

GFORCE ARMS™

Your Authority For Quality Firearms



GFLVR410®

LEVER-ACTION SHOTGUN INSTRUCTION MANUAL

MODEL
WSG410®

MANUFACTURER
FAISSI

ITEM NUMBER
GFLVR410®

DESCRIPTION
GFORCE ARMS LVR410
LEVER-ACTION .410GA
2½" CHAMBER
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) 3GFORCE
343-6723

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 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 (if applicable) and open the bolt to visually inspect the chamber and confirm that it is clear. Always unload all ammunition from the chamber and remove the magazine (if applicable) 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 LVR410 should only be used with modern 2 1/2" .410 gauge (GA) ammunition.

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

This model is equipped with a lever engaged safety. When the lever is released from the body of the firearm (Fig 1.), the safety is "engaged" and in "safe" position. When the lever is pressed against the body of the firearm, the safety is OFF and the firearm is in the FIRE position. (Fig 2.)



FIGURE 1



FIGURE 2

LOADING THE FIREARM

To load the the firearm, insert the .410 shell into the side magazine tube with the primer end to the REAR. Press the round firmly into the tube until the magazine tube guard releases back into position.

This firearm is a "7+1" (7 in the tube and one in the chamber) capacity for the 20" barrel length model, and "9+1" (9 in the tube and one in the chamber) on the 24" barrel length model.



WARNING - HANDLING



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.

