

# ***SIPAHI***

**HUNTING AND TACTICAL INC.**



## **LEVER ACTION SHOTGUN USER MANUAL**



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

## GUN SAFETY RULES

Observe these rules of safe gun handling.

- 1.** Always keep the muzzle pointed in a safe direction. Watch the muzzle at all times: never point a gun, accidentally or intentionally, at any person or anything you do not intend to shoot. Identify the target before shooting; do not shoot at sounds.
- 2.** Always treat any gun as if it is loaded - it may be!
- 3.** Keep your finger off the trigger while operating the action and at all other times until you are ready to shoot.
- 4.** Keep the safety "on" or in the "safe" position at all times until you are ready to fire the gun.

Do not rely on your gun's safety, the safety on any gun is a mechanical device and is not intended as a substitute for common sense or safe gun handling.

- 5.** Learn how your gun functions and handles. If you do not thoroughly understand the proper use and care of your gun, seek the advice of someone who is knowledgeable.
- 6.** Do not alter or modify any parts of a firearm.
- 7.** Store guns unloaded, separate from any ammunition, and where children cannot get to them.
- 8.** Be sure the barrel is clear of any obstructions before loading. Make it a habit to check the barrel every time before loading.
- 9.** Be sure you have and use the proper ammunition. A 20-gauge shell will enter a 12-gauge chamber far enough so that a 12-gauge shell can be loaded behind it. Also, a 3-inch shell may fit into a 2 3/4-inch chamber, but the crimp at the mouth of the shell will unfold into the forcing cone. If either of these things occur and you fire the gun, the gun will explode, damaging the gun and possibly causing serious injury or death to you and those around you.
- 10.** Wear protective shooting glasses and adequate ear protection when shooting.
- 11.** Never climb or jump over anything, such as a tree, fence, or ditch, with a loaded gun. Open the barrel, remove the shells, and hand over the gun to a friend

or place it on the ground on the other side of the obstacle. Do not lean a gun against a tree or other object; it could fall and possibly discharge.

**12.** Do not shoot at a hard surface or at water. Bullet and shot can bounce in unpredictable directions with great velocity.

**13.** Never transport a loaded gun. Do not place a loaded gun into a vehicle. The gun should be unloaded and placed into a case when not in use.

**14.** Never drink alcoholic beverages before or during shooting.

## **INTRODUCTION TO HUNTGROUPE ARMS**

Established in 1992, Sipahi Arms is one of the most well-known firearms manufacturer and exporter in Turkey. Our export activities started in 2008, aiming to establish one of the biggest shotgun sales network in the World. We have been manufacturing and exporting variety of firearms combining modern technology and innovation.

On one hand, we are manufacturing and exporting semi-automatic (inertia), magazine fed semi-automatic, pump action, magazine fed pump action, over under, side by side, single barrel shotguns in different qualities and standards. On the other hand, we are able to supply variety of tactical shotguns to areas like European countries, USA, Middle East, Asia and South America.

Our motto is: "provide our clients high quality standards with affordable prices". This principle is Sipahi International Arms & Security Company's main philosophy and distinctiveness.

## **SAFETY SWITCH OR BUTTON**

The safety is designed to stop the trigger mechanism.

**DON'T RELY ON YOUR GUN'S SAFETY.  
TREAT EVERY GUN AS IF IT WERE  
LOADED AND READY TO FIRE.**

The safety on any gun is a mechanical device, and it is not intended as a substitute for common sense or safe gun handling. Always keep the muzzle pointed in a safe direction.

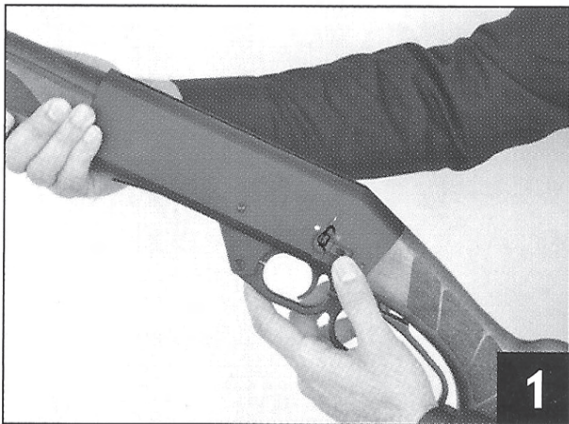
**A.** The safety is located left side of the receiver, and provides protection against accidental or unintentional discharge under normal usage when properly handled.

**B.** 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. The safety should always be in the "RED" or "WHITE" position until you intend to fire the gun.

