually check the weapon is totally clear of ammunition prior to handing someone an unloaded firearm.
24. Always check that the status of any firearms before handling. Check the status of the firearm even if the firearm is believed to be “unloaded” and even if you witnessed another person clear the firearm.
25. Use of substandard ammunition will void the warranty and may damage your firearm. Only use quality, clean burning, commercial ammunition designed and specified for your firearm that meets Sporting Arms and Ammunition Manufacturers’ Institute (SAAMI) specifications. Poor quality ammunition that generates excessive fouling may cause your XM15-E2S® to malfunction and necessitate additional cleaning. Use of substandard ammunition can cause damage, injury or death. Use of remanufactured, reloaded or otherwise altered ammunition will void your warranty. Use of steel case ammunition is not suggested.

26. Always store your firearm and ammunition in separate locked gun safes or vaults where children will not have access.
27. Never abuse your firearm by using it for some purpose other than what it was designed to do.
28. Never dry fire when the upper receiver and bolt carrier group are not in place. This action may damage the lower receiver.
29. Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may cause birth defects, reproductive harm, cancer, and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly with cold water and soap after exposure.
30. Be sure the Cam Pin is installed in the Bolt Group. The firearm can fire and may explode if it is not installed. Any claim of warranty will be void in the event that the firearm is fired without the Cam Pin properly installed.
31. If you do not understand any comments noted above, seek help from your licensed retailer or seek professional training prior to use.
32. Do not provide access, possession, custody or control of any firearm, even if only temporary, to any person known to be a felon or whom is otherwise prohibited from possessing any firearm.
33. Be mindful of those who have access, possession, custody or control of your firearm. Do not permit others whom you believe may intend to do harm to themselves or others, or whom have a history of mental health instability that may affect their judgment or ability to operate and use a firearm safely and lawfully from to access, possess, or control any firearm.
32. When firearms are present, always be mindful of how each firearm is being used or handled. If you witness someone mishandling or misusing any firearm, take all appropriate precautions to ensure your safety and the safety of others.

Manufacturer's Warning:

Please be sure to contact your local licensed firearms retailer, state department of justice, attorney general, local police or sheriff's office, and/or a licensed attorney to ascertain if there have been any additional changes in laws pertaining to ownership of firearms within your locality. Firearms laws change so rapidly and these changes may affect how you acquire, possess, use, store, and transfer your firearm lawfully. It is the user's responsibility to know all laws in their jurisdiction **prior to purchasing or using this firearm.**

Manufacturer's Warning:

This is a semiautomatic firearm! Every time the firearm is fired, a new round will automatically be loaded into the chamber until all ammunition is depleted. Removing the magazine may not completely unload the firearm, and a cartridge may be left in the chamber even after the magazine has been removed. The user must also lock the bolt back and check that the chamber is clear. This firearm does not utilize a magazine disconnect. If a round is left in the chamber and the trigger is depressed, the ammunition will discharge even if the magazine is removed! Be aware that firearms equipped with a Binary Firing System® operate differently and users must follow the specific directions that accompany those products.

Manufacturer's Notice:

Bushmaster Firearms International™ will not be responsible for damage, injury, or death resulting from intentional or accidental discharge of this firearm due to improper handling, maintenance, alterations, or for any other reason.

Manufacturer's Notice:

This firearm was inspected, and quality checked multiple times prior to leaving the factory, however, we cannot guarantee that it has not been damaged or tampered with after it has left our facility. Therefore, it is important that the purchaser of this firearm inspect the firearm carefully prior to using it. If anything appears deficient, do not fire the weapon and contact your licensed retailer immediately.

Manufacturer's Notice:

This manual should always accompany the firearm. If the firearm is transferred or lent to someone else, be sure that the person is legally allowed to receive the firearm and make sure the person reads the manual prior to handling the firearm. Additional manuals are available and can be downloaded Online at: www.bushmaster.com

Manufacturer's Warning:

This product from Bushmaster Firearms International™ is defined by the Alcohol, Tobacco, and Firearms Division of the Federal Government as a firearm. By definition, this product is **Potentially Lethal!**

Manufacturer's Warning:

Any unusual force applied to the firearm through a use that is inconsistent with the intended design parameters of this firearm can possibly cause premature failure.

