

# VENZA

## OWNER'S MANUAL

**WARNING:** This Manual contains important warnings and should be read carefully before using the shotgun.





## Contents

1. ATA ARMS BRIEF HISTORY
2. INTRODUCTION
3. SAFETY RULES
4. OPERATING SYSTEM
5. PARTS 6
6. BARREL ASSEMBLY
7. BEFORE SHOOTING
  - 7.1 Safety Mechanism
  - 7.2 Choke Selection
    - 7.2.1 Choke Replacement
8. CARTRIDGE LOADING
  - 8.1 Feeding a Cartridge into The Chamber
9. UNLOADING THE SHOTGUN
10. DISASSEMBLY
  - 10.1 Forend Removal
  - 10.2 Barrel Group Removal
  - 10.3 Piston Removal
  - 10.4 Valve Group Removal
  - 10.5 Bolt Group Removal
  - 10.6 Trigger Group Removal
  - 10.7 Buttstock Removal
  - 10.8 Choke Removal
  - 10.9 Safety Button Direction Change
11. TRIGGER PULL LENGHT INCREMENT
12. PISTON USE
13. USING BUTT STOCK SETTING KIT
14. MAINTENANCE
  - 14.1 General Maintenance and Lubrication
  - 14.2 Maintenance After Use
    - 14.2.1 Barrel Maintenance
    - 14.2.2 Choke Maintenance
    - 14.2.3 Maintenance Of Gas Chamber And Piston
15. ASSEMBLY DRAWINGS AND PART LIST



## 1. BRIEF HISTORY

The founder of Ata Arms, gifted craftsmen Celal YOLLU began writing his success story in the very heart of Anatolia when he discovered his talents for mechanical engineering as a young boy living in the Incesu township of Kayseri. He attained legendary successes for disassembling and then reassembling and for manufacturing any mechanical tool he laid his eyes on he succeeded in repairing shotguns that many experienced gunsmiths failed to repair and in 1955, when he was just 13 years old, his first signs of the success began to appear. When he produced his first single barrel shotgun.

In the name of innovation, Celal YOLLU he opened a modest workshop in Anatolia which allowed him to transform his dreams into reality.

By the year 1967, Celal YOLLU produced the first side by side shotgun in Turkey and every successful design thereafter Has increased the demand for his products.

This increase in demand ultimately led Celal YOLLU to relocate his operations to Düzce, the center of the Turkish firearms industry. Within a short time of this move, he produced the first over-under shotgun in Turkey.

By the year 1990 Celal YOLLU has relocated the company once again, to Istanbul, in order to be closer to the European and Global markets.

Since the move to Istanbul, Celal YOLLU produced the first semi-automatic shotgun in Turkey

In 2000, a partnership with the Beretta Group was formed and ATA Arms shotguns have thoroughly enjoyed a solid reputation for unwavering quality and reliability at a fantastic price point.

ATA Arms continues successful journey with the same determination and desire as Celal YOLLU expressed when he founded the company more than a half-century ago.



## 2. INTRODUCTION

Thank you for choosing VENZA shotgun, the newest member of the ATA ARMS family.

With a valve system, the Venza reduces recoil and muzzle rise to a minimal level, allowing for an enjoyable shooting experience.

For future reference, please keep a copy of this guide with the shotgun in the event you ever sell it. A copy of this user guide is also available at the web page of our company which can be accessed at

<http://www.ataarms.com/en/index.php>



### 3. SAFETY RULES

Please read the following safety rules carefully before you use your shotgun. If not used properly, shotguns can be dangerous and can result in serious injury or death to both yourself and others. The following safety rules illustrate some of the user's basic responsibilities when handling the firearm.

- a) Never point your barrel in the direction of anything you do not intend to shoot, regardless of whether the shotgun is loaded or not.
- b) Do not direct your shotgun towards an unsafe place for firing such as hard surfaces including but not limited to metals, rocks and water.
- c) Keep safety button engaged until you are ready to shoot (the red warning line should be invisible).
- d) Keep your finger outside of the trigger guard, completely away from the trigger, until you decide to shoot
- e) Make sure the inside of the barrel is clean and free of obstructions before shooting.
- f) Learn the operation and safety features of your shotgun by heart. However, that no safety mechanism is a substitute for safe handling procedures.
- g) Keep your shotgun out of the reach of children and other unauthorized possessors of firearms.
- h) Do not neglect performing routine maintenance on your shotgun.
- i) Always use appropriately marked and factory loaded cartridges to SAAMI/CIP specifications with your shotgun. Avoid manually reloaded cartridges as this can be unsafe and will void the shotgun's warranty.
- j) Always use eye and ear protection when shooting.
- k) Do not drink alcohol or use drugs before or during operation of the shotgun. If you take medicine do not handle a firearm while you are under its influence.
- l) Do not leave cartridges in your shotgun after usage.
- m) Do not make any mechanical changes to your shotgun. This can be unsafe and will void the shotgun's warranty.
- n) Have your shotgun repaired only by an authorized service.

