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INSTRUCTIONS MANUAL

Models 212-212 TAC-220-228

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

FIREARMS SAFETY

We believe that safe firearms handling is the most important consideration for anyone who uses firearms and ammunition. Please take a few minutes to thoroughly read and understand this instruction manual included with this shotgun.

CAUTION

FIREARMS SAFETY DEPENDS ON YOU!

- Don't rely on your gun's safety. Treat every gun as if were loaded and ready to fire.
- Never cross a fence, climb a tree or jump a ditch with a loaded gun.
- Never load or carry a loaded gun until you intend to use it.
- Watch your muzzle so the other fellow doesn't have to.
- Keep guns and ammunition separately and in locked storage.
- Don't shoot unless absolutely sure of your target and what is beyond it.
- Know the range of your gun.
- Always wear eye and ear protection when shooting.
- Always be sure the barrel is free of obstructions, and only carry ammunition specifically intended for the gun you are using.
- Do not alter or modify your gun. Have your gun regularly checked by a gunsmith.

THIS MANUAL CONTAINS

SAFE GUN HANDLING IS YOUR PERSONAL RESPONSIBILITY AT ALL TIMES. Disregarding warnings in this manual may result in injury or death to you and others and damage to property.

1. Important warnings that should be read and understood before using this firearm.
2. Directions and procedures for handling, loading, firing and unloading.
3. Instructions for care, cleaning, repair, and service of this shotgun.

This instruction and safety manual is designed to help you in learning how to properly use and care for your shotgun. Only when you are certain you have fully familiarized yourself with the function of your firearm should you practice loading, unloading and firing with live rounds of ammunition.

This instruction manual should always accompany this firearm and be transferred with it upon change of ownership. Should you ever need to replace it, this manual is available FREE upon request.

DISCLAIMER OF LIABILITY

We shall not be responsible for product malfunctioning or for physical injury, death or damage to property resulting from either intentional or accidental discharge of this firearm, its criminal or negligent use, improper or careless handling, unauthorized modifications or alteration, use of defective or improper or hand-loaded or (replaced) ammunition, or from its use for purposes or subjection to treatment for which it was not designed. For your safety, use only original high quality commercially manufactured ammunition in good condition that is appropriate to the caliber / gauge of your gun. We shall not be responsible for products or results from use of defective, improper or reloaded ammunition.

WARNING - LEAD EXPOSURE

Discharging firearms in poorly ventilated areas, cleaning firearms, or handling ammunition may result in exposure to lead and other substances that may cause birth defects, reproductive harms, and other serious physical injuries. Have adequate ventilation at all times. Wash your hands thoroughly after exposure. Shooting or cleaning guns may expose you to lead.

WARNING

Prior to removing this gun from its packaging and prior to loading and firing, carefully and thoroughly read the entire instruction manual which gives advice on the gun's proper handling and functioning. Your safety and that of others (including your family) depends on your responsible compliance with that advice. If unfamiliar with firearms, seek supervised instruction.

FIREARMS SAFETY IS YOUR RESPONSIBILITY.

GENERAL SAFETY WARNINGS

1. Careless and improper handling of this gun could result in unintended discharge causing injury, death or property damage. Safety must be the first and constant consideration when handling a firearm and ammunition.
2. This shotgun was designed to function properly in its original condition. Alterations can make it unsafe. Do not alter any part or add or replace parts.
3. Shotguns should only be carried with the action open and chamber empty to prevent accidental discharge.
4. Always handle and treat your gun as if it were loaded so you never fire it accidentally when you think it is unloaded. Never take anyone's word it is unloaded. Always check it yourself with your fingers off the trigger and the gun pointed in a safe direction.
5. Never place your finger inside the trigger guard unless you intend to fire.
6. Water, snow, mud, excessive lubricating oil or grease or any other material can obstruct the barrel of your gun. Always check the barrels of your firearm for obstruction before loading and firing. Clean a fouled gun immediately to ensure its correct and safe function.
7. Keep the gun's muzzle pointed in a safe direction at all times. Never let the muzzle of a firearm point at any part of your body, another person or at anything you do not intend to shoot. Always be certain of your target before firing.
8. UNLOAD ALL FIREARMS WHEN NOT IN USE. NEVER STORE A LOADED FIREARM. Firearms and ammunition should be safely stored separately so that they are inaccessible to children or unauthorized users.
9. Always make sure your gun is not loaded before cleaning, storing, or handing it to another person.

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

11. Always wear ear protection when shooting, especially on a range. Without ear protection the noise from your gun and other guns close to you, could leave a "ringing" in the ears for some time after firing. Repeated exposure to shooting noise could result in permanent hearing loss.

12. Never climb a tree, fence or wall while carrying a loaded firearm.

13. Don't shoot at a hard surface or water. A ricochet may travel in unpredictable directions to strike you or an object you cannot see.

14. Firearms and alcohol do not mix. Never drink alcoholic beverages or take drugs before or during shooting, as this constitutes criminal disregard for your safety and that of others. Never use a gun while you are taking medication unless you have checked with your doctor to ensure your fitness to handle your gun safely.

