

GFORCE ARMS™

Your Authority For Quality Firearms



GF11220B® SEMI-AUTOMATIC SHOTGUN INSTRUCTION MANUAL

MODEL
SAX 12GA®

MANUFACTURER
FRANCOLIN

ITEM NUMBER
GF11220B®

DESCRIPTION
GFORCE ARMS GF1
TUBE-FED
SEMI-AUTOMATIC
SHOTGUN

This instruction manual should always accompany this firearm and be transported with it upon transfer of ownership, or when this firearm is loaned or presented to another person.

FOR SERVICE ON THIS MODEL CALL
(833) 343-6723

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

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STATE-BY-STATE WARNINGS

Some states have their own legally required warning notices in larger than normal type that must be conspicuously included by the manufacturer, distributor or retailer with firearms sold in that state. GForce Arms, Inc. sells its products in compliance with applicable laws and regulations, and so we include the following:



Connecticut:

"UNLAWFUL STORAGE OF A LOADED FIREARM MAY RESULT IN IMPRISONMENT OR FINE."



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."



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."



Texas:

"IT IS UNLAWFUL TO STORE, TRANSPORT, OR ABANDON AN UNSECURED FIREARM IN A PLACE WHERE CHILDREN ARE LIKELY TO BE AND CAN OBTAIN ACCESS TO THE FIREARM."



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."



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."

Please check with your licensed retailer or state police for additional warnings which may be required by local law or regulation. Such regulations change constantly, and local authorities are in the best position to advise you on such legal matters.

FIREARM SAFETY

IMPORTANT WARNING: FAILURE TO ADHERE TO THE RULES OF FIREARM SAFETY CAN RESULT IN SERIOUS INJURY, DEATH, OR DESTRUCTION OF PROPERTY.

IMPORTANT WARNING: IT IS IMPORTANT FOR YOU TO RECEIVE PROPER TRAINING FROM A COMPETENT FIREARMS INSTRUCTOR OR AUTHORITY BEFORE BEGINNING TO SHOOT OR WHEN HANDLING THE FIREARM.

COMPLETELY READ AND UNDERSTAND YOUR OWNER'S MANUAL GUIDELINES BEFORE USING YOUR FIREARM.

You should fully understand the function of all of the components and mechanics of the firearm. Before you remove the firearm out of the box thoroughly read the owner's manual on how to properly carry, handle, load, unload, and store your new firearm. Know the rules of proper gun safety and exercise them at all times because failure to do so may result in death or injury to yourself or others. Because it is impossible to list every firearm situation or scenario, be aware that certain circumstances may require additional safety rules unique to a particular situation. In these cases, we recommend that you use your best judgement.

ALWAYS LEARN THE SPECIFIC MECHANICAL AND HANDLING CHARACTERISTICS OF YOUR SHOTGUN

All firearms are different thus it is important for you to understand how to properly carry, use, and handle each one according to its specific guidelines. Before using any firearm, one must completely familiarize themselves with the type of firearm and its specific safe handling procedures for loading, unloading and carrying.

NEVER GIVE THE SHOTGUN TO ANY PERSON WHO HAS NOT THOROUGHLY FAMILIARIZED HIMSELF OR HERSELF WITH ALL OF THE INFORMATION, SAFETY RULES, AND WARNINGS IN THE OWNER'S MANUAL

NEVER ALTER OR MODIFY YOUR SHOTGUN

This shotgun was produced under specific manufacturer guidelines and should not be modified under ANY circumstances. Altering the trigger, mechanical components, safety mechanisms, or using any parts or accessories other than those that were provided in the original box with your gun or specifically recommended in this manual is NOT RECOMMENDED by the manufacturer, and could result death, bodily harm, or compromise your safety or the safety of others. Any alteration made to the firearm also voids the factory warranty.