**WARNING:** Every shotgun has the potential to claim the life of another human being. Read this manual carefully and comply with all safety rules.

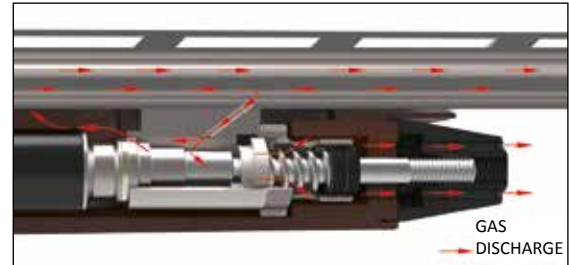
**WARNING:** Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances known to cause birth defects, permanent damage and other serious injuries. When maintaining your shotgun after use, make sure to do so in a well-ventilated area and remember to wash your hands after maintenance. (Friendly Tip: Use cold water when washing your hands to keep the chemicals and lead outside of your pores).

## 4. OPERATING SYSTEM

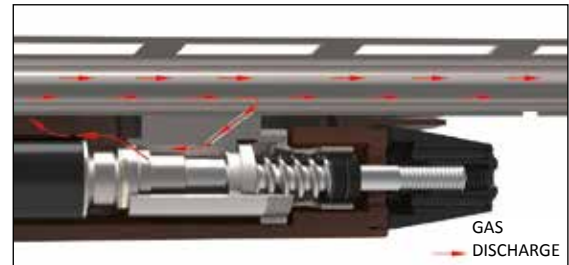
The VENZA operates by way of a “Gas Pressure Control System” (“GPCS”), an integration of two systems (a short recoil system and an automatic gas pressure operated system).

When firing a high-pressure cartridge, the barrel and all of the moving systems move backwards, opening the gas discharge holes and allowing the gases to exit. (Picture 1)

When firing a low-pressure cartridge, the barrel does not move backward, but the pressurized gas that comes to the gas chamber, providing the backward movement of the bolt by pushing on the plunger. (Picture 2)



**Image 1 Gas Discharge with heavy loads**



**Image 2 Gas Discharge with light loads**



## 5. NOMENCLATURE



Image 3 VENZA Overview



**Image 4 VENZA Overview**

A	BUTT STOCK	C	RECEIVER	F1	BARREL PLUG
A1	SHIM KIT	C5	MAGAZINE GROUP	F2	BREECH
A2	RECOIL PAD	C6	BOLT GROUP	F3	VALVE GROUP
A3	BUTT STOCK ASSEMBLY KIT	C7	SLIDING BAR TUBE	G	FRONT SIGHT
A4	RECOIL PAD SCREW (2 PCS)	D	FOREND	H	PISTON
A5	BUTT STOCK EXTENSION	E	MAGAZINE CAP		
B	TRIGGER GROUP	F	BARREL GROUP		

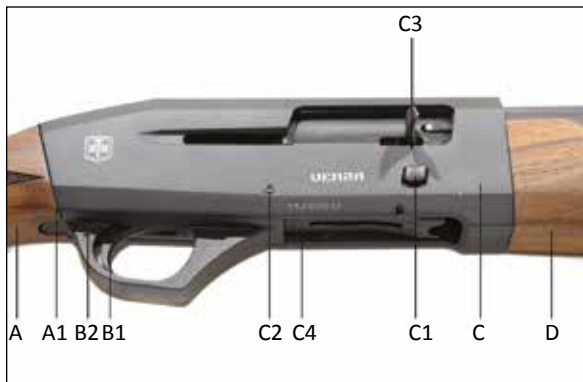


Image 5



Image 6

- A STOCK
- A1 SHIM KIT
- B1 TRIGGER
- B2 SAFETY BUTTON
- C RECEIVER
- C1 CARRIER BUTTON
- C2 RECEIVER PIN
- C3 BOLT HANDLE
- C4 CARRIER
- D FOREND

- B1 TRIGGER
- B2 SAFETY BUTTON
- B3 FEED/STOP (CUT OFF) BUTTON
- C2 RECEIVER PIN



## 6. REASSEMBLY



Image 7

To install the barrel, please follow the instructions below:

- Remove the magazine cap by turning it counter-clockwise. (Image 8)



Image 8

- Carefully remove the forend by sliding it forward with one hand, while firmly grasping the receiver with your other hand. (Image 9)



Image 9



- Fit the barrel into the breech slot in the receiver, paying particular attention in order to make it coincide with the magazine tube shaft of the gas chamber. (Image 10)



Image 10

- Refit the forend over the magazine tube and pull to the rear. (Image 11).



