



SAFETY & INSTRUCTION MANUAL

## **USER'S MANUAL**

For **GFORCE ONE** Inertia driven Semi Auto  
Shotgun  
12 Ga/Cal

READ THE INSTRUCTIONS & WARNING IN THIS  
MANUAL CAREFULLY BEFORE USING THIS FIREARM!



DO NOT MODIFY THIS FIREARM IN ANY WAY. DOING SO MAY CHANGE THIS FIREARM'S CLASSIFICATION AND MAY RESULT IN VIOLATION OF APPROVAL CRITERIA.

PURCHASER'S RECORD

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

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

Gauge/Caliber: \_\_\_\_\_

Serial #: \_\_\_\_\_

Purchase Price: \_\_\_\_\_

Store Name: \_\_\_\_\_

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## WARNINGS

The manufacturer is not responsible for damage to objects caused by misuse of the firearm or for injuries to persons or animals, or in case of death, caused voluntarily or involuntarily by the firearm user.

The manufacturer is not responsible for injuries caused by poor maintenance, misuse of the firearm, unauthorized or improper modifications.

The manufacturer declines responsibility for the indirect consequences of any injuries and/or death of persons or animals, damage to objects caused by use of the firearm or by primer explosion, by bullet's ricochet, or unsafe loading practices and/or procedure.

Read the entire manual and learn the proper use of the firearm without live ammunition.

It is important that you understand the proper use of this product. The life of the people close to you may depend on your safe behavior.

If the manual is not clear, please contact the dealer where you bought the firearm or call the distributor or the manufacturer by using the contact information provided within this manual.

The manufacturer declines any responsibility for misuse of the firearm. In case of alteration of the firearm, The manufacturer declines any civil and penal responsibility and will not refund any damage.

**Quality Inspection:** Every firearm is thoroughly inspected by the manufacturer, for function and cosmetic blemish, prior to shipment.

## SAFETY RULES

1. Read the instructions carefully before use. Reading the manual and careful examination of the firearm are fundamental to avoid any kind of problem.
2. Be aware that you are handling a firearm; therefore your knowledge and behavior may affect your life and those of the people close to you.
3. Firearms and ammunitions must be kept in separate places.
4. Always keep firearm and ammunitions out of reach of children.
5. Store the firearm in a clean, dry and airy place after use to avoid rust in mechanical parts that may cause serious problems in functioning after a period of inactivity.
6. The firearm must always be stored unloaded, always check that the chamber is empty.
7. Keep away from open flames or heating sources.
8. Never leave a loaded firearm unattended.
9. Never leave the firearm loaded, it could fall and cause injury and death. Always point the firearm in a safe direction, and handle it as though it were loaded. This is especially important when loading and unloading the firearm and when handing it to someone else. Never take someone's word that it is unloaded. Always make sure the firearm is unloaded before laying it down or handing it to someone else.
10. After use, clean and lubricate the inside of the barrel with appropriate oil. Grease or oil build up can cause excessive pressure and result in serious personal injuries. Before using the firearm again, inspect the barrel and chamber to make certain that there are no obstructions in the bore. Remove any oil residue with rod and dry patch before shooting.



## SAFETY RULES

11. Accumulation of rust in the barrel can cause excessive pressures resulting in serious injury and may cause the explosion of the barrel. A rusted, pitted or eroded barrel should be replaced.
12. Before shooting always check to ensure that the barrel is free of obstructions.
13. Never force a jammed action, this act could cause explosion of the round and consequent injury.
14. Use factory loaded ammunition of the caliber specified on the firearm barrel. Use of different calibers may cause serious personal injuries to you and to people close to you.
15. In case of misfire, manually extract the cartridge from the chamber. If firearm fails to fire when trigger is pulled, as a result of slow primer ignition (hang fire), keep muzzle pointed downrange for a minimum of 30 seconds. If the round does not fire, remove the magazine, clear the firearm and examine the ejected, unfired cartridge. If the indent from the firing pin is off center, light or absent, take the gun to a competent gunsmith. If the indent appears normal compared to other rounds, assume a faulty round, separate from other cartridges, reload and continue shooting.
16. Do not attempt to re-use unexploded ammunitions.
17. Never modify any parts of your firearm. Any alteration may cause serious personal injury and voids the warranty.
18. Only a qualified gunsmith may service the firearm for repair or serious maintenance.
19. Pay great attention during transportation and use. Mechanical safety devices can fail. Developing intelligent, good safety habits is the best way to prevent accidents.