ALWAYS KEEP THE FIREARM UNLOADED UNTIL READY TO USE

Firearms should be kept unloaded when not in use. Whenever you pick up a firearm, immediately engage the safety device and remove the magazine to visually inspect the chamber and confirm that it is clear. Always unload all ammunition from the chamber and remove the magazine after:

- 1.) Shooting
- 2.) Putting the firearm away
- 3.) Putting the firearm into a case
- 4.) When not in use
- 5.) When handing it to another person

ALWAYS KEEP THE MUZZLE POINTED IN A SAFE DIRECTION

It's as simple as that, and it's up to you. Never point your gun at anything you do not intend to shoot. The safe direction may be "up" on some occasions or "down" on others, but never pointed at anyone or anything not intended as a target.

KNOW YOUR TARGET AND WHAT IS BEYOND IT

Whether you are at the range or in the woods, if you're going to shoot, you must know what lies beyond your target. In almost all cases, you must be sure that there is something that will serve as a backstop to capture projectiles that miss or go through the target.

A GUN OWNER'S RESPONSIBILITY

As the owner of a firearm you have the responsibility and obligation of ensuring that any and all shooting activities are safe for everyone. This requires your personal commitment to carefully read, fully understand, and exercise the principles of proper firearm safety at all times. If this is the first shotgun you have ever owned, or if you have limited experience with firearms, please visit your local shooting range and ask a trained professional to provide you with hands on training and tutorial. Doing this will improve your confidence and safety when using your firearm.

DISCLAIMER

THE FIREARM TO WHICH THESE SAFETY RULES APPLY IS SOLD UNDER THE EXPRESS RESULTING CONDITION THAT THE MANUFACTURER ACCEPTS NO LIABILITY IN PART OR WHOLE FOR BODILY INJURY, DEATH, OR PROPERTY DAMAGE FROM:

- IMPROPERLY OR CARELESSLY HANDLING THE FIREARM.
- USING DEFECTIVE, IMPROPER CALIBER, HAND-LOADED, OR RELOADED AMMUNITION.
- INADEQUATE MAINTENANCE OF THE SHOTGUN RESULTING IN CORROSION OR DAMAGE.
- NEGLIGENCE.
- RESALE IN CONTRADICTION OF ANY APPLICABLE LAWS OR REGULATIONS.
- ALTERING OR CONVERTING THE FIREARM'S ORIGINAL AESTHETIC, FUNCTIONING MECHANISMS, ACCESSORIES, OR MECHANICAL CONFIGURATION.
- DISCHARGING WITH CRIMINAL INTENT OR NEGLIGENCE.
- FAILURE TO UNDERSTAND, ADHERE TO, AND FOLLOW THE RULES OF FIREARM SAFETY WHEN USING OR HANDLING THE FIREARM.
- OR ANY OTHER CIRCUMSTANCES OUTSIDE THE MANUFACTURER'S DIRECT OR IMMEDIATE CONTROL.

ALWAYS STORE YOUR FIREARM IN A SECURE STORAGE AREA TO PREVENT UNAUTHORIZED ACCESS

GForce Arms, Inc. recommends storing your firearm in a safe made specifically for firearms. Metal gun safes are recommended over open racks or glass front cabinets. In the case that a safe is not available for use, there are aftermarket trigger locking devices that can also be used to ensure that the firearm is unusable before storing in a conspicuous location such as a closet shelf, or other location out of plain view that is high enough to be out of the reach of young children. GForce Arms, Inc. also recommends that ammunition is stored in a separate location from the firearm. Never store a firearm loaded or with ammunition in the magazine.

NEVER:

- Leave a loaded gun unattended, propped up against a surface, or out of your hands.
- Assume a firearm is unloaded, even if you used it last. Always check to make sure that there is no ammunition and the chamber is clear.
- Load a cartridge into the chamber until you are ready to fire.
- Carry or transport your firearm with live ammunition in the chamber.
- Pass a firearm to another person or accept a firearm from another person, until the cylinder or action is open and you have personally checked that the weapon is completely unloaded.
- Haul a loaded firearm openly or in a carrying case.
- Never transfer or hand a loaded firearm to someone else.

