

# SAUER 101

## OPERATING INSTRUCTIONS AND SAFETY INSTRUCTIONS



VERSION 101.01 //

**SAUER** 

ÜBERLEGENE WERTE



# EN SAUER 101 //

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# EN SAUER 101 //

## General information

### 1 // General information

Please read these regulations carefully prior to each use or prior to using your SAUER 101.

Store these operating instructions carefully for later use together with your SAUER 101.

In case the rifle changes owners, these instructions must be provided to the new owner.

Understanding and technically correct application of the information contained in these regulations are **required** for correct initial operation and for safety during use, maintenance, and upkeep of the SAUER 101

Only use the rifle once you have completely understood all safety regulations and correct handling of the rifle.

If you require additional information, then please contact your dealer, importer, or the manufacturer.

Please observe local and national laws that regulate the ownership, carrying, and use of firearms.

Please note that rifles are dangerous, as are all firearms.

The rifle accompanying these operating and safety instructions is sold together with the explicit warning that the manufacturer and the importer of the rifle reject all liability for the consequences of all changes made to the rifle and for all use of the rifle.

This applies especially to liability involving physical injury or property damage that is caused partially or completely due to:

- Use with criminal intent or negligence,
- incorrect or unsafe handling,
- defective, incorrect, hand-loaded, or re-loaded ammunition,
- insufficient care of the rifle (e.g. rust, damage),
- failure to observe functional faults,
- resale against regional laws and regulations,
- other influences that lie outside of our direct and immediate control.

These limitations apply independent of whether liability is enforced based on a contract, negligence, or strict liability (including omission of a warning).

The manufacturer and the importer may also not be held liable for coincidental or subsequent damages such as loss of use of property, commercial losses such as wage and profit reductions.

## **2 // Safety instructions**

Read these instructions carefully each time prior to handling or using the SAUER 101 and ensure that you have understood them.

### **2.1 // Handling the rifle safely**

- Never attempt to modify the rifle yourself or to make any conversions. Only use authorized original accessories.
- Always treat the rifle as if it were loaded and the safety were off, until you have made sure that the rifle is not loaded by unloading it.
- Never shoot a rifle that has been penetrated by water, sand, dirt, or other foreign substances.
- Always store the rifle and the ammunition at different locations and ensure that both of these items remain out of reach of unauthorized persons and children.
- Always handle the rifle as if the safety mechanisms were deactivated. The best safety measure is correct, well-trained, and safe handling of the rifle.
- Never rely completely on the safety mechanisms. They cannot replace careful and correct handling of the rifle.
- Never store the rifle loaded, and always remove the magazine and make sure by unloading that there are no cartridges present in the cartridge chambers of the barrel.
- Never relieve the tension from the firing pin by depressing the trigger alone.

### **2.2 // Dangers to the user and avoiding them**

- Never use the rifle under the influence of alcohol or drugs, in case of illness, or other problems; this can impair your judgment and your reflexes.
- Never hold your hand in front of the muzzle, over the cartridge chamber, or behind the breech block while shooting.
- Always unload the firearm immediately after shooting, before setting the firearm down, storing it in a container for transport, or passing it to another authorized person.
- Never point the rifle towards doors, panes of glass, walls, concrete, stones, or flat surfaces (including water). A shot could penetrate these surfaces or deflect in an unsafe direction.
- Ensure that you do not inhale resulting gun smoke or vapor or allow this to come in contact with your eyes. In case this happens, stop shooting immediately.

# **EN SAUER 101 //** **Safety instructions**

## **2.3 // Dangers to other persons and avoiding them**

- Never allow a loaded rifle out of your possession.
- Never leave the rifle unattended, and protect the rifle against unauthorized access.
- Never provide the rifle to any person who has not informed himself about the safety regulations and handling the rifle by reading the associated regulations and instructions.
- Always hold the muzzle of the barrel in a safe direction whenever handling the firearm. Safe directions include areas where no people, other living creatures, or third-party property are located.
- Make sure that the area behind your target is also clear.
- Instruct everyone present regarding possible dangers caused by noise, empty cartridges, and gun smoke. Stop shooting immediately in case of any danger.

## **2.4 // Ensure correct use**

- The owner of the rifle must ensure that it is only used for the permitted purpose.
- Risks of personal injury and even death may result to the user and other persons or living creatures due to incorrect, careless, or faulty handling of the rifle.

## **2.5 // Personal protective equipment**

- Always wear hearing protection and protective glasses during shooting.
- Instruct all persons in the area to wear hearing protection and protective glasses.

## 2.6 // Indication of safety instructions

The following safety instructions in the individual chapters of this guide indicate potential dangers to you:



**DANGER!**

Information regarding dangers that could immediately lead to severe injuries or even to death in case it is not observed.



**WARNING!**

Information regarding dangers that could lead to severe injuries or even to death in case it is not observed exactly.



**CAUTION!**

Information regarding dangers that could lead to damage to the rifle in case it is not observed exactly.

**CAUTION!**

Information involving technical requirements that could lead to damage to the rifle in case it is not observed exactly.