## SAFETY RULES

20. Never rest your finger on the trigger until the very moment you wish to shoot. Always keep the safety on until you are ready to safely shoot at an intended target. Note: Safety devices on firearms are extras and are not a substitute for your proper and safe handling practices.
21. Always keep the firearm unloaded when transporting it from home to the shooting areas. Carefully check that cartridge chamber is empty.
22. When you walk around with the firearm in a shooting area, always keep the muzzle pointed in a safe direction.
23. Never run with a loaded firearm, do not cross any obstacle (fences or water courses, etc.) or walk where there is any possibility of slipping or falling without having your firearm unloaded and in safety position.
24. When selecting a place to shoot, always be absolutely sure of your target and the area behind it before you touch the trigger, making sure there is an adequate backstop which will stop and contain bullets. A bullet can travel through or past your target with a range up to 1.5 miles. If you have any doubt, do not shoot.
25. Never shoot against a solid surface or in a pool of water, the projectiles could ricochet and shoot toward any direction. Do not shoot up into the sky.
26. Keep all bystanders behind you, standing beside a shooter is not a safe position. Make sure all other shooters and bystanders are well away from the ejection port.
27. Do not smoke while handling, loading or shooting any ammunition, especially black powder. Keep black powder in a closed container at all times, re-closing the container after each and every use.



## SAFETY RULES

28. Never drink alcoholic beverages or take any drugs before or during shooting, as this not only constitutes criminal disregard for your safety and that of others, but will seriously impair your judgment and vision. Never use a firearm while you are taking medication unless you have checked with your doctor to ensure you are fit to handle the firearm safely.

29. Always wear and encourage others near you to wear proper ear protection when shooting, especially on a range since the noise from your firearm and other firearms close to you, could result in permanent hearing loss.

30. Always wear protective shooting glasses to protect your eyes from injury by gun powder, gas, lubricant, dirt or metallic particles, carbon residue, sparks or other debris.

31. Wash hands thoroughly after shooting and handling firearms to remove any unwanted residues. 32. Never leave the loaded firearm or the loaded magazine in the sun.

33. By replica firearms there is no modern safety. In this case you must pay even more attention to safety rules.

**Remember:** No mechanical safety device is infallible. The user is responsible for injuries or damages caused to him or to other persons. Complete knowledge of your firearm can make the difference.

## IDENTIFYING MARKINGS

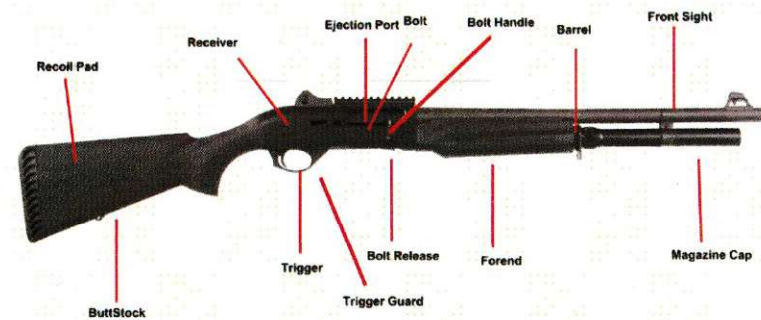
Every firearm produced in our factory has a serial number that is marked on the receiver/frame . In addition to the serial number you will also find the manufacturers information with the model name and caliber marked either on the frame or the barrel as required by law.

**Warning:** These markings must not be removed from the firearm for any reason.

## DESCRIPTION & SPECS

Your shotgun operates with the kinetic recoil (inertia) energy this recoil energy completes the cycle of the action. This operating system is based on the rotary head which is located inside the mechanism. Once the first shell has been fired, the next shell in the magazine will automatically cycle into the chamber, and this cycle will continue (each time the trigger is pulled) until all shells loaded in the magazine have been fire. The bolt will remain locked in the open position after the last shell is fired.

## NOMENCLATURE





## SAFETY SWITCH/BUTTON

The safety is designed to stop the trigger mechanism. **Do not rely on your firearms' safety, treat every firearm as if it were loaded and ready to fire.** The safety on any firearm is a mechanical device, and it is not intended as a substitute for common sense or safe firearms handling. Always keep the muzzle pointed in a safe direction.

1. The safety is located behind the trigger, and provides protection against accidental or unintentional discharge under normal usage when properly used.

