

# Maintenance Manual

# ATLAS FORCES

UNIQUE IN EVERY RESPECT



## AR-12

MAGAZINE FED

# ESPOW



UNIQUE IN EVERY RESPECT



[www.atlasforces.com](http://www.atlasforces.com)

# UNIQUE IN EVERY RESPECT



GÜLER WORLD  
INDUSTRY & TECHNOLOGIES INC.

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# UNIQUE IN EVERY RESPECT ABOUT US

Since the day we were established, we, as ATLAS FORCES, have always aimed to keep customer satisfaction at the highest level by establishing a sales network in the defense sector, hunting rifles and military equipment.

We continue to serve with many products that the industry needs, from REWOLD, which is considered to be the best tactical rifle in the world, to shotguns with magazines, bullpups, pumps, semi-automatic shotguns, superpose and single shotguns.

We know how long a skill a defensive weapon requires. We at ATLAS FORCES have a solid industrial heritage that is strengthened by the expertise of our employees and the constant pursuit of innovation in our core technologies. With a sustainable business model, we continue to follow a long-term growth path that will create value for all our stakeholders. Our firearms, each of which is a work of art of a different delicacy, and which takes a long time to manufacture according to its model, passes only through the hands of experienced and expert masters during the time it spends in our factory.

ATLAS weapons are designed for superior performance. The production process relies on the precision of both modern technology and professional craftsmanship to meet the quality our customers expect. Our products have managed to become one of the most recognized brands in the world of firearms for civilians, suppliers and military customers.

Since our inception, we strive to ensure that every product we offer is unmatched in terms of quality, precision and world-class customer service. By making use of our design and production efficiency, we were able to offer our consumers valuable, special and quality products.

We love to produce high quality products and we always care about our suppliers more than any of our competitors. Our belief in the high value placed on reliable self-defense tools has led us to success over the years. As our company continues to grow, our commitment to continuing to deliver quality products, affordability and a level of service unprecedented in the firearms industry remains.

Not only do our firearms work well mechanically, we even test the mechanism parts inside. We believe that the subtleties in the details are important.

Our R&D department always attaches importance to testing in order to design creative, talent-enhancing and logical solutions to the ongoing dynamic challenges encountered in the field. State-of-the-art engineering, manufacturing and quality assurance methods are integrated into leading technologies that ensure the

products we manufacture exceed even the best industry standards. All of our products are rigorously tested in the toughest environments and under extreme conditions. Our unmatched manufacturing standards precede operational field experience leading to the use of tactical accessories.

As important as it is for hunting rifles to work with zero error mechanically, it is extremely important that the stock is accompanied by its perfect unity. A shotgun stock isn't made just to look good. It increases the ability of the forend shooters to observe the target much faster with their rifles, and also affects the success rate of their shots.

Our primary goal is to provide our customers, law enforcement and military personnel with the tools they need to defend their home, family or themselves and fulfill their duties, giving them the advantage they need, and providing optimum security and operational readiness. Everyone wants safety and security for their loved ones. We adopt a management system that provides leadership at all levels, using our workforce, processes and technology effectively to achieve sustainable success.

Producing robust and reliable products with strong target detection is among the priorities that make Atlas Atlas. We are committed to helping the world build self-confidence in defense and security. If the firearm in your hand is 100% suitable for you, you will definitely hit at least 7 out of 10 shots.

A firearm has a highly complex mechanism made up of countless sensitive parts. For example, in order for the trigger mechanism of a shotgun to be durable, the metal parts must fit together perfectly, so each piece is cut with a precision of 1/200 of 1 mm. This is a margin of error less than a hair's thickness. The most important part is where the chamber of the rifle is attached to the mechanism.

For this, the spark etching method is mostly used, which can cut extremely accurately. This reveals the fine workmanship in the production of firearms. Whether the last chamber closes perfectly or not is tested by our expert teams. An important step to prevent accidents from happening when you pull the trigger. We are aware of how and how much skill any firearm requires. Innovative mechanical design, meticulous manufacturing processes and innovative materials used in weapons stand out as the defining features of ATLAS and distinguish the company from other companies in this sector.





