

# ***SAUER 202***



***Operating and  
Safety Instructions***  
(Version 10.07)

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## 1 General instructions

**Be sure to read through these instructions carefully before any manipulation on this SAUER rifle.**

**Keep this instructions carefully with the SAUER rifle for later use.**

**If the rifle changes hands these instructions must be given to the new owner.**

Understanding these instructions and the technically correct implementation of the information contained therein are **imperative** to correct preparation and safety during handling, maintenance and care of this SAUER rifle.

Do not use the rifle until you have fully understood all safety instructions and its handling procedures.

Should you require further information, do not hesitate to contact your dealer, importer or the manufacturer.

Please observe the local and national legislation governing the ownership, carrying and use of firearms.

The owner of the rifle must have a valid firearms licence in order to buy and own the rifle.

Permission to shoot the rifle is given by way of a permit.

Be aware that rifles, like all firearms, are dangerous. The rifle accompanying these Operating and Safety Instructions has been sold under the express understanding that the manufacturer and the importer of the rifle decline any responsibility for consequences of manipulations on the rifle or use of the rifle.

This applies in particular to liability for bodily harm or damage to property resulting in part or in whole to:

- use with criminal intent or negligent use,
- improper or careless handling,
- defective, incorrect, hand-loaded or reloaded ammunition,
- inadequate care of the rifle (e.g. corrosion, damage),
- disregard of malfunctions,
- resale in contradiction of regional legislation and regulations,
- other circumstances beyond our direct and immediate control.

These limitation apply regardless of whether liability is asserted on the basis of contract, negligence or strict liability (including any failure to warn).

The manufacturer and the importers are not liable for incidental or consequential damages such as loss of use of property, commercial loss or loss of earnings and profits.

## 2 Safety regulations

**Be sure to read through these instructions carefully before each handling or use of this SAUER rifle and that you have understood them.**

### 2.1 Safe handling of the rifle

- Never try to modify or convert the rifle yourself. Only use approved original accessories.
- Always think of the rifle as being loaded and with the safety off until you have established the opposite through the unloading procedure.
- Never shoot with a rifle which has been penetrated by water, sand, dirt or other foreign bodies.
- Always keep the rifle and the ammunition separate from one another, and ensure that neither is obtained by unauthorised persons or children.
- Always treat your rifle as if the safety mechanisms were not functioning. The best safety precaution is a correct, well-trained and safe handling of the rifle.
- Never rely on safety mechanisms alone. Safety mechanisms are not a substitute for careful, correct and secure handling of the rifle.
- Never store the rifle loaded, but remove the magazine and verify that there is no cartridge left in the chamber of the barrel by following the unloading procedure.
- Never check the safety lock of the rifle by pulling the trigger.

### 2.2 Risks for the user and how to avoid them

- Never use the rifle under the influence of drugs or alcohol, while ill or suffering other such difficulties. These conditions can impair your powers of judgment and reflexes.
- Never aim at yourself or other people.
- Never place your hand in front of the muzzle, above the barrel chamber or behind the slide.
- Always unload the rifle immediately after firing, before putting the rifle away, putting into a holster or handing it to another authorised person.
- Never point the rifle at doors, panes of glass, walls, concrete, stone or flat surfaces (including water). A bullet can penetrate such surfaces or be ricocheted in an unsafe direction.
- Take care not to breathe in the developing gunpowder smoke or get it into the eyes. Should this happen, stop shooting immediately.

### 2.3 Risks for other people and how to avoid them

- Never let a loaded rifle out of your hand.
- Never leave the rifle unattended and protect the rifle against unauthorised access.
- Never give the rifle to a person who has not thoroughly familiarised himself or herself with the safety instructions and handling of the rifle, by reading the corresponding instructions.

# Safety regulations

- Always keep the muzzle of the rifle in a safe direction with all handling. A safe direction is towards an area where there are no people, other living beings or property that is not a recognised target.
- Also make sure what lies behind your target.
- Point out any dangers from noise, empty cartridges and gunpowder smoke to those present. Stop shooting immediately if such dangers occur.

## 2.4 Ensure proper use


- The owner of the rifle must ensure that it is only used for its intended purpose.
- The incorrect, careless or improper use of the rifle causes risks for the life and limb of the user and for other people or living beings.


## 2.5 Personal protective equipment


- When shooting, always wear ear protection and protective glasses. Inform other people close to you about the need to wear ear protection and protective glasses.

## 2.6 Graphical representation of safety indications

**In the individual sections of these instructions, the following safety indications alert you to risks:**

	<b>DANGER!</b>
Information on dangers, which if not scrupulously observed, will result in immediate severe bodily harm or death.	

	<b>WARNING!</b>
Information on dangers, which if not scrupulously observed, can lead to severe bodily harm or death.	

	<b>CAUTION!</b>
Information on dangers, which if not scrupulously observed, can lead to bodily harm, damage to property and damage to the rifle.	

	<b>CAUTION!</b>
Information on technical requirements, which if not scrupulously observed, can lead to damage to the rifle.	

- Each of these safety indications consists of:
  - a headline with a signal word, a signal pictorial and a corresponding colour code
  - a description of the danger type and source
  - a description of possible consequences if the safety indications message is ignored
  - a description of actions or regulations for danger prevention

3 Product description

3.1 Main parts



Fig. 1

Item	Description
100	Bolt
200	Receiver
300	Barrel
400	Main stock

Item	Description
500	Front stock
600	Magazine
700	Trigger

# Product description

## 3.2 Technical Specifications

Functional principle	Repeater rifle	
Action type	Direct lug locking in the barrel	
Caliber	<b>Mini:</b> .222 Rem., .223 Rem.  <b>Medium:</b> .22-250 Rem.; .243 Win.; .25-06 Rem.; 6,5x55; 6.5x57; .270 Win.; 7x64; .308 Win.; .30-06; 8x57 IS; 9.3x62  <b>Magnum:</b> 6.5x68; .270 Wby. Mag.; 8x68 S; 7 mm Rem. Mag.; .300 Win. Mag.; .300 Wby. Mag.  <b>BigGame:</b> .375 H&H Mag.; .416 Rem. Mag.; .458 Lott	
Length, overall	<b>Mini:</b> approx. 1,115 mm (with barrel length 600 mm) <b>Medium:</b> approx. 1,115 mm (with barrel length 600 mm) <b>Magnum:</b> approx. 1,170 mm (with barrel length 650 mm) <b>BigGame:</b> approx. 1,120 mm (with barrel length 600 mm)	
Barrel length	<b>Mini:</b> 510, 560, 600 mm <b>Magnum:</b> 600, 650 mm	<b>Medium:</b> 510, 560, 600 mm <b>BigGame:</b> 600 mm
Stock length (Monte Carlo stock)	approx. 355 mm	
Stock indentation (Monte Carlo stock); from top edge of receiver	<b>front:</b> 32 mm <b>centre:</b> 25 mm <b>back:</b> 50 mm	
Stock offset	5 mm	
Trigger weights	<b>Pure rifle trigger:</b> approx. 15 N <b>Rifle trigger (with set trigger):</b> approx. 13 N <b>Set trigger:</b> approx. 3 N <b>Match trigger:</b> approx. 7 N	
Magazine content	<b>Mini:</b> 3 rounds <b>Magnum:</b> 2 rounds	<b>Medium:</b> 3 rounds <b>BigGame:</b> 2 rounds
Replacement magazine	<b>Medium:</b> 5 rounds <b>Magnum:</b> 4 rounds <b>BigGame:</b> 4 rounds	
Weight without telescopic sights with steel receiver, 600 mm barrel length and Monte Carlo stock.	<b>Mini:</b> 3.5 kg <b>Medium:</b> 3.5 kg <b>Magnum:</b> 3.7 kg <b>BigGame:</b> 3.8 kg	

## Product description

### 3.3 Main features

The SAUER 202 is a high precision hunting rifle built to the latest technology. It is an easy to handle repeater with rifle trigger which can be fitted with a rear set trigger.