ALWAYS KEEP YOUR FINGER OFF THE TRIGGER UNTIL YOU ARE READY TO SHOOT

When holding the firearm be sure to rest your finger on the trigger guard or along the side of the gun.

NEVER:

- Touch the trigger until you are ready to fire.
- Engage in horseplay while handling a firearm.
- Rely on the safety devices of the gun. Mechanical safeties are never foolproof and can wear out and malfunction.

ALWAYS KEEP THE GUN POINTED IN A SAFE DIRECTION

A safe direction is one in which an accidental discharge cannot or would not cause injury or harm to yourself or others. Use extreme caution especially when loading and unloading your firearm. When handling any firearm always treat it as if it was loaded and ready to fire, even if you think it is empty. The recommended carrying position of your shotgun is with the hammer in de-cocked position.

NEVER:

- Point your firearm at anything you don't intend to shoot.
- Use a firearm under the influence of alcohol, drugs, or any other substances that may impair your judgment, skills, or physical abilities.
- Target shoot or hunt with a firearm when you are fatigued or too tired to operate the firearm safely.

AMMUNITION

RECOMMENDED AMMUNITION

It is imperative to understand that the GF1 should only be used with modern 12 gauge (GA) ammunition. In order to ensure that your new GF1 properly functions and cycles, GForce Arms, Inc. recommends the use of ammunitions that produce projectile velocities of 1300 feet per second (FPS) or faster. The firearm is compatible for the use of 2 ¾" inch and 3" inch 12GA cartridge lengths.

The firearm is also compatible for the use of slug projectiles; however, only with the use of smooth bore slug projectiles, and only with the use with cylinder or improved cylinder chokes.

IMPORTANT WARNING - AMMUNITION

Death, serious injury, and damage can result from the wrong ammunition, bore obstructions, powder overloads or incorrect cartridge components. Even the strongest gun can be blown up by excess pressure. Only use correct ammunition loaded to U.S. Industry Standards. Always wear shooting glasses and hearing protection. IMPROPER AMMUNITION DESTROYS GUNS

IMPORTANT WARNING - LEAD EXPOSURE

Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances known to the State of California to cause birth defects, reproductive harm and other serious physical injury. Have adequate ventilation at all times. Wash hands thoroughly after exposure. SHOOTING OR CLEANING GUNS MAY EXPOSE YOU TO LEAD

AMMUNITION [CARTRIDGES] NOTICE

WE SPECIFICALLY DISCLAIM RESPONSIBILITY FOR ANY DAMAGE OR INJURY WHATSOEVER OCCURRING IN CONNECTION WITH, OR AS A RESULT OF, THE USE OF FAULTY, SUB-STANDARD, REMANUFACTURED, OR HAND LOADED (RELOADED) AMMUNITION, OR OF CARTRIDGES OTHER THAN THOSE FOR WHICH THE FIREARM WAS ORIGINALLY CHAMBERED.

SAFETY OPERATION

It is imperative as the owner of this firearm that you clearly understand where the safety mechanism is located on the firearm and how the safety mechanism works. To engage the safety, push the button so that it protrudes from the right side of the gun and the **RED BAND MARKING CAN NOT BE SEEN**.



LOADING THE FIREARM

First, make sure that the safety is in the "ON" position and the firearm is pointed in a safe direction. Pull the charging handle to the rear to ensure that the gun is unloaded. Put one shell through the ejection port into the chamber of the barrel making sure it is the correct gauge and length. Release the charging handle. Push a shell upward against the bottom of the carrier/lifter and then forward to install a shell in the magazine tube. Repeat this step until the tube is full or you have achieved the desired number of shells.



The firearm is now loaded and ready to fire. This is the "4+1" loading position. To only load the magazine tube, simply do not load one into the chamber prior to loading the tube.