Image 11

- Tighten the magazine cap by turning it clockwise (Image 12)



Image 12



## 7. BEFORE SHOOTING

Please make sure you selected the correct ammunition. The cartridges you have chosen should be appropriate to the dimension marked on the barrel. Our VENZA 12 Gauge model shotgun is available for use cartridges from 7/8 oz. to 2 oz., VENZA 20 Gauge model shotgun is available for use cartridges from 7/8 oz. to 1 1/4 oz

**WARNING: NEVER USE STEEL AMMUNITION WITH CHOKES NUMBERED 1 or 2 (ONLY USE STEEL AMMUNITION WITH CHOKES NUMBERED 3, 4 or 5).**

**WARNING: ONLY USE FACTORY AMMUNITION LOADED IN ACCORDANCE WITH SAAMI/CIP SPECIFICATIONS. HAND-LOADED AMMUNITION CAN BE DANGEROUS AND WILL VOID YOUR WARRANTY.**

### 7.1 Trigger Safety

To the safety is located on the trigger guard.

- When you press from left to right, the edge of button will appear as black. In this case, the safety on the trigger of the shotgun is engaged.(Image 13)
- If you press the button from right to left, the edge of button will appear as red. In this case, the safety of your shotgun is not engaged and you can fire your shotgun. (Image 14)

**WARNING: Please refer to sections 10.9 with regard to the changing direction of the safety button that can be used Double-sided.**

**WARNING: When not in use, always make sure that your shotgun is not loaded and the safety mechanism is engaged.**



Image 13 Trigger Safety On








Image 14 Trigger Safety Off



## 7.2 Choke Selection

The “choke” changes the diameter of the barrel by fitting onto the muzzle tip. Its purpose is to provide the user with different pellet distributions.

### CHOKES AND USE

Choke No	Name	Area of Usage	Sign
1	FULL	During long-distance hunting such as; duck and goose, with the long-range shots made with lead pellet cartridges	
2	IMPROVED MODIFIED	During hunting such as; partridge, rabbit and pheasant in 35-40 meters distance, also during long-distance hunting shots in which lead pellets are used.	
3	MODIFIED	During hunting such as; woodcock, pheasant and quail in 30-35 meters distance, also during long-distance hunting shots in which steel pellets are used	
4	IMPROVED CYLINDER	During short-range hunting such as; for dove and quail, and in target shooting	
5	SKEET	During skeet and plate shooting for sporting purposes in the shootings made in order to open pellets in short distance in order	



## 7.3 Choke Replacement

**WARNING:** Make sure that your shotgun is not loaded and the safety is engaged whenever you are installing or removing the choke.

**WARNING:** When installing or removing a choke, make sure that the choke and the bearing of the shotgun are completely clean. Otherwise, your barrel can deform during firing.

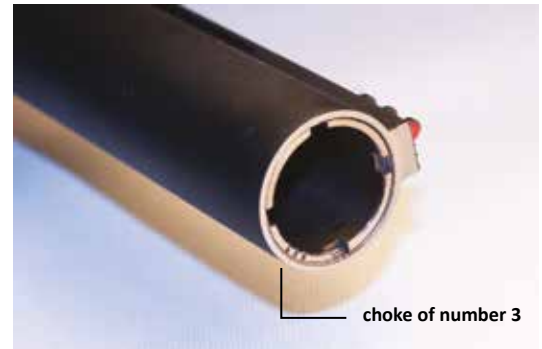
- To remove the, use the choke wrench provided with the shotgun.
- If the thread of the choke is dirty, clean it.
- Using the choke wrench, tighten clockwise and ensure that all of the threads of the choke are fully seated in the barrel.

**WARNING:** When reassembling, do not tighten the choke unless you make sure that the threads of the choke are completely mated with the threads of the barrel.

**WARNING:** In order to make sure that the chokes have been fully Tightened, you should not see any protrusions emerging from the tip of the barrel.

- Do not shoot without a choke in order to avoid damaging the barrel.
- Never look into the muzzle to see the choke number, regardless of whether the shotgun is loaded or not.
- Remove and clean the choke after shooting during maintenance. After having lubricated, the threads continue with the assembly.

- Do not use a different tool or a spanner for removal and installation of choke, except your choke wrench produced and provided by ATA Arms.
- You can look at the notches on the screw side in order to see the choke number. (Figure 15)



**Image 15**



## 8. CARTRIDGE LOADING

The magazine capacity of your VENZA your shotgun is 2+1 for 3" cartridges and 3 +1 for 2 ¾" cartridges.

**WARNING: Make sure that the safety of the gun is engaged when loading cartridges.**

**WARNING: Make sure that the muzzle is pointed in a safe direction.**

- To load your shotgun, follow the steps below;
- Release the carrier by pressing the carrier button.
- Put the cartridge into the magazine slot and push until you hear a click. Repeat the same process for other cartridges. (Image 16)



Image 16

### 8.1 Feeding A Cartridge Into The Chamber

**WARNING: Be sure that the muzzle is pointed in a safe direction.**

For feeding a cartridge into the chamber, follow the steps below;

- Drop the cartridge onto the carrier (Image 18) by pressing the feed/stop (Cut Off) button (Image 17)



Image 17



Image 18



- Pull the bolt backwards and release the lever. Thus, since the magazine will be missing a cartridge, you can add another cartridge. (Image 19)



- Your shotgun is now ready to fire.

