

GFORCE ARMS™

Your Authority For Quality Firearms



GFLVR357 & GFLVR44

LEVER ACTION RIFLE INSTRUCTION MANUAL

MODEL
SADDLEHORN®

MANUFACTURER
GFORCE ARMS

ITEM NUMBER
LVR357® LVR44®

DESCRIPTION
GFORCE ARMS
LEVER-ACTION
RIFLE

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
info@gforcearms.com

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

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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 obtain specific training by a certified instructor for unique situations.

ALWAYS LEARN THE SPECIFIC MECHANICAL AND HANDLING CHARACTERISTICS OF YOUR FIREARM

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 FIREARM 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 FIREARM

This firearm 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 open the action to visually inspect the chamber and confirm that it is clear. Always unload all ammunition from the chamber 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 firearm 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 firearm 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 chamber.

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 slide is open and you have personally checked that the firearm 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 firearm 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

SADDLEHORN 357

The SADDLEHORN 357 is recommended to be used with modern 357 Magnum ammunition cartridges. It can also handle .38 Special shells.

SADDLEHORN 44

The SADDLEHORN 44 is recommended to be used with modern 44 Magnum ammunition cartridges.

“+P” ammunition can be dangerous. Never fire ammunition marked “+P+” in your firearm. It does not comply with industry standards as to chamber pressures. There are only four calibers that can carry a “+P” rating from SAAMI. There are Special +P, 9mm Luger +P, 38 Super Automatic and 45 Automatic +P. There are no other SAAMI approved “+P” loads. Any ammunition in any other caliber marked “+P” is not SAAMI compliant, may be dangerous and should not be used.

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 excessive pressure. Only use correct ammunition loaded to U.S. Industry Standards. Always wear shooting glasses and hearing protection.

WARNING: IMPROPER AMMUNITION DESTROYS GUNS.

IMPORTANT WARNING - LEAD EXPOSURE

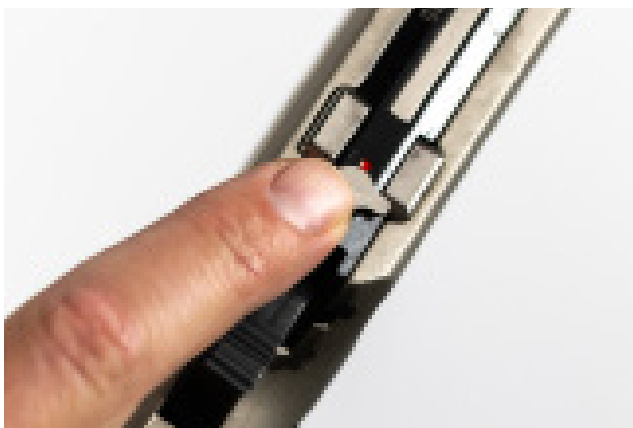
Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances known to the State of California to cause birth defects, reproductive harm and other serious physical injury. Have adequate ventilation at all times. Wash hands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

WARNING: SHOOTING OR CLEANING GUNS MAY EXPOSE YOU TO LEAD.

SAFETY OPERATION

Always use the manual safety. The manual safety should be all the way in the safe position, not half way or at some other point in its travel. The manual safety should remain in the safe position until ready to fire. The trigger guard is a physical obstruction that helps prevent unintended pressing of the trigger or trigger safety. Do not modify the trigger guard.

THE SAFETY LEVER CAN BE ROTATED COUNTER-CLOCKWISE TO THE SAFE POSITION WHEN THE HAMMER IS IN THE REARMOST FULLY COCKED POSITION OR IS IN THE HALF-COCKED POSITION. HALF-COCKED IS A POSITION BETWEEN THE REST AND THE FULLY COCKED POSITIONS. TO REACH THE HALF-COCKED POSITION SLOWLY PULL THE HAMMER FROM ITS REST POSITION TILL YOU HEAR THE CHARACTERISTIC SOUND OF A COUPLING.



Manual Safety OFF



Manual Safety ON

DE-COCKING

If you wish to safely decock the hammer from the fully cocked position, engage manual safety as described above and with the hammer under the full control of the user and keeping the muzzle pointed in a safe direction, holding and controlling the hammer with the thumb, pull the trigger, then slowly and carefully let the hammer move forward a bit, then release the trigger and continue moving the hammer slowly until it reaches the half-cocked position.