Each safety instruction includes:

- a title featuring a signal word, a pictogram, and corresponding color shading
- information regarding the type and source of the danger
- information regarding possible consequences of failure to observe the safety instruction
- Information regarding procedures and prohibited actions to avoid danger



# EN SAUER 101 //

## Product description

### 3 // Product description

#### 3.1 // Main components



fig. 1 // Overview of main components

Item	Description
100	Chamber
200	Stock (1 piece) including magazine frame
300	Barreled action (system housing including barrel and trigger assembly)
400	Magazine

### 3.2 // Technical data

Principle of function	Repeating rifle
Breech block	Bolt action featuring direct locking lug on barrel
Caliber	<b>Medium:</b> .22-250 Rem.; .243 Win.; 6.5 x 55 SE; .270 Win.; 7 x 64; .308 Win.; .30-06 Spr.; 8 x 57 IS; 9.3 x 62 <b>Magnum:</b> 7 mm Rem. Mag.; .300 Win. Mag.; .338 Win. Mag.
Total length	<b>Medium:</b> approx. 1,095 mm <b>Magnum:</b> approx. 1,155 mm
Barrel length	<b>Medium:</b> 560 mm <b>Magnum:</b> 620 mm
Stock length	approx. 365 mm
Stock drop from the edge of the housing	<b>front:</b> 20 mm <b>center:</b> 15 mm <b>rear:</b> 10 mm
Trigger weight	<b>Direct trigger:</b> approx. 950 g
Magazine contents	<b>Medium:</b> 5 shots <b>Magnum:</b> 4 shots
Weight without targeting scope and wooden stock	<b>Medium:</b> approx. 3,000 g <b>Magnum:</b> approx. 3,200 g
Weight without targeting scope and with plastic stock	<b>Medium:</b> approx. 3,050 g <b>Magnum:</b> approx. 3,250 g

#### Note:

- Weight including wooden stock may differ due to specific material density properties.

# EN SAUER 101 // Product description

## 3.3 // Main features

The SAUER 101 is a highly precise hunting firearm that has been designed according to state-of-the-art knowledge. It is an easy to use repeating rifle featuring a direct trigger mechanism.

Both the mechanical and the optical targeting equipment may be mounted.



fig. 2 // Standard delivery scope

## 3.4 // Delivery scope

The scope of the standard delivery includes:

- 1 x SAUER 101
- 1 x magazine
- 1 x manual including operating and safety instructions
- 1 x warranty card

risk that the housing could be damaged or the mount could loosen under stress.


- Only attach mounting base to the housing if the radiuses fit perfectly with those of the case.
- Ensure that the mounting bases are not only screwed on properly, but also that they are glued flush and equally with high-quality two-component glue.

## 3.5 // Mounting optics and accessories

All targeting scope mount types based on the Remington 700 may be mounted.

Note:

- When mounting the targeting scope, please ensure that the mounting base and the system housing are completely flush. In case an incorrect fit is corrected by tightening the mount screws, there is a

	<b>CAUTION!</b>
<b>Incorrect targeting scope assembly</b>	
<b>Possible damage to the rifle</b>	
<ul style="list-style-type: none"><li>• Damage to the housing may have negative effects on shooting precision. The threading for the mounting screws may also be damaged or destroyed.</li><li>• The company does not guarantee the function or shooting performance of rifles that are mounted differently than described here.</li></ul>	

**Note:**

- A table featuring the item numbers and the names of the replacement parts is available on page 33. The overview drawing on page 34 will make it easier for you to identify the replacement parts.

### **3.6 // Replacement parts**

J. P. Sauer & Sohn GmbH only ships to contract distributors in Germany and to corresponding SAUER importers outside of Germany. Therefore, please always contact your specialist Sauer distributor when ordering replacement parts, who will forward your order to the importer (outside of Germany) or to Sauer & Sohn (Germany) accordingly. In order to ensure speedy and dedicated processing of your order, we request that you keep the following information handy when ordering replacement parts:

- model, caliber, barrel length, special equipment
- number
- Item number in the replacement part list
- Name of the replacement part required

# EN SAUER 101 //

## Transporting, storing, shipping

### 4 // Transporting, storing, and shipping the rifle

#### 4.1 // Transporting the rifle



#### WARNING!

**Uncontrolled discharge of fire in case of negligent handling**

**Possible death or severe injuries**

- Always transport the rifle unloaded and decocked for your own safety and the safety of others.

- Never carry a rifle that has been cocked and that possesses a cartridge in the cartridge chamber with you.
- Always carry the rifle such that you will have control over the direction of the muzzle in case you fall, slip, or similar.
- Transport the rifle separate from the ammunition in a locked case.
- The rifle and the ammunition must not be accessible to children or other inexperienced and unauthorized persons.
- Comply with regional and national laws regarding the transportation, storage, and safekeeping of firearms.

#### 4.1.1 // Transporting in assembled condition

Procedure:

1. Remove the magazine (see section 5.9.1 //).
2. Unload the rifle and activate the safety (see section 5.7 //, 6.2 //).
3. Disassemble the chamber (see section 4. 5.8.3 //).

**Disassemble** the strap clip as required (see section 7.1 //) in order to avoid scratching parts on the stock.

4. Clean the rifle (see section 8 //).

#### 4.2 // Storing the rifle

- Never leave the rifle in plain sight when it is not being used.
- The rifle and the ammunition must not be accessible to children or other inexperienced and unauthorized persons during storage.
- Clean the rifle and keep it safely stored in a locked case. National and regional laws regarding the safekeeping of firearms must be observed.
- The rifle must be lubricated with oil prior to storage for longer periods of time. Normal lubrication is insufficient in this case.

### 4.3 // Shipping the rifle

#### Note:

- Inform yourself thoroughly about regional laws and regulations regarding shipping and transportation of firearms.

#### Procedure:

1. Check whether the rifle is unloaded and decocked.
2. Pack the rifle well (in the original packaging, if possible) in order to avoid damage during transport.
3. Do not include any accessories during packing, provided there is no room available in the original packaging.
4. In order to ensure that it is not recognizable that a rifle is packed during transport, cover the original packaging with a second packaging cover.
5. Include a letter featuring the following information:
  - Your name
  - Your address (please indicate the street, not a post code)
  - Your telephone number at which you maybe reached during the day
  - Model and serial number of the rifle
  - An extensive description of the problem or the work that needs to be taken care of.
  - A copy of your purchase receipt or identification of your ownership of the firearm.
6. Send the rifle insured and free delivery to (deliveries with insufficient postage or without postage will not be accepted):
  - the point of sale where the rifle was purchased
  - the local J. P. Sauer & Sohn GmbH specialist distributor
  - to the J. P. Sauer & Sohn representative (importer) in your country
  - if there is no local Sauer & Sohn specialist distributor or no Sauer & Sohn representative in your country, to J. P. Sauer & Sohn GmbH.