The modular construction makes it easy to change individual components including the caliber.

Both mechanical and optical aims can be fitted.

There is a wide range of accessories available. The SAUER 202 is also available as a left-handed version.

### 3.4 Scope of delivery

The standard scope of delivery includes:

- 1 x rifle
- 1 x magazine
- 1 x special socket spanner (2 parts)
- 1 x Allen key for dismantling the barrel
- 1 x Operating and Safety Instructions manual
- 1 x Warranty card



Fig. 2, Standard scope of delivery



3.5 Modular principle

Components manufactured to perfect dimensions make it possible to produce a hunting rifle optimally tailored to your needs. It also allows you to modify and specialise your S 202 at a later date.

The complete and current option selection and individual possibilities can be found in the price list, the SAUER hunting catalogue or most conveniently on the SAUER homepage ([www.sauer.de](http://www.sauer.de)).

3.5.1 Caliber change retrofit table

The S 202 allows you to change between the caliber categories "Mini" and "Medium" and between the categories "Magnum" and "Big Game". Dependent on the caliber combination the bolt and/or magazine might also have to be replaced. Changing a barrel, i.e. a caliber change across the categories "Mini-Medium" and "Magnum-Big Game" is not possible.

All information about the barrel contours available for the respective calibers and the required front stocks can be found in the price lists, the SAUER hunting catalogue or most conveniently on the SAUER homepage ([www.sauer.de](http://www.sauer.de)).

Mini and Medium calibers

Barrel with caliber	Magazine	Bolt
.222 Rem.	Mini	Mini
.223 Rem.	Mini	Mini
.22-250 Rem.	Medium Short	Medium Short
.243 Win.	Medium Short	Medium Short
.25-06 Rem.	Medium	Medium
6,5x55	Medium	Medium
6,5x57	Medium	Medium
.270 Win.	Medium	Medium

Barrel with caliber	Magazine	Bolt
7x64	Medium	Medium
.308 Win.	Medium Short	Medium
.30-06	Medium	Medium
8x57IS	Medium	Medium
9,3x62	9,3x62	Medium

Magnum and BigGame calibers

Barrel with caliber	Magazine	Bolt
6,5x68	Magnum	Magnum
.270 Wby. Mag.	Magnum	Magnum
7 mm Rem. Mag.	Magnum	Magnum
.300 Win. Mag.	Magnum	Magnum
.300 Wby. Mag.	Magnum	Magnum
8x68S	Magnum	Magnum
.375 H&H	.375 H&H	Magnum
.416 Rem. Mag.	.416 Rem. Mag.	Magnum
.458 Lott	.458 Lott	Magnum

### 3.6 Accessories

Your SAUER 202 is a modular hunting rifle which can be easily adapted to new uses at a later date. The complete and current option selection and individual possibilities can be found in the price list, the SAUER hunting catalogue or most conveniently on the SAUER homepage ([www.sauer.de](http://www.sauer.de)). There you will also find all telescopic sight assemblies, replacement barrels, replacement magazines, sights and any other rifle accessories.

In addition Sauer & Sohn offers accessories for the perfect transport and stylish presentation of your rifle and for successful hunting. More precise information can be found in the catalogue or on the internet at ([www.sauer.de](http://www.sauer.de)).

### 3.7 Installation of optics and accessories

#### Note:

- **When fitting the telescopic sights please ensure an exact fit between the mounting base and the system housing. If a maladjustment is compensated for by firmly tightening the assembly screws there is a risk that the system sleeve will be damaged or the installation comes loose when a load is applied.**


	<b>CAUTION!</b>
<b>Improper installation of telescopic sights Rifle may be damaged</b>	
<ul style="list-style-type: none"><li>• A damage of the receiver results in a change of the barrel attachment which can make changing the barrel difficult or impossible on the one hand, and can have a negative impact on the firing precision on the other. The threads for the assembly screw could also be damaged or destroyed.</li><li>• For differently assembled rifles J. P. &amp; Sohn GmbH will not accept any warranty of the functionality and accurate firing.</li></ul>	

- Please only install mounting bases onto the receiver whose radii match those of the sleeve exactly.
- It should also be ensured that the mounting base is not only screwed on but also glued widely and evenly using a **dual component adhesive**.
- J. P. Sauer & Sohn GmbH recommends the original SAUER swivel mounting

## 3.8 Extras

### 3.8.1 Muzzle brakes

If your SAUER 202 is equipped with a muzzle brake (MagNaPort, Pendelton or SAUER muzzle brake) the sound pressure during firing increases by approx. 30 percent. This can result in severe damage to the hearing including deafness. For this reason a suitable ear protection must be worn whenever the rifle is used.



**WARNING!**  
**Increased sound pressure**  
**Potential severe hearing damage**

- When firing the rifle with a muzzle brake always wear a suitable ear protection.

### SAUER muzzle brake

The SAUER muzzle brake is screwed onto the barrel if required. For this the rifle must be prepared ex-factory with a corresponding thread and a rear offset sight. If the brake is not in use the barrel thread is protected by a metal screw cap included in the scope of delivery.

The rifle is supplied ex-factory with the protective cap attached and has been calibrated in this configuration. To remove the protective cap unscrew it anti-clockwise from the barrel.

To attach the muzzle brake, place the supplied brake onto the barrel thread and hand-tighten it clockwise.



Fig. 3

#### Note:

- With every change from protective cap to muzzle brake or vice versa the rifle must be recalibrated, because the the aiming point position will change considerably dependent on the chosen thread attachment!

### 3.8.2 Magazine lock MagLock

The special magazine lock MagLock is a 100% effective safety lock against unintentional unlocking of the magazine. Nonetheless, the shooter can rapidly change the magazine when required.

To lock (a) the magazine unlock button slide the cap on the button forward. To unlock (b) slide the cap back.

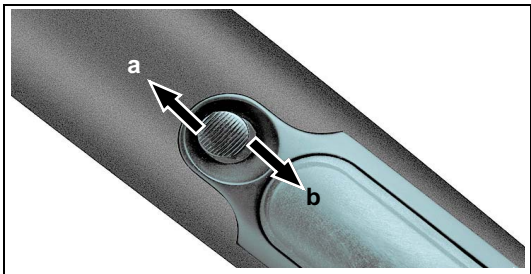


Fig. 4, a) locking, b) unlocking

### 3.8.3 Express sights

The SAUER Express sights are the perfect aiming device for hunting, moving game or for all those who frequently hunt without telescopic sights. The sights consist of an Express sight with a mechanical sight and a flap. The Holland & Holland front sight consists of a large white bead sight and a small brass bead sight which is visible when the large front sights are folded.