WARNING - HANDLING



Never carry the shotgun loaded with the safety selector in the "ON" position. If dropped or struck with the safety off, the shotgun may fire. Such a discharge can occur without the trigger being directly struck or touched. Never rest a loaded shotgun against any object (wall, fence, vehicle, tree, etc.) because there is always the possibility that the rifle will be jarred or slide from its position and fall with sufficient force to discharge. Keep safety on unless actually firing.

ANY GUN MAY FIRE IF DROPPED.

UNLOADING THE FIREARM

Ensure that the safety is on and point the firearm in a safe direction. Keep your finger off of the trigger. Press the action release button and firmly pull the charging handle to the rear. The round in the chamber will be extracted and another shell loaded into the chamber from the tube. Repeat the above action until all rounds have been cycled through and individually ejected through the ejection port. Finally, press the action release button one additional time and pull the charging handle to the rear. Do a thorough VISUAL and PHYSICAL inspection of both the chamber and the action tube with eyes and fingers to ensure that all rounds have been removed from the firearm.





SHOOTING THE FIREARM

WARNING - USE SAFETY GLASSES AND HEARING PROTECTION WHEN SHOOTING

Wear safety glasses when firing the weapon to protect your eyes from airborne debris or projectile ricochet. When shooting, shotguns will often produce decibels of 155 and higher. Exposure to sounds producing decibels over 70 can lead to hearing loss. Therefore, it is important to wear hearing protection when shooting.

WARNING - ALWAYS MAKE SURE THAT THE BARREL IS CLEAR OF ANY OBSTRUCTIONS BEFORE SHOOTING

Before loading always perform a safety check to make sure that there is no ammunition in the chamber or magazine. Examine the barrel for any obstructions or debris such as excess lubricant, dirt, or grease. If the bore is obstructed it can cause increased pressure causing the barrel to bulge or burst during use. Always use a cleaning rod and patch to remove any residues or obstructions in the barrel.

DO NOT TOUCH THE TRIGGER UNTIL YOU ARE ACTUALLY READY TO FIRE THE FIREARM

WARNING - FIRING

When firing the weapon, be sure that bystanders are well clear of the shooter and standing a safe distance behind the shooter. Empty cartridge cases are hot and are normally ejected from the shotgun to the right of the shooter. They could cause injury to another person who is standing too closely alongside the shooter. Shooters who fire right-handed shotguns from their left shoulder should be particularly cautious concerning ejected cartridge cases (and the back of the bolt as it is drawn rearward.)

CLEARING A JAM OR MISFIRE

A jam occurs when the shotgun is fired, but the bolt does not cycle properly causing the fired/empty cartridge to remain in the receiver or chamber. A misfire occurs when the trigger is pulled, the hammer releases hitting the firing pin, but the cartridge does not discharge/fire.

While firing your shotgun, if you experience a jam or misfire, keep the firearm pointed in a safe direction and flip the safety selector to "OFF." Unload the shotgun to remove the jammed or misfired cartridge. Visually check the chamber to ensure it is unloaded.

MISFIRE

In the event of a misfire check the primer on the ejected cartridge for a strike mark. In the event that there is a shallow dimple in the primer, it is most commonly caused by a light strike. We recommend trying a different brand of ammunition to determine whether the light strike is caused by a deeply seated primer or if it is a malfunction of the firearm itself. If it is determined to be a malfunction of the firearm, please make sure to fill out a service request on the www.gforcearms.com website. GForce Arms, Inc. wants to get your firearm into the service shop for review and repair as needed.

CYCLING JAM

In the event of a jam, double check the velocity listed on the ammunition box by the manufacturer. In order for this firearm to properly cycle ammunition that produces a projectile velocity of 1300 FPS or faster. If the ammunition produces adequate velocity, but does not cycle, the firearm may need to be disassembled, thoroughly cleaned, oiled and reassembled before attempting to fire it again.

