1. BRIEF HISTORY

The founder of Ata Arms the gifted craftsmen Celal YOLLU has begun writing his success story in the very heart of Anatolia as follows...

He has discovered his talent in mechanics when he was too young in İncesu township of Kayseri where he was born in 1942. He attained a legendary successes for disassembling or reassembling and for manufacturing any mechanical tool he sees from scratch in İncesu township of Kayseri. He has succeeded in repairing shotguns which many gunsmiths failed to repair. In 1955, yet 13 years old, the first signs of the successes started to show up which he would attain. He has managed to produce the first single barrel that year which will completely open different doors to him in the future and in which he would devote his whole life that was to turn into a success story later on. But no one could expect that the master would satiate with just one shotgun. Thus in order to always produce better he opened a workshop where he can transform his dreams into reality. This initiative and the successful moves, had soon become enough to make him have a say in the local market.

The turning of a modest workshop into a world-renowned shotgun brand has started in a minor township in Anatolia was just like that. By the year 1967 with the innovative structure that is always aiming the better it provided our founder of Celal YOLLU to produce the first side by side shotgun in Turkey.

Every successful design, has increased the demand and thus increased the production in a direct proportion day by day. This acceleration, has inevitably led our founder to take the decision to relocate to Düzce which has been the center of firearms industry. Here in a very short time has brought a novelty in the sector by producing the first Over&under shotgun in Turkey. Celal YOLLU has also been busy with the new generation gunsmith trainings that he carried out in coordination with his professional life. His success and vision has led him to put emphasis on the R & D studies which would bring in the competitive strength.

By the year 1990 almost became a legend having made an indelible impression with the weapons he produced wherever he goes, Celal YOLLU has relocated to Istanbul in order to be in close contact with the world market. Ongoing studies in Istanbul soon brought the results and Celal YOLLU has brought a novelty in the sector: He has produced the first semi-automatic shotgun Turkey under the Vursan trademark.

VURSAN that attracted attentions in the industry, which has become a legend with its achievements, has started to receive venture proposals from the leading companies in the world and having accepted the proposal of Beretta Group in 2000 he has established a strong partnership.

Today, with a solid reputation for quality and reliability that has gained even more reputation the ATA brand has become a worldwide known, quality proven brand.

Ata Arms continues to the success journey with the same determination and desire. Today together with Yavuz YOLLU and Fatih YOLLU, the sons of the great master.
2. INTRODUCTION

Thank you for choosing VENZA which is the newest member of the family ATA ARMS. It is an eyeful product with the dynamic design and unique appearance. When aimed at the target; with the angular body design, VENZA brings the front sight directly in front of the eye and makes you focus on the target faster as completely isolated from the surrounding reflection during firing.

VENZA, with the moving barrel and the valve system the jumping falls to a minimum level while reducing the recoil to the level that can be felt. Thus, more precise and effective series of shots can be made.

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

For future reference, please keep a copy of this guide. If you sell or lend your shotgun please pass on the instruction manual as well. A copy of this user guide is available at the web page of our company.
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 cause results of serious injury and death. The following safety rules illustrate the related responsibilities of the shotgun users.

a) Never direct your barrel to a human (whether the shotgun is loaded or empty).
b) Do not direct your shotgun towards an unsafe place for firing. Never fire on hard floors and water.
c) Keep safety button on until you are ready to shoot (the red warning line should be invisible).
d) Keep your finger away from the trigger until you decide to shoot.
e) Make sure inside of the barrel is clean.
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.
h) Do not set back any maintenance of your shotgun.
i) Use appropriate cartridges with your shotgun and avoid using manually refilled cartridges.
j) Always use eye and ear protection when shooting.
k) Do not drink alcohol and shoot. If you take medicine do not handle a firearm while you are under influence of it.
l) Do not leave cartridges in your shotgun after usage.
m) Do not make any mechanical changes on your shotgun.
n) Have your shotgun repaired only by an authorized service.

WARNING: Every shotgun has the potential to claim the life of another human being. They arise by accidents, failure to comply with safety rules and carelessness.

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. Perform the maintenance of your shotgun in an always well-ventilated area. Wash your hands after maintenance.
4. OPERATING SYSTEM

VENZA is produced with the “Gas Pressure Control System” known as the “GPCS” in order to provide users with excellent performance. This system whose patent belongs to ATA ARMS all over the world is actually an integration of two systems. The first of these is a short recoil system and the other is the automatic gas pressure operated system.