## 9. UNLOADING THE SHOTGUN

**WARNING: Be sure that the muzzle is pointed in a safe direction**

To unload your shotgun, follow the steps below;

- Make the full cartridge inside the barrel eject through the extraction port by pulling and releasing the bolt handle. (Figure 20)
- Drop the cartridge onto the carrier by pressing the feed/stop button for other cartridges by pulling the bolt



handle make the cartridge settle the barrel and repeat the process above

- Repeat the same procedure for each of the remaining cartridges in the magazine.
- When the red plug is observed it means that there are no cartridges left in the magazine. (Image21)
- In order to verify that no cartridges are left in the chamber pull the bolt back and visually check the chamber

**WARNING: Make sure you have no cartridge left in the magazine**





## 10. DISASSEMBLY

**WARNING:** Before disassembling your VENZA shotgun, make sure that the magazine and chamber are empty.

Follow the steps below to disassemble and general maintenance/cleaning of your shotgun.

### 10.1 Forend Removal

- Remove the magazine cap by turning counterclockwise. (Image 22)
- Remove the forend by pulling parallel to the barrel. (Image 23)



Image 22



Image 23



## 10.2 Barrel Group Removal

- Press the feed/stop (cut off) button.
- Pull the bolt to the end. (Bolt will be left behind).
- By holding the receiver and the butt stock, pull the barrel forwards and parallel to the magazine tube remove (Image 24)



Image 24

## 10.3 Piston Removal

- After you remove the barrel, take the plunger out of the gas chamber (Image 25)



Image 25



## 10.4 Valve Group Removal

- Holding the barrel in your hand, remove the circlip located within the valve body at the top of the gas chamber from the valve body with the help of pliers. (Image 26)
- Remove the valve nut using the wrench. (Image 27)
- Remove the valve spring in the valve body. (Image 28)

**WARNING:** Use wrench when installing the valve nut into the valve body. While tightening the valve nut you can increase or decrease the spring force.

**WARNING:** The valve body is fixed. Please do not try to disassemble.





## 10.5 Bolt Group Removal

**WARNING:** Make sure the hammer is not cocked before removing and installing the bolt group.

- By pressing the Receiver button make sure that the bolt settles forward
- Remove the Bolt Handle by pulling in the direction of the arrow. (Image 29)
- Remove the Bolt Group out of the receiver by pulling with the bolt tube located on the magazine tube. (Image 30)



Image 29



Image 30



## 10.6 Removing The Trigger Group

- Push the receiver pin located on the receiver with a pin and remove from its seat. (Figure 31)



Image 31

- Remove the Trigger group from its seat, by pressing the Carrier Latch Extractor button. (Figure 32)



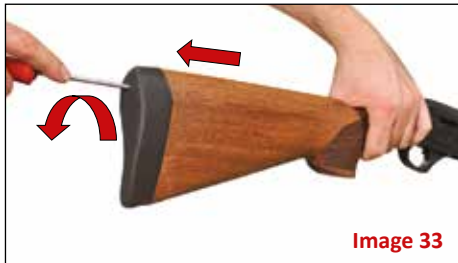
Image 32

**WARNING:** When reinstalling the Trigger Guard, depress the receiver button to facilitate reinsertion into the receiver.



## 10.7 Buttstock Removal

- Remove the two screws in the recoil pad by unscrewing counter-clockwise, then remove the recoil pad from its seat. (Image 33)
- While holding the receiver with one hand, pull out the buttstock in the direction of the arrow. (Figure 35)
- After you remove the buttstock, if there is an angle set piece, remove it by pulling in the same arrow direction.
- **Refer to section 11 for using the butt stock adjustment kit.**



- Remove the bolt that connects buttstock to the recoil tube using the wrench of the right size (Image 34)





## 10.8 Choke Removal

**WARNING:** Always be sure your shotgun is not loaded and the safety is on.

**WARNING:** During disassembly, be sure the choke and the bearing of the choke are clean.

- Dislodge the choke by using choke wrench and turning it counter clockwise. (Figure 36)

**WARNING:** While reassembling the choke, be sure the threads of the choke and the threads of the barrel fully mate with each other. NEVER FIRE THE SHOTGUN WITH THE CHOKE NOT FULLY INSERTED IN THE BARREL.



Image 36

## 10.9 Safety Button Direction Change

- Remove the trigger guard.
- Remove the safety pin marked in the Image (Figure 37) by using other pin. After the pin is removed the safety spring and safety pin will come out of the slot. Pay attention for not to jump out (Figure 38).
- First, insert the safety pin then the spring and refit the pin marked in the image.
- Place the red zone safety button so as to be on the right side for LEFT HANDED USER and on the left side for RIGHT HANDED USER.