Rifles with these sights are always calibrated as follows:

- Fixed sight with large white bead sight to 50 metres (letting the aim rest),
- Folding sight with small brass bead sight to 100 metres (letting the aim rest).



Fig. 5

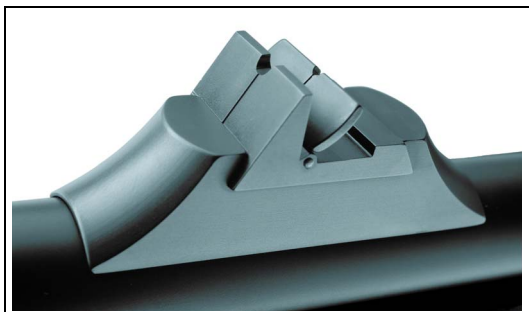


Fig. 6

### 3.9 Spare parts

J. P. Sauer & Sohn GmbH only supplies to authorised dealers in Germany or to the respective SAUER importer abroad. For ordering spare parts always contact your dealer who will then forward your order accordingly to the importer (abroad) or Sauer & Sohn (Germany). To enable the speedy and focused processing of your order, always provide the following information when ordering spare parts:


- Model, caliber, barrel length, extras
- Rifle number
- Item number from the spare parts list
- Designation of the desired spare part

#### Note:

- A table with the item numbers and designations is located on page 33 of this manual. A drawing on page 34 guides you in finding the correct item.

### 4 Transporting, storing and shipping the rifle

#### 4.1 Transporting the rifle

	<b>WARNING!</b>
<b>Careless actions may cause uncontrolled discharge of shot</b>	
<b>May lead to death or severe injuries</b>	
<ul style="list-style-type: none"><li>• For your own safety and for the safety of others, always transport the rifle in the unloaded condition and decocked.</li></ul>	

- Never carry a cocked rifle containing a round in the barrel chamber.
- Always carry the rifle in such a manner that, should you fall or otherwise slip, you are able to control the direction of the muzzle.
- Transport the rifle separate from the ammunition in a locked carrying case.
- The rifle and ammunition must not be accessible to children and other inexperienced or unauthorised persons.
- Ensure that you comply with all regional and national laws relating to the transport of firearms.

#### 4.1.1 Transport in assembled condition

##### Procedure:

1. Remove the magazine (see section 5.8.1).
2. Unload and lock the rifle (see section 5.6, 6.2).
3. Remove the bolt (see section 5.7.2).
4. If necessary remove the sling attachment (see section 7.1) to prevent scratching the stock components.
5. Clean the rifle (see section 8).

#### 4.1.2 Transport in the carrying case

##### Procedure:

1. Remove the magazine (see section 5.8.1).
2. Unload the rifle (see section 5.6).
3. Remove the bolt (see section 5.7.2).
4. Remove the sights/accessories (see section 3.7).
5. Remove the sling attachment (see section 7.1).
6. Clean the rifle (see section 8).
7. Remove the main stock (see section 7.2).

### **4.2 Storing the rifle**

- Never leave the rifle lying around when not in use.
- The rifle and ammunition must not be accessible to children and other inexperienced or unauthorised persons.
- Clean the rifle and keep it in a locked case during storage.
- Prior to prolonged storage the rifle must be greased with rifle grease. Ordinary oiling is not sufficient in this case.

### **4.3 Shipping the rifle**

#### **Note:**

- **Familiarise yourself fully with regional legislation governing the shipping and transportation of firearms.**

#### **Procedure:**

1. Check the rifle to ensure that it is unloaded and decocked.
2. Pack the rifle well (if possible in its original packaging) to prevent damage in transit. To prevent the rifle being recognised as such during shipping, wrap the original packaging in a second outer layer.
3. Do not include any accessories in the shipment.
4. Enclose a letter stating the following:
  - your full name
  - your full address (street, not P.O. Box)
  - your daytime telephone number
  - model and serial numbers of the rifle
  - detailed description of the problem encountered or the service work to be performed.
5. Send the rifle properly insured and carriage-paid (packages without correct postage will not be accepted) to:
  - the sales outlet from which you purchased the rifle
  - the local Sauer & Sohn dealer,
  - the Sauer & Sohn agent (importer) for your country
  - if there is no local appointed Sauer & Sohn dealer or Sauer & Sohn agent in your country, to J.P. Sauer & Sohn GmbH.

## 5 Handling the rifle

For safety reasons the bolt and the magazine must not be inserted during:

- first commissioning and
- taking possession of the rifle.


**Note:**

- **The rifle is generally delivered preserved with a thin, protective grease and oil coating and must be stripped before being used for the first time, protective oil or grease removed and lubricated again.**

### 5.1 Initial preparation

**Note:**


- **For your own safety the rifle must always be subjected to this initial preparation. This alone guarantees the faultless operation of the rifle.**

	<b>WARNING!</b>
<b>Undefined condition of the rifle may cause uncontrolled discharge of shot May lead to death or severe injuries</b>	
<ul style="list-style-type: none"><li>• If the shooter takes possession of the rifle in any other condition it must be treated as loaded and unlocked.</li></ul>	


**Procedure:**

1. Unload the rifle (see section 5.6).
2. Remove the bolt (see section 5.7.2).
3. Check whether ammunition is still in the barrel chamber or in the magazine.
4. Clean the barrel (see section 8.2).
5. In addition during first commissioning:
  - Clean external metal surfaces (see section 8).
6. If supplied in compact case:
  - Fit the main stock (see section 9.2).

### 5.2 Ammunition

	<b>WARNING!</b>
<b>Malfunction due to inadmissible ammunition May lead to death or severe injuries and damage to the rifle</b>	
<ul style="list-style-type: none"><li>• For your rifle, use only commercial grade ammunition according to CIP resp. SAAMI specifications in its original packing which corresponds with the caliber of the rifle.</li><li>• Never use recharged, "reconditioned", hand-charged or non-standard ammunition in your rifle.</li><li>• Never use dirty, wet, corroded, bent, damaged or oiled ammunition.</li><li>• Never spray lubricants, preservatives or cleaning agents directly onto the rounds.</li><li>• Never leave the ammunition lying around unattended.</li></ul>	

## 5.3 Loading the rifle (ready to fire)

**WARNING!**

**Insufficient awareness of the risks may lead to careless actions**  
**May lead to death or severe injuries**

- Never load or unload the rifle inside a vehicle, inside a building or any other confined space (except in a designated firing range).
- Never rely on safety mechanisms. They are never a substitute for careful and correct handling of the rifle.
- Never let a loaded rifle out of your hands.

### Preparation:

1. Before loading, always wipe off any excess grease and oil and check that there is no obstruction in the bore of the barrel.
2. Always keep the muzzle of the rifle pointed in a safe direction.
3. Do not place the finger onto the trigger tongue, but outside the trigger guard.
4. Do not load the rifle by inserting the magazine until immediately before shooting.


### Procedure:

1. Unlock the rifle (see section 6.1).
2. Insert the bolt (see section 5.7.3).
3. Open the bolt and pull it back to the stop.
4. Fill the magazine (see section 5.8.3).
5. Insert the magazine (see section 5.8.2).
6. Push the bolt forward and lock.
7. Lock the rifle (see section 6.2).