## **GENERAL INFORMATION**

## **PAGE**

6

### **SERIAL NUMBER OF THE FIREARM**

6

### **IMPORTANT SAFETY WARNINGS**

6

### **USAGE OF MULTI CHOKE**

17

### **CHOKE TYPES AND BENEFICIAL USAGE**

18

### **PARTS**

19

### **MAINTENANCE AND CLEANING**

19

### **SERVICE AGREEMENT AND LIMITED WARRANTY**

20

### **WARANTY CARD**

21

## GENERAL INFORMATION

This semi automatic shotgun (AR 12 )uses gas pressure from the discharged shell in a precision,spring-loaded mechanism to eject empty shell, and load a new cartridge into the chamber(each time the trigger pulled).The system reduces recoil , and allows the shooter to concentrate on target.

This technologically advanced gas metering system allows you to shot 2 ¾" and 3" shells interchangeably with ammunition of the proper gauge for your shotgun with flawless performance.This and other fine features ensure that your shotgun will be a source of pride and pleasure for many years in forward.For 3 ½" models the metering system allows you to shot heavy 2 ¾" , 3" , 3 ½" shells interchangeably.

## Safety Switch or Button

The safety is designed to stop the trigger mechanism.

Do not rely on your guns 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.

## 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.

## IMPORTANT SAFETY WARNINGS

Be certain this owner's manual is available for reference and is kept with this firearm if transferred to another party. If the manual is lost or misplaced, contact your "Product Service Center" for a free replacement copy, or download a copy from [www.atlasforces.com](http://www.atlasforces.com)

After performing any work on your firearm such as cleaning, adjustments, disassembly, or installation of any accessory, the firearm should be re-checked for proper functioning before firing live ammunition.

Firearms are complicated mechanisms. Any modification, alteration, or improper fitting of parts may result in a dangerous malfunction, damage to the firearm and injury to the shooter and others. The firearm's owner must accept full responsibility for the correct reassembly and functioning of the firearm after any disassembly or replacement of parts.

If you do not understand any of the material in this manual or have any questions, contact your dealer or a qualified gunsmith.

Do not attempt to load or use any firearm until you have read and understood the information contained in its owner's manual. Before handling your firearm, you should learn how it operates and how to maintain it. This includes knowing its basic parts, how the manual safety and other safety features operate, how to safely open and close the action, and how to safely load and unload ammunition from the firearm. Improper use and handling is dangerous and could cause serious injury or death to you or those around you. All users of the firearm must become thoroughly familiar with the instructions in this manual.

As the owner of a firearm, you must undertake the full-time responsibility of safe firearms handling for your own safety and the safety of those around you:

- Keep all firearms and ammunition out of the reach of children.
- Store your firearms and ammunition separately.
- Never store a loaded firearm.
- Never leave a loaded firearm unattended.
- Never transport a loaded firearm in a vehicle.
- Unload your firearm when you have stopped shooting and when you have to climb a tree, fence, cross a slippery surface or have to transport it in a vehicle.
- Do not load your firearm before you are in a place where it is safe to shoot, and keep your finger off the trigger until you are on target and have decided to fire.
- Never shoot at water, rocks or any hard surfaces. Shots may glance off such surfaces and cause injuries.
- Do not use alcohol or drugs before or while handling firearms.
- Do not touch the trigger while the safety button is being engaged or disengaged.

Always point the muzzle of your firearm in a safe direction, regardless of whether the firearm is loaded or unloaded. Always treat every firearm as if it were loaded. Give your firearm to someone with the action open (bolt fully rearward) and safety in the "ON" (SAFE) position, after you verify the firearm is unloaded. Insist on the same procedure when receiving a firearm from someone else. Learn the location of all the safety features of your firearm and how they operate. Wear eye and ear protection when shooting. Shooting without proper ear protection can cause hearing damage. The use of eye protection during any type of shooting is important to protect your eyesight. Due to the heavy recoil of a shotgun, maintain an adequate distance between the rear of the scope (if equipped) and your face at all times. Be certain the scope installation does not interfere with access to, or the proper functioning of the safety.