# EN SAUER 101 // Handling

## 5 // Handling the rifle

The chamber and the magazine may not be inserted for safety reasons during:

- initial operation and
- when passing the firearm.

**Note:**

- The rifle is delivered featuring a protecting and preserving layer of oil and grease, and excess protective oil and grease must be removed prior to the initial operation.

### 5.1 // Initial operation

**Note:**

- For your own safety, the rifle must be subjected to the initial operation procedure under all circumstances. Error-free function of the rifle cannot be guaranteed otherwise.



**WARNING!**

**Uncontrolled discharge of fire due to uncertain condition of the rifle**

**Possible death or severe injuries**

- If the rifle is provided by the shooter in an uncertain condition, then it must always be considered to be loaded and the safety off.

**Procedure:**

1. Ensure that the rifle is unloaded, i.e. there are no cartridges in the cartridge magazine.
2. Ensure that there are no cartridges in the magazine.
3. Clean inside the rifle (see section 8.2 //).

4. Remove and clean excess grease and oil from the exterior metal surfaces (see section 8.3 //).
5. Cock the chamber (see section 5.8.2 //).
6. Insert the chamber (see section 5.8.4 //).
7. Insert the empty magazine (see section 5.9.2 //).
8. Decock the firearm.
9. Fire multiple 'empty' repeating shots to ensure that the function is correct.

### 5.2 // Ammunition



**WARNING!**

**Functional fault due to use of incorrect ammunition**

**Possible death or severe injury and damage to the rifle**

- Only use ammunition available from specialist dealers that provided in its original packaging according to CIP or SAAMI specifications and that corresponds with the caliber of the rifle.
- Never use reloaded, 'recycled', hand-loaded, or non-standard ammunition.
- Never use dirty, wet, rusty, warped, damaged, or oiled ammunition.
- Never spray cartridges directly with lubricant, protective agents, or cleaners.
- Never leave ammunition unattended. Ammunition must be kept out of reach of children and unauthorized persons.

### 5.3 // Loading the rifle (prepared to fire)

Condition of the rifle:

The rifle is loaded and prepared to fire.



#### **WARNING!**

**Negligent handling due to a lack of concern regarding dangers**

#### **Possible death or severe injuries**

- Never load or unload the rifle in a vehicle, in a building, or in any other tightly enclosed space (with the exception of a shooting range that has been built for this purpose).
- Never rely completely on the safety mechanisms. They cannot replace careful and correct handling of the rifle.
- Never allow a loaded rifle out of your possession.

#### **Preparation:**

1. Always wipe off excess grease and oil prior to loading and ensure that there are no foreign objects in the barrel.
2. Always point the muzzle of the rifle in a safe direction.
3. Never keep your finger on the trigger, but rather always outside of the trigger area.
4. Only load the rifle by inserting the magazine immediately prior to shooting.

#### **Procedure:**

1. Open the chamber and pull it back to the stop position.
2. Fill the magazine (see section 5.9.3 //).
3. Insert the magazine (see section 5.9.2 //).
4. Slide the chamber forward and lock it.
5. Activate the safety (see section 6.2 //).



# EN SAUER 101 // Handling

## 5.4 // Firing a shot



### WARNING!

**Negligent handling due to a lack of concern regarding dangers**

**Possible death or severe injuries**

- Ensure that the target and the area around it allow the shot to be fired without any danger.
- When firing, ensure that your hands and other body parts are not in front of, above, or beside the muzzle or the ejector opening.
- Stop shooting immediately and unload the rifle in case you suspect that a cartridge has not been loaded properly, a shell is jammed, a shot may have plugged the barrel, or in case you think that a shot sounds or feels weak or abnormal.
- Never try to shoot out a blocked shot out of the barrel using another cartridge.

**Procedure:**

1. Wear hearing protection and protective glasses.
2. Ensure that no other persons are located in the immediate area, where they could be struck by ejected cartridge shells.
3. Point the rifle at the safe target.
4. Deactivate the safety (see section 6.1 //).



### DANGER!

#### Discharging fire

**Immediate death or severe injuries**

- Only discharge fire if you have sighted your target and you are sure that discharging fire will not result in any danger to you or other persons.
5. Place your finger on the trigger and pull the trigger back (discharge fire).
  6. Leave the rifle pointed at the target and repeat firing additional shots as desired (see section 5.5 //).
  7. In case the magazine has been emptied, reload the rifle (see section 5.6 //).
  8. Activate the safety and unload the rifle (see section 5.7 //).



### WARNING!

**Uncontrolled discharge of fire because the rifle is prepared to fire.**

**Possible death or severe injuries**

- If you have decided that it is time to stop shooting, activate the safety and unload the rifle immediately.

## 5.5 // Reloading during shooting (repeating process)



### WARNING!

**Negligent handling due to a lack of concern regarding dangers**

**Possible death or severe injuries**

- Never allow the rifle out of your possession.
- Leave the rifle pointed at the safe target.

#### Procedure:

1. Activate the safety (see section 6.2 //).
2. Press the unlocking button and pull the chamber back to the stop position. (see section 5.9.1 //).
3. Slide the chamber forwards and lock it so that a cartridge may be loaded into the cartridge magazine.

#### Condition of the rifle:

The rifle is loaded and prepared to fire.

## 5.6 // Reloading during shooting (filling the magazine)



### WARNING!

**Negligent handling due to a lack of concern regarding dangers**

**Possible death or severe injuries**

- Never allow the rifle out of your possession.
- Leave the rifle pointed at the safe target.