If these steps are taken, but they do not improve the function of your shotgun and it continues to jam, please make sure to fill out a service request on the www.gforcearms.com website. GForce Arms, Inc. wants to get your firearm into the service shop for review and repair as needed.

DISASSEMBLY PROCEDURES

Step by step instructions to disassemble and re-assemble the GForce Arms GF1 semi-auto shotgun as demonstrated by Matt H. our firearms specialist. If you prefer to follow along with a video, please visit our YouTube channel and watch along by searching for your model.

STEP 1: ENSURE FIREARM IS COMPLETELY UNLOADED BY PULLING THE CHARGING HANDLE REARWARD UNTIL ALL ROUNDS ARE REMOVED FROM THE FIREARM. YOU CAN ALSO REMOVE AMMO FROM THE MAGAZINE TUBE BY TURNING THE FIREARM OVER, DEPRESSING THE LOADING LIFTER AND THEN PRESSING THE SHELL LATCH LEVER ON THE LEFT SIDE TO DISCHARGE ROUNDS FROM THE MAGAZINE TUBE. ONCE IT APPEARS ALL ROUNDS ARE REMOVED, VISIBLY INSPECT THE CHAMBER TO ENSURE THAT THE FIREARM IS UNLOADED.



STEP 2: REMOVE MAGAZINE TUBE CAP BY UNSCREWING COUNTER-CLOCKWISE.



STEP 3: REMOVE THE FOREARM FROM THE MAGAZINE TUBE BY LIFTING UPWARD FROM THE TUBE.



STEP 4: HOLDING THE FIREARM IN AN UPWARD POSITION AND APPLYING SLIGHT DOWNWARD PRESSURE ON THE CHARGING HANDLE, GRIP THE BARREL AND OPERATING ARM ASSEMBLY TO REMOVE THE BARREL AND OPERATING ARM ASSEMBLY FROM THE RECEIVER. IF THE BARREL IS TIGHT IN THE RECEIVER AND DOESN'T EASILY PULL AWAY FROM THE RECEIVER, PULL THE CHARGING HANDLE BACK ALL THE WAY AND RELEASE, ALLOWING IT TO "BUMP" THE BARREL TO JAR IT LOOSE FROM THE RECEIVER.



STEP 5: ON THE BARREL ASSEMBLY, REMOVE THE GAS PISTON FROM THE PISTON HOUSING.



STEP 6: APPLY DOWNWARD PRESSURE ON THE OPERATING ARM AND SPRING TO RELEASE TENSION ON THE BOLT. LINE THE CHARGING HANDLE UP WITH THE HALF MOON NOTCH IN THE BOLT AND PULL OUTWARD FIRMLY TO REMOVE THE CHARGING HANDLE FROM THE BOLT.



STEP 7: SLIDE THE OPERATING ARM, SPRING AND BOLT OFF OF THE MAGAZINE TUBE.



STEP 8: LIFT THE BOLT ASSEMBLY AWAY FROM THE OPERATING ROD.