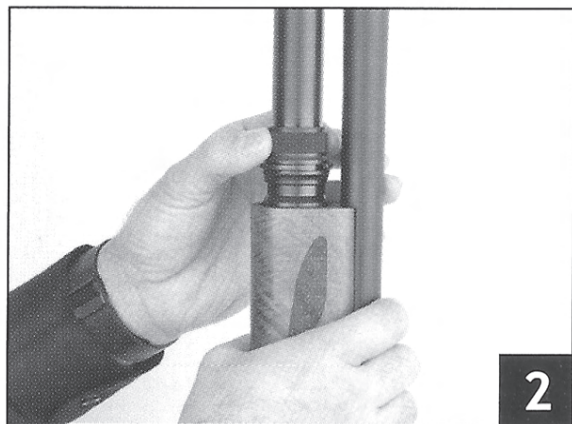
**C.** When you are ready to fire the gun, press the safety button to the "RED" or "FIRE" position, so that the safety protrudes from the left side of the gun and the **RED BAND MARKING IS SHOWING.**

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

### DISASSEMBLY



**1** - Safety ; Red is ready to fire & white is safe mode.



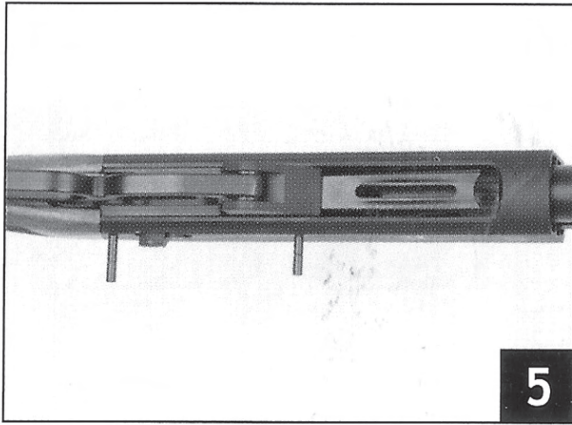
**2** - Remove the forend cap by turn it to anti-clockwise.



**3** - Remove forend & barrel assembly together by pulling forward.



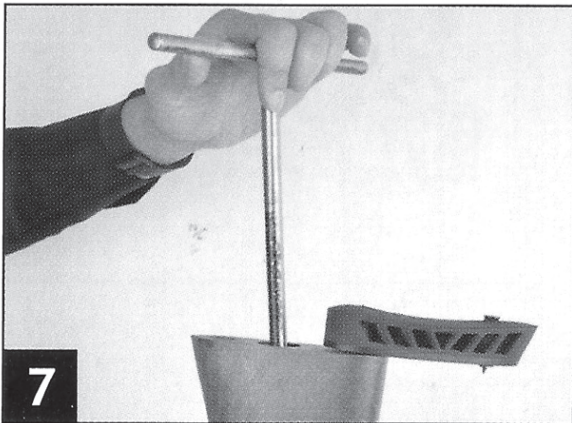
**4** - Take down the receiver pins by pressing with external screw.



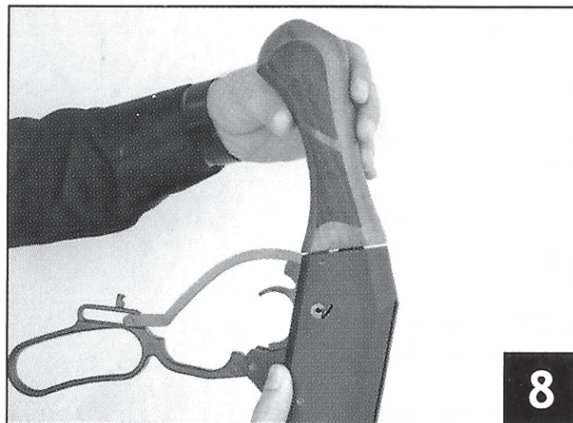
**5** - Over view of pins from downward.