**!!! WE SPECIFICALLY DISCLAIM ANY RESPONSIBILITY FOR DAMAGE OR INJURY WHATSOEVER OCCURRING IN CONNECTION WITH, OR AS A RESULT OF, THE USE OF FAULTY, OR "REMANUFACTURED," OR HAND-LOADED ( RELOADED) AMMUNITION. ADDITIONALLY, WE DISCLAIM ANY RESPONSIBILITY FOR DAMAGE OR INJURY WHICH RESULTS FROM ANY MODIFICATIONS OR CHANGES THAT ARE NOT A PART OF THE FIREARM AS DELIVERED FROM THE FACTORY.**

Learn to clean your firearm thoroughly and make certain no oil, grease, or other materials are blocking the barrel. Obstructions of any kind can cause damage to the firearm, and may result in serious personal injury to the shooter and/or others nearby. Practice proper firearm maintenance and safety. Make sure all exposed metal surfaces are coated with a thin film of oil, especially after exposure to damp weather. (See proper section of this manual for cleaning instructions). Do not plug barrel or store in a fabric-lined case which will absorb lubricants from the firearm.

Before using after storage, follow complete instructions stated in this manual for refamiliarization with the firearm. A thorough inspection should be performed before going into the field. Have your firearm periodically checked by a qualified gunsmith.

### CONGRATULATIONS!!!

You are now the owner of the Atlas Forces AR12 12-gauge shotgun. Your shotgun has an innovative design and is manufactured from high quality materials. With regularly performed maintenance and the use of proper ammunition it will provide you with many years of service.

In order to achieve the best performance and reliability from your shotgun, please read and fully understand all of the instructions, safety guidelines, and warnings carefully in this manual. Your quality shotgun is enormously reliable and safe unless it is handled in a careless or irresponsible manner.

**REMEMBER:** It is imperative that the firearm handler be fully educated and conscious of the importance of executing proper gun safety rules when operating any firearm.

Before using or firing with any live ammunition you should know and fully understand your shotgun's parts, function, and operating mechanisms. So carefully read and fully understand all of the information about the parts and procedures of using the shotgun safely and effectively.





**Photo 1 -)** Point the gun in safe direction and be sure about that the gun is empty.



**Photo 2 -)** Pull AR 12 charging handle to operation direction then use shell safety kit (yellow part) to make ready your gun disassembling in right way. If you do not use that shell safety kit , you will damage shell carrier ramp absolutely!!



**Photo 3 -)** Turn AR12 muzzle break by using your hand to direction of clockwise until thread on barrel allows to disassemble muzzle completely.



**Photo 4 -)** Your AR12 shotgun is ready to disassemble in right way with that shell safety kit.



**Photo 5 -)** Push takedown pin at the back side of lower frame receiver by a tool or your finger as in the photo.



**Photo 6 -)** Push pivot pin at the front sight of lower frame by a tool or your finger as in the photo.



**Photo 7 -)** You will be able to separate upper and lower frame of your gun after these steps as in the photo easily in right way.