Manufacturer's Warning:

This firearm has an external safety device that can be toggled from "Safe" to "Fire." With the firearm on "Fire," never insert your finger or any other object within the trigger guard or depress the trigger unless you intend to fire the firearm. If the safety is ever found to be defective for any reason, immediately unload the firearm. DANGER of an unintentional discharge exists if the firearm remains loaded with an inoperable safety. If the safety is defective, do not use the firearm again (or allow anyone else to have access to it) until a qualified gunsmith or Bushmaster Firearms International™ armorer can properly repair the deficiency.

Manufacturer's Warning:

Never allow a finger to enter the ejection port while the bolt catch is depressed. The bolt carrier will slide forward with considerable force.

Binary Firing System Warning:

Your firearm may have also been equipped from the factory with a Binary Firing System®. If your firearm is so equipped, it will have a three position safety selector and a brightly colored selector indicator. (Red for BFS®) The BFS® can be toggled to "Safe," "Semi," or the third position labeled "Binary®" on your model. Please be sure to read the supplementary directions for these accessories prior to using the firearm.

Lead Exposure Warning:

Ammunition used in this firearm often contains lead. The use of this ammunition may expose you to lead. Lead or lead compounds are known to the State of California to cause cancer, birth defects, reproductive toxicity, and other serious physical injury. Those who clean firearms should take protective measures to avoid contact or exposure to such chemicals.

For Warranty Repair Please Contact Customer Service At:
800-883-6229

Warranty Notice:

Bushmaster Firearms International™ will provide service for defects in materials or workmanship at no charge to the purchaser for a period of one year from the date of sale of any BFI™ product. Be sure to retain your sales receipt in order to demonstrate the proof of purchase date.

Shipping Notice:

It is illegal to ship a firearm with ammunition in the same packaging. It is also illegal to ship a firearm with serial numbers that have been obliterated.

Exclusions From Warranty:

1. If this firearm has been disassembled further than what is necessary for basic “Field Strip” maintenance, and if damage has occurred as a result of improper disassembly, reassembly, or use, then the purchaser shall forfeit any claim. Further, the firearm owner must accept full responsibility for the correct reassembly and functioning of all parts, including replaced parts.
2. This firearm is intended to be used with expertly loaded ammunition adhering to specifications set by the Sporting Arms and Ammunition Manufacturers’ Institute. (SAAMI) Bushmaster Firearms International™ can, at its sole discretion, void any obligation to service the firearm or any claim if any non-SAAMI specified ammunition is employed.
3. The following activities are **not allowed**:
 - (a) With the upper removed, the trigger should never be depressed so as to allow the hammer to strike the lower receiver.
 - (b) Never apply excessive heat to the firearm or any component parts to the point that it may effect the hardening surface treatments.
 - (c) Never apply and leave corrosive or abrasive agents on any surfaces.
 - (d) Never use corrosive ammunition.
 - (e) Never disable the safety.
 - (f) Never fire the rifle without the Cam Pin properly installed.
 - (g) Never use foam cleaning agents.
4. Any damages associated with the possession and/or use of any BFI™ product are limited to, and may not exceed, an amount equivalent to the Manufacturer’s Suggested Retail Price (MSRP) of the firearm. Any consumer that intends to purchase a BFI™ product hereby agrees to this limitation as a precondition of the sale.
5. In no way shall BFI™ be responsible for incidental or consequential damages related to economic loss, injury, death, or property damage, even if such damages are as a result of a breach of this warranty, negligence or otherwise.

XM15-E2S® Operations

Model & Caliber Identification:

The Bushmaster™ Firearms name and model designation can be found on the left side of the lower receiver outside the magazine well. The serial number and caliber are also found at this location.

All BFI™ Firearms are marked “multi” caliber in case users switch upper receivers to different calibers such as 5.56 NATO (.223 Remington), 350 Legend, 450 Bushmaster, and 300-Blackout.

To eliminate confusion, users are instructed to look on the barrel of their firearm to determine the specific caliber designation.



Proper Ammunition:

Your firearm is designed to use ammunition specified by the Sporting Arms and Ammunition Manufacturers' Institute (SAAMI.) Only use SAAMI spec ammunition that your firearm is chambered in. If your firearm is chambered in 5.56 NATO, it will also accommodate the use of .223 Remington ammunition.