### Condition of the rifle:

The rifle is loaded and ready to fire.

## 5.4 Discharging a shot


**WARNING!**

**Insufficient awareness of the risks may lead to careless actions**  
**May lead to death or severe injuries**

- Ensure that the target and the environment allow shots to be fired without danger.
- When discharging shots, ensure that neither your hands nor any other parts of the body are located in front of, over or adjacent to the barrel muzzle or the ejection port.
- Immediately stop shooting and unload the rifle if you suspect that a round has not been chambered properly, a case is jammed, a bullet is lodged in the bore or a discharge sounded or felt weak or abnormal.
- Never attempt to dislodge a blockage in the barrel by firing another round.

### Procedure:

1. Put on ear protection and protective glasses.
2. Never allow a third person to stand next to you where they could be hit by ejected cartridge cases.
3. Aim the rifle at a safe target.
4. Unlock the rifle (see section 6.1).
5. If necessary, set the trigger (see section 5.9.2).


**DANGER!**

**Shot will be fired**  
**Risk of immediate death or severe injuries**

- Only discharge the shot after you have aimed at your target and are sure that there is no risk to you and others caused by the discharge of the shot.



- 6. Place finger on trigger tongue and pull back the trigger tongue to discharge the shot. The trigger behaviour depends on the trigger fitted (see section 5.9).
- 7. Keep the rifle aimed at the target and fire further shots as required.
- 8. If the magazine is empty, reload the rifle (see section 5.5).
- 9. Lock and unload (see section 5.6).



**WARNING!**  
**Uncontrolled discharge of shot as the rifle is ready to fire**  
**May lead to death or severe injuries**

- If you decide to end the shooting session, immediately unload the rifle.

## 5.5 Reloading during shooting



**WARNING!**  
**Insufficient awareness of the risks may lead to careless actions**  
**May lead to death or severe injuries**

- Never let the rifle out of your hands.
- Keep the rifle pointed at the safe target.


### Procedure:

1. Lock the rifle (see section 6.2).
2. Remove the empty magazine (see section 5.8.1).
3. Unlock the rifle (see section 6.1).
4. Open the bolt and pull it back to the stop.
5. Fill the magazine (see section 5.8.3).
6. Insert full magazine and check engagement (see section 5.8.2).
7. Push the bolt forward and lock.
8. Lock the rifle (see section 6.2).

### Condition of the rifle:

The rifle is loaded and ready to fire.

## 5.6 Unloading the rifle




**WARNING!**

**Uncontrolled discharge of shot as the rifle is ready to fire**  
**May lead to death or severe injuries**

- Never let the rifle out of your hands before it is unloaded.
- The rifle is loaded, a round is located in the chamber of the barrel.
- Never place your hand over the ejection port of the bolt.

**Procedure:**

1. Lock the rifle (see section 6.2).
2. Aim the rifle at a stop-butt.
3. Remove the magazine (see section 5.8.1).
4. Unlock the rifle (see section 6.1).
5. Open the bolt. The cartridge or cartridge case is pulled out of the barrel chamber and is ejected.
6. Check that the cartridge has been ejected and that there is no further cartridge in the barrel chamber.
7. Empty magazine.
8. Pick up ejected round and clean the rifle.



**WARNING!**

**Malfunction due to not properly cleaned rifle**  
**May lead to death or severe injuries and damage to the rifle**

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

**Condition of the rifle:**

The rifle is unloaded.

## 5.7 Bolt

### 5.7.1 Cocking the bolt

In order to insert the bolt **100** into the rifle, the firing pin must be cocked.

A cocking indication provides information about the cocking state of the bolt.

**Procedure:**

1. Insert the tapered end of the supplied key into the side opening of the lock **113**.
2. Turn the lock towards the cocking wheel until it engages.

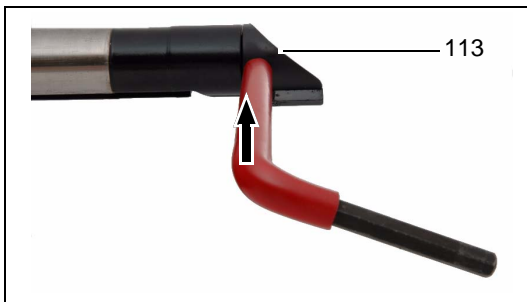


Fig. 7, Cocking the bolt



Fig. 8, Tension indication 103 of the bolt (left: cocked, right decocked)

## 5.7.2 Removing the bolt

### Procedure:

1. Unlock the rifle (see section 6.1).
2. Open the bolt and pull approximately half way back.
3. Fully push in the bolt handle catch **711** and pull out the bolt.



Fig. 9

## 5.7.3 Inserting the bolt



### WARNING!

**Careless actions may cause uncontrolled discharge of shot  
May lead to death or severe injuries**

- The rifle must be unloaded.


1. Unlock the rifle (see section 6.1).
2. Cock the bolt (see section 5.7.1).
3. Press the bolt handle catch and insert the cocked bolt into the receiver, close and lock.

### CAUTION!

**Rifle may be damaged**

- Never use force when inserting the bolt.
4. As functional check: carry out a repeater action.
  5. Check the safety functions with the rifle unloaded:
    - The safety and unlocking bolts must be freely moveable.
    - Firing a shot must not be possible in the locked state.
    - The bolt must not open in the locked state.
    - With the trigger set the rifle must automatically unset when the bolt is opened.
  6. If problems arise during the functional check or with the safety function, remove the bolt and repeat steps 1 to 5.

## 5.7.4 Uncock the firing pin

	<b>WARNING!</b>
<p><b>Careless actions may cause uncontrolled discharge of shot</b></p> <p><b>May lead to death or severe injuries</b></p> <ul style="list-style-type: none"> <li>Only uncock the firing pin with the rifle unloaded and the barrel chamber empty.</li> </ul>	

### Procedure:

1. Unload the rifle and check that there is no round in the barrel chamber (see section 5.6).
2. Pull the trigger tongue and slowly close the bolt with the trigger tongue held pulled.

### Note:

- **The cocking indication must not be visible (see Fig. 8).**

## 5.8 Magazine

### 5.8.1 Removing the magazine

#### Procedure:

1. Hold magazine **600** by hand.
2. If fitted: Push magazine safety towards the magazine (see section 3.8.2).

<b>CAUTION!</b>
<p><b>Magazine may fall out</b></p> <p><b>Magazine may be damaged</b></p> <ul style="list-style-type: none"> <li>When removing the magazine always keep your hand exactly underneath the magazine.</li> </ul>

3. Press the stud **207** with the index finger of the same hand.
4. Remove magazine.

### 5. Empty magazine.



Fig. 10

### 5.8.2 Inserting the magazine

#### Procedure:

1. Insert the magazine into the magazine shaft and push upwards until the magazine engages audibly. Do not jam the magazine.
2. If fitted: Push magazine safety towards the barrel (see section 3.8.2).