**Photo 8 -)** Use your AR12 Special Wrench Set for starting to disassemble forend of your shotgun.



**Photo 9 -)** You can pull easily forend of AR12 as in the photo ,if you operated the process in Photo 8.



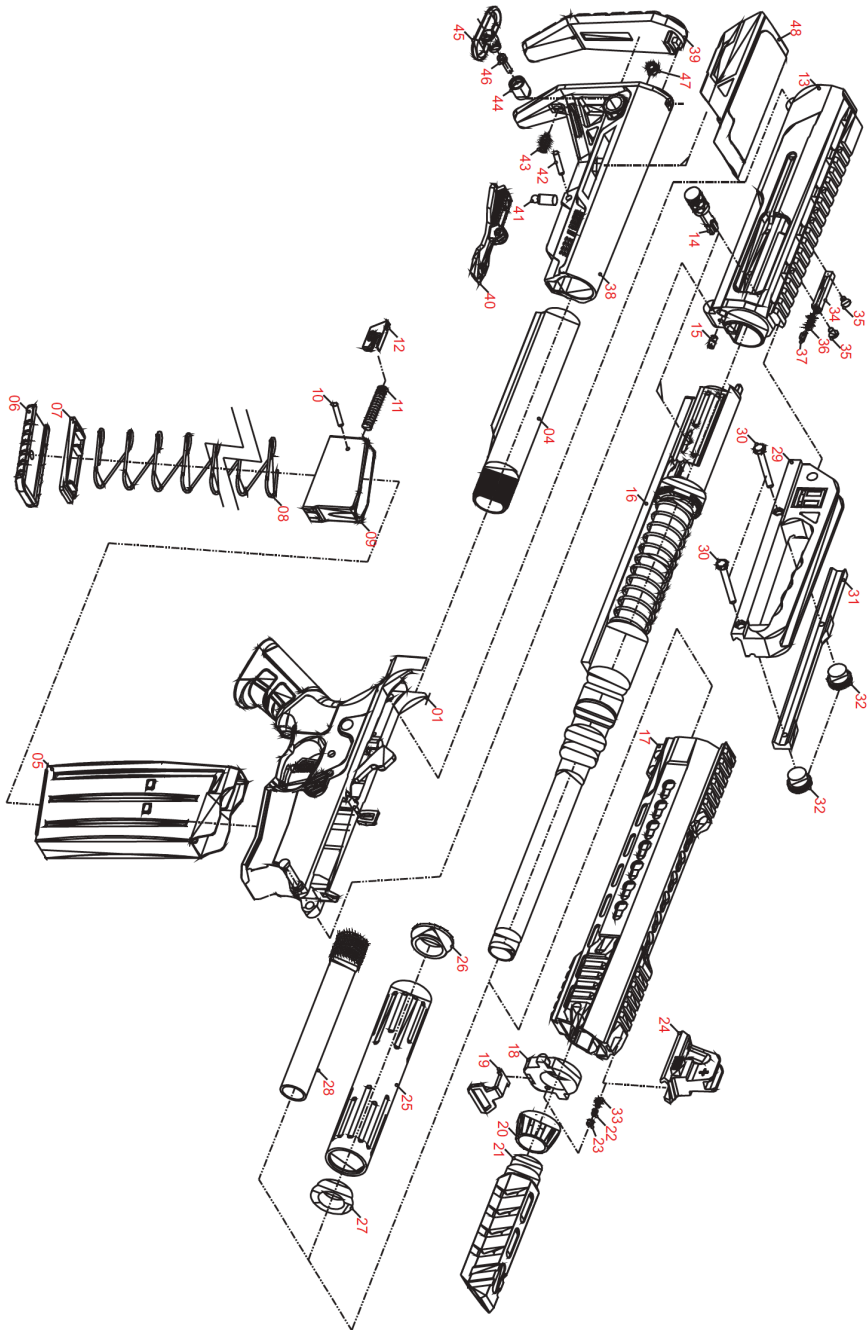
**Photo 10 -)** Unscrew the fixing screws which are on the gas cylinder with 2,5mm allen wrench which are sent you in box