**WARNING:** Place the red zone safety button so as to be on the right side for LEFT HANDED USER and on the left side for RIGHT HANDED USER



Image 37



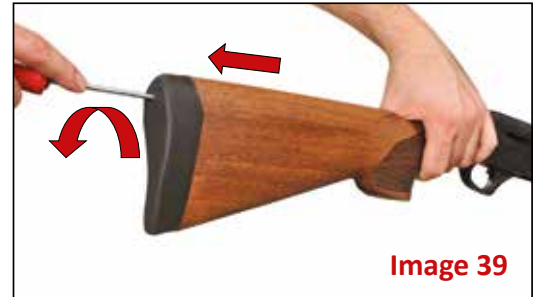
Safety Spring   Safety Spring   Safety Spring Retaining Pin   Safety Pin

Image 38

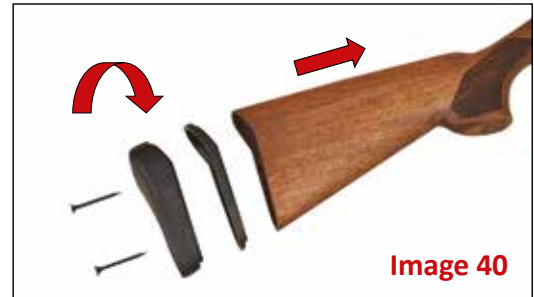


## 11. TRIGGER PULL LENGTH INCREMENT (WHEN REQUIRED)

- Remove the recoil pad screws through counter-clockwise direction ( Image 39)
- Remove recoil pad in the direction shown in Image 39.

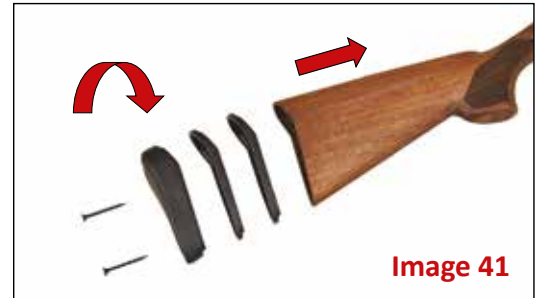


- For 5 mm increment use only one butt stock extension. As shown in Image 40, place the butt stock extension and the pad. Screw them using the screws supplied.





- If you like to increase the trigger pull length by 10 mm use second butt stock extension. Assemble them as shown in Image 41. Use longer screws for second butt stock extension. (Longer screws are put inside your shotgun box)





## 12. PISTON USE

The VENZA shotgun works with a single plunger. You can use cartridges from 7/8 oz. up to 2 oz. together with these plungers. You can find the disassembly and reassembly process of the plunger in the section of this manual titled “Piston Removal” (See section 10.3 on page 17).

## 13. USING BUTTSTOCK SETTING KIT

- There is shim kit on the VENZA Shotgun that you have bought. You can adjust the height and direction of butt stock of your shotgun with the adjustment kit provided along with your shotgun. Review the section
- 10.7 again for the removal of butt stock (Image 42)
- You can adjust the lowness of the stock of your shotgun with the shims that came with your shotgun by selecting dimensions (50mm, 55mm, and 65mm). (Image 43)



Image 42



Image 43

- The butt stock shim kit consists of 5 parts. They are marked on one side of the butt stock adjustment to indicate its size. (Image 44)



## 14. MAINTENANCE

**WARNING: Be sure, your shotgun is not loaded and safety is on before performing any routine maintenance.**

**WARNING: Avoid using excess oil while lubricating.**

### 14.1 General Maintenance and Lubrication

Parts to be cleaned during general maintenance: bolt, trigger group, magazine tube and the receiver.

- Clean the dirt, rust and sediments on the parts specified for general maintenance with a lubricated cotton cloth and a bronze wire brush, if necessary.
- Use a dry and clean cotton cloth to remove oil residues after cleaning.
- After cleaning, lubricate the parts to leave a thin layer of oil.
- Please make sure that the tools you use for cleaning such as the cloth and brush are products that will not damage the parts.

## **14.2 Maintenance After Use**

Carry out the maintenance of the muzzle, gas chamber and plunger of your shotgun at the end of each shooting session.

### **14.2.1 Barrel Maintenance**

- Clean the combustion residues that have accumulated in the barrel bore using a cotton cloth lubricated with maintenance oil. If you should use a brush, use a bronze wire brush.
- Use a dry and clean cotton cloth to remove oil residues after cleaning.
- After cleaning, apply a thin layer of lubricant with a cotton cloth.

WARNING: DO NOT USE EXCESSIVE OIL IN AND AROUND THE BREACH OF THE BARREL SO AS TO NOT OBSTRUCT THE BARREL.