### 5.8.3 Loading the magazine

#### Procedure:

1. Push the rear feeder down.
2. Push the round from the front under the magazine lip.

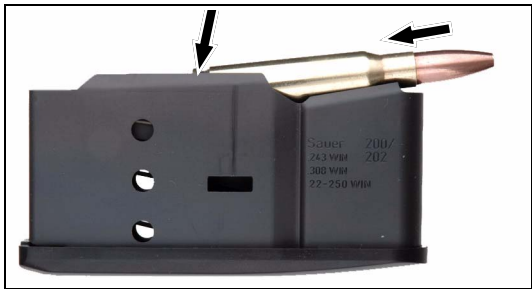


Fig. 11

## 5.9 Trigger

### Note:

- Three trigger variants are available for the SAUER 202: A rifle trigger, a rifle trigger with rear set trigger, and a pressure point match trigger.

	<b>CAUTION!</b>
<b>Rifle may be damaged</b>	
<ul style="list-style-type: none"><li>• The trigger can be changed, but this must only be carried out by a gunsmith.</li></ul>	


### 5.9.1 Rifle trigger

#### Note:

- The trigger weight has been set to approx. 15 N (1,500 g) at factory.

The rifle trigger is a direct trigger without creep.

- The shot is fired after the resistance has been overcome.

	<b>WARNING!</b>
<b>Careless actions may cause uncontrolled discharge of shot</b>	
<b>May lead to death or severe injuries</b>	
<ul style="list-style-type: none"><li>• For safety reasons the rifle trigger weight must only be modified by the manufacturer.</li></ul>	

### 5.9.2 Rifle trigger with rear set trigger


#### Note:

- The trigger weight of the rifle trigger has been set to approx. 13 N (1,300 g) at factory.

The rifle trigger with rear set trigger is a direct trigger without creep, which allows for a reduced trigger resistance by way of setting. The trigger resistance of the rear set trigger can be set individually (see page 21).

- The shot is fired after the resistance has been overcome.

#### Priming

	<b>WARNING!</b>
<b>Careless actions may cause uncontrolled discharge of shot</b>	
<b>May lead to death or severe injuries</b>	
<ul style="list-style-type: none"><li>• For safety reasons the rifle trigger weight must only be modified by the manufacturer.</li><li>• The set trigger can be triggered already by the slightest vibration. Therefore the trigger must not be set until immediately before firing the shot. Aim the rifle at a stop-butt. If the intended shot cannot be fired, immediately lock and reset the rifle.</li></ul>	

## Procedure:

1. Unlock the rifle (see section 6.1).
2. Press the trigger tongue **706** forward with the thumb until it engages.



Fig. 12

## Resetting

### Procedure:

1. Lock the rifle (see section 6.2).
2. Aim the rifle at a stop-butt.
3. Grip the trigger tongue with the thumb and index finger and pull back slowly.

### Note:

- If the bolt is opened, a reset will be carried out automatically.

## Modifying the trigger weight

### Note:

- The trigger weight of the set trigger has been set to approx. 3 N (300 g) at factory. It can be modified using the adjustment screw **729**.



## WARNING!

**Careless actions may cause uncontrolled discharge of shot**

**May lead to death or severe injuries**

- The trigger weight must not be adjusted to a value below 3 N (300 g).
- Set the set trigger for rough hunting use clearly harder than for use in the shooting range, because the trigger finger often loses feeling during the cold season.
- If the rifle unsets automatically when locked, the trigger weight has been set too low. It must immediately be set to a value where the rifle does not automatically unset when locked.

## Adjusting downwards:

- Turn the adjustment screw **729** clockwise.

## Adjusting upwards:

- Turn the adjustment screw **729** anti-clockwise.

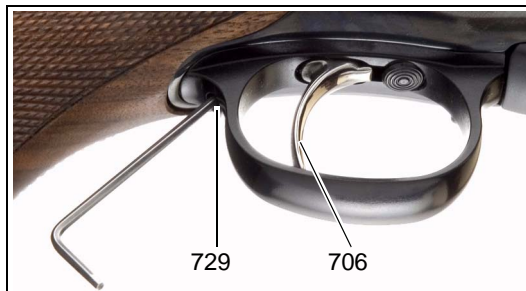


Fig. 13

## 5.9.3 Match trigger

### Note:

- The trigger weight has been set to approx. 7 N (700 g) at factory.

The match trigger is a pressure point trigger with adjustable creep.

- The trigger tongue must be pulled until it reaches a noticeable resistance (pressure point).
- The shot is fired after the resistance has been overcome.



### WARNING!

**Uncontrolled discharge of shot as the rifle is ready to fire**

**May lead to death or severe injuries**

- For safety reasons the trigger weight must only be modified by a qualified gunsmith. He can adjust the trigger weight between approx. 5 N (500 g) and 10 N (1,000 g).

### Creep adjustment (see Fig. 13):

#### Note:

- The creep travel cannot be adjusted to "zero", there will always be a travel by design.

#### Short creep:

- Turn the adjustment screw **729** clockwise.

#### Longer creep:

- Turn the adjustment screw **729** anti-clockwise.



### WARNING!

**Uncontrolled discharge of shot as the rifle is ready to fire**

**May lead to death or severe injuries**

- Any screws sealed with red varnish must not be interfered with by the user. If these screws are manipulated, the warranty will be void.
- The screw for reducing the creep must only be turned clockwise to a degree that the safety lock will still work properly.
- If the free movement of the safety lock is impeded, the screw **must** be **immediately** turned back **anti-clockwise** until the normal safety lock function is restored.

## 5.10 Sights

Dependent on the model selected the SAUER 202 is supplied with various sights or without open sights. If a rifle is supplied with open sights, those have been - dependent on the sight type - calibrated to 50 or 100 metres. The sights can be changed at a later date, but this should only be carried out by a gunsmith.

## 6 Safety lock

The safety lock of the SAUER 202 is an indirect firing pin safety lock.

It locks the trigger tongue, the trigger stop, and the firing pin nut and thus blocks all safety-relevant components.

Its function is based on a principle proven a million times over: A single function – a single button.

- The safety bolt is positioned at the top of the handle of the stock.
- The unlock slide is positioned well protected and easy to grip within the trigger guard in front of the trigger tongue.

### 6.1 Unlocking

#### Procedure:

1. Slide the unlock slide **714** with the trigger finger upwards to the stop.
  - The safety bolt **210** is also pushed upwards thereby and releases a red signal ring.

#### Condition of the rifle:

Rifle unlocked:

- Red signal ring visible
- The safety bolt can be felt with the thumb.



Fig. 14, Rifle unlocked



## 6.2 Locking

### CAUTION!

#### Rifle may be damaged

- If the rifle has its trigger set and is then locked, the rifle cannot be unlocked and opened. To unlock and open the rifle again, it has to be unset manually (see section 5.9.2).

#### Procedure:

1. Press the safety bolt **210** down with thumb up to the stop.
  - The unlock slide **714** is pushed out of the trigger device at the bottom where it can be easily controlled with the trigger finger.

#### Condition of the rifle:

Rifle locked:

- Red signal ring not visible
- The unlock slide can be felt with the trigger finger.



Fig. 15, Rifle locked

## 7 Dismantling



### WARNING!

**Uncontrolled discharge of shot as the rifle is ready to fire**

**May lead to death or severe injuries**

- There must be no magazine in the rifle.
- Before stripping your rifle, ensure once again that it is unloaded (see section 5.6).