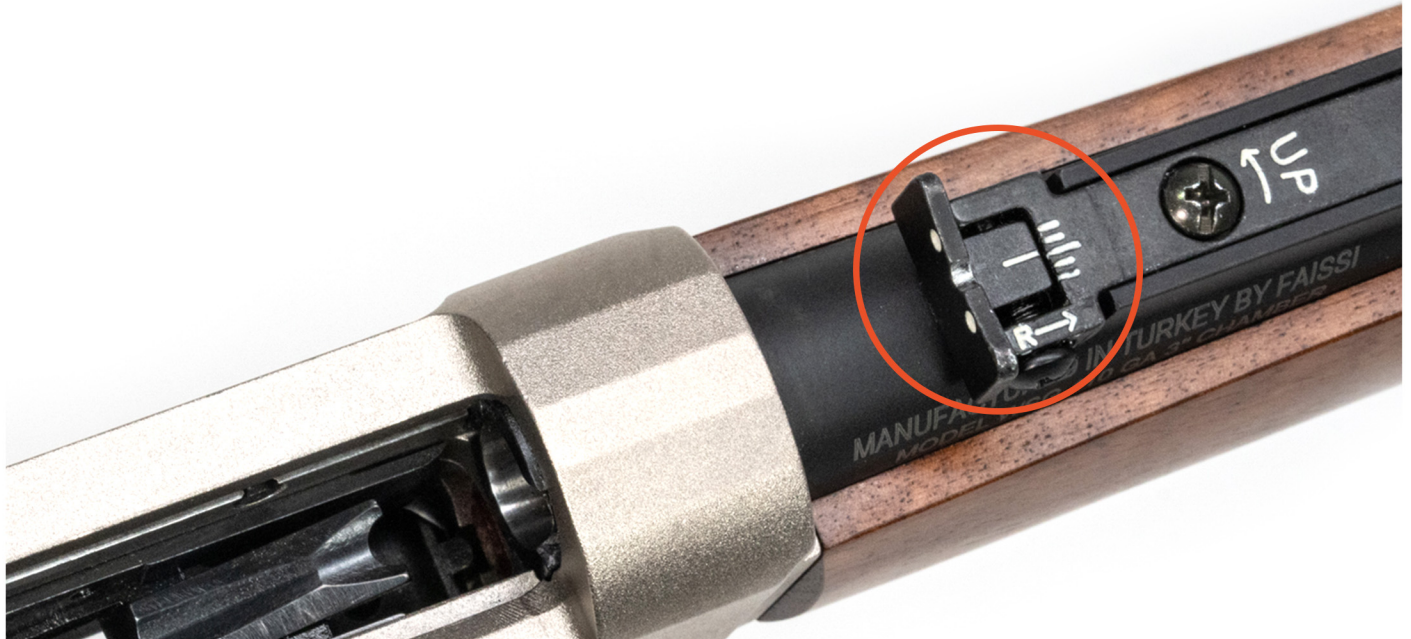
UNLOADING THE FIREARM

Ensure that the lever is released from the body of the firearm to engage the safety and ensure the firearm is pointed in a safe direction. Keep your finger off the trigger. Insert fingers into the lever action and push the lever downward to release a round from the tube. Raise the lever UP to chamber the round while continuing to **KEEP FINGER OFF OF TRIGGER and FIREARM POINTED IN A SAFE DIRECTION**. Press the lever action downward again to eject the undischarged shell and release another shell from the tube. Repeat this process until all undischarged rounds have been removed from the firearm. Visibly check the chamber AND the side loading area to ensure no shells are remaining in the firearm.



ADJUSTING THE SIGHTS

The rear sight has a WINDAGE screw on the right side and an ELEVATION screw on the top. The sight can be adjusted to the RIGHT by turning the WINDAGE screw clockwise, and LEFT by turning it counter-clockwise. Elevation can be lowered DOWN by turning the elevation screw clockwise and raised UP by turning it counter-clockwise.



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.)

SHOULDERING THE FIREARM

Firmly grasp the pistol grip with your right hand and the forend with your left hand. Shoulder the firearm by pulling the recoil pad firmly against your right shoulder.



With your right eye, align the front and rear sights and visually place your sights on your target. Always be sure of your target and anything **BEYOND** your target before placing your finger on the trigger. Release the safety by gripping the lever and pulling it towards the body of the firearm. You are now ready to **FIRE** the firearm. When ready, place your finger on the trigger and pull. To discharge the spent round and chamber the next round, press the lever action downward to eject the discharged shell and raise it to chamber the next round. Repeat as desired until the magazine tube is empty.



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 push the lever action downward. You will be able to remove a jam or misfired shell. Always treat misfired shells with top safety precautions to avoid accidental discharge resulting in bodily injury or death.

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.

DISASSEMBLY PROCEDURES

Step by step instructions to disassemble and re-assemble the GForce Arms GFLVR410 Lever Action Shotgun. If you prefer to watch a video, visit our YouTube channel and watch the video.

STEP 1: ENSURE THE FIREARM IS UNLOADED BY VISIBLY INSPECTING THE CHAMBER AND MAGAZINE TUBE. ALWAYS POINT THE GUN IN A SAFE DIRECTION.



STEP 2: REMOVE THE STOCK BY UNSCREWING THE SCREW AT THE REAR OF THE TANGS BEHIND THE HAMMER ON THE TOP SIDE OF THE GUN.



STEP 3: REMOVE THE LARGE SCREW ON THE LEFT SIDE OF THE RECEIVER.



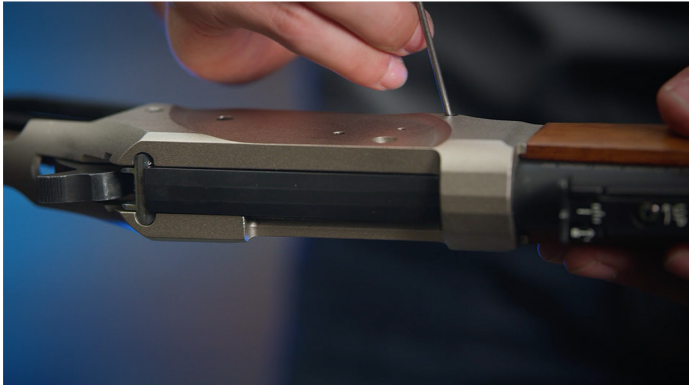
STEP 4: ON THE RIGHT SIDE OF THE RECEIVER, USE A PUNCH TO PUSH OUT THE PIN.