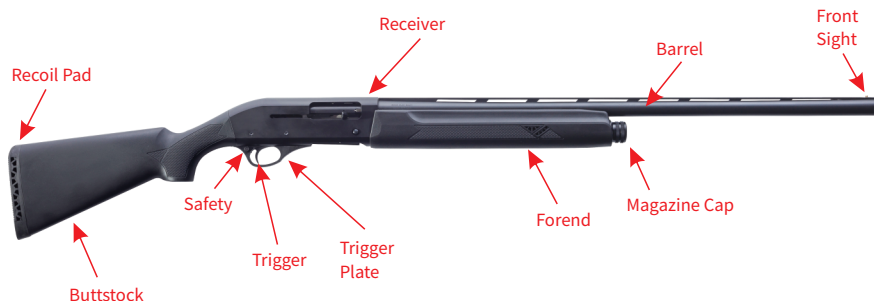
15. If you have any doubts about your ability to handle or use this shotgun safely, seek supervised instruction.

16. Horseplay has no place around firearms. Guns can't think - you can!

17. Remember, safety is your responsibility. Be a safe shooter.

18. FOLLOW THE LAW: Obey all local, state and federal laws regarding storage, shooting and transporting your firearm.

NOMENCLATURE



UNPACKING YOUR SHOTGUN

When you remove the shotgun from its box, you will see the 2 major components, the barrel and the shotgun (Fig.1). Your shotgun comes with a choke tube installed in the barrel along with a choke tube wrench if it is equipped with mobile chokes. A magazine capacity plug should be installed into the magazine or separately located. You should also have an instruction manual in the package.



Fig.1

WARNING

NEVER RELEASE THE BOLT WHILE BARREL NOT INSTALLED.
THIS MAY DAMAGE THE BOLT HANDLE.

ASSEMBLY

1. Unscrew the magazine cap from the front of the forend in a counter clockwise direction as shown in (Fig.2).



Fig.2

2. Remove the forend by sliding it forward, off the shotgun as shown in (Fig.3). Note that the piston should remain in its place.



Fig.3

3. While holding the bolt handle with your right hand, carefully align the barrel with the receiver and the end of the magazine tube, as shown in (Fig.4) and begin to pull back on the bolt handle as you insert the barrel into the receiver.



Fig.4

4. Continue pulling the bolt handle back while inserting the barrel until the bolt is in its rear locked position and the barrel is completely seated in the receiver. The barrel should mate to the receiver at this point in the assembly as shown in (Fig.5).



Fig.5

5. Slide the forend over the magazine tube assembly as shown in (Fig.6), bringing it to rest against the receiver.



Fig.6

6. There are two small tabs in the forend that will align with the small cutout in the front end of the receiver. The forend is in its proper position when it is seated completely against and around the receiver as shown in (Fig.7).



Fig.7

7. Reattach the magazine cap to the magazine tube by rotating it in a clockwise direction until it is firmly screwed down against the forend as shown in (Fig.8).



Fig.8

8. The shotgun is now completely assembled. To close the bolt/action, depress the action release button as shown in (Fig.9). Check, to be sure no fingers or other objects are located near the bolt as it closes. Put the safety in the “ON” position!



Fig.9

CAUTION

Do not load your shotgun until you are ready to use it and unload it immediately after you have finished shooting. Always carry your shotgun with the safety engaged. The user of this shotgun, and all firearms, should never depend on the manual safety, or any other mechanical device, to make a firearm completely safe. It is your responsibility to always keep the muzzle of your firearm pointed in a safe direction.

OPERATING INSTRUCTIONS

WARNING: READ AND UNDERSTAND ALL INSTRUCTIONS AND WARNINGS IN THIS MANUAL BEFORE USING THIS SHOTGUN. IT IS IMPORTANT TO LEARN THE PARTS OF YOUR SHOTGUN AND THEIR FUNCTIONS BEFORE USING THIS FIREARM.

MANUAL SAFETY

Your shotgun is equipped with a manual trigger block safety button located in the trigger guard, just behind the trigger (Fig.10). When the button is pushed from the left side of the receiver, protruding to the right side, the trigger is blocked and the safety is on.



Fig.10

When the button is pushed from the right side of the receiver, protruding to the left side, you will see a red circle on the safety button indicating the safety is off and the shotgun is in an unsafe condition, ready to fire if the trigger is pulled, as shown in (Fig.11). The directions are opposite for left hand shotguns.



Fig.11

CAUTION

The manual safety of your shotgun should always be on except for when you are ready to pull the trigger and fire the shotgun. This will help insure that no accidental discharges take place. You should only have the safety off, and be able to see the red line on the left side of the receiver, when you are ready to shoot. (The directions are opposite for left hand shotguns.)

MULTI CHOKE TUBES

All semi-auto shotguns, except slug models, equipped with interchangeable multi choke tube. The notches on the top of the tube can identify the choke tube (Fig.12).

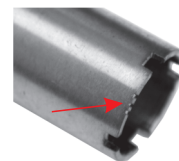


Fig.12

Multi-Choke Tube Markings and Constrictions

Name	Constriction Inch mm	Notches	Markings
Cylinder	.000" 0.00		C
Skeet	.005" 0.13		S
Improved Cylinder	.010" 0.25		IC
Modified	.020" 0.51		M
Improved Modified	.025" 0.64		IM
Full	.035" 0.89	I	F

WARNING: PERIODICALLY CHECK TO BE SURE THE CHOKE TUBES ARE TIGHT & PROPERLY SEATED.