Unloading Your firearm:

1. Be sure to always point the firearm in a safe direction while performing this task.
2. Place the firearm on “SAFE” as shown in the picture. If the hammer is not cocked, the lever cannot be pointed toward safe.
3. Remove the ammunition source by removing the magazine. To do so, depress the magazine release button and pull the magazine out the bottom of the magazine well.



4. To lock the bolt open, pull charging handle rearward. Press the bottom of the bolt catch and allow the bolt to move forward until it engages the bolt catch. Return the charging handle to full forward position. If you hadn't before, place selector to safe.



5. Visually check receiver and chamber to ensure that these areas contain no ammunition.

5. Look through the ejection port to the inside of the chamber. Visually and physically verify with a tool, or if no tool is available, carefully use your finger, to ensure that there is not a round of ammunition in the chamber.



Field Stripping Your Firearm:

PRIOR TO FIELD STRIPPING THE FIREARM, FOLLOW THE DIRECTIONS ABOVE FOR “UNLOADING YOUR FIREARM.”

Warning: Wear safety glasses when field stripping the firearm.

Warning: Never disassemble the rifle further than described herein.

Any damage incurred from disassembly beyond the field strip described herein may void your warranty and forfeit any claim to factory repair.

1. Place the safety selector lever on “Safe,” and make certain that the firearm is unloaded
2. To field strip the handguard, rest the buttstock on a firm base while pointing the firearm straight up. Depress the delta ring in a downward motion with one hand and pivot the upper and/or lower handguard out and away. Note that some firearms are shipped with aluminum free float rails or picatinny railed forearms and are not meant to be field stripped.



3. This procedure is often made easier by having an assistant hold down the delta ring while the other person removes the handguard. There are also several handguard removal tools available on the market that make it easier for one person to accomplish this task.



With the handguards out of the way, be certain not to distort or damage the gas tube.

(Note: The gas tube comes with a preset double bend from the factory.)



Push the top of the bolt catch firmly and ensure that the bolt is in the forward position.

Warning: Never allow a finger to enter the ejection port while the bolt catch is depressed. The bolt carrier will slide forward with considerable force and may cause serious injury.



4. Push the take down pin on the left side so that it will slide out to the right side. The pin is designed to stop its travel just short of falling completely out. This action, when completed, will allow the upper receiver to pivot forward.



Warning:

Never dry fire the firearm when the upper and lower are not fully assembled. The steel hammer will hit the rear of the aluminum magazine well and eventually cause damage.

5. For convenience, the pivot pin may be pushed from left to right (just like the take down pin) and the upper receiver will then be separated from the lower receiver.



6. Slowly pull the charging handle back and remove the bolt carrier assembly. Be careful not to drop the bolt out as the charging handle comes back.



7. Remove the charging handle by sliding the charging handle to the point where the “ears” (or protruding tabs) on the charging handle can slip through the keyway on the upper receiver. When the charging handle is extended out approximately 4.4” from the upper receiver, the ears on the charging handle should be lined up and can slide up through the keyway.



8. To field strip the bolt, make sure that the bolt is in the forward or extended position. Next remove the firing pin retaining pin. (It looks like a cotter pin and is designed to only go through one side of the bolt carrier.)



9. Push the bolt into the carrier body.

10. Remove the firing pin. It will slide out to the rear of the carrier.



11. Turn the bolt cam pin 90 degrees and remove it from the carrier.



12. Remove the bolt from the bolt carrier body.



13. Push on the back of the extractor to relieve pressure off of the extractor roll pin. Use an appropriate sized punch to remove the roll pin.



14. Do not attempt to remove the rubber grommet from the extractor spring.



15. To remove the buffer assembly and buffer spring from the receiver extension in the lower assembly, push in the buffer assembly slightly while depressing the buffer retainer. Note that the buffer assembly has three flats on it. It is easier to remove the assembly if one of the buffer assembly flats is positioned over the buffer retainer. Also, the hammer should be cocked so that it is not in the way. Slowly let the buffer and spring slide past the buffer retainer until it is fully removed.



16. In order to disassemble the magazine for cleaning, place a tool into the hole in the magazine floorplate. Carefully use the tool to leverage and slightly lift the edge of the magazine base so that it can slide off the rear of the magazine. (See Photos on Next Page)



17. You may now remove the spring and follower from the magazine.

Warning:

Never disassemble your firearm beyond what has been described herein. To do so will void the warranty. Seek out a qualified gunsmith or Bushmaster Firearms International™ armorer if your firearm is in need of further disassembly.