**Photo 11 -)** Use your AR12 Special Wrench Set for turning the barrel nut of your gun.



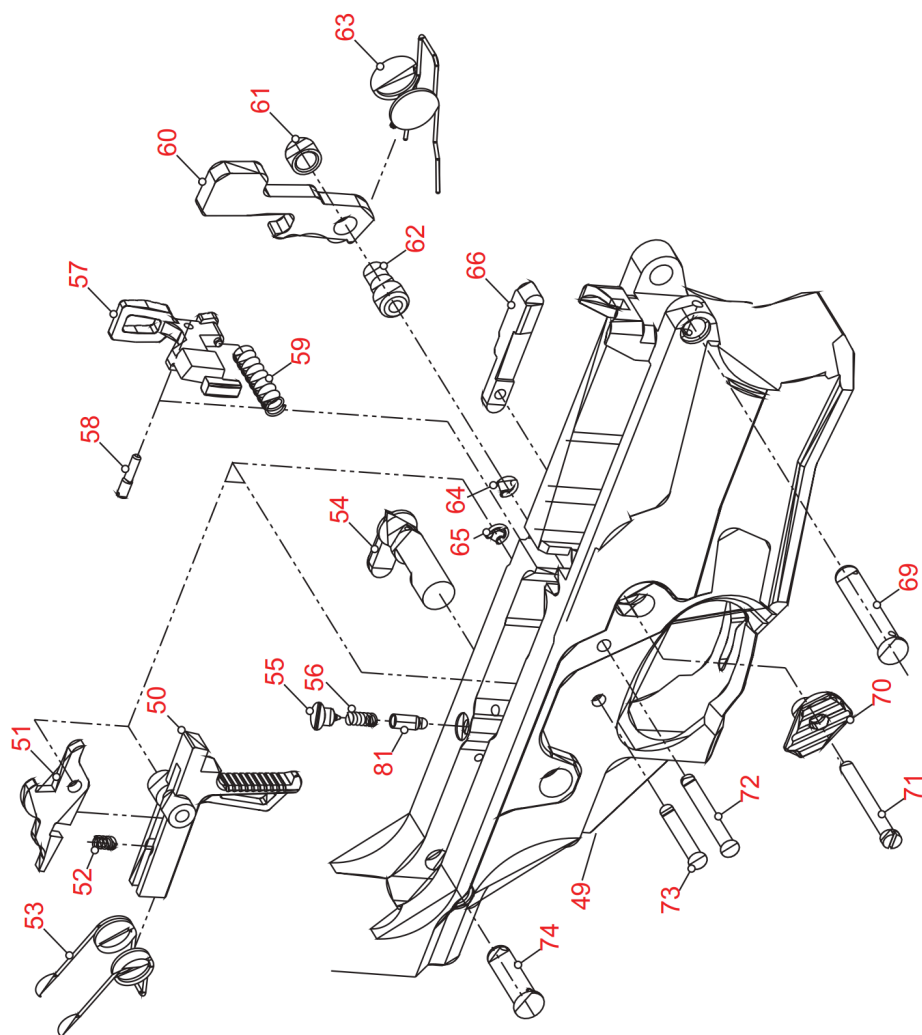
**Photo 12-)** You can disassemble bolt group of AR12 completely after required steps as in the photo easily.