The manual safety can be disengaged in the forward safe position or with the hammer in the fully cocked position by rotating the manual safety lever clockwise to the position where it exposes the red dot.

KEEP THE MANUAL SAFETY ON THE SAFE POSITION UNTIL YOU ARE READY TO SHOOT.



Hammer in the rest position



Hammer in the half-cocked position



Hammer fully cocked

If the firearm is fully cocked and the user desires to place the hammer in the rest position, then the hammer must be under full control of the user.

KEEP THE MUZZLE POINTED IN A SAFE DIRECTION. PUT THE SAFETY LEVER ON (red dot covered). WHILE CAREFULLY HOLDING AND CONTROLLING THE HAMMER WITH THE THUMB, PULL THE TRIGGER, SLOWLY AND CAREFULLY LET THE HAMMER MOVE FORWARD APPROXIMATELY 1/2" AND RELEASE THE TRIGGER. CONTINUE TO LET THE HAMMER DOWN UNTIL IT IS RESTING ON THE HALF COCKED POSITION.

WARNING - You should practice this method with an empty firearm until you are completely familiar and comfortable with this procedure.

LOADING THE FIREARM

This firearm must be loaded through the loading port located on the right side of the receiver. Note that the loading port is covered by a loading gate. With the muzzle pointed in a safe direction, make sure that the hammer is not cocked and the finger lever is in its resting position (action fully closed, finger lever close to the lower tang). Slowly and carefully push the cartridge against the loading gate to make it open and keep pushing the cartridge until it is completely inside the receiver. It is possible to load the firearm with any quantity of cartridges from one up to the maximum allowed on each model.

If a cartridge is stuck in the barrel and you are unsure if it fired or not: Keep the muzzle pointed in a safe direction. Treat it as a live round and handle in accordance with "WHAT TO DO IF FIREARM FAILS TO FIRE" ON PAGE 9.

WARNING - The rifle is now loaded and ready to fire.



WARNING! LOADED RIFLE

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

Set the manual safety ON (red dot covered) and consecutively swing the finger-lever forward and back WITHOUT PULLING THE TRIGGER to eject the cartridges. Keep doing this until the firearm is empty (no cartridges come out after swinging the lever-finger).

Always make sure the breech bolt will open in a safe direction and that the unfired cartridges will fall on a safe place. Cartridges ejecting from the chamber can cause injury. ALWAYS INSPECT THE BARREL AND BORE VISUALLY TO MAKE SURE THAT THE CHAMBER IS EMPTY.



SHOOTING THE FIREARM

WARNING - USE SAFETY GLASSES AND HEARING PROTECTION WHEN SHOOTING

Wear safety glasses when firing the firearm to protect your eyes from airborne debris or projectile ricochet. When shooting, firearms 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 firearm, 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 firearm to the right of the shooter. They could cause injury to another person who is standing too closely alongside the shooter.

ADJUSTING THE SIGHTS

Check the firearm to ensure it is unloaded and the muzzle is pointed in a safe direction.

To adjust elevation on the rear sight, pull the rear sight upward using one hand and with the other hand move the elevator forward to make the sight shorter or rearward to make the sight taller. The taller you set the rear sight, the taller the point of impact will be.

The front sight is fixed and cannot be adjusted.



WHAT TO DO IF FIREARM FAILS TO FIRE

MISFIRES - If you squeeze the trigger and the cartridge does not fire, remain in the shooting position and wait 30 seconds. Then, swing the lever-finger as previously described. This will eject the misfired cartridge from the gun.

UNDERPOWERED CARTRIDGE - An underpowered cartridge is unusual if the ammunition is fresh, clean, and factory loaded. However, if you hear an unusual sound or low report, you should stop immediately, wait a full 30 seconds and check, visually, both the chamber and bore to make sure there is obstruction.

MAINTENANCE PROCEDURES

Customers are advised not to attempt a full teardown of their firearm.

Customers should take their firearm to a qualified gunsmith for any internal service or repairs.

For light maintenance, we suggest users spray solvent (e.g., CLP or brake cleaner) into the receiver's moving parts to flush out grime, followed by re-lubrication with Rem Oil or a similar light oil.