Cleaning and Lubricating Your Firearm:

Before cleaning or lubricating your firearm, follow the directions specified above for “Unloading” and “Field Stripping Your Firearm.”

Be sure to clean the firearm arm prior to initial use. The reason for this is that the metals (including the bore and chamber) have been treated with special preservatives at the factory that protect the firearm during shipping and storage. These preservatives should be wiped clean with a flannel patch prior to initial use. While there are many quality products in the marketplace, Bushmaster Firearms International™ recommends Lucas Oil products for cleaning, lubricating and maintaining your firearm. Gun Lube and CLP are very effective lubricants. Whatever you chose, be sure to use lubricants applicable for the intended environment. Some other oils may slow or halt the operation of the firearm in extremely cold environments. **DO NOT USE FOAM CLEANERS!**

Maintenance of your firearm is classified into two major categories. “Routine maintenance” is expected to be performed by the firearm owner. “Periodic maintenance” is expected to be performed by a gunsmith or Bushmaster™ Firearms armorer only. Routine maintenance is to be performed as prescribed below. Periodic maintenance must be performed every year or 10,000 rounds, whichever comes first.

Always perform routine maintenance on your firearm after it has been exposed to the elements such as water, dirt, sand, or extreme humidity. Routine maintenance of the firearm is essential to retain proper functioning of your firearm. The firearm should be thoroughly cleaned after each day that it is used. Most of our firearms utilize a standard "Direct Impingement Gas System" that was originally developed over 60 years ago and works very well. However, since the propellant gases are siphoned off of the barrel and forced into the upper receiver and bolt carrier key, carbon build up may occur in several places. Excessive carbon build up is the leading cause of malfunctions in any AR type rifle, so it is imperative that the firearm be maintained on a regular basis. We recommend that your firearm be field stripped, cleaned, and lubricated at least every 500 rounds for proper functioning. The quality of ammunition and propellant used may affect the need to clean more or less frequently. Some poor quality foreign ammunition may require thorough cleaning after just 100 rounds in order to maintain reliable functioning.

Warning:

Always have proper ventilation while cleaning the firearm. Cleaning a firearm in poorly ventilated areas, discharging firearms, or handling ammunition may result in exposure to lead and other substances known to cause birth defects, reproductive harm and other serious physical injury. Wash hands thoroughly in cold water after exposure.

Warning:

If improper solvents are used, damage to the firearm finish may occur. Use of strong ammonia or alkaline type solvents is not recommended your firearm. DO NOT USE FOAM CLEANERS!

1. Use a properly sized bore brush to remove fouling from the bore. Always run the brush in from the breach and not the muzzle.
2. Wipe away the fouling with a properly sized flannel bore patch.
3. Repeat steps one and two until all residue is removed.
4. Use a chamber brush specifically designed for the 5.56 NATO chamber to remove all fouling from the chamber.
5. Wipe away the fouling with a properly sized flannel chamber patch, or similar product.
6. Repeat steps four and five until all residue is removed.
7. After the barrel has been cleaned, use a very light coat of lubricant to protect the bore.
8. Remove all carbon residue from the extractor, bolt, bolt carrier key, firing pin, firing pin chamber, carrier, charging handle, and upper receiver. Specifically designed "pipe cleaners" and cotton swabs will aid in removing fouling from many of these areas.
9. Wipe down the firearm and component parts with a soft cloth.
10. After cleaning, use a high quality firearms specific lubricant to lightly coat the external parts. A quality "dry lube" is recommended for the exterior metal surfaces. In any case, do not leave any obvious finger prints on the metal surfaces as finger moisture may lead to corrosion.

Reassembly of your firearm:

1. Reassemble your firearm in the reverse order that it was taken apart.
2. Prior to assembling the bolt into the bolt carrier assembly, ensure that the three gas ring gaps are staggered and NOT in alignment. The gaps must be staggered for proper functioning.

CORRECT



Correctly Staggered Gas Rings

INCORRECT



Incorrectly Staggered Gas Rings

3. Always make sure that the cam pin is installed correctly.

Warning:

The firearm can fire and may explode if the cam pin is not installed into the bolt carrier. Failure to reassemble the bolt carrier without the cam pin will result in damage to your firearm and may potentially injure you and others around you. It is your responsibility to make sure that the cam pin is installed correctly.