2. To engage the safety, push the button so that it protrudes from the right side of the gun and **RED BAND MARKING CAN NOT BE SEEN.** The safety should always be in the "on" or "safe" position until you intend to fire the gun. As shown in the figure on the right.



3. When you are ready to fire the gun, press the safety button to the "off" position so that the safety protrudes from the left side of the gun and the **RED BAND MARKING IS SHOWING.**

**WARNING: The gun will fire when the trigger is pulled intentionally or accidentally when the RED BAND MARKING IS SHOWING.**

### BARREL ASSEMBLY

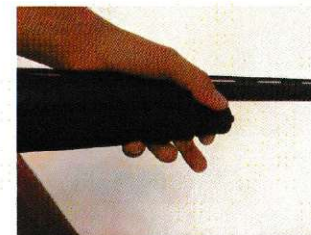
In the packaging, your firearm is divided into two parts: a) receiver and b) barrel



Unscrew the fore-end cap and remove from the magazine tube



Install the fore end on the barrel-breech unit and Fit the breech extension onto the receiver by sliding the fore-end along the magazine tube.



Screw the magazine cap and hand tighten.



## LOADING

Be sure the safety is in the "on" or "safe" position and the barrel is pointed in a safe direction.

1. Push in the carrier on the bottom of the receiver and make sure there are no cartridges in the magazine tube.
2. Press the carrier plunger and pull the bolt rearward locking into rear position. Visually inspect chamber for no cartridge then press the bolt release button.
3. Begin loading the shotgun from the bottom by pushing cartridge through the carrier and into magazine tube until it is retained by the magazine release button/shell stop. Repeat loading cartridges until desired amount is reached.
4. Press the carrier plunger then pull and release the bolt. This will feed a cartridge into the chamber. An additional round can now be loaded into the bottom of receiver if desired, otherwise your shotgun is ready to be fired when the trigger is pulled with the safety in the "off" or "fire" position.

## UNLOADING

Be sure the safety is in the "on" or "safe" position and the barrel is pointed in a safe direction.

1. Press the carrier plunger.
2. Pull and release the bolt. Repeat this until all cartridges are cleared.
3. Bolt will lock in rear position once all cartridges are cleared.

## DISASSEMBLY

Be sure the safety is in the "on" or "safe" position and the barrel is pointed in a safe direction.

Warning: Make sure the gun is unloaded.



1-Unscrew the magazine cap and take out the forend and barrel group by sliding forward.

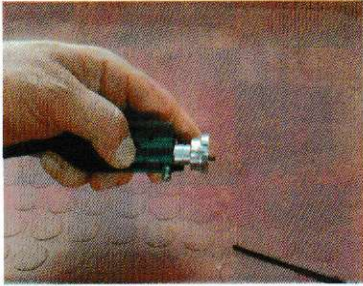


2-Take out the charging handle and the bolt group.

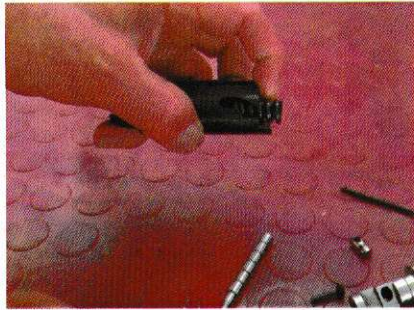


3-Remove the firing pin retaining pin from the bolt assembly, while holding the firing pin and firing pin spring in place