STEP 5: REMOVE THE SCREW ON THE BOTTOM SIDE OF THE FIREARM AT THE FRONT OF THE TANG (IN FRONT OF THE LEVER PIVOT.)



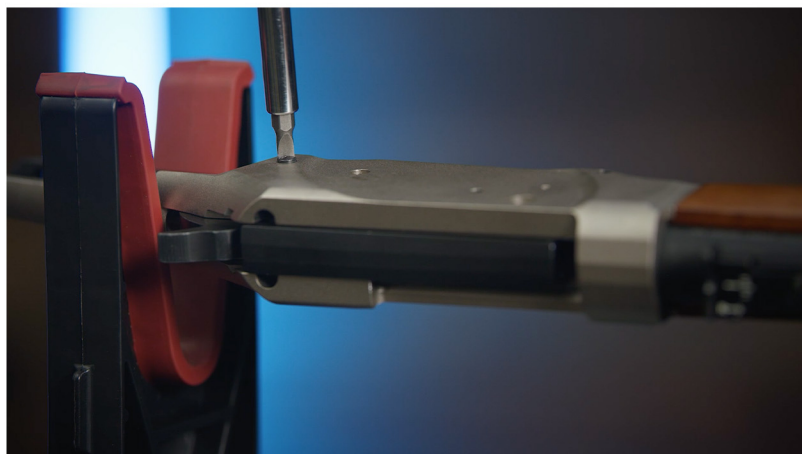
STEP 6: PUNCH OUT THE LEVER ACTION PIVOT PIN. THIS ALLOWS THE LEVER ACTION ASSEMBLY TO BE REMOVED FROM THE RECEIVER.



STEP 7: ON THE LEFT SIDE OF THE FIREARM, THERE ARE TWO REMAINING SCREWS TO BE REMOVED. THE FIRST IS THE LIFTER PIVOT SCREW. REMOVE THAT SCREW AND DROP THE LIFTER OUT OF THE BOTTOM OF THE RECEIVER.



STEP 8: THE SECOND SCREW ON THE LEFT SIDE OF THE RECEIVER TO REMOVE IS THE TRIGGER AND HAMMER RETENTION SCREW. REMOVE THAT SCREW AND DROP THE TRIGGER & HAMMER ASSEMBLY OUT OF THE RECEIVER.



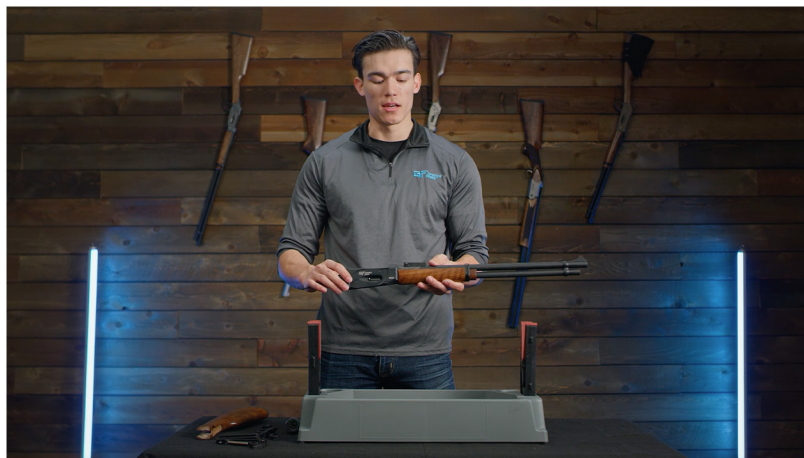
Be very careful to keep the trigger and hammer group intact with the action spring.

There is no need to disassemble the trigger and hammer action for cleaning.