4. Lightly lubricate all metal parts during reassembly. Remove any excess oil.
5. Be sure to inspect the firearm for wear, cracks or any other deficiencies while reassembling the rifle. If any deficiencies are found, be sure to have the firearm inspected by a knowledgeable gunsmith or Bushmaster® Firearms armorer prior to using the firearm again. Also, be sure to secure the firearm so that no one else uses it until the deficiency is resolved.

Warning:

Do not use any ammunition other than the ammunition your firearm is chambered in! (See barrel markings for specific chambering.)

Collapsible Stock:

Your firearm may be equipped with a six position collapsible stock. To change the position on the collapsible stock, depress the lever underneath the stock and slide the stock forward or aft on the receiver extension tube until it is placed at the desired location. Release the lever, and it should lock into place. If it does not lock into place, slide the stock further until it snaps into one of the six pre-positioned points.

This collapsible buttstock is designed to have tolerance to allow for operation if fouled by small amounts of sand or dirt. However, from time to time, the collapsible buttstock may require cleaning in order to function properly.



Sights:

Your firearm may be equipped with a front sight. After the rear sight is selected and properly installed per the directions of the rear sight manufacturer, the front sight may be adjusted for elevation only. Depress the front sight detent and rotate the post clockwise to lower the post (and raise the point of impact,) or rotate the post counter-clockwise to raise the post (and lower the point of impact.)



Loading Your Firearm:

Warning:

Follow the unloading procedures (Page 13) to ensure that the firearm is unloaded before loading the firearm.

Warning:

Prior to loading your firearm, be sure to read, understand, and follow the “Basic Rules of Firearm Safety” listed above. Do not load the firearm until you are ready to use it.

Always point your muzzle in a safe direction.

1. While starting with an unloaded firearm, pull the charging handle back.
2. The empty fixed magazine should hold the bolt carrier back, but if for some reason it does not, pull the charging handle back again and simultaneously depress the lower portion of the bolt catch.



2. Push the charging handle forward until it snaps back into position.



3. Place the safety selector lever on "Safe."
4. At this point, the bolt should be locked back. Remove the magazine by depressing the magazine release button.



Manufacturer's Warning:

To load the magazine, make sure that the bolt carrier group is forward and in battery, push the takedown pin to the right, open the action by pivoting the upper receiver forward to access the Drop-in Fixed Magazine, load ten live rounds into the Drop-in Fixed Magazine, close the action, and secure the upper receiver to the lower receiver by pushing the takedown pin to the left. Next, pull the charging handle all the way back and proceed from Step 8.



California customers will receive their firearm equipped with a Drop-in Fixed Magazine® that is not designed to be removed from the firearm.

5. Now that the magazine has been removed from the magazine well, hold the magazine with your weak hand. With your strong hand, use your thumb to push a live round straight down against the feed lips and magazine follower. When the spring loaded magazine follower has been depressed far enough, you will be able to push the live round underneath the feed lips. Be sure to align the live rounds in the magazine so the bullets are pointing forward. The case heads should be positioned adjacent to the spine of the magazine.



6. Repeat step five, placing additional rounds on top of each other in a staggered column, until the magazine is fully loaded.
7. Insert the magazine into the magazine well with the bullet end of the cartridges pointing forward until the magazine catch engages the magazine. Pull down on the bottom of the magazine to confirm that it is firmly seated.



8. Drop the bolt carrier by depressing the upper portion of the bolt catch while keeping the muzzle pointed in a safe direction. This activity will automatically strip the top live round off of the magazine and chamber the round. Keep the firearm safety selector lever on “Safe” until you are ready to fire.



Warning:

Do not carry your firearm with the bolt carrier locked back while a loaded magazine is locked into the magazine well. If the bolt carrier were to get jostled and slide forward, an accidental discharge may result, especially if the safety selector is not set on “Safe.”

Warning:

Do not carry your firearm with a loaded round in the chamber if the firearm may be accidentally dropped or struck with significant force. Due to the fact that this firearm is equipped with a floating firing pin, it may accidentally discharge if dropped or struck hard enough even if the safety selector lever is set on “Safe.”

9. If the bolt does not fully seat after the bolt carrier has slid forward, articulate the forward assist plunger so that the bolt goes into battery.