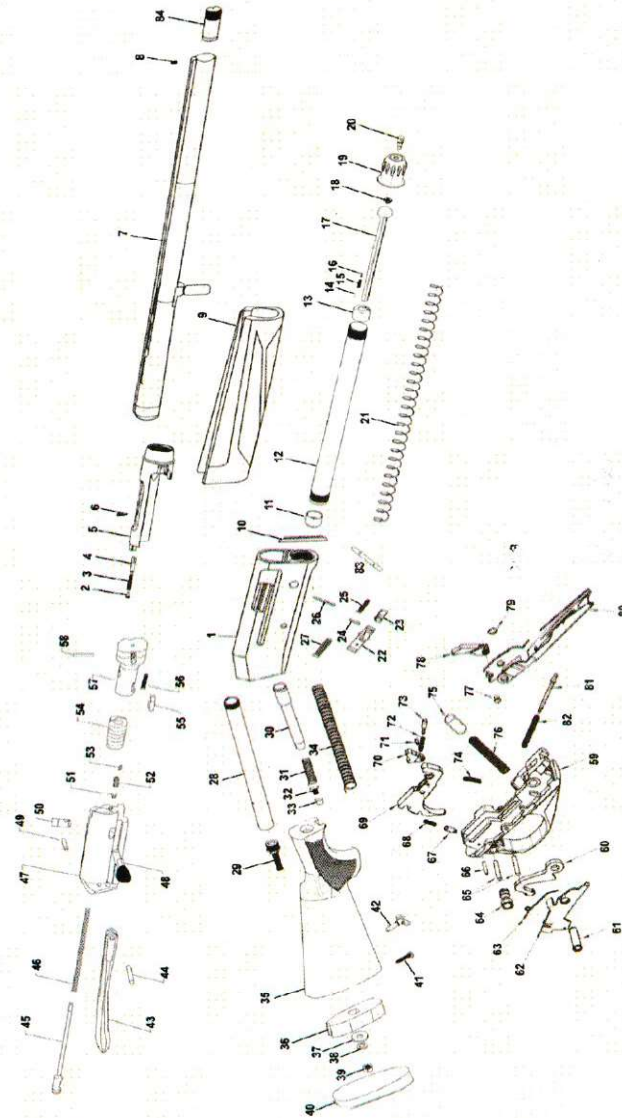


4-Remove the locking head pin from the bolt and remove the bolt locking head from the bolt.



5-Remove the inertia spring from its seat in the bolt.

### EXPLODED VIEW





## PART LIST

PART	DESCRIPTION	PART	DESCRIPTION
1	Receiver	44	Action Bar Pin
2	Ejector Pin	45	Firing Pin
3	Ejector Spring	46	Firing Pin Spring
4	Ejector	47	Bolt
5	Barrel Extension	48	Bolt Handle
6	Ejector Retaining Screw	49	Firing Pin Retaining Pin
7	Barrel	50	Rotating Head Pin
8	Front Sight	51	Bolt Handle Detent Ball
9	Forend	52	Bolt Handle Spring
10	Forend Receiver Guide	53	Bolt Handle Retaining Pin
11	Mag Follower	54	Rotating Head Spring
12	Magazine Tube	55	Extractor
13	Magazine Retainer	56	Extractor Spring
14	Mag Cap Retaining Spring Plunger	57	Rotating Head
15	Mag Cap Retaining Spring	58	Extractor Retaining Pin
16	Mag Cap Retaining Spring Screw	59	Trigger Guard
17	Magazine Limiter	60	Hammer
18	Forend Swivel Nut	61	carrier through bushing
19	Magazine Cap	62	Cartridge Dropper
20	Forend Swivel	63	Cartridge Dropper Latch Spring
21	Magazine Spring	64	Safety
22	Cartridge Latch	65	Trigger Pin
23	Cartridge Stop	66	Safety Spring Retaining Pin
24	Cartridge Latch Pin	67	Safety Spring Detent Plunger
25	Cartridge Stop Spring	68	Safety Spring
26	Cartridge Stop Pin	69	Trigger
27	Cartridge Latch Spring	70	Sear
28	Recoil Spring Guide	71	Sear Return Spring Retaining Pin
29	Recoil Spring Guide Cap	72	Sear Return Spring
30	Recoil Plunger	73	Sear Return Spring Plunger
31	Recoil Plunger Internal Spring	74	Trigger Return Spring
32	Recoil Plunger Internal Buffer	75	Hammer Spring Tube
33	Recoil Plunger Internal Buffer Retaining Nut	76	Hammer Spring
34	Recoil Spring	77	Carrier Latch Connection Pin
35	Stock	78	Carrier Latch
36	Stock Internal Retaining Block	79	carrier Bushing Retaining Spring
37	Stock Holding Washer	80	Carrier
38	Stock Holding Lock Washer	81	Carrier Latch Spring Guide
39	Stock Holding Nut	82	Carrier Latch Spring
40	Recoil Pad	83	Trigger Group Receiver Pin
41	Recoil Pad Screw	84	Mobil Choke
42	Stock Swivel		
43	Action Bar		

## RECOMMENDED AMMUNITION

It is imperative to understand that the ONE shotguns should only be used with modern 12 Gauge (Ga) ammunition. In order to ensure that your new ONE properly functions and cycles, GFORCE Arms recommends the use of ammunitions that produce projectile velocities of 1300 FPS or faster. The firearm is compatible for the use of 2 3/4" inch and 3" inch 12Ga shotshells.