Before changing a choke tube, always make sure that your shotgun is unloaded and the safety is in the "Safe" position. To change the choke tubes, use the choke tube wrench. The wrench and additional chokes are supplied in the shotgun box. Insert the wrench into the recessed space of the tube and unscrew counterclockwise. Insert the desired choke tube and seat with the wrench in the clockwise direction (Fig.13).

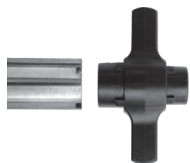


Fig.13

WARNING: NEVER FIRE YOUR SHOTGUN WITHOUT A CHOKE TUBE INSTALLED. This could damage the choke tube threads on the inside of the barrels.

WARNING

Your shotgun is equipped with an o-ring inside the gas cylinder enabling it to cycle properly with light loads. It can be removed to reduce the recoil force when shooting with heavy loads.

AMMUNITION

Use only high quality factory ammunition specifically designed for your gauge of shotgun. The gauge and chamber are marked on barrel. The shells that can be used for each gauge are listed at below table. We do not recommend using slugs with choke tubes tighter than improved cylinder.

WARNING: STEEL SHOT USAGE

Your shotgun will accommodate steel shot. However steel shot (up to and including shot size #2) should not be fired through your shotgun with a choke tighter than modified. If shot larger than #2 is used, the tightest choke used should be an improved cylinder. Do not use steel shot with improved modified, full or extra full choke tubes (flush mount or external).

WARNING: ACCIDENTAL LOADING AND DISCHARGE OF SHELLS OF THE WRONG GAUGE IN YOUR GUN CAN RESULT IN DAMAGE TO YOUR GUN AND INJURY TO THE SHOOTER OR OTHERS.

Only carry the proper ammunition with you when shooting.

LOADING

When loading, keep the safety on at all times and keep the muzzle pointed in a safe direction.

Gauge & Chamber		Shells can be used			
12/76	12Ga 3"	12/70	12Ga 2 ¾"	12/76	12Ga 3"
12/89	12Ga 3 ½"	12/70	12Ga 2 ¾"	12/76	12Ga 3"
20/76	20Ga 3"	20/70	20Ga 2 ¾"	20/76	20Ga 3"
28/70	28Ga 2 ¾"	28/70	28Ga 2 ¾"		

Do not use a cartridge that is longer than the maximum cartridge length that is stamped on the barrel.

To load the magazine, turn the shotgun upside down. Insert your cartridge and push it into the magazine tube until it is held in place in the tube by the cartridge latch. As you insert each cartridge you will hear a "click" that tells you the latch has closed behind the cartridge and you can now load the next shell (Fig.14).



Fig.14

Note: Your shotgun is equipped with a plug that limits the number of cartridges that your magazine tube will hold to 2 shells. Removal and installing of the plug is shown in this manual in the DISASSEMBLY section.

To load a cartridge into the chamber, pull back on the bolt handle. As you pull the bolt handle fully rearward, a cartridge will come out of the magazine tube and the cartridge carrier will raise the shell aligning it with the chamber. Release the bolt handle and the forward travel of the bolt will chamber the first round (Fig.15). Never allow your fingers or another object to come in contact with the trigger while loading.



Fig.15

Your shotgun is now loaded and ready to fire if the safety is moved to the OFF position.

FIRING

To fire the shotgun, hold the shotgun firmly with both hands and the proper placement of the butt stock to your shoulder and cheek. Aim at your target. Press the safety button into the OFF position and pull the trigger.

The system that operates your semi-auto will fire the cartridge in the chamber, eject the fired case and load the next cartridge into the chamber, each time that you pull the trigger. Be prepared to either fire your next shot or engage the safety in the ON position after firing.

UNLOADING

Before unloading, make sure the safety is in the ON position. And keep the muzzle pointed in a safe direction. Never allow your fingers or another object to come in contact with the trigger during unloading.

Pull the bolt handle completely to the rear and this will eject any cartridge that is remaining in the chamber.

Close and open the bolt repeatedly to chamber and then eject all cartridges that may be remaining in the magazine tube or chamber (Fig.16).



Fig.16

Visually check to make sure that no cartridges may be remaining in the chamber or magazine tube and depress the bolt release button to close the action/bolt.

If you want to unload without pulling the bolt handle; turn your gun and press the carrier, press the latch which is the right side of the receiver. The shell, which had been loaded, will eject (Fig.17). Unload the shells by pressing the latch for every one. Be careful not to allow the shot shell to eject onto a hard surface, which may cause the shell to discharge.

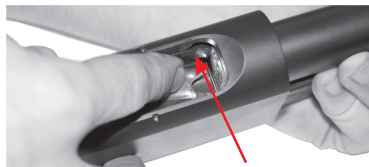


Fig.17

DISASSEMBLY

Before disassembling your shotgun, be absolutely certain that it is unloaded. As an added precaution, visually check the chamber and the magazine tube for any cartridges. Put the safety in the on position.

1. Remove the magazine tube cap by unscrewing it counter clockwise (Fig.18).



Fig.18

2. Remove the forend by sliding it away from the receiver and off the end of the magazine tube (Fig.19).



Fig.19

3. Remove the barrel by pulling the barrel out of the receiver assembly and out from around the magazine tube (Fig.20).



Fig.20

4. Remove the gas piston and piston buffer (Fig.21).



Fig.21

5. You can remove the bolt handle by moving the action bar rearward under spring tension with your left hand, until the bolt moves enough for you to align it with the cutout hole in the bolt that receives the handle. At this point, the bolt handle can be freely removed from the bolt (Fig.22). Remember that the bolt is still under tension from the spring.