**6** - Take out the trigger assembly by pushing it outside.



**7** - First remove the screw of rubber pad and than take out the screw of stock/butt.



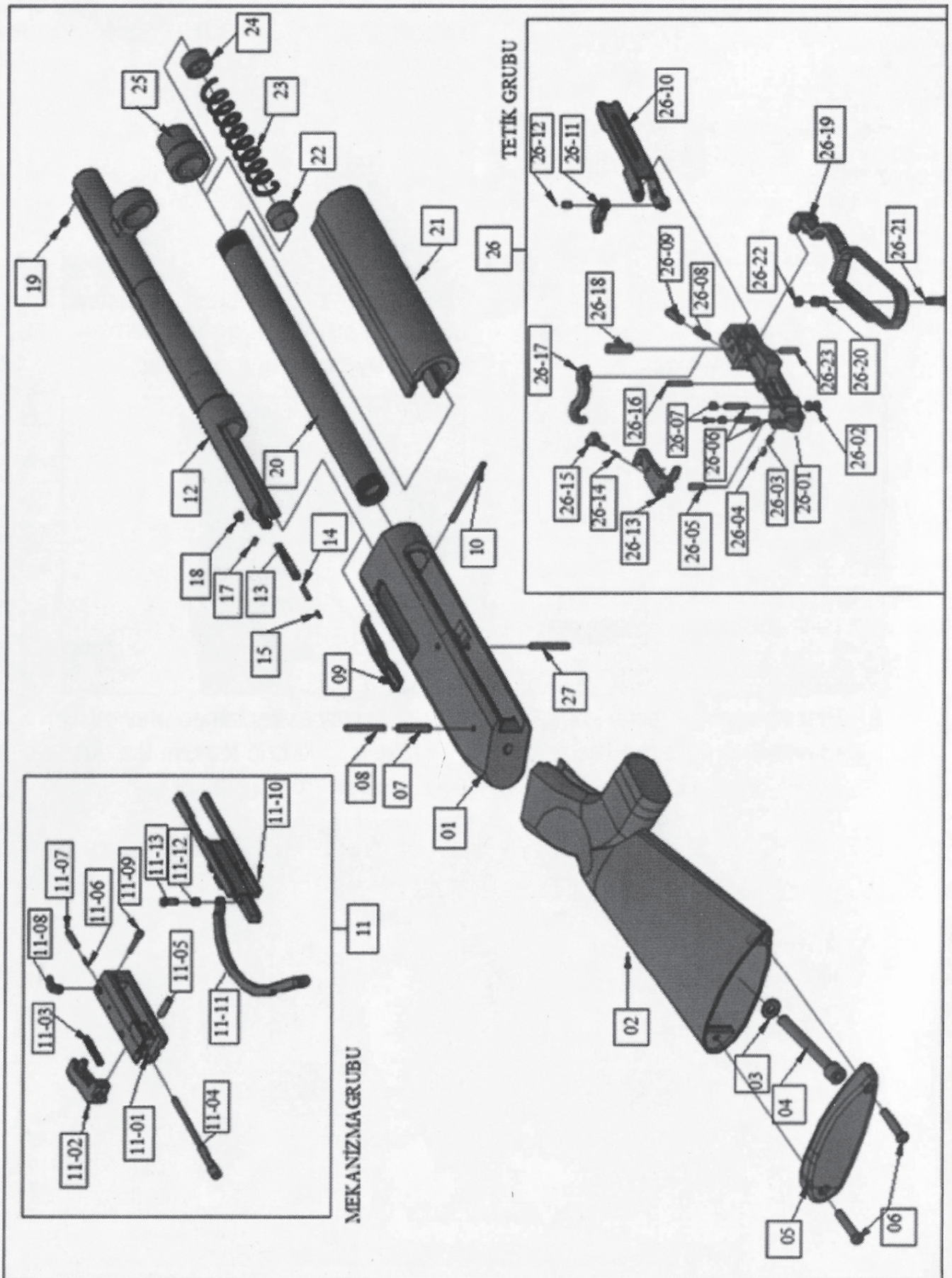
**8** - Same way as explained previously to take off the grip remove the nut / screw from inside of grip.



**9** - Assembled gun in action mode.

### **ASSEMBLY**


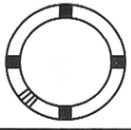
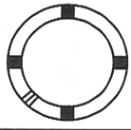
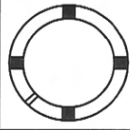
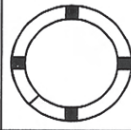
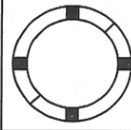
Assembly of gun is vise versa as explained above.