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

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

## 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 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.

## CHOKE COMPATIBILITY AND INSTALLATION

ONE shotgun is threaded for the use of Benelli Mobil chokes, and is coming with three(3) chokes. One is installed in the muzzle, and the other two are stored in a small storage case along with the choke installation tool.

The three choke diameters that come with the shotgun include #1(full), #3(modified), and #5(cylinder).



## CLEANING & MAINTENANCE

**WARNING:** Make sure the firearm is unloaded.

1. Make sure the broad, polished finely fitting mating surface of the breech block and receiver is especially clean and lightly oiled with high quality gun oil. Do not use silicone, lanolin or WD-40.
2. Run an oil patch through the bore with a cleaning rod starting from the breech end. To prevent leading, use a cleaning solvent and brass brush to clean the bore periodically. Follow this cleaning with one or two clean oil patches.

**Important:** If your gun is equipped with choke tubes, do not use a brass brush to clean the barrels without having a choke tube installed.

Barrels that utilize choke tubes must also have the choke tubes removed to clean and oil the threads inside the barrel and the choke tubes themselves. This will protect the threads and prevent dirt build up that can cause tubes to become difficult to remove.

## CLEANING & MAINTENANCE

Never fire your gun without choke tubes completely tighten in barrels. Do not over tighten choke tubes. Wipe all exposed metal surfaces with an oiled cloth before storing. Do not squirt or pour oil into the mechanism because it may hamper proper functioning and will soak into the wood.

After extended periods of heavy use, your gun should be taken to a qualified gunsmith to have the action disassembled for professional cleaning and lubrication.

3. Care for your wood stock and forearm the same way you would a piece of furniture with the same finish.

## STORAGE

1. Clean thoroughly and oil your firearm before storage.
2. Store the firearm in a case to prevent scratches and dents.
3. Store your firearm in a dry place to prevent corrosion.
4. Store the firearm away from children and in a place where it cannot be obtained by those unauthorized to use it.
5. Always store firearm unloaded and separately from and ammunition.

## HAZARDOUS MATERIAL WARNING

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



## WARRANTY CONDITIONS

The manufacturer guarantees that its products are scrupulously checked against defects in materials, workmanship, aesthetics and functioning problems.

GFORCE agrees to service its products free of charge for defects in materials and workmanship in accordance with the service agreement listed below. The obligation of GFORCE under this agreement is limited to the repair or replacement of unserviceable parts and does not cover any incidental or consequential damages. Other than the express warranty contained herein GFORCE makes no warranties, express or implied.

GFORCE will repair or replace any unserviceable part(s) for one (1) year from date of purchase and further will supply free parts (Wood not included) for an additional one (1) year in accordance with the above warranty statement provided your firearm had not been altered, abused, willfully damaged, or damaged by overpressure ammunition. This agreement is not transferable; its benefits apply only to the original purchaser. The customer must provide evidence they are the original owner and proof of the purchase date with a receipt or other valid proof.

**THE MANUFACTURER RESERVES THE RIGHT OF  
DEFINING THE TYPE OF DEFECT OF THE FIREARM AND  
THEREFORE TO STATE WHETHER THE DEFECT IS  
COVERED BY GUARANTEE.**

The manufacturer's decision will be fair but final. Should the manufacturer become aware of a defect of a product during the guarantee period, the defective part will be replaced free of charge.

The guarantee does not cover parts subject to wear and corrosion.

**THIS MANUAL MUST ALWAYS FOLLOW THE PRODUCT,  
ALSO IN THE EVENT OF NEW OWNERSHIP.**

## WARRANTY CONDITIONS

### The Guarantee Is Void In Case:

- Inadequate ammunition has been used (any ammunition but those commonly on sale, reloaded ammunition, different from caliber and specification indicated on the firearm barrel)
- The product failed to be provided proper maintenance and cleaning
- The product has been modified without our prior consent
- Unauthorized, inadequate or incorrect repairs have been carried out
- Non-original spare parts were used
- Parts subject to wear and corrosion
- Damage (improper use of the gun by the user)
- Expired guarantee

In the above cases the repair, if completed, will be charged to the customer.

In case, for any valid reason, you do not have the possibility to obtain repair under guarantee at the shop where you bought the product, you may contact us directly for warranty service or questions:

### For USA Customers;

\*Importer name and brand can be found on the receiver/frame or barrel. You can directly contact the importer.





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