**DIAGRAM OF ATLAS FORCES ESPOW AR12**

## DIAGRAM OF ESPOW AR 12

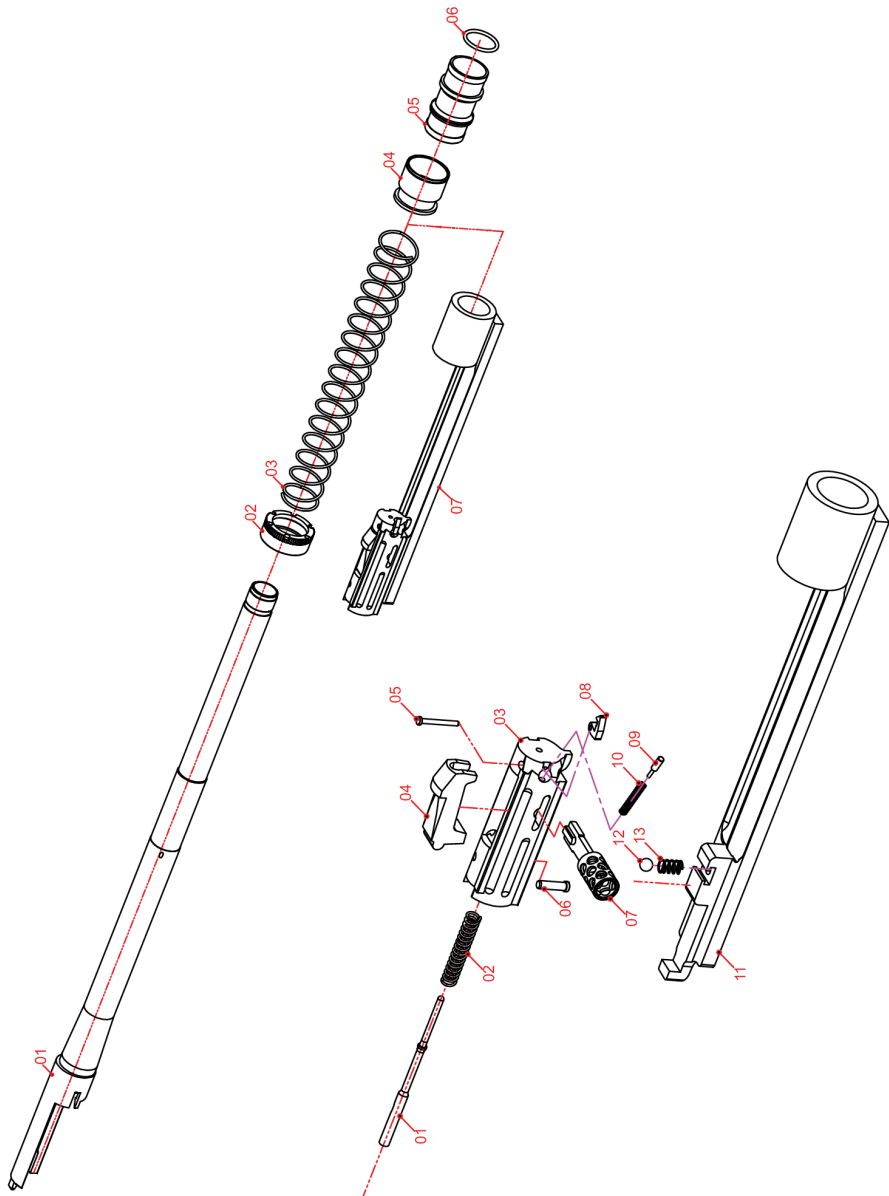
Part Nr	Parts Name	Part Nr	Parts Name
1	AR 12 LOWER FRAME	25	AR 12 SILENCER
2	STOCK END PLATE	26	AR 12 SILENCER BACK SIDE NUT
3	CASTLE NUT	27	AR 12 SILENCER FRONT SIDE NUT
4	6 POSITION BUFFER TUBE	28	EXTENDED CHOKE
5	MAGAZINE	29	ADJUSTABLE REAR SIGHT
6	MAGAZINE BUTTOM PLUG	30	A.R.S SCREW-1
7	SPRING RETAINER APARATUS	31	A.R.S RETAINER CAP
8	MAGAZINE SPRING	32	A.R.S NUT
9	MAGAZINE UPPER PLUG	33	HANDGUARD RETAINER SPRING
10	MAGAZINE UPPER PLUG PIN	34	AR 12 SPRING EJECTOR
11	MAGAZINE SIDE EXTRACTOR SPRING	35	AR 12 SPRING EJECTOR RETAINER SCREW
12	MAGAZINE SIDE EXTRACTOR	36	AR 12 EJECTOR SPRING
13	AR 12 UPPER FRAME	37	AR 12 SPRING EJECTOR RETAINER PIN
14	CHARGING HANDLE	38	AR 12 POSITION ADJUSTABLE STOCK
15	HANDGUARD RETAINER PIN	39	AR 12 RECOIL PAD
16	BARREL GROUP ASSEMBLY	40	STOCK ADJUSTING KIT
17	ALUMINIUM HANDGUARD	41	STOCK RETAINER PIN
18	HANDGUARD RETAINER	42	STOCK ADJUSTING KIT PIN
19	FRONT SWIVEL	43	AR 12 RECOIL PAD SCREW
20	HANDGUARD RETAINER NUT	44	AR 12 SWIVEL HOLE
21	AR 12 FLASHHIDER	45	AR 12 SWIVEL
22	HANDGUARD RETAINER PIN	46	AR 12 SWIVEL SCREW
23	HANDGUARD RETAINER SCREW	47	AR 12 SWIVEL NUT
24	AR 12 FRONT SIGHT	48	AR 12 CHEEK ADJUSTMENT