#### Procedure:

1. Activate the safety (see section 6.2 //).
2. Press the unlocking button and pull the chamber back to the stop position.
3. Remove the empty magazine (see section 5.9.1 //).
4. Fill the magazine (see section 5.9.3 //).
5. Insert the full magazine and check that it has snapped in (see section 5.9.2 //).
6. Slide the chamber forwards and lock it so that a cartridge may be loaded into the cartridge magazine.

#### Condition of the rifle:

The rifle is loaded and prepared to fire.

# EN SAUER 101 // Handling

## 5.7 // Unloading the rifle



### WARNING!

**Uncontrolled discharge of fire because the rifle is prepared to fire.**

#### Possible death or severe injuries

- Never allow the rifle out of your possession before it has been unloaded.
- The rifle is loaded, a cartridge is present in the cartridge magazine of the barrel.
- Never reach into the chamber opening with your hand.



### WARNING!

**Functional fault due to poor cleaning of the rifle**

#### Possible death or severe injury and damage to the rifle

- The rifle must be cleaned after every shooting session (see section 8 //).

### Procedure:

1. Activate the safety (see section 6.2 //).
2. Point the rifle at a bullet trap.
3. Remove the magazine (see section 5.9.1 //).
4. Press the unlock button and open the chamber. The cartridge or cartridge shell will push out of the cartridge magazine and eject.
5. Check to make sure the cartridge has been ejected and that there are no cartridges in the cartridge magazine.
6. Empty the magazine.
7. Pick up the ejected cartridge and clean it.

### Condition of the rifle:

The rifle is unloaded.

## 5.8 // Chamber

### 5.8.1 // Cocking indicator

A cocking indicator displays the cocking condition of the chamber.

Fig. 3 cocking indicator, cocked and safety off

Fig. 4 cocking indicator, decocked and safety off

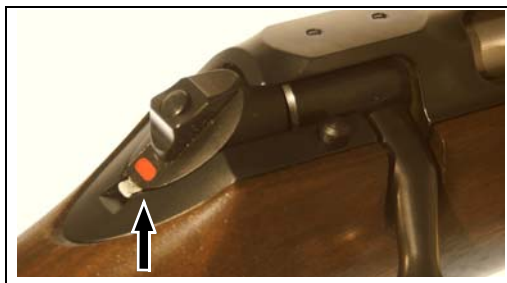


fig. 3 // Cocking indicator, cocked, safety off



fig. 4 // Cocking indicator, decocked, safety off

### 5.8.2 // Cocking the chamber

Note:

In order for the chamber (100) to be inserted into the rifle, the firing pin must be cocked.

Procedure:

1. Cock the firing pin by pressing the firing pin nut (7) against a solid surface (fig. 5 //).

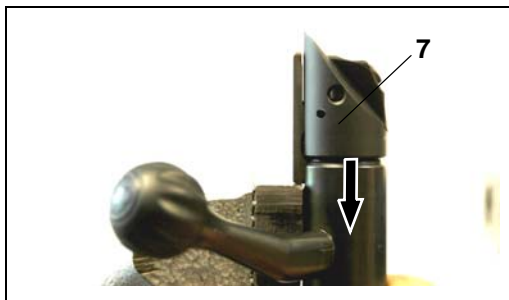


fig. 5 // Cocking the firing pin nut

2. Pull the safety slider back (to the "safe" position, red signal field becomes covered) (fig. 6 //).

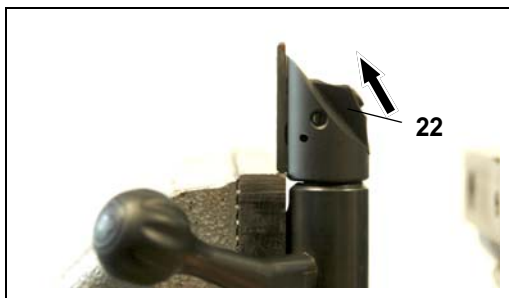


fig. 6 // Pull the safety slider back

3. Turn the cocking piece clockwise until the locking device (25) snaps into the notch intended for this (fig. 7 //).
4. The chamber is cocked when the grey cocking indicator becomes visible (fig. 3 //).

# EN SAUER 101 // Handling

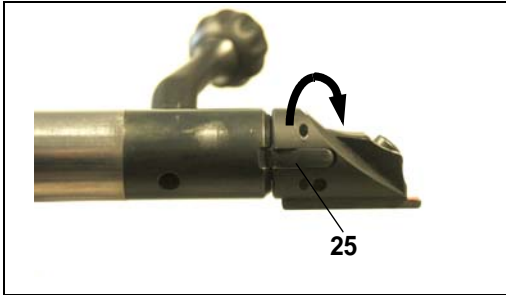


fig. 7 // Snap the locking device in place.

## 5.8.3 // Disassembling the chamber



### WARNING!

**Uncontrolled discharge of fire in case of negligent handling**

**Possible death or severe injuries**

- The chamber may not be disassembled when safety is activated

**Procedure:**

1. Activate the safety.
2. Press the unlock button and open the chamber.
3. Hold down the unlocking button and pull out the chamber.



fig. 8 // Disassembling the chamber

## 5.8.4 // Inserting the chamber



### WARNING!

**Uncontrolled discharge of fire in case of negligent handling**

**Possible death or severe injuries**

- No cartridges may be present in the cartridge magazine
- A magazine may not be inserted into the firearm.
- The chamber may only be inserted when safety is activated.

### CAUTION!

**Damage may result to the rifle and the chamber if the decocked chamber is forced into place.**

- In order to insert the chamber into the rifle, the firing pin needs to be cocked (see section 5.8.2 // cocking the chamber).
- Never resort to force to insert the chamber.