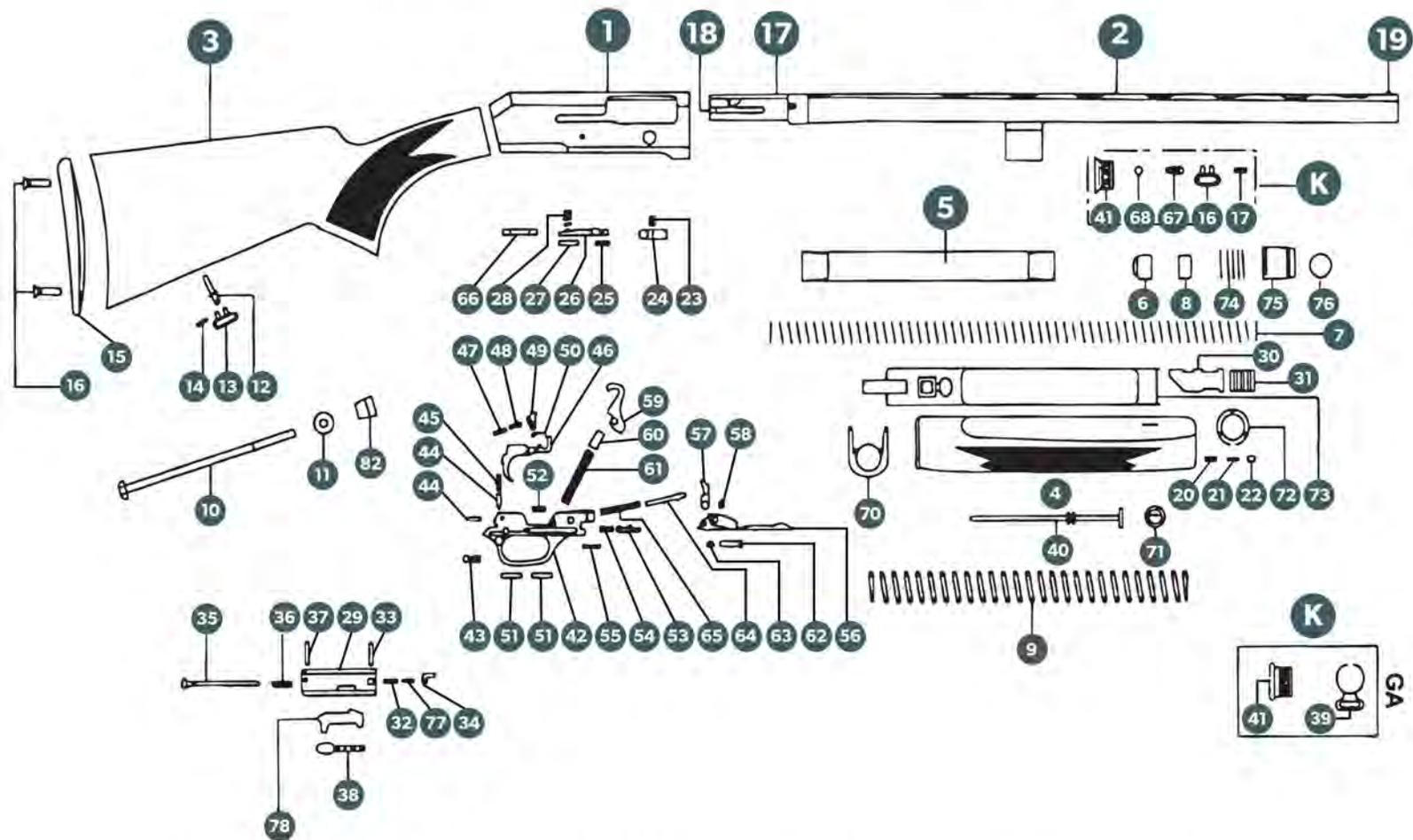
STEP 9. WITH THE FIREARM NOW FULLY DISASSEMBLED, CLEAN AND LUBRICATE THE FIREARM, BARREL AND OPERATING PARTS WITH A SOLVENT AND LUBRICATION APPROVED FOR FIREARMS.



REASSEMBLY PROCEDURES

RE-ASSEMBLE THE FIREARM BY REVERSING THE DISASSEMBLY STEPS ABOVE.