### 7.1 Removing the sling attachment

#### Procedure:

1. Firmly press in the spring bolt.
2. Turn the sling attachment gently and pull out.



Fig. 16, rear sling attachment bushing

#### Note:

- **Clean and oil the sling attachment regularly.**

### 7.2 Removing the main stock

#### Procedure:

1. Removing the string attachment (see section 7.1).
2. Unscrew the main stock screw in the hole of the main stock **401** anti-clockwise using the long end of the special spanner supplied (approx. 5 turns).
3. Remove the main stock by pulling it downwards.

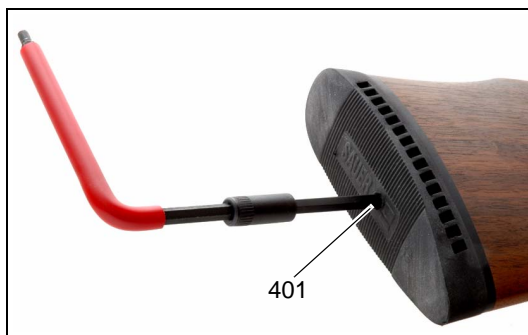


Fig. 17

## 7.3 Front stock removal

### Procedure:

1. Removing the string attachment (see section 7.1).
2. Insert the special spanner with the long end through the sling attachment bushing **503**.
3. Turn the front stock screw with the special spanner clockwise until the resistance at the spanner disappears.
4. Remove the front stock **502** by pulling it to the front.

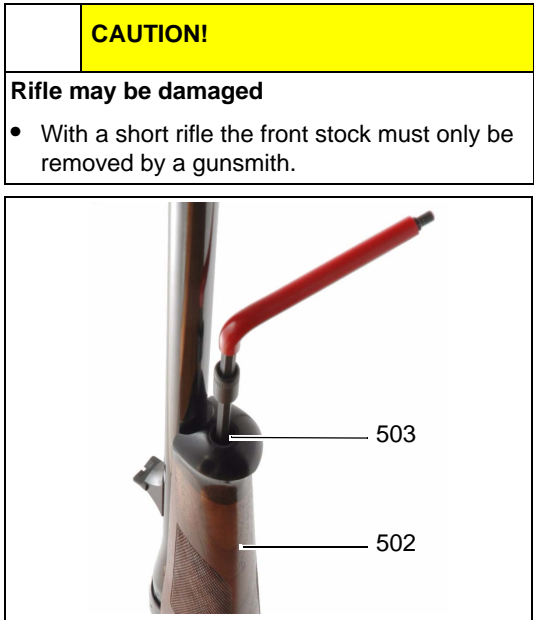


Fig. 18

## 7.4 Barrel removal

### Procedure:

1. Open and remove the bolt (see section 5.7.2).
2. Remove the front stock (see section 9.3).
3. With the spanner supplied undo the clamping screws **203** but do not remove them.
4. Only fully pull out the clamping screw **203A**.
5. Remove the insert **208** by pulling downwards.
6. Pull the barrel **301** off the receiver **200**, if necessary, turn to and from whilst pulling.

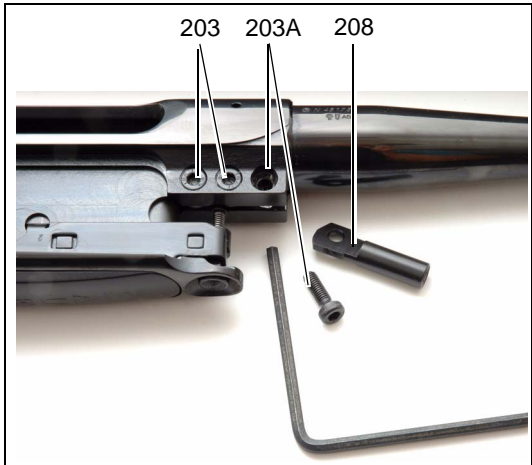
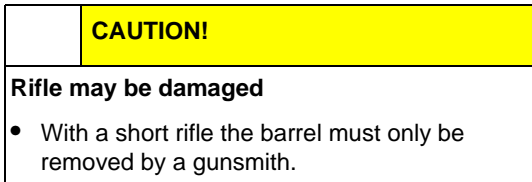


Fig. 19



## 8 Care

### 8.1 General

The proper functioning and precision of the rifle can only be maintained through regular and expert care. The rifle must be cleaned and protected against corrosion after each use. The bore must be cleaned and protected against corrosion after each firing. Wooden stocks must be treated with a suitable agent in accordance with the corresponding instructions and must be protected against the weather.

For the optimum care for your SAUER 202 we recommend care products such as a Premium rifle grease.

For a normal cleaning it is sufficient to remove or dismantle the following rifle parts:

- Magazine
- Bolt
- Rifle sling

If the rifle has been exposed to extreme moisture or is heavily soiled, it is recommended to remove or dismantle the following rifle components:


- Bolt
- Magazine
- Telescopic sights
- Rifle sling
- Main stock
- Front stock

### 8.2 Cleaning the barrel

<b>CAUTION!</b>
<p><b>Rifle may be damaged</b></p> <ul style="list-style-type: none"> <li>• Never clean barrel from the front end and do not use a steel or brass wire brush as it can destroy the smooth surface of the barrel. Use a suitable cleaning rod and a brush of matching caliber.</li> <li>• Detergents can damage the surface of the rifle. Read the manufacturer's indications and warnings before using solvents or cleansers.</li> </ul>

#### Procedure:

1. Unload the rifle (see section 5.6).
2. Remove the bolt (see section 5.7.2).
3. Instead of the bolt insert a cleaning aid ("False lock") for the exact centred guidance of the cleaning rod.
4. Clean the bore and barrel chamber from the back using suitable fluids or grease (observe the respective instructions for use) and a suitable, caliber-matched, bronze or plastic cleaning brush.
5. Check whether deposits of the rounds have collected in the sections. If necessary, clean the barrel with a commercial grade barrel cleaning agent (observe the respective instructions for use) designed for firing residue.
6. Coat the barrel bore and the barrel chamber with a little rifle oil or rifle grease.
7. Dry the barrel bore and the barrel chamber from the back using a plastic coated cleaning rod of the correct caliber.

	<b>WARNING!</b>
<p><b>Uncontrolled discharge of shot as the rifle is ready to fire</b></p> <p><b>May lead to death or severe injuries</b></p> <ul style="list-style-type: none"> <li>• There must be no magazine in the rifle.</li> <li>• Before stripping your rifle for cleaning, ensure once again that it is unloaded (see section 5.6).</li> </ul>	

## 8.3 External metal and wood surfaces

For the care and preservation of the external metal and wood surfaces we recommend a Premium rifle grease. Minute spherical Teflon® particles seal the pores of all wood and metal surfaces and provide perfect protection and optimal sliding characteristics.

### Benefits:

- dry surfaces - dust etc. does not adhere;
- water and salt water proof;
- absolute corrosion protection;
- perfect sliding characteristics, reduced wear;
- resistant to sweaty palms;
- pressure resistant up to 57,000 kg/cm<sup>2</sup>;
- temperature resistant from -50 to +230 °C;
- perfect protection and care for steel **and** wood;
- neutral smell;

	<b>CAUTION!</b>
<b>Rifle may be damaged</b> <ul style="list-style-type: none"> <li>• Caring for the external metal surfaces is particularly important in wet weather or if the metal surfaces have come into contact with sweaty body parts.</li> <li>• Always wipe dry the rifle prior to preservation.</li> </ul>	

### Procedure:

1. Thoroughly clean the rifle using suitable cloths and cleaning agents.
2. Thinly apply the grease with a cloth or sponge over the whole rifle (including the stock) including all mechanical and moveable parts.
3. After a reaction time of at least 60 minutes wipe dry and polish the rifle with a clean cloth.
4. Dependent on the weather and frequency of use the protective effect will last between two to six months.