Bore cleaning should be limited to a bore snake or cleaning rod through the barrel.

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:

- Barrel
- Breach
- Friction Stud
- Bolt assembly
- Trigger assembly
- Sear
- Hammer

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.

YOUTH FIREARM SAFETY ACT NOTICE

1. The misuse of firearms is a leading contributor to juvenile violence and fatalities.
2. Safely storing and securing firearms away from children will help prevent the unlawful possession of firearms by juveniles, stop accidents, and save lives.
3. Federal law prohibits, except in certain limited circumstances, anyone under 18 years of age from knowingly possessing a firearm, or any person from selling, delivering, or otherwise transferring a firearm to a person under 18.
4. A knowing violation of the prohibition against selling, delivering, or otherwise transferring a firearm to a person under the age of 18 is, under certain circumstances, punishable by up to 10 years in prison.

SERIAL NUMBER OF THE FIREARM

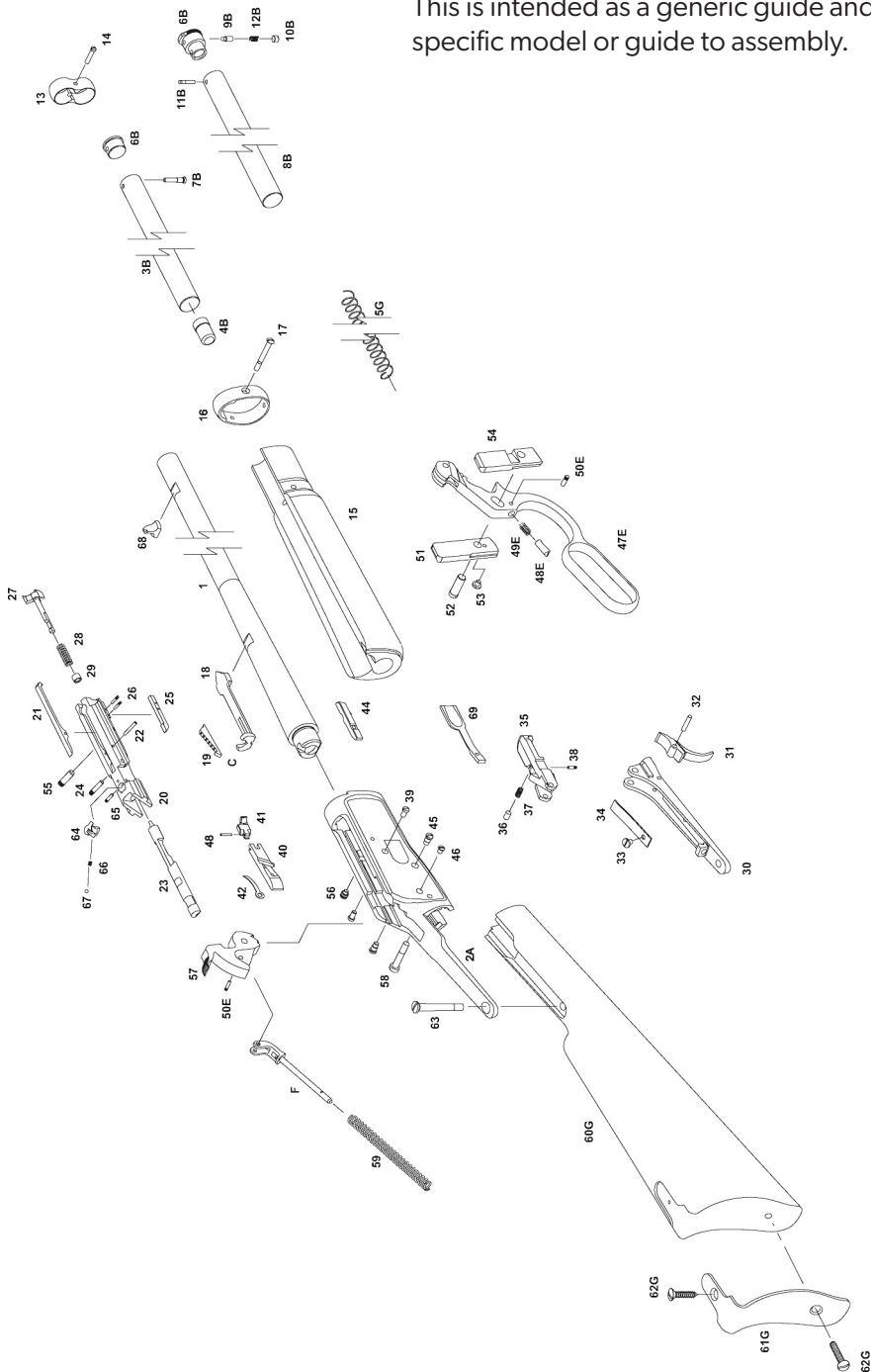
The serial number is located on the frame of the firearm directly in front of the trigger guard. Each serial number is specific to that firearm and is used for identification and registration. It is recommended that you record your serial number in your manual and keep the information in a secured location. Always keep the serial number visible and unobstructed from view.