Warning: The force necessary to articulate the forward assist is slight. If it takes significant force to push the forward assist button, stop what you are doing and disassemble the firearm to diagnose why the firearm is not operating correctly. Often dirt, fouling, or improper ammunition may be the cause. Make sure that the chamber is not in any way encumbered before proceeding.

10. After the firearm is loaded, you may close the ejection port cover to reduce the likelihood of sand, dirt, or debris from entering the action.

Warning:

Always load the firearm from the magazine. Never attempt to load the firearm by inserting a live round through an open ejection port.

Firing your firearm:

Warning:

Before attempting to fire your Bushmaster™ firearm, it is critical that the trigger system be clearly identified. If your firearm is equipped with a brightly colored label around the three position safety selector, please read the instructions that shipped with that BFS® trigger. If your firearm has a two position selector, please follow the instructions herein.

1. Firmly hold the firearm pistol grip with one hand being sure to keep your finger out of the trigger area until you are ready to shoot.



2. Grab the handguard with your remaining hand.
3. Use both hands to bring the firearm up to a level position and firmly seat the buttstock to your shoulder high enough so that you do not have to crane your head over too far to see your sights.



4. Place the safety selector lever to “Fire” and maintain strict muzzle discipline.
5. Gently pull the trigger with your index finger until it fires.



Warning:

Like all semi-automatic firearms, your firearm will automatically feed another round into the chamber after it has fired and ejected the first round.

6. In order to fire a successive round, release and gently pull the trigger again. This activity can be repeated until the magazine is empty.
7. When done firing, place the safety selector lever to “Safe” and if the magazine is empty, the bolt will be held to the rear by the bolt catch.



Clearing a Misfire:

If for any reason there is any indication that your firearm is not performing properly, stop firing, point the muzzle in a safe direction, and unload the firearm. Do not use the firearm again until it has been evaluated by a knowledgeable gunsmith or Bushmaster Firearms International™ armorer.

If a cartridge does not fire when it should have....

1. Keep the muzzle pointed in a safe direction for at least one minute. The possibility of a delayed or “hang fire” may exist.
2. Place the safety selector lever in the “Safe” position while waiting.



3. After one minute, unload the firearm per the directions noted under “Unloading Your Firearm” and inspect the primer on the live round that did not fire. Evaluate whether it is just a bad primer or if the primer was adequately struck by the firing pin. A light firing pin strike on the primer may be a result of a damaged or worn firing pin chamber, a dirty firing pin chamber, or a broken hammer spring.

If a misfeed or “jam” occurs....

1. Keep the muzzle pointed in a safe direction.
2. Place the safety selector lever in the “Safe” position.



3. Depress the magazine release button and remove the magazine.

4. Pull the charging handle to the rear while depressing the lower portion of the bolt catch. This will hold the bolt back.



5. Remove any remaining ammunition.
6. Visually inspect the action and chamber to make sure there is not any ammunition or any other substance in the action.



Warning:

Do not closely peer into the ejection port when clearing a misfeed. If a cartridge primer were to be struck by a hard object such as another cartridge, the primer could ignite causing a case head rupture. A case head rupture could cause severe injury or death to you or others around you.

Warning:

Do not attempt to reuse damaged ammunition.

7. After you are certain that all ammunition is cleared, you may reload the firearm per the instructions under "Loading Your Firearm"

Troubleshooting Procedures

Malfunction	Test Or Inspection	Corrective Action
Won't Fire	Tight indentation on the primer	Discard ammunition.
	Selector lever on SAFE.	Put in fire position.
	Improper assembly of firing pin.	Assemble correctly retaining pin goes in back of large shoulder of firing pin.
	Too much oil in firing pin recess.	wipe out with pipe cleaner.
	Defective ammo.	Remove and discard.
Bolt Won't Unlock	Too much carbon on firing pin or in firing pin recess.	Clean.
	Dirty or burred bolt.	Contact Bushmaster Firearms.
	Dirty or corroded ammo.	Clean.
	Dirty magazine.	Clean.
	Defective magazine.	Replace.
Won't Feed	Too many rounds in magazine.	Take out excess.
	Action of buffer assembly is restricted.	Take out buffer and spring and clean.
	Magazine not fully seated.	Tap on magazine or adjust magazine catch.
Double Feed	Defective magazine.	Replace.