### Note:

- **The sling attachments must also be cleaned regularly and their locking mechanism oiled.**
- **So-called "water stains" on the stock after rain cannot be avoided. Dependent on the limestone, dust and dirt particle content of the rain this phenomenon is stronger or weaker. It is not a defect in the stock finish.**

## 9 Assembly

	<b>CAUTION!</b>
<b>Rifle may be damaged</b>	
<ul style="list-style-type: none"><li>• Only assemble cleaned rifle parts.</li><li>• Only tighten the screws for the stock attachment by hand (only operate the special spanner with two fingers), (see Fig. 21).</li></ul>	

### 9.1 Fitting the barrel

	<b>CAUTION!</b>
<b>Rifle may be damaged</b>	
<ul style="list-style-type: none"><li>• Do not use force when inserting the barrel into the receiver.</li><li>• Only tighten clamping screws until the hexagonal leg in the screw starts turning with a spring action (noticeable torque limit), (see Fig. 20).</li><li>• The spanner must not be extended by attaching a tube.</li><li>• When using a torque spanner tighten the screw to 7 Nm.</li></ul>	

#### Procedure:

1. Insert the barrel **301** with the barrel groove facing downwards up to the stop into the receiver.
2. Push the insert **208** from below up to the stop into the clamping device. Ensure that the barrel is aligned in such a way that the insert remains easy to move all the time.

3. Turn the barrel until the insert engages in the barrel groove.
4. Insert the clamping screw **203A**.
5. Gently tighten the clamping screws **203**, **203A**.
6. Insert and lock the bolt (see section 5.7.3).
7. Check the bolt action with the rifle unloaded.
8. Alternatively tighten the clamping screws **203** and **203A** a little more until the barrel is held without tension (alternative: tightening with a torque spanner: torque 7 Nm).
9. Fit the front stock (see section 9.3).

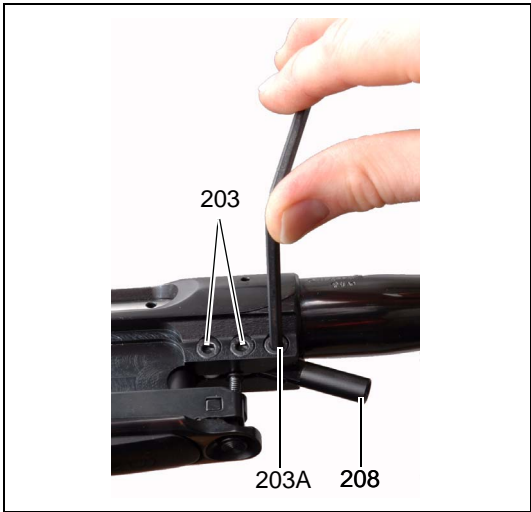


Fig. 20

#### Note:

- **A test firing is required each time the barrel was changed.**

## 9.2 Fitting the main stock

Corresponding figure, see Fig. 17.

### Procedure:

1. Slide the main stock onto the rifle.
2. Hand-tighten the main stock screw clockwise with the long end of the special spanner supplied (approx. 5 turns).
3. Fit the sling attachment (see section 9.4).

## 9.3 Fitting the front stock

Corresponding figure, see Fig. 21.

### Procedure:

1. Slide the front stock **502** onto the rifle and press the sides of the front stock into the sides of the receiver.
2. Hand-tighten the front stock screw clockwise with the long end of the special spanner supplied.
3. Fit the sling attachment (see section 9.4).

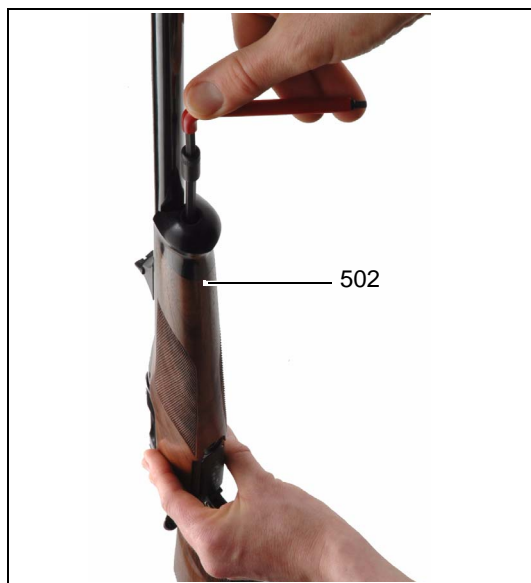


Fig. 21

## 9.4 Fitting the sling attachment

Corresponding figure, see Fig. 16.

### Procedure:

1. Insert the bolt of the rear sling attachment into the sling attachment bushing **407**.
2. Press in the spring bolt.
3. Gently turn the sling attachment until the bolt safety lock engages.
4. Insert the bolt of the front sling attachment into the front sling attachment bushing **503**.

### Note:


- The sling attachment must be aligned exactly  $90^\circ$  to the orientation of the barrel.
- The bolts must protrude clearly above the edge of the sling attachment body.

10 Malfunctions

10.1 Detecting a malfunction

Rifle maintenance (cleaning and inspection) according to the instructions can prevent malfunctions.

Should, nevertheless, a malfunction occur during shooting, proceed as follows:



**WARNING!**

**Careless actions may cause uncontrolled discharge of shot**  
**May lead to death or severe injuries**

- Hold the rifle pointed in the firing direction (safe direction) and keep your finger off trigger tongue while you carry out the steps described below.


Procedure:

1. Immediately stop shooting and alert others to the malfunction.
2. Remove magazine and unload the rifle (see section 5.8.1).
3. Open the bolt. The cartridge or cartridge case is pulled out of the barrel chamber and is ejected.
4. Check that no bullet, round, cartridge case or foreign matter is in the barrel chamber or barrel.

5. If the malfunction is listed in the table below and its remedy is described, then the user is allowed to remedy the malfunction in accordance with the table.
6. Clean, lubricate and assemble the rifle.
7. Have the rifle inspected by an armourer or gunsmith.

Note:

- For malfunctions not listed in the table, the user must under no circumstances remedy the malfunction.
- In this case the rifle must be checked and repaired by a qualified armourer or gunsmith.



**WARNING!**

**Improper servicing of the rifle**  
**Possibly death or serious injuries**

- Never force a bullet stuck in the barrel (jammed bullet) by „firing it free” with another bullet.
- Never repair broken or worn components yourself. Broken or worn components must be disposed of.