**DIAGRAM OF ESPOW AR 12 LOWER FRAME**

## DIAGRAM OF ESPOW AR 12 LOWER FRAME

Part Nr	Parts Name	Part Nr	Parts Name
49	AR 12 LOWER FRAME	66	MAGAZINE CATCH
50	TRIGGER	69	PIVOT PIN
51	DISCONNECTOR	70	AR 12 MAGAZINE CATCH BUTTON
52	DISCONNECTOR SPRING	71	MAGAZINE CATCH SCREW
53	TRIGGER SPRING	72	HAMMER PIN
54	SELECTOR SAFETY	73	TRIGGER PIN
55	SAFETY SCREW	74	TAKEDOWN PIN
56	SAFETY SPRING	81	SELECTOR DETENT
57	BOLT CATCH		
58	BOLT CATCH PIN		
59	BOLT CATCH SPRING		
60	HAMMER		
61	HAMMER FIXING KIT-1		
62	HAMMER FIXING KIT-2		
63	HAMMER SPRING		
64	HAMMER PIN SEGMAN		
65	TRIGGER PIN SEGMAN		



**DIAGRAM OF ESPOW AR 12 BARREL GROUP & BOLT GROUP**

## DIAGRAM OF ESPOW AR 12 BARREL GROUP & BOLT GROUP

### BARREL GROUP ASSEMBLY

Part Nr	Parts Name
83	AR 12 STYLE BARREL
84	AR 12 BARREL NUT
85	OPERATION SPRING
86	AR 12 GAS PISTON
87	AR 12 DUAL GAS SYSTEM
88	GAS ROOM O-RING
89	BOLT GROUP ASSEMBLY

### BOLT GROUP ASSEMBLY

Part Nr	Parts Name
90	FRING PIN
91	FRING PIN SPRING
92	BOLT
93	BOLT LOCK
94	EXTRACTOR PIN
95	FIRING PIN RETAINER
96	BOLT HANDLE
97	EXTRACTOR
98	EXTRACTOR SPRING PIN
99	EXTRACTOR SPRING
100	ACTION BAR (CARRIER)
101	CARRIER BALL
102	CARRIER BALL SPRING



## USAGE OF MULTI CHOKE

The purpose of multi(internal) choke is to make barrel's tip narrowed down to shoot far and more collectively or to enlarge barrel's tip to shoot more wider groupment for small shoots.

To change or clean the internal choke, proceed as follows:

- 1) Unscrew the internal choke using the special choke wrench supplied with the shotgun and extract it completely from the barrel seat.
- 2) If the threaded seat of the choke on the barrel is too dirty, clean it.
- 3) Reassemble on the barrel seat the kind of choke required, taking care to insert the nonthreaded part inside the barrel, before screwing the choke on the barrel's thread.

NOTE: when choke is correctly mounted, it must not protrude from the barrel's muzzle.

- 4) Finish the assembly of the choke by screwing it firmly using the choke wrench.

NOTE: before re-using the shotgun, make sure that the choke wrench has been removed from the barrel's muzzle.

Before the shotgun is put away, cleaning the internal choke and relative barrel thread is recommended.

### **WARNING!!!**

Do not use choke values 1-2-3 with slugs , single projectiles. Do not use choke 1 or 2 with steel shot.

### **WARNING!!!**

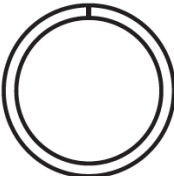
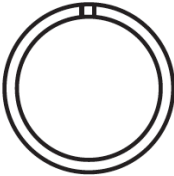
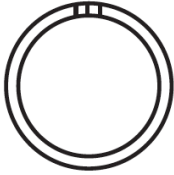
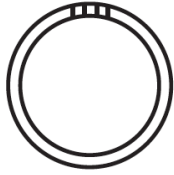
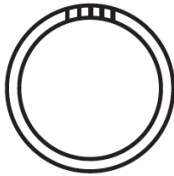
Never shoot steel shot with a full or improved modified cylinder or skeet chokes (marked 3-4-5 cuts respectively).

Do not use full,improved modified and modified (marked 1-2-3 cuts ) with slugs, single bullets or single projectiles.

Never use cartridge with a case longer than the chamber, as this would have serious consequences for bolt the gun and the shooter.Do not use 3 1/2" cartridges (super magnum) in this shotgun.