When fired with a high-pressure cartridge, barrel and all of the moving systems move backwards by opening the gas discharge holes. The pressurized gas arrived to the gas chamber through the barrel, exits out of the opened discharge holes. (Picture 1) This status ensures that the recoil energy of the shotgun to be felt less severely and thus the barrel reacts much less. When fired with low-pressure cartridges the barrel does not move backward but the pressurized gas that comes to the gas chamber, provides the backward movement of bolt by pushing the plunger. (Picture 2) Thus, the system runs optimally. This patented integrated system of ATA ARMS increases the stability of the shotgun by optimizing the speed of operation of the mechanism. While user makes series of shots in a row, he/she finds the possibility to make his/her shootings with a shotgun less shaking and has an extremely smooth shooting stability.

VENZA, allowing users shoot with a single plunger from 24 grams up to full magnum prominently reduces the impact felt with magnum cartridges at the shoulder of the user due to the recoil of the shot gun.
VENZA, the newest member of ATA ARMS family, is designed with a choice of four receivers. It is eyeful with its dynamic design and grade 2 mat oily walnut looking. When aimed at the target; with the angular body design, VENZA brings the front sight directly in front of the eye and accelerates your focus on the target as completely isolated from the reflections in the surroundings during firing.
A  BUTT STOCK
A1  SHIM KIT
A2  RECOIL PAD
A3  BUTT STOCK ASSEMBLY KIT
A4  RECOIL PAD SCREW (2 PCS)
A5  BUTT STOCK SWIVEL RING (2 PCS)
B  TRIGGER GROUP
C  RECEIVER
C5  MAGAZINE GROUP
C6  BOLT GROUP
C7  SLIDING BAR TUBE
D  FOREND
E  MAGAZINE CAP
F  BARREL GROUP
F1  BARREL PLUG
F2  BREECH
F3  VALVE GROUP
G  FRONT SIGHT
H  PISTON

Image 4 VENZA Overview
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

VENZA comes as pre-assembled two parts out of its shotgun case (or box). (Image 7) Please follow the instructions below for reassembling.

- Remove the magazine cap by turning it counter-clockwise. (Image 8)
- Carefully remove the forend (Image 9)
• Refit the barrel into 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](image10.png)

• Refit the forend. (Image 11).

![Image 11](image11.png)

• Refit the forend - nut by turning it clockwise. (Image 12)

![Image 12](image12.png)
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 model shotgun is available for use of cartridges from 24 grams to 50 grams.

**WARNING:** Do absolutely not use steel ammunition with the chokes number 1 and 2. Use only steel ammunition with the chokes number 3, 4 and 5.

**WARNING:** Only use fabricated cartridges. Using any hand loaded ammunition would cause the warranty of your shotgun be void.

7.1 Trigger Safety

To the trigger safety button on the trigger guard (for right handed users);

- 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 open. It will not be possible to pull the trigger. (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 closed 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:** Apart from shots, make sure that your shotgun is not loaded and in safety.
7.2 Choke Selection

The choke; changes the diameter of the barrel by fitting onto the muzzle tip. It provides creating different ranges and different pellet distributions with your shotgun. In this way, you are able to use your shotgun in different hunting or sporting activities.

### MOBILE CHOKES AND USE

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

WARNING: Make sure that your shotgun is not loaded and in safety while reassembling or disassembling chokes.

WARNING: During the choke changing procedure, make sure that the chock and the bearing of the chock of the shotgun is completely clean. Otherwise, your barrel can deform during firing.

- When chokes need to be changed, remove the choke on it by using the choke changing wrench provided along with the product.
- If the thread of the choke is dirty clean it with chemical substance (solvent) and synthetic brushes.
- Use the chock wrench for the new chock to be fitted, tighten clockwise and ensure that all of the thread is fully seated.

WARNING: When reassembling do not tighten unless you make sure that the thread of the choke absolutely mated with the thread of the barrel.

WARNING: In order to make sure that the chokes have been fully tightened you should see no protrusion out of 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 when your shotgun is full.
- Before shooting, make sure that the choke has been tightened well. Check it back after a few shots.