WARRANTY INFORMATION

This firearm has a lifetime warranty that covers all working components for workmanship and breakage due to faulty parts. Firearms confiscated, modified, or used for purposes other than legally intended immediately VOID the warranty. All warranty service is completely at the discretion of GForce Arms, Inc. and their service agents.

EXPLODED VIEW

This is intended as a generic guide and not a specific model or guide to assembly.



PARTS LIST

1. Barrel
2. Receiver
- A. Receiver Assembly
- B. Magazine Assembly
- 3-B. Magazine Tube Outside
- 4-B. Magazine Follower
- 5-B. Magazine Spring
- 6-B. Magazine Plug
- 7-B. Magazine Plug Screw
- 8-B. Magazine Tube Inside
- 9-B. Magazine Plug Slide Pin
- 10-B. Magazine Plug Screw
- 11-B. Magazine Plug Stop Pin
- 12-B. Plug Slide Pin Spring
13. Front Band
14. Front Band Screw
15. Forearm
16. Rear Band
17. Rear Band Screw
18. Buckhorn Rear Sight
- C. Complete Rear Sight
19. Elevator
20. Breech Bolt
21. Extractor
22. Extractor Pin
23. Firing Pin
24. Firing Pin Stop Pin
25. Ejector Spring Stop
26. Ejector Spring Stop Pin
27. Ejector
28. Ejector Spring
29. Ejector Collar
30. Lower Tang
31. Trigger
32. Trigger Pin
33. Trigger Spring Screw
34. Trigger Spring
35. Carrier
36. Carrier Stop
37. Carrier Stop Spring
38. Carrier Stop Pin
39. Carrier Screw
40. Cartridge Guide, Left
41. Cartridge Stop
42. Cartridge Stop Spring
43. Cartridge Stop Pin
44. Cartridge Guide, Right
45. Cartridge Guide Screws
- D. Complete Spring Cover
46. Spring Cover Screw
- 47-E. Finger Lever
- 48-E. Friction Stud Spring
- 49-E. Friction Stud Spring
- 50-E. Friction Stud Stop Pin
51. Locking Bolt, Left
52. Locking Bolt Pin
53. Locking Bolt Pin Stop Screw
54. Locking Bolt, Right
55. Lever & Breechbolt Pin
56. L & B Pin Hole Plug Screw
57. Hammer
- F. Main Spring Rod
58. Hammer Screw
59. Main Spring
- G. Stock Assembly
- 60-G. Stock
- 61-E. Butt Plate
- 62-E. Butt Plate Screw
63. Upper Tang Screw
64. Locking
65. Locking Pin
66. Locking Spring
67. Locking Ball
68. Front Sight
69. Loading Gate

SERIAL NUMBER

Write your serial number here for easy reference:

NOTES

GFORCE ARMS™

Your Authority For Quality Firearms

IMPORTANT: DO NOT DISCARD

Keep this manual with the firearm
upon change of ownership.

LIFETIME WARRANTY

Your GForce Arms SADDLEHORN has a 5-YEAR FULL WARRANTY that covers any functional issue with the firearm for any reason.

This warranty is transferrable. If, for any reason, your firearm malfunctions, please visit **gforcearms.com/service** and complete a service request. We will cover shipping to our service center, labor and parts costs for repair.

CONTACT US

General Questions: **info@gforcearms.com**

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