01	Receiver	19	Brass Bead
02	Stock	20	Magazine Tube
03	Stock Connection Bolt Washer	21	Forend
04	Stock Connection Bolt	22	Magazine Follower
05	Synthetic Stock Pad	23	Magazine Spring
06	Stock Pad Screws	24	Magazine End
07	Ayceki ( Lever Arm ) Stopper Reel	25	Barrel Connection Nut Complete
08	Ayceki ( Lever Arm ) Stopper Pin	26	Trigger
09	Magazine Stop Complete	26-01	Trigger Body
10	Magazine Stop Connection Pin	26-02	Safety
11	Bolt	26-03	Safety Push Reel
11-01	Bolt Body	26-04	Safety Push Spring
11-02	Locking Lug	26-05	Safety Push Connection Pin
11-03	Firing Pin Spring	26-06	Ayceki ( Lever Arm ) Stop Connection Pins
11-04	Firing Pin	26-07	Ayceki ( Lever Arm ) Stop Reels
11-05	Firing Pin Connection Pin	26-08	Operating Handle Spring
11-06	Extractor Spring	26-09	Operating Handle Reel
11-07	Extractor Pin	26-10	Carrier
11-08	Extractor	26-11	Carrier Hand
11-09	Extractor Connection Pin	26-12	Carrier Connection Pin
11-10	Bolt Carrier	26-13	Trigger
11-11	Ayceki ( Lever Arm )	26-14	Hammer Sear Spring
11-12	Ayceki ( Lever Arm ) Connection Nut	26-15	Hammer Sear
11-13	Ayceki ( Lever Arm ) Connection Bolt	26-16	Hammer Sear Connection Pin
12	Barrel	26-17	Hammer
13	Ejector	26-18	Hammer Connection Reel
14	Ejector Pin	26-19	Operating Hand Lever
15	Ejector Pin Spring	26-20	Ayceki ( Lever Arm ) Connection Pin
17	Ejector Screw Front	26-21	Ayceki ( Lever Arm ) Handle Reel Screw
18	Ejector Screw Back	26-22	Ayceki ( Lever Arm ) Handle Reel
		26-23	Ayceki ( Lever Arm ) Connection Screw
		27	Trigger Guard Dissassembly Pin

## USAGE OF CHOKE TUBES

The choke is what controls the openness or tightness of the pattern of your Shotgun. The chart below lists the choke available (from open to tight), and the corresponding marks that indicate the choke of your specific shotgun.

	SKEET	IC	M	IM	F	XF
CHOKE TUBE						
BBLS	CL	****	***	**	*	XF

Never fire or run gun cleaning tools through a barrel that uses choke tubes without having a choke tube installed. The threads of the choke tube and the internal threads of the barrel should be cleaned after each use and before installation of the tube.

To install a tube, insert the tube into the barrel and tighten with your fingers. Once the tube is finger tightened, tighten with the appropriate choke tube Wrench until the tube sits on the threads. DO NOT over tighten or forcefully tighten with wrench.

## MAINTENANCE AND CLEANING

**Caution:** Make sure the gun is unloaded.

1. Make sure that the broad, polished, finely fitted mating surfaces of the breech block and receiver are especially clean and lightly oiled with a high quality gun oil. Do not use pure silicone.
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 unless a choke tube is installed in each barrel. 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 from being damaged by cleaning tools and also prevent a dirt build up that would cause the choke tube to become difficult to remove from the barrel. Damage can result to choke tubes and barrel when attempting to remove sticky choke tubes. Never fire your gun without choke tubes tightened in barrels. Do not over tighten choke tubes. Wipe all exposed metal surfaces with an oiled cloth before storing. Do not pour oil into the inside mechanism because it may hamper proper functioning and will soak

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

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

### **STORAGE**

Clean thoroughly and oil your gun before storage. Store the gun in a case to prevent scratches and dents. Store in a dry place to prevent corrosion.

Store the gun away from children and in place where it cannot be obtained by those unauthorized to use it. Always store gun unloaded and separately from any ammunition.

### **PARTS**

To order parts, please mention the following information: Your name, address, telephone number, firearm serial number, make and model. When we receive your request we will send you an order form and a parts breakdown with prices.

## **SERVICE AGREEMENT AND LIMITED WARRANTY**

Sipahi Arms 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 Sipahi Arms 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 Sipahi Arms makes no warranties, express or implied.

Sipahi Arms will repair or replace any unserviceable parts for one (1) year from date of purchase and further will supply free parts (Wood not included) for an additional (1) years in accordance with the above warranty statement provided your firearm had not been altered, abused, willfully damaged, or damaged by over pressure ammunition. This agreement is not transferable;

its benefits apply only to the original purchaser. To obtain free service during the time this agreement is in effect, make sure your firearm is unloaded, and send it to Hunt Group Arms.

This agreement and the warranties contained herein are void if your registration card is not received with a copy of your sales slip within 30 days from date of purchase.

## **SHIPPING**

When returning your gun for service, please take care in packing. Disassemble your gun, wrap in paper or other protective media and place gun in the original box. (THIS BOX WILL PROTECT THE GUN BUT IS NOT DESIGNED FOR SHIPPING). Wrap box in a cardboard box approved for interstate shipping. Sipahi Arms is not responsible for damage occurred during shipping.

Ship the firearm prepaid to the adress mentioned below:

**THANK YOU**

Thank you for purchasing a Sipahi Arms shotgun We are sure this gun will bring you years of hunting and/or shooting pleasure. Your satisfaction is the key to our success.

***SIPAHI***

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