Fig.22

6. After you remove the bolt handle, the entire action bar/bolt assembly and action bar sleeve can be removed from the shotgun by pulling the action bar off the end of the magazine tube (Fig.23).

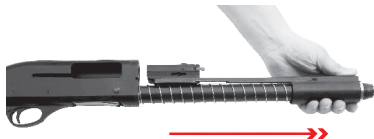


Fig.23

7. Remove the magazine spring from around the magazine tube (Fig.24).



Fig.24

8. The action bar, action bar sleeve and bolt assembly can be separated for cleaning. Lift the bolt off the action bar by simply pulling it up and off the bar (Fig.25).

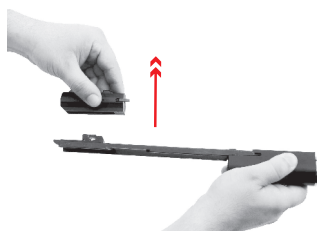


Fig.25

9. Separate the action bar from the action bar sleeve by pulling the action bar up and away from the action bar sleeve as shown in (Fig.26).

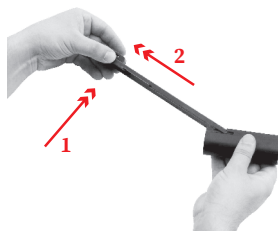


Fig.26

10. The trigger group may be removed from the receiver for further cleaning of the receiver and trigger group. It is recommended that a thorough cleaning be performed every 300 rounds.

To remove the trigger group, first remove the two trigger group retaining pins by using a punch to drive the pins out of the receiver (Fig.27).



Fig.27

11. Once the retaining pins are removed, the entire trigger group can be removed from the receiver by pulling down on the trigger guard (Fig.28).



Fig.28

No further disassembly of the trigger group is recommended for anyone other than a trained gunsmith.

12. When reinstalling the trigger group, the hammer must be in its cocked position. To cock the hammer, pull down on the hammer with your thumb until it locks into place as shown in (Fig.29).

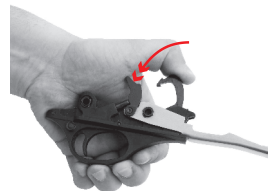


Fig.29

MAGAZINE CAPACITY PLUG

Your shotgun is supplied with a plug to limit the capacity of cartridges in the magazine tube. Your country's regulations may not require this plug to be used so it may be removed.

When the barrel is removed from the shotgun, hold the magazine spring retainer with one of hand and push it down gently. With the other hand, press in the slot on the magazine tube with a screwdriver and push it upwards (Fig.30).



Fig.30

Be careful at this point, as the retainer holds a spring inside of the magazine tube and the spring is under tension. To replace the retainer plug, align the tab on the plug so that it clicks into place and push.

Your shotgun has now been completely disassembled. No further disassembly of your shotgun is necessary for routine maintenance and cleaning. Our service department or a competent gunsmith should only perform any further disassembly.

An exploded view of the disassembled shotgun is shown in (Fig.31).

Note: Photographs shown in this manual may not be from the exact model that you have but the instructions will apply to the model you have.

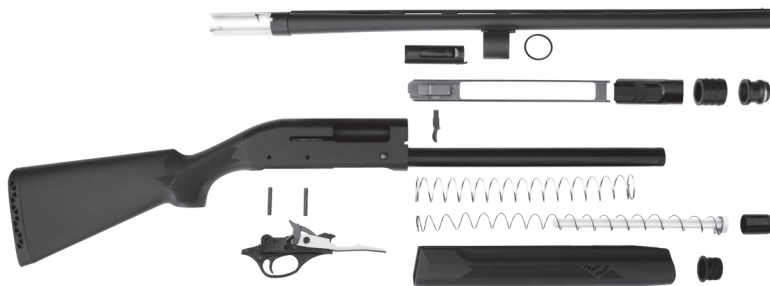


Fig.31

CLEANING AND STORAGE

After extended shooting sessions, it will be necessary to clean your shotgun. Semi-auto shotguns require more cleaning than any other type of shotgun, because of their gas operated construction.

Periodically, clean the bore with proper cleaning equipment. Oil all metal surfaces lightly with high quality gun oil. Never pour oil into any inside mechanisms.