### **14.2.2 Choke Maintenance**

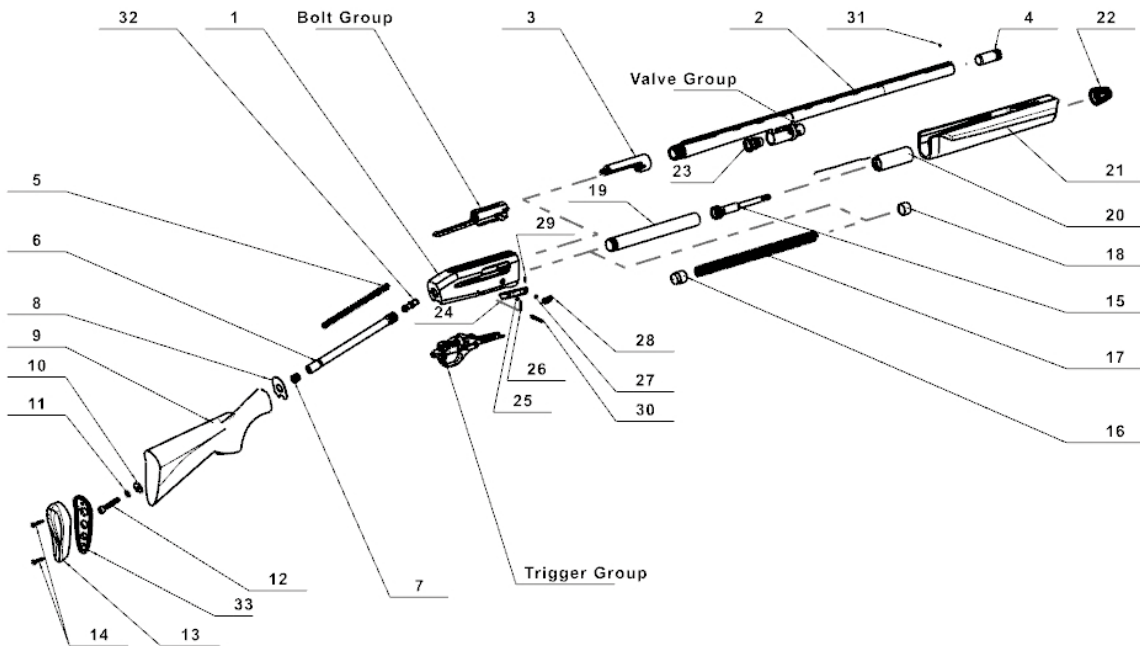
- Clean the combustion residues pile up inside the choke using a cotton cloth lubricated with maintenance oil. If you should use a brush please prefer a bronze wire brush.
- Use a dry and clean cotton cloth to remove the remaining dirty oil after the first operation.
- After the cleaning process lubricate so as to leave a thin layer of oil on the surface using a cotton cloth lubricated with maintenance oil.

### **14.2.3 Maintenance of Gas Chamber and Piston**

- Carefully remove the plunger.
- Clean the combustion residues using a cotton cloth lubricated with maintenance oil
- Be sure, it can move back and forth on the magazine tube shaft comfortably.