## 10.2 Cause and remedy of malfunctions

Malfunction	Possible cause of malfunction	Possible remedy of malfunction
No round chambered.	Magazine not properly inserted, deformed or dirty.	Insert magazine all the way until it engages (see section 5.8.2).
	Rifle faulty.	Repair by manufacturer.
Bolt cannot be inserted into the receiver.	Bolt handle catch not pressed.	Press bolt handle catch (see section 5.7.3).
	Mainspring is uncocked.	Cock the bolt (see section 5.7.1).
	Rifle faulty.	Repair by manufacturer.
Rifle trigger cannot be set.	Rifle is uncocked.	Cock the rifle (see section 5.7.1).
	Rifle faulty.	Repair by manufacturer.
Rifle cannot be locked.	Rifle is uncocked.	Cock the rifle (see section 5.7.1).
	Rifle faulty.	Repair by manufacturer.
Rifle can be neither unlocked nor opened.	Rifle has trigger set and is locked.	Unset the rifle trigger (see section 5.9.2).
	Rifle faulty.	Repair by manufacturer.
Rifle trigger is set. When pulling the trigger tongue no shot fires, instead the trigger tongue returns to the start position.	Trigger tongue was pulled to the side.	Reset, pull trigger tongue back straight/linear.
Rifle disengages automatically when locking.	Set trigger is set too soft.	Immediately adjust the set trigger harder (see section 5.9.1).

## 11 Spare parts

### Item designation

#### 100 Bolt assembly

- 102 Straight pin
- 103 Striking pin nut
- 104 Brazed nipple
- 105 Firing pin spring
- 106 Firing pin
- 107 Ejector pin
- 108 Ejector pressure spring
- 109 Clamping sleeve
- 110 Extractor
- 111 Pin for extractor spring
- 112 Bolt
- 113 Lock

#### 200 Receiver assembly

- 201 Magazine ejector spring
- 202 Magazine case, light alloy or steel
- 203 3 clamping screws
- 204 Magazine catch
- 205 Guide pin
- 206 Pressure spring for magazine catch
- 207 Pressure bolt
- 208 Insert
- 209 2 Spring pins
- 210 Safety bolt
- 211 Threaded bolt
- 212 Set screw

### Item designation

#### 300 Barrel assembly

- 301 Barrel
- 302 Spring collet
- 303 Pan head screw
- 304 Pan head screw
- 305 Fixed sight
- 306 Sight base
- 307 Pan head screw
- 308 Front sight base

#### 400 Main stock assembly

- 401 Main stock
- 402 Retention sleeve
- 403 Main stock screw
- 404 Crown gear
- 405 Washer
- 406 Flat head wood screw
- 407 Sling attachment bushing
- 408 Butt
- 409 2 screws for butt

#### 500 Front stock assembly

- 501 Front stock screw
- 502 Front stock
- 503 Sling attachment bushing for front stock
- 510 "Stutzen" cover

#### 600 Magazine assembly

- 601 Magazine floor plate
- 602 Magazine spring
- 603 Feeder
- 604 Magazine case

### Item designation

#### 700 Set trigger device

- 701 Set trigger hammer
- 702 Straight pin
- 703 Pressure spring
- 704 Trigger stop
- 705 Straight pin
- 706 Trigger tongue
- 707 Straight pin
- 708 Pressure spring
- 709 2 spacers
- 710 Rocker lever
- 711 Bolt handle catch
- 712 Bolt catch
- 713 Spring for bolt catch
- 714 Unlock slide
- 715 2 straight pins
- 716 Pressure spring
- 717 Spring bolt
- 718 Trigger lever
- 719 Safety lock
- 720 Spring bolt
- 721 Pressure spring
- 722 Adjustment screw
- 723 Rocker lever
- 724 Spring bolt
- 725 Spring
- 726 Safety lever
- 727 Spring counter bearing
- 728 Trigger housing
- 729 Adjustment screw
- 730 Roll

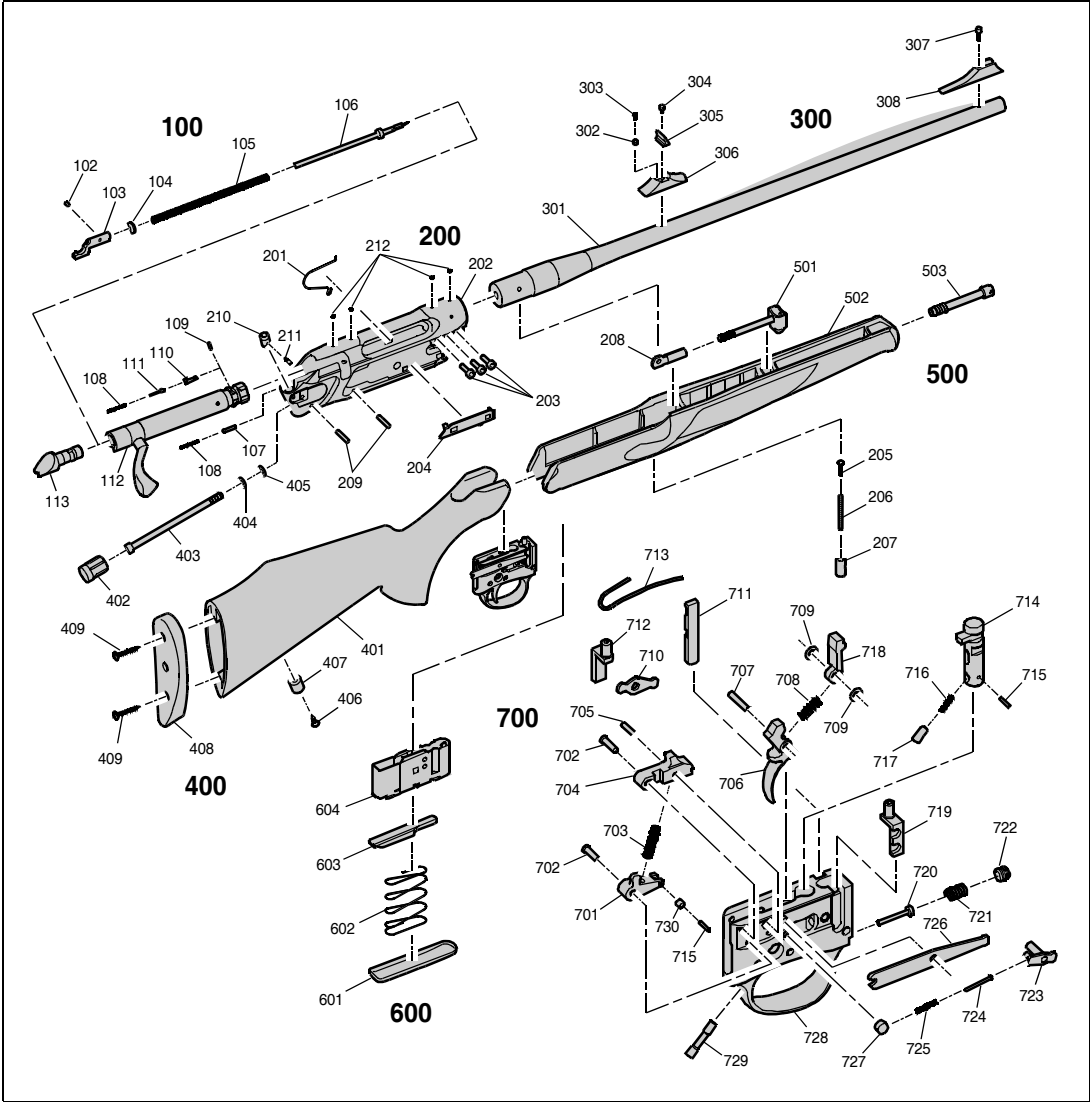


Fig. 22, Spare parts for S 202

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