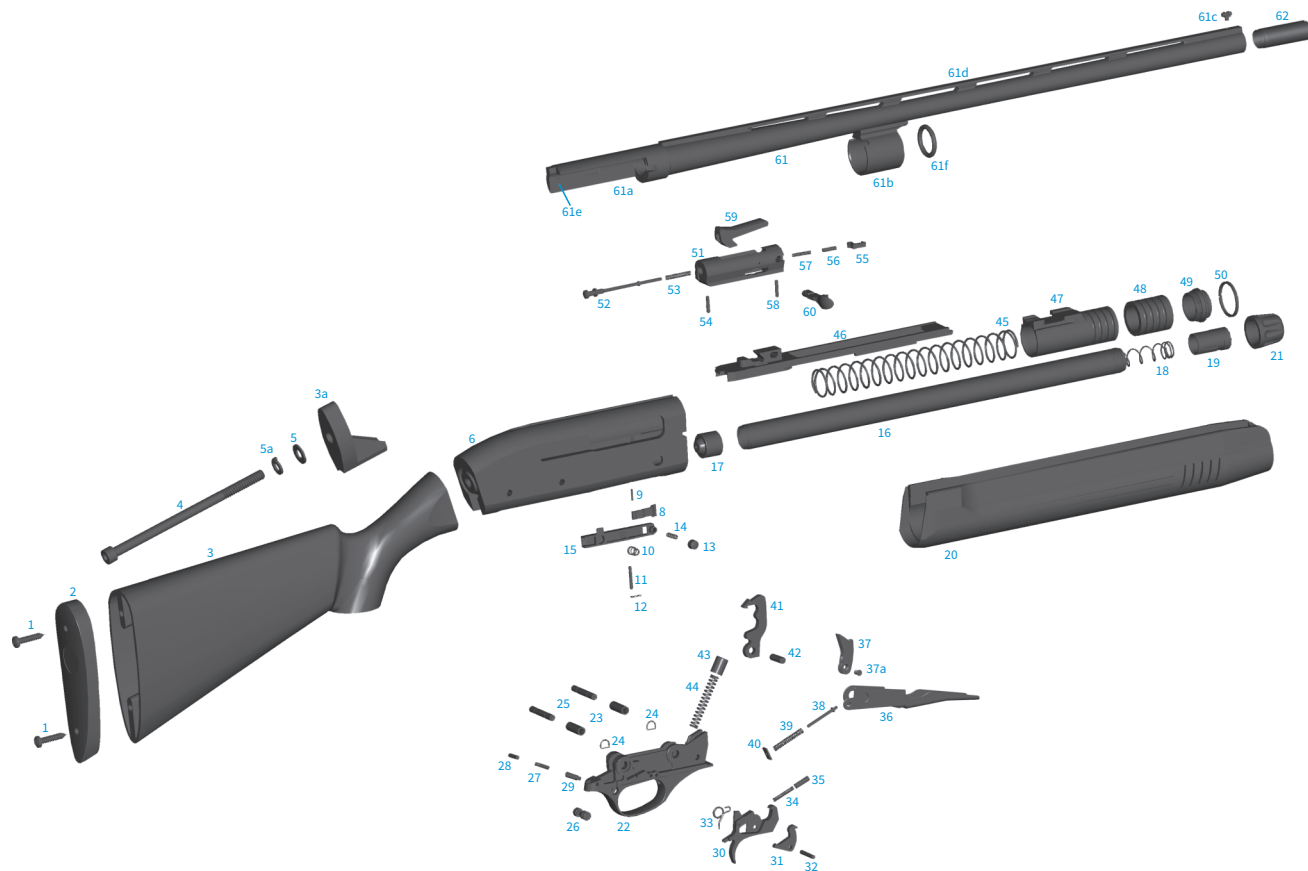
If you will be storing your shotgun for long periods of time, apply gun grease to all metal parts, store the shotgun in a dry, and secure area. When you clean the shotgun, make sure the muzzle is not plugged with any heavy grease that would cause a barrel obstruction.