## 15. ASSEMBLY DRAWINGS AND PART LIST

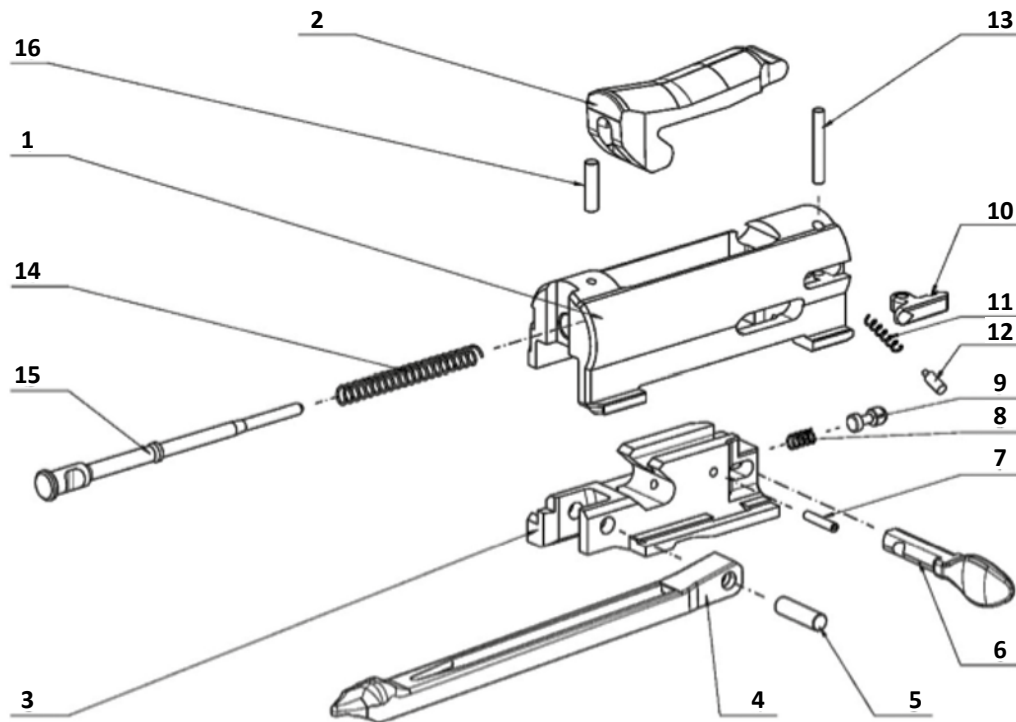
### GENERAL ASSEMBLY AND PARTS LIST



<b>Part No</b>	<b>Part Name</b>	<b>Part No</b>	<b>Part Name</b>
1	Receiver	18	Magazine Spring Cap-Front
2	Barrel	19	Magazine Tube
3	Breech	20	Sliding Bar Tube
4	Choke	21	Forend
5	Recoil Spring	22	Forend Nut
6	Recoil Spring Tube	23	Piston
7	Recoil Spring Retaining Nut	24	Carrier Latch
8	Shim Kit	25	Carrier Latch Spring
9	Butt Stock	26	Carrier Latch Pin
10	Washer	27	Carrier Button Spring
11	Washer	28	Carrier Button
12	Butt Stock Connecting Screw	29	Carrier Button Pin
13	Recoil Pad	30	Receiver Pin
14	Recoil Pad Screw	31	Front Sight
15	Magazine Tube Shaft	32	Recoil Spring Cap
16	Magazine Spring Follower	33	Butt Stock Extension
17	Magazine Spring		



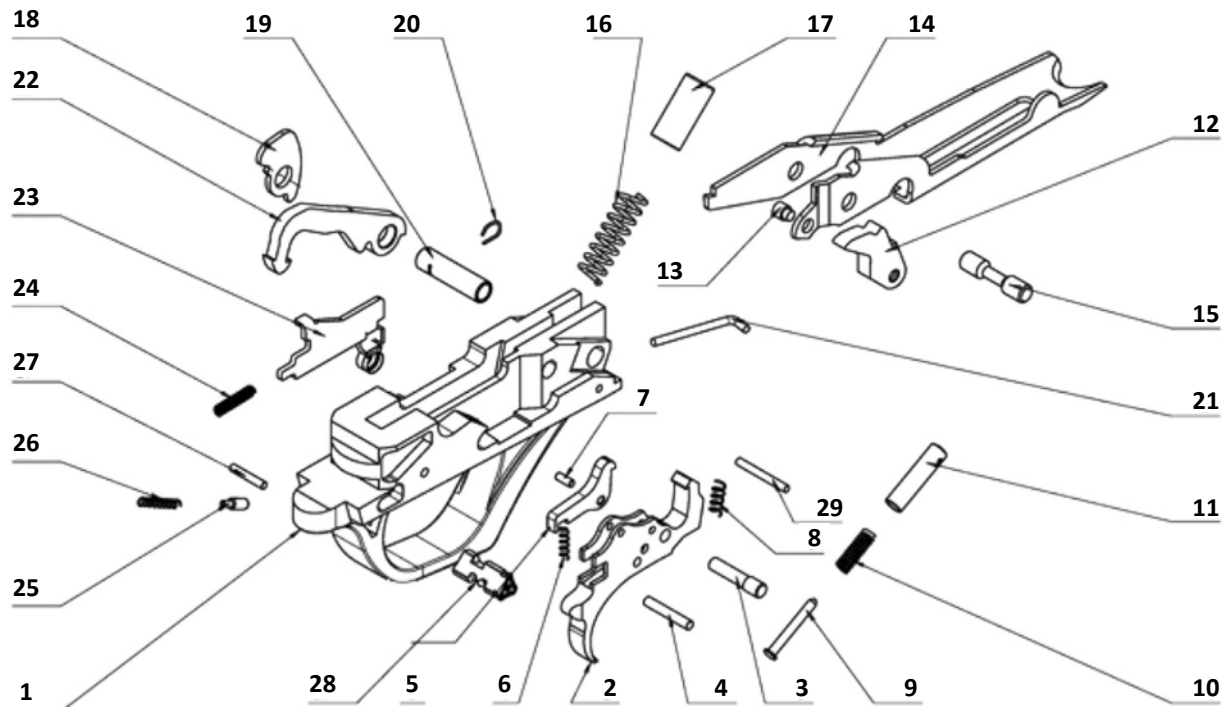
## BOLT GROUP ASSEMBLY



## BOLT GROUP PART LIST

Part No	Part Name	Part No	Part Name
1	Bolt	9	Bolt Handle Plunger
2	Locking Block	10	Extractor
3	Blocker Sliding Bar	11	Extractor Spring
4	Link	12	Extractor Spring Plunger
5	Link Pin	13	Extractor Pin
6	Bolt Handle	14	Firing Pin Spring
7	Bolt Handle Spring Retaining Pin	15	Firing Pin
8	Bolt Handle Pin Spring	16	Firing Pin Retaining Pin