Never shot without the choke tube fitted on the barrel.

## CHOKE TYPES AND BENEFICIAL USAGE

CHOKE TYPE	SYMBOL	GAME	PELLET SIZE	USEFUL SHOOTING DISTANCE
* 1 FULL		Goose, Duck, Wood Grouse. For long range hunting with lead shot and tight groups	1-2-3	50-60 Metres
** 2 IMPROVED MODIFIED		Duck, Pheasant, Wood Grouse, Rabbit	4-5-6	41-44 Metres
*** 3 MODIFIED		Partridge, Pheasant, Quail, Pigeons, Woodcock For long range hunting with lead shot and tight groups.	5-6-7-8	31-41 Metres
**** 4 IMPROVED CYLINDER		Quail, Dove and target shooting For shooter distance more open shooting	7-8 9-10-11-12	30-35 Metres
***** 5 CYLINDER		For sporting clay and skeet shooting. Short distances more open shooting.	7-8 9-10-11-12	20-30 Metres

## PARTS

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

## MAINTENANCE AND CLEANING

**LUBRICATION WARNING:** Firing a shotgun with oil, grease, or other debris partially obstructing the bore may result in damage to the firearm or injury to the shooter and those nearby. Before firing make sure the bore and chamber of the barrel is unobstructed and dry. Never spray or apply lubricant on shotshells. Firing another shotshell behind an obstruction may damage the shotgun and cause death or injury. Only use lubricants properly and sparingly. You are responsible for the proper care and maintenance of your shotgun.

1. Disassemble your shotgun.
2. Using a proper cleaning rod, run a solvent-wetted patch through the bore several times. This will then be followed by running dry patches through the bore to remove any debris or residue.
3. If the bore is leaded to the extent that the above patch cleaning procedure did not remove the lead, then scrub the bore full length with a solvent-wetted brass bristle brush. When the leading is loose then repeat step #2.
4. The surfaces of bolt carrier, ejector, and inside surfaces of the receiver should be coated very lightly with non-penetrating lubricating oil.
5. Reassemble the shotgun and wipe the exterior metal surfaces sparingly with an oiled cloth. Swab the bore with an oily patch before storing the firearm.
6. Place the shotgun in a safe, locked storage space where unauthorized persons cannot access the firearm. Never store the shotgun in a leather case as leather attracts moisture even though it may appear dry.
7. Never fire your gun without choke tubes snugly tightened in barrels. Do not over tighten choke tubes. Wipe all exposed metal surfaces with an oiled cloth before storing. Do not squirt or pour oil into the inside mechanism because it may cause deformation.

## **SERVICE AGREEMENT AND LIMITED WARRANTY**

Atlas Forces Defence 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 Atlas Forces Defence Industries 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 Atlas Forces Defence Industries makes no warranties, express or implied.

Atlas Forces Defence will repair or replace any unserviceable part(s) for two (2) year from date of purchase and further will supply free parts (Wood not included) for an additional two (2) years in accordance with the above warranty statement provided your firearm had not been altered, abused, willfully damaged, or damaged by overpressure 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 Atlas Forces Defence Industries.

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

**WARANTY CARD**

NAME OF PURCHASER: \_\_\_\_\_

ADRESS OF PRUCHASER: \_\_\_\_\_

CITY: \_\_\_\_\_ STATE: \_\_\_\_\_ ZIPCODE: \_\_\_\_\_

MOBILE PHONE: \_\_\_\_\_

PURCHASE DATE: \_\_\_\_\_

PRODUCTMODEL/NUMBER: \_\_\_\_\_

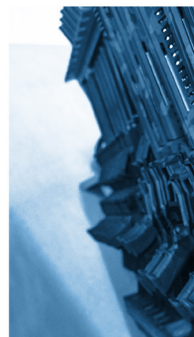
GAUGE: \_\_\_\_\_ SERIAL NUMBER: \_\_\_\_\_

PURCHASEPRICE: \_\_\_\_\_

STORE NAME: \_\_\_\_\_

SIGNATURE: \_\_\_\_\_







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## ATLAS FORCES

### CONTACT INFORMATION

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