SERVICE INSTRUCTIONS

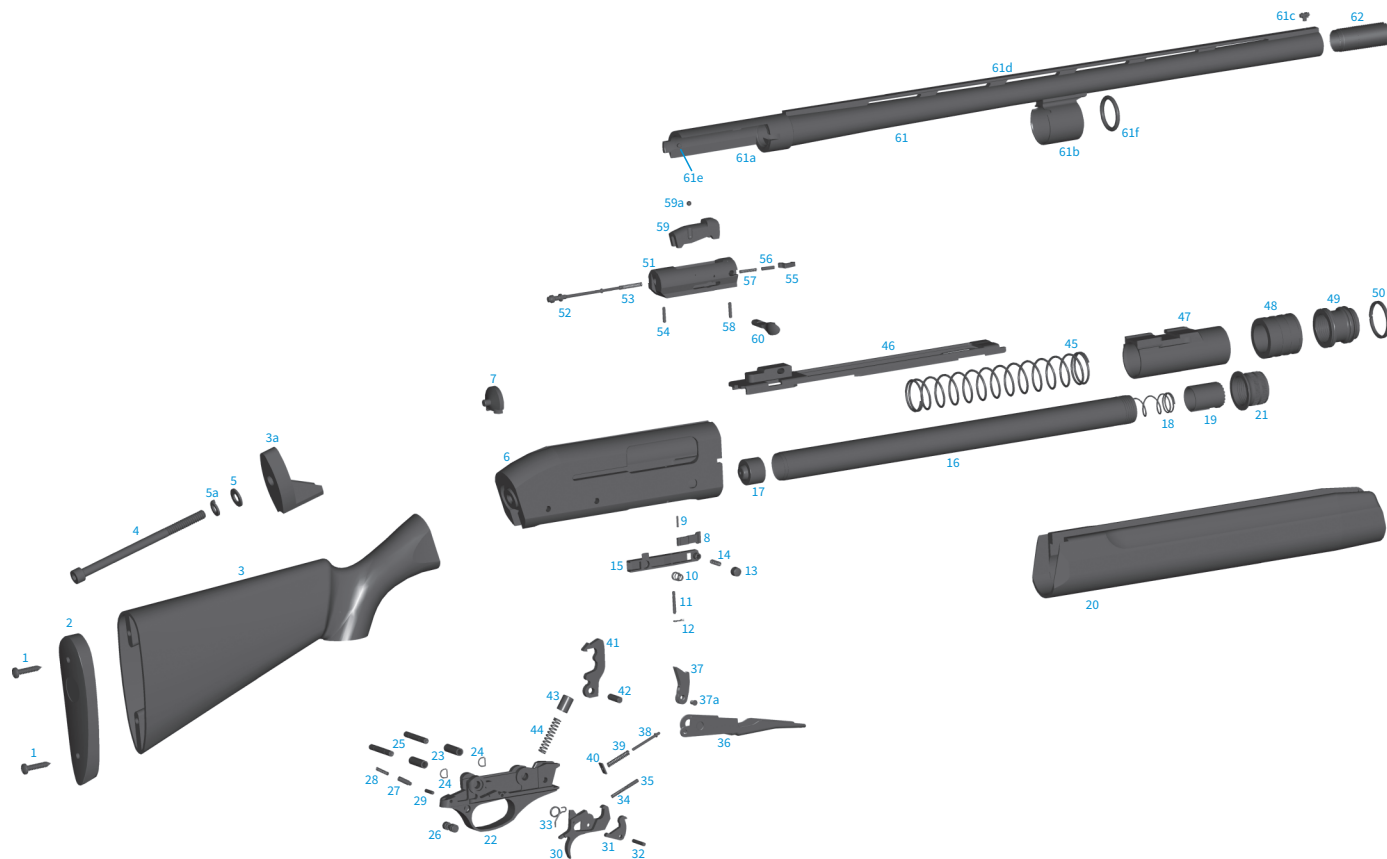
If your shotgun does require service, contact our local service department by e-mail, letter, fax or telephone. If you should ever have to send your shotgun back for repair please follow these instructions:

- a) Make absolutely certain it is unloaded;
- b) Do not send ammunition with your shotgun;
- c) Remove any accessories;
- d) Please package the gun securely (be certain gun parts can not shift during shipment) in a suitable shipping container;
- e) Please include, with your firearm, a clear description of the problem and service you wish us to perform;
- f) Please give us a clear ship-to address, (no P.O. Box numbers) your daytime phone number and if possible a fax number and email address;
- g) Please place your correspondence inside the package;
- h) If you have any questions, please contact the service department, at;

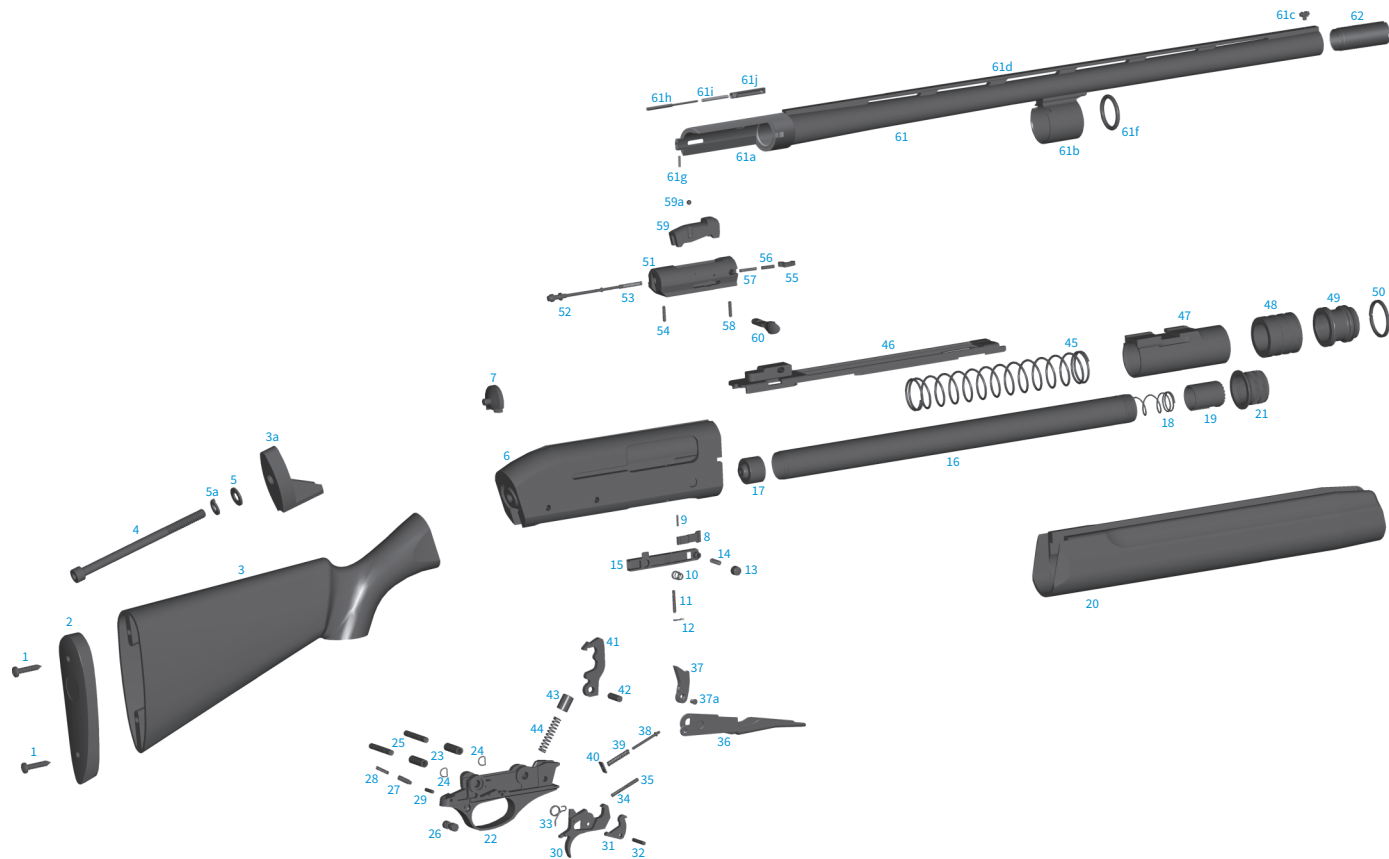
MODEL 228 SEMI AUTO SHOTGUN PART DIAGRAM