EXPLODED VIEW



1. RECEIVER

2. BARREL

3. STOCK

4. FOREARM

5. MAGAZINE TUBE

6. MAGAZINE FOLLOWER

7. MAGAZINE SPRING

8. MAGAZINE SPRING RETAINER

9. ACTION SPRING

10. STOCK BOLT

11. STOCK BOLT WASHER

12. STOCK SWIVEL STUD

13. STOCK SWIVEL

14. STOCK SWIVEL PIN

15. BUTT PLATE

16. BUTT PLATE SCREW

17. BEARING BOLT

18. EJECTOR

19. FRONT BEAD

20. MAGAZINE CAP SPRING

21. MAGAZINE CAP PIN

22. MAGAZINE CAP SCREW

23. BOLT RELEASE SPRING

24. BOLT RELEASE

25. BOLT RELEASE PIN

26. BOLT RELEASE LATCH

27. BOLT RELEASE LATCH PIN

28. BOLT RELEASE LATCH SPRING

29. BREECH BOLT

30. ARM PIPE

31. CONNECTION RUBBER

32. EXTRACTOR SPING BOLT

33. EXTRACTOR RETAINING PIN

34. EXTRACTOR

35. FIRING PIN

36. FIRING PIN SPRING

37. FIRING PIN RETAINER

38. OPERATING HANDLE

39. FRONT SWIVEL

40. MAGAZINE PLUG

41. MAGAZINE CAP

42. GUARD

43. SAFETY

44. SAFETY PLUNGER

45. SAFETY SPRING

46. TRIGGER

47. SEAR SPRING

48. SEAR PLUNGER

49. SEAR

50. SEAR PIN

51. TRIGGER PIN

52. TRIGGER SPRING

53. CARRIER PLUNGER

54. CARRIER SPRING

55. CARRIER RETAINING PIN

56. CARRIER

57. CARRIER LATCH

58. CARRIER LATCH PIN

59. HAMMER

60. HAMMER PLUNGER

61. HAMMER SPRING

62. TRIGGER ASSEMBLY PIN SLEEVE

63. TRIGGER ASSEMBLY PIN RETAINER

64. CARRIER LATCH PLUNGER

65. CARRIER LATCH SPRING

66. TRIGGER GUARD

67. SWIVEL STUD

68. SWIVEL STUD RETAINER

69. STOCK BOLT RETAINER

70. PLATE

71. MAGAZINE PLUG RETAINER

72. MAGAZINE CAP SUPPORT

73. ACTION BAR

74. GAS PISTON SPRING

75. GAS PISTON

76. RUBBER GAS RING

77. EXTRACTOR SPRING

78. LOCKING BLOCK



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CARE AND MAINTENANCE

It is essential that regular maintenance and cleaning be performed to maintain the accuracy, function, and maximize the longevity of your firearm. Before cleaning ALWAYS perform a safety check to make sure that the firearm is unloaded prior to cleaning. Your firearm should be free from rust, dirt, grease and firing residues in order to function reliably.

The critical components that should be kept clean and oiled regularly include the following:

- Interior of the upper receiver
- Barrel
- Breach
- Piston
- Gas seal
- Action bar
- Action bar tube
- Bolt assembly
- Trigger assembly
- Sear
- Hammer
- Safety selector

Failure to maintain these key components could result in damage to the firearm, failure to function, and could result in a major safety hazard.

We encourage our customers to visit the GForce Arms website (www.gforcearms.com) and watch the maintenance and assembly tutorial video's specific to your firearm model.

SERIAL NUMBER OF THE FIREARM

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

WARRANTY INFORMATION

This firearm is covered by a LIMITED LIFETIME warranty to the ORIGINAL RETAIL OWNER/PURCHASER. This warranty covers defects in material or workmanship. The Validity of any claim shall be determined by GForce Arms after visual inspection and/or testing of the firearm. If a defect in materials or workmanship is present, GForce Arms will, at its discretion, repair or replace the firearm. Please go to www.gforcearms.com/warranty to register for this warranty.

WARRANTY EXCLUSIONS

The warranty is VOID if the firearm has been altered, abused, misused, damaged by accident, fired with hand load or reload ammunition, obstructions in the barrel, or damage due to failure to provide regular and necessary maintenance. This warranty is also VOID if any unauthorized repair or alteration is performed on the firearm.