**Procedure:**

1. Press the unlocking button and insert the cocked chamber into the housing, close it and lock it.
2. Activate the safety.
3. To check the function: Complete the repeating process.
4. To check the safety function when unloading the rifle:
  - The safety button and safety slider must be easy to activate.
  - It is impossible to fire a shot when the safety is activated.

- In case problems occur when checking the function or the safety function, remove the chamber and repeat the steps in the procedure from 1 to 5.

### 5.8.5 // Cocking the firing pin



#### WARNING!

**Uncontrolled discharge of fire in case of negligent handling**

**Possible death or severe injuries**

- Only decock the firing pin when the rifle is unloaded and the cartridge magazine is empty.

#### Procedure:

- Unload the rifle and ensure that no cartridges are present in the cartridge magazine (see section 5.7 //).
- Pull the trigger and close the chamber slowly with the trigger depressed.

#### Note:

- The grey cocking indicator is now covered from sight (see fig. 4 //).

## 5.9 // Magazine

### 5.9.1 // Removing the magazine

#### Procedure:

- Hold below the magazine 400 with your hand.

#### CAUTION!

**The magazine falls out**

**Possible damage to the magazine**

- Always hold your hand exactly below the magazine when removing the magazine.

- Press the magazine button with your index finger.
- Remove the magazine.
- Empty the magazine.



fig. 9 // Removing the magazine

### 5.9.2 // Inserting the magazine

#### Procedure:

- Insert the magazine into the magazine shaft and slide it upwards until the magazine can be heard snapping in. Do not twist the magazine in the process.

# EN SAUER 101 // Handling

## 5.9.3 // Filling the magazine


### Procedure:

1. The magazine may be loaded directly from above.
2. The cartridges are pressed onto the feeder from above until they snap into the magazine.



fig. 10 // Filling the magazine

## 5.9.4 // Filling with the magazine inserted

	<b>WARNING!</b>
<b>Uncontrolled discharge of fire in case of negligent handling</b>	
<b>Possible death or severe injuries</b>	
<ul style="list-style-type: none"><li>• The chamber may only be opened when safety is activated</li><li>• Do not hold any fingers on the trigger during loading</li></ul>	

### Procedure:

1. Open the chamber
2. Cartridges are pressed into the feeder via the ejector window until they snap into the magazine.

## 5.9.5 // Loading a single shot

### Procedure:

1. Place the cartridge onto the feeder with your fingers or insert it directly into the cartridge magazine.
2. Close the chamber.
3. Ensure that the safety is activated.


## 5.10 // Direct trigger

### Note:

- The trigger weight is set at the factory to approx. 9.5 N (950 g).

The trigger is a direct trigger without any objects in front of it.

- The shot is triggered by bypassing the resistance.

	<b>WARNING!</b>
<b>Uncontrolled discharge of fire in case of negligent handling</b>	
<b>Possible death or severe injuries</b>	
<ul style="list-style-type: none"><li>• The trigger weight may <b>not</b> be changed for safety reasons.</li></ul>	

## 6 // Safety

The SAUER 101 features a direct firing pin safety device.

The SAUER 101 also features an internal firing pin safety device that hinders discharge of a shot if the chamber is not completely closed.

The safety slider (24) is located on the cocking device

### 6.1 // Deactivating the safety

**Procedure:**

Press the safety button (22) and slide the safety slider (24) forwards.

**Condition of the rifle:**

The safety is deactivated:

- The red signal field is visible

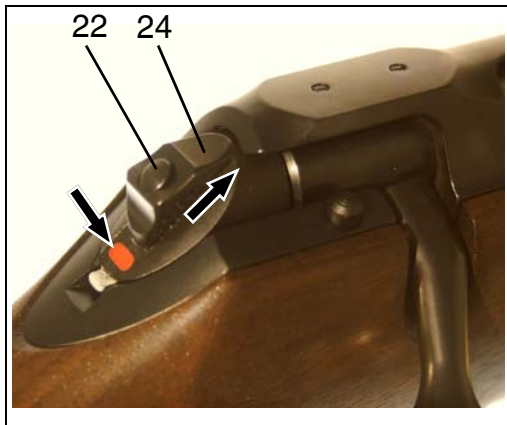


fig. 11 // The safety is off

### 6.2 // Activating the safety

**Procedure:**

Press the safety button (22) and slide the safety slider (24) back.

**Condition of the rifle:**

The safety is activated:

- The red signal field is not visible

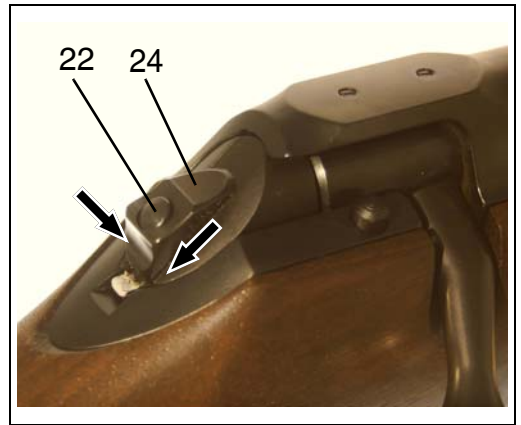


fig. 12 // The safety is activated



# EN SAUER 101 // Disassembly

## 7 // Disassembly



### WARNING!

**Uncontrolled discharge of fire because the rifle is prepared to fire**

**Possible death or severe injuries**

- A magazine may not be inserted into the rifle.
- Before you disassemble the rifle, ensure once again that it is unloaded (see section 5.7 //).

### 7.1 // Disassembling the strap clip

#### CAUTION!

**Possible damage to the rifle**

- Follow the accompanying mounting instructions when using strap clips from other manufacturers.