MODEL 220 SEMI AUTO SHOTGUN PART DIAGRAM



MODEL 212 SEMI AUTO SHOTGUN PART DIAGRAM



MODELS 212 - 220 - 228 SEMI AUTO SHOTGUN PART LIST

NO PART NAME

1	Recoil Pad Screw (x2)
2	Recoil Pad
3	Stock
3a	Stock Inner Frame
4	Stock Screw
5	Stock Screw Washer
5a	Washer Stopper
6	Receiver
7	Bolt Recoil Pad
8	Latch Tip
9	Latch Tip Pin
10	Latch Spring
11	Latch Pin
12	Latch Pin Detent Spring
13	Action Release Button
14	Action Release Button Spring
15	Latch
16	Magazine Tube
17	Magazine Follower
18	Magazine Spring
19	Magazine Spring Retainer
20	Forend
21	Magazine Cap
22	Trigger Plate
23	Trigger Plate Pin Bushing (x2)

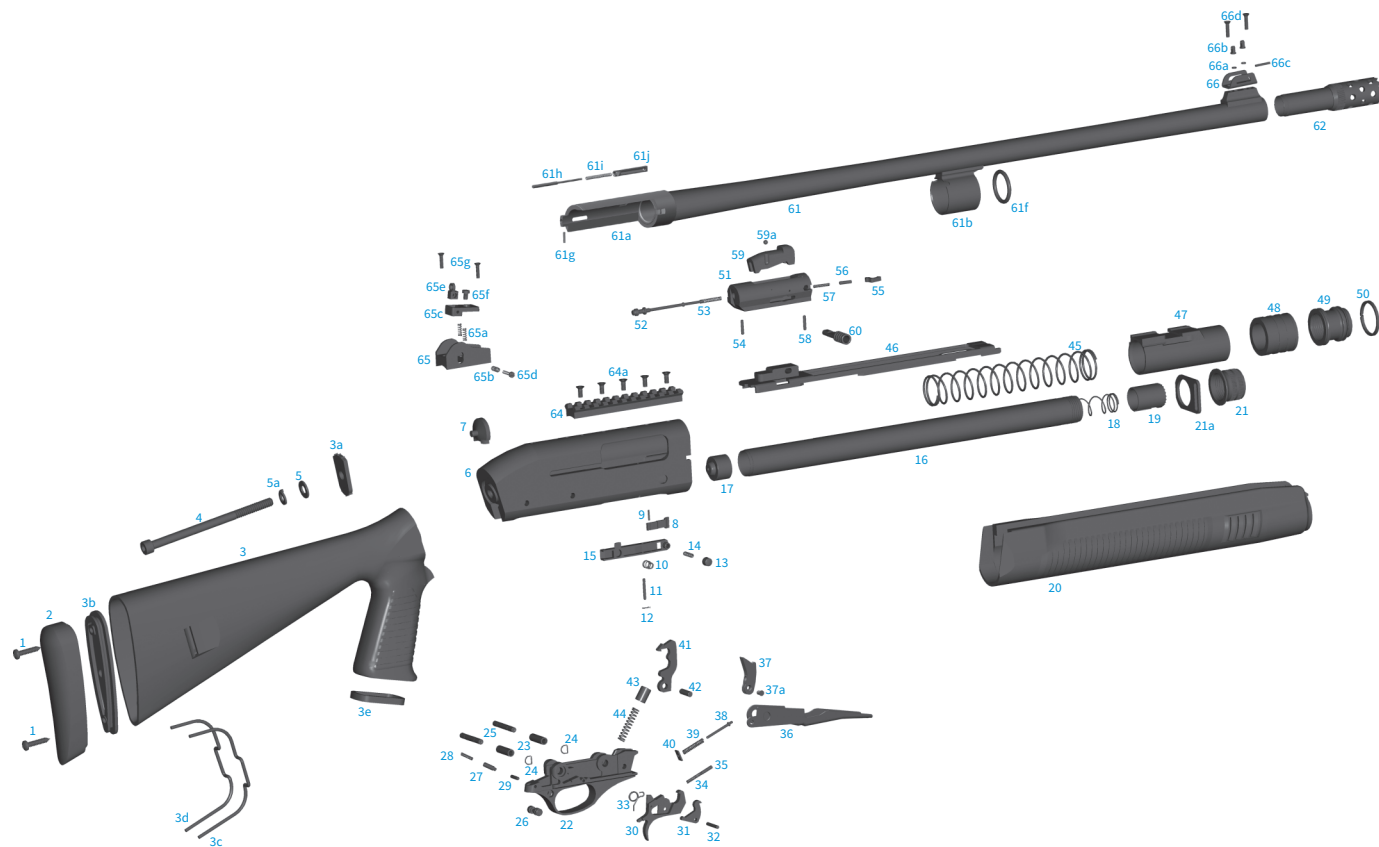
NO PART NAME

24	Trigger Plate Pin Detent Spring (x2)
25	Trigger Plate Pin (x2)
26	Safety Button
27	Safety Button Detent Pin
28	Safety Button Spring
29	Safety Spring Retaining Pin
30	Trigger
31	Trigger Sear
32	Trigger Pin
33	Trigger Spring
34	Trigger Sear Detent Spring
35	Trigger Sear Detent Pin
36	Carrier
37	Carrier Dog
37a	Carrier Dog Pin
38	Carrier Dog Follower
39	Carrier Dog Follower Spring
40	Carrier Dog Follower Plate
41	Hammer
42	Hammer Pin
43	Hammer Plunger
44	Hammer Spring
45	Action Spring
46	Action Bar
47	Action Bar Sleeve

NO PART NAME

48	Piston Buffer
49	Piston
50	Piston Seal
51	Breech Bolt
52	Firing Pin
53	Firing Pin Spring
54	Firing Pin Retaining Pin
55	Extractor
56	Extractor Plunger
57	Extractor Spring
58	Extractor Pin
59	Locking Block
59a	Locking Block Ball
60	Bolt Handle
61	Barrel
61a	Barrel Rear Part
61b	Barrel Collar
61c	Front Sight
61d	Top Ventilated Rib
61e	Ejector Pin
61f	O-Ring
61g	Ejector Block Pin
61h	Ejector Spring Guide
61i	Ejector Spring
61j	Ejector
62	Mobile Choke

MODEL 212 TAC SEMI AUTO SHOTGUN PART DIAGRAM



MODEL 212 TAC SEMI AUTO SHOTGUN PART LIST

NO PART NAME

1	Recoil Pad Screw (x2)
2	Recoil Pad
3	Stock
3a	Stock Connection Part
3b	Recoil Pad
3c	Sling Attachment R.H.