STEP 9: THE BOLT ASSEMBLY CAN NOW BE REMOVED FROM THE FIREARM BY SLIDING IT TOWARDS TO REAR. THE FIRING PIN CAN ALSO BE REMOVED BY SIMPLY TIPPING THE BOLT TO THE REAR. THE FIRING PIN WILL SLIDE OUT OF THE REAR SIDE OF THE BOLT.



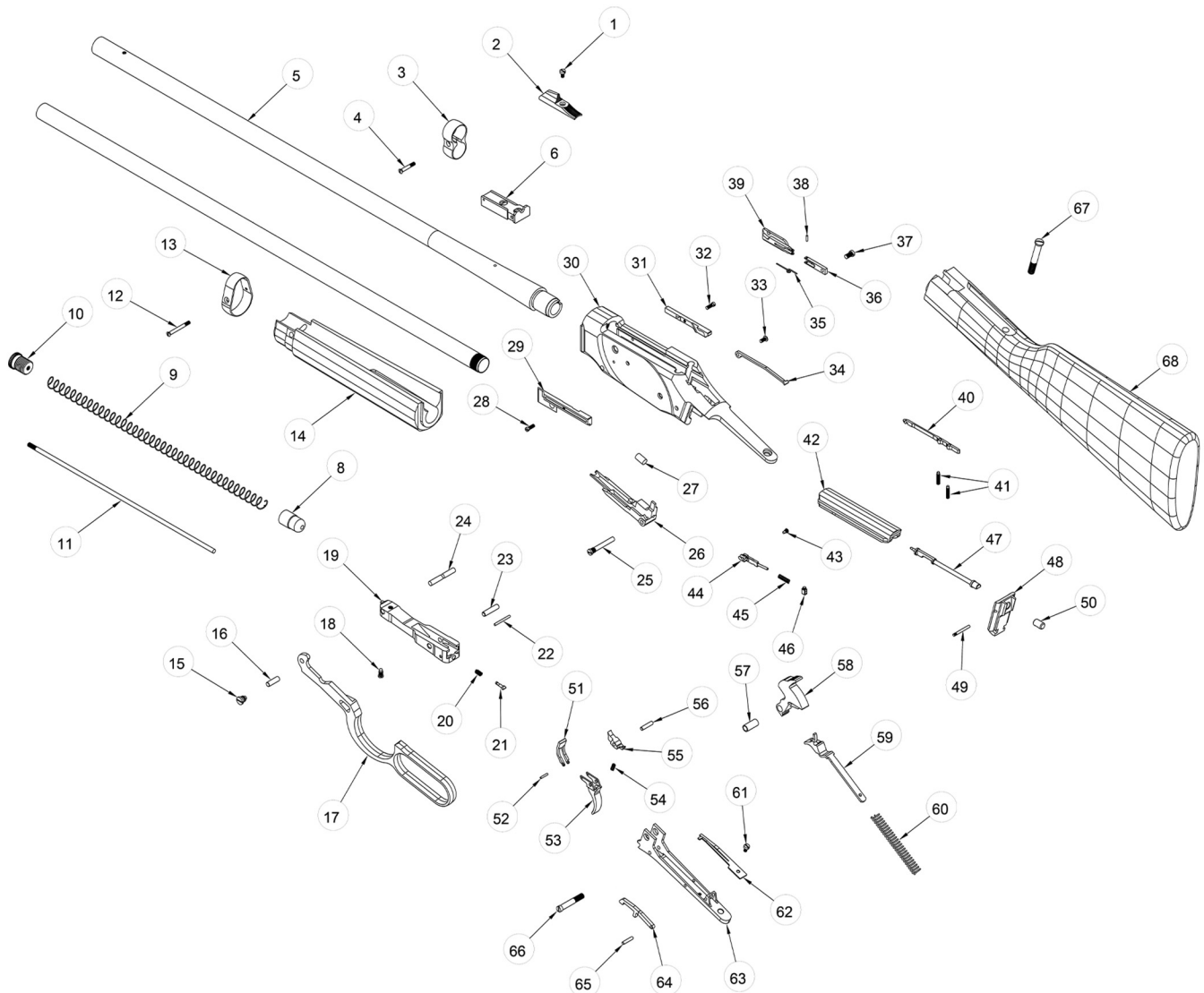
STEP 10: THE FIREARM IS NOW DISASSEMBLED AND READY FOR A DEEP CLEANING.