**Procedure:**

1. Loosen the strap clip from the strap clip screw with a slotted screwdriver.
2. Turn the strap clip screw counter-clockwise out of the stock. Ensure that the o-ring below this is not lost.



fig. 13 // Front strap clip screw

### 7.2 // Removing the magazine

**Procedure:**

see section 5.9.1 // Removing the magazine

### 7.3 // Disassembling the chamber

**Procedure:**

see section 5.8.3 // Disassembling the chamber

#### CAUTION!

**Possible damage to the rifle**

- Never resort to force to insert the chamber.
- Prior to reinserting the chamber into the firearm, the chamber must be cocked (see section 5.8.2 // Cocking the chamber).

**Note:**

In case the chamber is stored outside of the firearm for a longer period of time, decock the chamber.

## 8 // Care

### 8.1 // General

Error-free function and precision of the rifle can only be ensured if the item is cared for regularly and professionally. The rifle must be cleaned after every use and protected against corrosion. The interior of the barrel must be cleaned after every shooting session and protected against corrosion. The wooden stock must be treated using suitable care products according to the instructions accompanying them and protected against the influences of weather.

To care or your SAUER 101 in the best way possible, we recommend high-quality brand-name products such as Brunox Turbospray, Brunox Lub & Core, and high-quality stock care products.

For normal care, it is sufficient if the following firearm components are disassembled or unmounted:

- Magazine
- Chamber
- Rifle strap

If the rifle is exposed to extreme wet or becomes severely dirty, we recommend unmounting or disassembling the following firearm components:

- Chamber
- Magazine
- Targeting scope
- Rifle strap


#### Note:

In more extreme cases of the rifle becoming dirty, the parts should be cleaned completely and the function should be tested by a qualified gunsmith or firearms

technician. In this case, the stock should be removed in addition to the points listed above and the chamber should be disassembled.

<b>CAUTION!</b>
<b>Possible damage to the rifle</b> <ul style="list-style-type: none"><li>• The firearm may only be completely disassembled by a qualified gunsmith or firearms technician.</li></ul>

<b>CAUTION!</b>
<b>Possible functional faults in case of low temperatures (&lt; -30°C) due to the thermal behavior of oils and greases</b> <ul style="list-style-type: none"><li>• Remove the grease from the firearm prior to use in case of extreme temperatures (e.g. when hunting in exotic locations).</li></ul>

 <b>WARNING!</b>
<b>Uncontrolled discharge of fire because the rifle is prepared to fire</b> <b>Possible death or severe injuries</b> <ul style="list-style-type: none"><li>• A magazine may not be inserted into the rifle.</li><li>• Before you disassemble the rifle to clean it, ensure once again that it is unloaded. (see section 5.7 //).</li></ul>

## 8.2 // Cleaning the barrel

**CAUTION!**

**Possible damage to the rifle**

- Never clean the rifle from the front and never use steel or brass brushes, since these could destroy the smooth surface of the barrel. Use an appropriate cleaning rod and brushes of the correct caliber.
- Solvents may damage the surface of the rifle. Follow the instructions and warnings of the manufacturer prior to using cleaning agents or solvents.

**Procedure:**

1. Unload the rifle (see section 5.7 //).
2. Disassemble the chamber (see section 5.8.3 //).
3. Insert a cleaning aid in place of the chamber ('false breech') in order to insert the concentric guide of the cleaning rod exactly.
4. Clean the bore and cartridge magazine from behind using suitable fluids or grease (follow the accompanying instructions), use a suitable bronze or plastic brush to clean the caliber.
5. Check whether firing residue has collected on the fields. As required, clean firing residue off of the barrel with barrel cleaner from a dealer (follow the accompanying instructions).
6. Add a small amount of gun oil or gun grease to the bore and the cartridge magazine.
7. Rub the bore and the cartridge magazine dry from behind using a plastic-coated cleaning rod of the correct caliber.

## 8.3 // Exterior metal surfaces

We recommend Brunox Turbospray and Brunox Lub & Core to care for and preserve the exterior metal surfaces.

Please follow the instructions on the packaging of the cleaning agent exactly.

**CAUTION!**

**Possible damage to the rifle**

- Care of the exterior metal surfaces is especially important in case of humid weather or if the metal surfaces come into contact with sweaty limbs.
- Always wipe the rifle dry prior to caring for it.

## 8.4 // Exterior wooden surfaces

We recommend a high-quality stock cleaning agent to care for and preserve the exterior wooden surfaces. Please follow the instructions on the packaging of the corresponding cleaning agent exactly.

**Note:**

- Water spots that remain on the stock after rain cannot be avoided. Depending on the level of lime or dust particles contained within the rainwater, this phenomenon will occur more or less strongly. There is no damage to the finish on the stock.

## 9 // Assembly

<b>CAUTION!</b>
-----------------

<b>Possible damage to the rifle</b>
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- Only assemble rifle components that have been cleaned.

### 9.1 // Mounting the strap clip

See fig. 13 // for the associated illustration.

<b>CAUTION!</b>
-----------------

<b>Possible damage to the rifle</b>
-------------------------------------

- Follow the accompanying mounting instructions when using strap clips from other manufacturers.

**Procedure:**

1. Place the o-rings in the drilled holes provided and turn the strap clip screws clockwise.
2. Mount the strap clip (differs according to the particular strap clip).

**Note:**

- The strap clip must be offset 90° to the direction of the barrel.

### 9.2 // Inserting the chamber

**Procedure:**

see section 5.8.4 // Inserting the chamber

<b>CAUTION!</b>
-----------------

<b>Damage may result to the rifle and the chamber if the decocked chamber is forced into place.</b>
---

- In order to insert the chamber into the rifle, the firing pin needs to be cocked (see section 5.8.2 // Cocking the chamber).

### 9.3 // Inserting the magazine

**Procedure:**


see section 5.9.2 // Inserting the magazine

## 10 // Faults

### 10.1 // Determining a fault

Functional faults may be avoided by maintaining the firearm properly (cleaning and inspection).