3d	Sling Attachment L.H.
3e	Stock Bottom Cap
4	Stock Screw
5	Stock Screw Washer
5a	Washer Stopper
6	Receiver
7	Bolt Recoil Pad
8	Latch Tip
9	Latch Tip Pin
10	Latch Spring
11	Latch Pin
12	Latch Pin Detent Spring
13	Action Release Button
14	Action Release Button Spring
15	Latch
16	Magazine Tube
17	Magazine Follower
18	Magazine Spring
19	Magazine Spring Retainer
20	Forend
21	Magazine Cap
21a	Sling Attachment
22	Trigger Plate
23	Trigger Plate Pin Bushing (x2)
24	Trigger Plate Pin Detent Spring (x2)

NO PART NAME

25	Trigger Plate Pin (2)
26	Safety Button
27	Safety Button Detent Pin
28	Safety Button Spring
29	Safety Spring Retaining Pin
30	Trigger
31	Trigger Sear
32	Trigger Pin
33	Trigger Spring
34	Trigger Sear Detent Spring
35	Trigger Sear Detent Pin
36	Carrier
37	Carrier Dog
37a	Carrier Dog Pin
38	Carrier Dog Follower
39	Carrier Dog Follower Spring
40	Carrier Dog Follower Plate
41	Hammer
42	Hammer Pin
43	Hammer Plunger
44	Hammer Spring
45	Action Spring
46	Action Bar
47	Action Bar Sleeve
48	Piston Buffer
49	Piston
50	Piston Seal
51	Breech Bolt
52	Firing Pin
53	Firing Pin Spring
54	Firing Pin Retaining Pin

NO PART NAME

55	Extractor
56	Extractor Plunger
57	Extractor Spring
58	Extractor Pin
59	Locking Block
59a	Locking Block Ball
60	Bolt Handle
61	Barrel
61a	Barrel Rear Part
61b	Barrel Collar
61f	O-Ring
61g	Ejector Block Pin
61h	Ejector Spring Guide
61i	Ejector Spring
61j	Ejector
62	Mobile Choke Tube
64	Picatinny Rail
64a	Picatinny Rail Screw (x4)
65	Rear Sight
65a	Rear Sight Spring (x2)
65b	Rear Sight Adjustment Spring
65c	Rear Sight Plate
65d	Rear Sight Horizontal Adjusting Screw
65e	Rear Sight Ring
65f	Rear Sight Vertical Adjusting Screw
65g	Rear Sight Screw (x2)
66	Front Sight Upper Part
66a	Front Sight O Ring (x2)
66b	Front Sight Fiber Optic Holder (x2)
66c	Front Sight Fiber Optic
66d	Front Sight Screw (x2)



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