REASSEMBLY PROCEDURES

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

EXPLODED VIEW



1. FRONT SIGHT FIXING SCREW
2. FRONT SIGHT
3. MAGAZINE TUBE SUPPORT
4. MAGAZINE TUBE SUPPORT FIXING SCREW
5. BARREL
6. REAR SIGHT
7. MAGAZINE TUBE
8. FOLLOWER
9. MAGAZINE SPRING
10. MAGAZINE TUBE COVER
11. CARTRIDGE LIMITER
12. FOREARM CAP FIXING SCREW
13. FOREARM CAP
14. FOREARM
15. LEVER PIN FIXING SCREW
16. LEVER PIN
17. LEVER
18. BOTTOM COVER SCREW
19. BOTTOM COVER
20. BOTTOM COVER LATCH SPRING
21. BOTTOM COVER LATCH
22. BOTTOM COVER LATCH PIN
23. BOTTOM COVER PIN

24. BOTTOM COVER SCREW FIXING PIN
25. CARRIER PIN
26. CARRIER
27. CARRIER MAGNET
28. LEFT CARTRIDGE ROUTER SCREW
29. LEFT CARTRIDGE ROUTER
30. RECEIVER
31. RIGHT CARTRIDGE ROUTER SCREW
32. RIGHT CARTRIDGE ROUTER
33. CARRIER PLATE SCREW
34. CARRIER PLATE
35. LOADING COVER SPRING
36. LOADING COVER PLATE
37. LOADING COVER SCREW
38. LOADING COVER PIN
39. LOADING COVER
40. EXTRACTOR
41. EXTRACTOR FIXING SCREW
42. BOLT
43. SAFETY LEVER
44. EJECTOR
45. EJECTOR SPRING
46. EJECTOR PIN

47. FRONT FIRING PIN
48. LOCKING BLOCK
49. FIRING INITIATOR PIN
50. FIRING INITIATOR
51. TRIGGER SEAR
52. TRIGGER SEAR PIN
53. TRIGGER
54. TRIGGER INSERT SPRING
55. TRIGGER INSERT
56. TRIGGER PIN
57. HAMMER PIN
58. HAMMER
59. HAMMER SPRING ROD
60. HAMMER SPRING
61. TRIGGER GUARD PLATE SCREW
62. TRIGGER GUARD PLATE
63. TRIGGER GUARD
64. SAFETY LEVER
65. SAFETY LEVER PIN
66. TRIGGER GUARD SCREW
67. BUTTSTOCK FIXING SCREW
68. BUTTSTOCK

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.

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

WHY NO WARRANTY CARD HAS BEEN PACKED WITH THIS NEW GFORCE FIREARM

The Magnuson-Moss Act (Public Law 93-637) does not require any seller or manufacturer of a consumer product to give a written warranty. It does provide that if a written warranty is given, it must be designated as "limited" or as "full" and sets minimum standards for a "full" warranty. GForce Arms, Inc. has elected not to provide any written warranty, either "limited" or "full", rather than to attempt to comply with the provisions of the Magnuson-Moss Act and the regulations issued thereunder. There are certain implied warranties under state law with respect to sales of consumer goods. As the extent and interpretation of these implied warranties varies from state to state, you should refer to your state statutes. GForce Arms wishes to assure its customers of its continued interest in providing service to owners of GForce firearms.