In case a fault occurs during shooting in spite of this, proceed as follows:


	<b>WARNING!</b>
<b>Uncontrolled discharge of fire because the rifle is loaded and possibly defective</b>	
<b>Possible death or severe injuries</b>	
<ul style="list-style-type: none"><li>• Point the rifle in a safe shooting direction and remove your finger from the trigger while you complete the following steps of the procedure.</li></ul>	

#### Procedure:

1. Stop shooting immediately and inform any other persons present regarding the fault.
2. Remove the magazine (see section 5.9.1 //) and store it in a safe place.
3. Open the chamber. The cartridge or cartridge shell will push out of the cartridge magazine and eject.
4. Check to make sure that there are no shots, cartridge shells, or foreign objects present in the cartridge magazine or in the barrel.
5. If the fault is listed in the following table and the remedy is described, then the operator may correct the fault according to the table.
6. Clean, lubricate, the assemble rifle.
7. Have the rifle checked by a firearms technician or a gunsmith.

#### Note:

- In case of faults that are not listed in the following table, the operator is not permitted to correct the fault by himself.
- In this case, have the rifle checked and repaired by a qualified firearms technician or gunsmith.

	<b>WARNING!</b>
<b>Incorrect maintenance of the rifle</b>	
<b>Possible death or severe injuries</b>	
<ul style="list-style-type: none"><li>• Never force a shot that has been jammed in the barrel by trying to shoot it free with another shot.</li><li>• Never try to repair broken or worn-out components yourself. Dispose of broken or worn-out components properly.</li></ul>	

## 10.2 // Troubleshooting and remedy

Fault	Possible cause	Remedy
No cartridges are being fed in.	<p>The magazine is not inserted properly, is deformed, or is dirty.</p> <p>The rifle is damaged.</p>	<p>Insert the magazine completely until it snaps in (see section 5.9.2 //).</p> <p>Have the manufacturer repair it.</p>
The chamber cannot be inserted into the housing.	<p>The unlocking button is not pressed.</p> <p>The firing pin is decocked.</p> <p>The rifle is damaged.</p>	<p>Press in the decocking button (see section 5.8.4 //).</p> <p>Cock the chamber (see section 5.8.1 //).</p> <p>Have the manufacturer repair it.</p>
The safety on the rifle cannot be activated.	<p>The rifle is decocked.</p> <p>The rifle is damaged.</p>	<p>Cock the rifle (see section 5.8.1 //).</p> <p>Have the manufacturer repair it.</p>

## **11 // Warranty conditions**

### **11.1 // Manufacturer's guarantee**

The warranty provided by J. P. Sauer & Sohn GmbH is provided in addition to the distributor's legal warranty conditions, provided the accompanying firearms certificate is completed and received by J. P. Sauer & Sohn GmbH within ten days following the purchase date. The warranty is only provided to the initial purchaser, who must also be a resident of the country of purchase.

The warranty only includes the metal and plastic components of the firearm, original SAUER conversion parts, but the targeting scope is not included. Wooden components of the firearm require special care, and as natural products, they are subject to natural changes; the wooden components are not included.

The warranty period is limited to ten years, begins with the purchase date, and includes all defects and damage to the firearm (metal and plastic components) that can be proved as the result of material and production errors. In this case, the manufacturer will assume the material and labor costs involved. In order to complete warranty work, the firearm must be submitted to an authorized specialist distributor or to J. P. Sauer & Sohn GmbH in Isny, Germany. The section 4.3 // "Shipping the rifle" must be observed exactly when shipping the rifle. The dangers and costs for transporting the firearm to and from are the customer's responsibility. The warranty service shall be selected at the manufacturer's discretion, e.g. repair or replacement of defective components; replaced components become the property of the manufacturer.

### **11.2 // Shooting performance guarantee**

The firearm's shooting precision depends on numerous factors. The ammunition is the most important factor. Not every barrel shoots every type of ammunition equally, and differences in performances may result. The targeting scope and its assembly is also important. Parallaxes (differences in perspective), a loose sight, a defective sight, and defective mounting are the most frequent causes of unsatisfactory shooting performances. For this reason, you should use a brand-name targeting scope mounted by a specialist and calibrate the ammunition to your rifle by checking the ammunition type. Ammunition of the same make and the same assembly may possess a different shooting performance and targeting precision from production run to production run and from firearm to firearm.

We guarantee excellent shooting performance using our firearms if the best possible ammunition, targeting scope, and assembly have been selected. Objections to the shooting performance must be submitted in writing within 20 days following the purchase date. We reserve the right to submit the firearm to an independent institute for testing (DEVA or National Firing Proof House). In case excellent shooting performance is confirmed, we shall be entitled to demand the resulting costs from the customer.

### **11.3 // Warranty scope**

Warranty services do not extend or renew the warranty period for either the firearm or replacement parts that have been installed. The warranty period for replacement parts that have been installed ends with the warranty period for the complete firearm.

### **11.4 // Warranty exclusion**

The warranty is excluded in case of:

- Damage resulting from normal wear and tear, failure to follow the operating instructions, incorrect use or handling, and in case the firearm exhibits mechanical damage of any kind.
- Damage due to force majeure or environmental influences.
- If the firearm is repaired, processed, or altered by third parties.
- Use of reloaded ammunition or non-CIP ammunition (unauthorized)
- Browning applied by third parties.

The warranty does not include optical targeting equipment and targeting scope mounts supplied by manufacturers other than J. P. Sauer & Sohn GmbH. Subsequent or other claims, especially claims involving compensation for damages caused outside of the firearm (subsequent damage) are excluded, provided liability is not explicitly regulated by law.