- 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.
- Do not fire a single bullet with the chokes No 1, 2, 3.
- You can look at the notches on the screw side in order to see the choke number. (Figure 15)

Image 15

- Remove and clean the choke after shooting during maintenance. After having lubricated, the threads continue with the assembly.1 ve 2 No’lu şoklar ile çelik saçma atmayın.
- Do not fire steel pellets with the chokes No 1 and 2
8. CARTRIDGE LOADING

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

**WARNING:** Make sure that the safety of the gun is set as on (SHOTGUN WILL NOT FIRE)

**WARNING:** Make sure that the muzzle is directed to a safe direction.

For loading 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)

8.1 Drawing a Cartridge Into the Barrel

**WARNING:** Make sure that the muzzle is directed to a safe direction.

For drawing cartridges into the barrel, follow the steps below;

- Drop the cartridge onto the carrier (Image 18) by pressing the feed/stop (Cut Off) button (Image 17)
• Pull the bolt backwards and release the lever. Thus, since the magazine will be missing a cartridge, you can add a cartridge more. (Image 19)

• Your shotgun has become ready to fire.

9. UNLOADING THE SHOTGUN

WARNING: Make sure that the muzzle is directed to a safe direction

For unloading 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 the chamber is 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)
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, by pulling parallel to the magazine tube remove the barrel group. (Image 24)

10.3 Piston Removal

- After you disassemble barrel group, take the plunger inside the gas chamber by pulling. (Image 25)
- When reassembling make sure that you put the right plunger in the right direction.
- While disassembling the barrel, the plunger may be left on the spindle of the magazine
- tube. In this case, take off the magazine tube pulling from the shaft.
10.4 Valve Group Removal

- Take the barrel group in your hands. Remove the circlip located within the valve body at the top of the gas chamber from the valve body with the help of a circlip 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 set before removing and installing the bolt group.

- By pressing the Receiver button make sure that the bolt settles
- 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)
10.6 Removing The Trigger Group

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

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

WARNING: When installing the Trigger Guard you should press the receiver button.
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)

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

- 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.
10.8 Choke Removal

WARNING: Absolutely be sure, your shotgun is not loaded and safety is turned on.

WARNING: During disassembling, be sure the chock and the bearing of the chock is totally clean. Otherwise, your barrel can deform during firing.

• You can dislodge choke by using choke wrench and turning it counter clockwise. (Figure 35)

WARNING: While reassembling the choke, be sure the thread of the choke and the thread of the barrel fully mates with each other.

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).

• 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.

• First, insert the safety pin then the spring and refit the pin marked in the image.
11. PISTON USE

Ata Arms VENZA (gas operated) shotgun is working with single plunger. You can use cartridges from 24 grams up to 52 grams together with these plungers. You can find the disassembly and reassembly process of the plunger in the section named “Disassembly”.

12. USING BUTTSTOCK SETTING KIT

- There is shim kit on the VENZA Shotgun that you have bought. You can adjust the lowness 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 39)

- 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 40)
13. MAINTENANCE

WARNING: Be sure, your shotgun is absolutely not loaded and safety is turned (SHOTGUN WILL NOT FIRE) on before routine maintenance.

WARNING: Before routine maintenance you should completely disassemble your shotgun. Please refer to “Disassembly” section.

WARNING: Avoid using excessive oil while lubricating.

13.1 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 the help of a cotton cloth lubricated with maintenance oil when needed, with a bronze wire brush.
- 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.
13.2 Maintenance After Use

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

13.2.1 Barrel Maintenance

- Clean the combustion residues pile up in the barrel bore 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 oil residues after cleaning.
- After the cleaning process lubricate so as to leave a thin film of oil on the surface using a cotton cloth lubricated with maintenance oil.

13.2.2 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 do away with 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.

13.2.3 Maintenance of Gas Chamber and Plunger

- 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.
14. ASSEMBLY DRAWINGS AND PART LIST

GENERAL ASSEMBLY AND PARTS LIST

Bolt Group

Valve Group

Trigger Group

Image 42
<table>
<thead>
<tr>
<th>Part No</th>
<th>Part Name</th>
<th>Part No</th>
<th>Part Name</th>
</tr>
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<tbody>
<tr>
<td>1</td>
<td>Receiver</td>
<td>18</td>
<td>Magazine Spring Cap - Rear</td>
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<td>2</td>
<td>Barrel</td>
<td>19</td>
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<td>7</td>
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<td>Shim Kit</td>
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<td>Butt Stock</td>
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<td>Recoil Pad Screw</td>
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<td>Magazine Tube shaft</td>
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<td>Magazine Spring Cap - Front</td>
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<td>17</td>
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BOLT GROUP ASSEMBLY
# BOLT GROUP PART LIST

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# TRIGGER GROUP PART LIST

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VALVE GROUP ASSEMBLY

VALF GROUP PART LIST

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<td>Valve Spring</td>
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<td>Valve Body Nut</td>
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