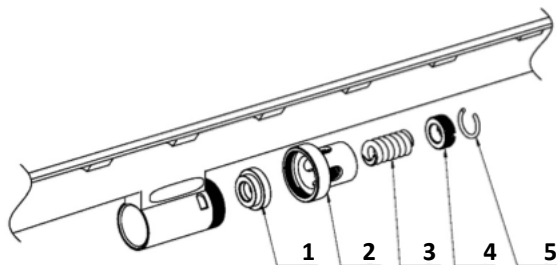
## TRIGGER GROUP ASSEMBLY AND PART LIST



## TRIGGER GROUP PART LIST

Part No	Part Name	Part No	Part Name
1	Trigger Guard	16	Hammer Spring
2	Trigger	17	Hammer Spring Cap
3	Trigger Pin	18	Hammer Latch
4	Trigger Fixing Pin	19	Hammer Tube Pin
5	Disconnecter	20	Hammer Tube Detent Clip
6	Disconnecter Spring	21	Hammer Latch Spindle
7	Disconnecter Pin	22	Hammer
8	Trigger Spring	23	Cartridge Cut Off
9	Breech Bolt Latch Spring Pin	24	Cartridge Cut Off Spring
10	Breech Bolt Latch Spring	25	Safety Plunger
11	Breech Bolt Latch Spring Capsules	26	Safety Plunger Spring
12	Breech Bolt Latch	27	Safety Spring Retaining Pin
13	Breech Bolt Latch Pin	28	Safety
14	Carrier	29	Hammer Fixing Pin
15	Carrier Pin		

## VALVE GROUP ASSEMBLY



## VALF GROUP PART LIST

Part No	Part Name
1	Spring Washer
2	Valve Body
3	Valve Spring
4	Valve Body Nut
5	Circlip

## Ata Arms Warranty Information

The Manufacturer warrants that this firearm was manufactured free of defects in material or workmanship; and for a period of two (2) years after date of original purchase, the Manufacturer and/or its local official Distributor/s agree to correct any such defect in this firearm by repair or replacement (at their discretion and, if the firearm is to be replaced, with the same or a comparable quality firearm). The Manufacturer does not warrant the wood (stock and forend), grips or metal finish with respect to finish, matching of pieces, dents, scratches, cut, dings, etc. which are or should be apparent to the purchaser when the product is purchased. It is the customer's responsibility to inspect this particular product prior to purchase to ensure that it is free from defects or damage. This Warranty is effective from the original retail purchase of the firearm only. Ata Arms assumes no liability for consequential, punitive or other damages (except as set forth herein) related to a warranty claim. A service and/or handling charge may be required for non-warranty repairs.

THE MANUFACTURER AND/OR ITS LOCAL OFFICIAL DISTRIBUTOR(S) ASSUME NO RESPONSIBILITY FOR PRODUCT MALFUNCTION OR FOR PHYSICAL INJURY OR PROPERTY DAMAGE RESULTING IN WHOLE OR IN PART FROM CRIMINAL OR NEGLIGENT USE OF THE PRODUCT, IMPROPER OR CARELESS HANDLING, UNAUTHORIZED MODIFICATIONS, USE OF DEFECTIVE, IMPROPER HAND-LOADED, RELOADED OR REMANUFACTURED AMMUNITION, CUSTOMER ABUSE OR NEGLECT OF THE PRODUCT OR OTHER INFLUENCES BEYOND THE MANUFACTURER'S DIRECT AND IMMEDIATE CONTROL. THIS WARRANTY DOES NOT APPLY TO NORMAL WEAR OF ANY PARTS, INCLUDING METAL, WOOD, PLASTIC, RUBBER, SURFACE FINISH OR OTHER MATERIALS, OR IF UNAUTHORIZED REPAIR AND/OR ALTERATION HAS BEEN PERFORMED.

The terms of this Warranty cannot be changed except in writing by an officer of the Manufacturer or its local official Distributor.



Wholesalers, dealers or gunsmiths (unless they are a repair station authorized by the Manufacturer and/or by its local official Distributor/s) are not authorized to make any warranty repair or adjustment on behalf of the Manufacturer.

This Warranty gives only the original personal retail purchaser specific legal rights.

Should warranty service be required for this firearm, please return it to the Manufacturer (for firearms purchased in Turkey) or to its local official Distributor/s in your country through the Retailer from whom purchased, giving the full details of the defect or malfunction and stating date of purchase, along with a copy of your sales receipt.



**“Warranty period is 2 (two) years for the manufacturing defects”**

**For Any Warranty Claims Please Contact:**

**Briley Manufacturing. Inc**

**1230 Lumpkin Road**

**Houston, Texas 77043**

**(713)932-6995**









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