# EN SAUER 101 // Replacement parts

## 12 // Replacement parts

### Item Name

#### 100 Chamber

- 3 Chamber
- 4 Firing pin
- 5 Hammer spring
- 6 Counter sunk screw
- 7 Firing pin nut
- 8 Flat washer
- 9 Spring locking device
- 10 Cylinder pin
- 11 Ejector pin
- 12 Ejector spring
- 13 Spring pin
- 14 Extractor spring
- 15 Extractor
- 16 Cocking piece
- 17 Safety lever
- 18 Safety latch
- 19 Steel ball
- 20 Pressure spring
- 21 Threaded pin
- 22 Safety slider
- 23 Spring for safety button
- 24 Safety button
- 25 Locking device
- 26 Cylinder pin
- 27 Bolt action
- 28 Plastic ball

#### 200 Stock (1 piece) including magazine frame

- 35 Light spring pin
- 36 Stock
- 37 Plastic stopper
- 38 Strap clip screw
- 40 O-ring
- 41 PK inlay
- 42 Stock cap insert
- 43 Rubber stock cap

- 44 Tapping screw

- 45 Magazine frame
- 46 Magazine catch
- 47 Cylinder pin
- 48 Magazine button
- 49 Pressure spring
- 50 System screw
- 51 System screw

#### 300 Barreled action (system housing including barrel and trigger assembly)

- 1 Housing
- 2 Barrel
- 29 Stock bolt
- 30 Cylinder pin
- 31 Fan-shaped washer
- 32 Threaded bushing
- 33 Clamping element
- 34 Unlock button
- 56 Trigger housing
- 57 Spring for bolt catch
- 58 Bolt catch
- 59 Light spring pin
- 60 Spring for magazine ejector
- 61 Magazine ejector plate
- 62 Cylinder pin
- 63 Spacer pin
- 64 Spacer pin
- 65 Cylinder screw
- 66 Trigger
- 67 Trigger screw
- 68 Sear spring
- 69 Trigger spring
- 70 Sear
- 71 Cylinder pin

#### 400 Magazine

- 52 Box magazine
- 53 Magazine base
- 54 Feed

# 55 Magazine spring

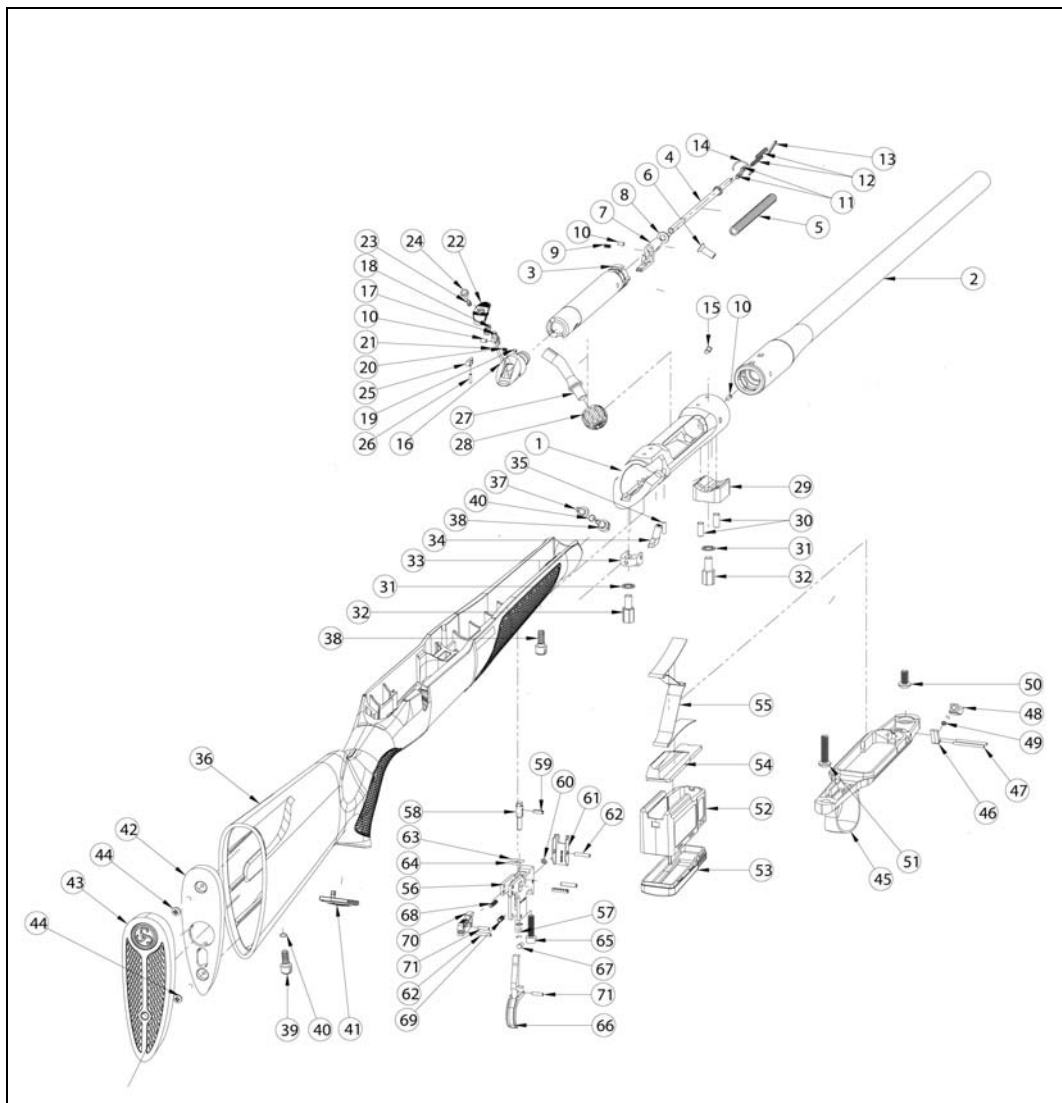


fig. 14 // , Replacement parts for S 101





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