Troubleshooting Procedures (Continued)

Malfunction	Test Or Inspection	Corrective Action
Won't Chamber	Dirty or corroded ammo.	Clean or replace.
	Damaged ammo.	Replace.
Won't Lock	Carbon in chamber or on gas tube.	Clean.
	Dirt, corrosion, or carbon buildup in barrel or bolt locking lugs.	Clean Lugs
Won't Extract	Frozen extractor.	Remove and clean.
	Broken extractor spring.	Replace.
	Restricted buffer assembly.	Remove and clean.
	Restricted movement of bolt carrier group.	Remove, clean, and lube. (Before putting bolt back in, make sure gas tube fits into carrier key and that the carrier moves freely.
Short Recoil	Dirty or corroded ammo.	Remove and clean.
	Dirty chamber.	Clean Chamber.
	Gaps in bolt rings (not staggered).	Stagger ring gaps.

Troubleshooting Procedures

Malfunction	Test Or Inspection	Corrective Action
Short Recoil (cont)	Damaged or broken rings.	Replace.
	Carbon or dirt in carrier key or on outside of gas tube.	Clean.
Bolt Fails to Lock After Last Round	Dirty or corroded bolt latch.	Clean.
	Faulty magazine.	Replace.
Selector Lever Binds	Needs oil.	Lubricate.
	Dirt or sand under trigger.	Clean.
Bolt Carrier "Hung Up"	<p>WARNING: Keep clear of muzzle. Round jammed between bolt and charging handle and/or double feed.</p> <p>CAUTION: If round is removed, bolt is under spring pressure.</p>	Remove magazine. Remove rounds, if not removed seek assistance from a range safety officer or qualified gunsmith.



DFM® MAGAZINE



XM15-CA™ MODEL

Manufacturer's Notice:

Firearms shipped to California (and jurisdictions with similar draconian laws) may be equipped with a patented “Drop-in Fixed Magazine®.” (Patent #9,395,130.) The DFM® is designed to be used as a fixed magazine and is not generally removable by the end user. Two tabs rear of the feed lips prevent the magazine from being removed out the bottom of the magazine well. It is important to note that it may be a violation of California law if the magazine were to be removed and the action closed. Consequently, we recommend that the DFM® never be removed while within the boundaries of California.

Firearms shipped to California and other restrictive jurisdictions may be equipped with a fixed magazine known as the “Drop-in Fixed Magazine.”

If your firearm is equipped with a DFM®, you will have to visually inspect the magazine to ensure that it does not contain any live ammunition. In addition, DFM® owners may remove the floor plate as shown on page 20.

Clearing Jam:

California firearms equipped with a Drop-in Fixed Magazine® will not be able to remove the magazine by depressing the magazine release button. Instead, it will be necessary to remove the magazine floor plate in order to remove all ammunition and clear the jam. Refer to Manual Page 30-31 for more steps.

Loading Firearm:

California customers will receive their firearm equipped with a Drop-in Fixed Magazine® that is not designed to be removed from the firearm. To load the magazine, make sure that the bolt carrier group is forward and in battery, push the take down pin to the right, open the action by pivoting the upper receiver forward to access the Drop-in Fixed Magazine, load ten live rounds into the Drop-in Fixed Magazine®, close the action, and secure the upper receiver to the lower receiver by pushing the takedown pin to the left. Next, pull the charging handle all the way back and proceed from Manual Page 24.

Locking Devices:

Every Bushmaster® firearm is packaged with a cable lock certified by the California Department of Justice. Please follow the directions that accompany the lock for proper use.

Storage of Your Firearm:

If your firearm is to be put in storage, be sure not to encase it in any container that will attract moisture, such as a leather case. Do not plug the barrel since this may cause moisture accumulation. If the firearm is to be stored for an extended period of time, a high quality anti-rust, preservative, lubricant should be liberally applied to all metal parts, inside and out. Be sure to remove these lubricants by cleaning the firearm prior to placing it in service again, and ensure that the firearm is stored in compliance with all state, federal, and local laws and regulations and that proper safety considerations have been given to ensure against unlawful, unsafe, or improper access while in storage.

SUGGESTIONS OR CORRECTIONS TO THIS MANUAL SHOULD BE MAILED TO:

**Bushmaster Firearms International™
3505 Arrowhead Dr
Carson City, NV 89706**



AMERICA'S RIFLE.

INFO@BUSHMASTER.COM

(800)-883-6229

WWW.BUSHMASTER.COM