

SAUER 

SAUER 303



***Operating and
Safety Instructions***
(Version 10.08)



S 303

New Dimensions

S 303 – superior technology, luxurious craftsmanship, perfected styling.

Leading innovations from the field now set new standards in safety, function and accuracy. Logical operations and perfect control combine for hunting success. The styling is testament to the sportsman's passion for the hunt and the result is a superior hunting rifle with the heart of a SAUER.

- A receiver milled from a solid block of metal is at its foundation. All other component parts are of modular design.
- The manual cocking feature on the upper wrist provides a premium on safety in any situation. All manual operations for loading, unloading and magazine removal as well as closing or opening the breech may be performed while the gun is decocked.
- The "IntraLock" firing pin safety engages automatically if the breech is not 100% in battery.
- Soldered or screwed-on barrel blocks are not necessary for gas management. Additionally, the automatic loading sequence cannot influence barrel vibrations since the forward part of the barrel is fully free-floating. The S 303 has inherited the accuracy for which SAUER is famous.
- The single-stage trigger sets new standards in its class. Creep is minimal and the shot breaks at 1,300 g like glass. With this unparalleled performance, the S 303 does as well from the blind as from the stand.
- The proprietary "isi-Mount" is perfectly tailored to the needs of today's hunter. With a 100% repeatable point of impact after removal, it puts the scope lower than ever before and only two motions are needed to adjust the eye relief by ca. 1 cm.
- The contrasting open sights consist of a triangular yellow rear blade and a red front bead which instinctively lead the eye to the target. The front sight is click-adjustable for windage and elevation. The optional Battue rib with its long sight line helps you make those tough snap shots.
- Snow, rain, cold and a pile of thorns – "NITROBOND X" is the new steel surface treatment that scoffs at the elements. Two elaborate plasma treatments ensure uncompromising protection against rust and scratching.

Table of contents

1	General instructions	2			
2	Safety regulations	3			
2.1	Safe handling of the rifle	3		5.7.3	Closing the slide silently
2.2	Risks for the user and how to avoid them	3		5.8	Magazine
2.3	Risks for other people and how to avoid them	3		5.8.1	Version with removable magazine
2.4	Ensure proper use	4		5.8.2	Version with fixed fold out magazine
2.5	Personal protective equipment	4		5.8.3	Loading the magazine
2.6	Graphical representation of safety indications	4		5.9	Trigger
3	Product description	5		5.9.1	Rifle trigger
3.1	Main parts	5		5.10	Sights
3.1.1	Version with removable magazine	5		5.10.1	Height adjustment of the sight
3.1.2	Version with fixed fold out cover magazine	5		5.10.2	Side adjustment of the sight
3.2	Technical Specifications	6		6	Hand cocking
3.3	Main features	7		6.1	Cocking the rifle
3.4	Scope of delivery	7		6.2	Decocking rifle
3.5	Accessories	8		7	Dismantling
3.6	Extras	8		7.1	Removing the sling attachment
3.7	Spare parts	9		7.2	Removing the main stock
4	Transporting, storing and shipping the rifle	9		7.3	Front stock removal
4.1	Transporting the rifle	9		7.4	Barrel removal
4.1.1	Transport in assembled condition	9		8	Care
4.1.2	Transport in the carrying case	10		8.1	General
4.2	Storing the rifle	10		8.2	Cleaning the barrel
4.3	Shipping the rifle	10		8.3	Cleaning the slide
5	Handling the rifle	11		8.4	External metal and wood surfaces
5.1	Initial preparation	11		9	Assembly
5.2	Ammunition	11		9.1	Fitting the barrel
5.3	Loading the rifle (ready to fire)	12		9.2	Fitting the main stock
5.3.1	Loading from the magazine	12		9.3	Fitting the front stock
5.3.2	Loading from your hand	12		9.4	Fitting the sling attachment
5.3.3	Silent loading	12		10	Mounting telescopic isi-Mount
5.4	Discharging a shot	13		10.1	Putting on the telescopic sight
5.5	Reloading during shooting	14		10.2	Removing telescopic sight
5.6	Unloading the rifle	14		10.3	Changing eye distance
5.7	Slide	15		11	Malfunctions
5.7.1	Open slide	15		11.1	Detecting a malfunction
5.7.2	Close the slide	15		11.2	Cause and remedy of malfunctions
				12	Spare parts
					29

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:

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

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

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

	CAUTION!
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

Product description

3 Product description

3.1 Main parts

3.1.1 Version with removable magazine

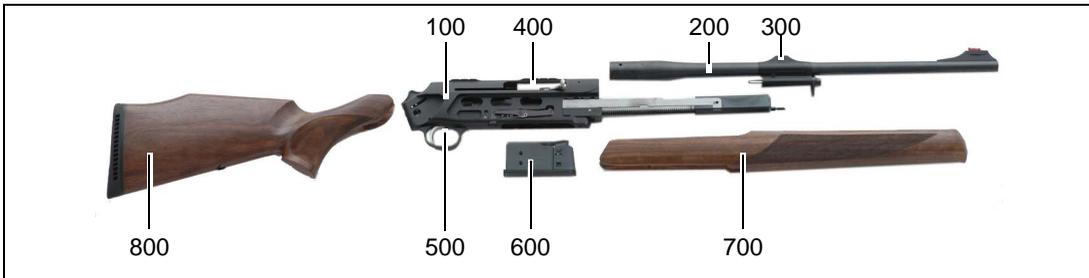


Fig. 1 Figure with closed slide

Item	Description	Item	Description	Item	Description
100	Receiver	400	Slide	700	Front stock
200	Barrel	500	Trigger mechanism	800	Main stock
300	Gas chamber with sights	600	Magazine		

3.1.2 Version with fixed fold out cover magazine



Fig. 2 Figure with open slide

Item	Description	Item	Description	Item	Description
100	Receiver	400	Slide	700	Front stock
200	Barrel	500	Trigger mechanism	800	Main stock
300	Gas chamber with sights	600	Spring magazine		

Product description

3.2 Technical Specifications

Functional principle	Self loading rifle/gas pressure loader
Action type	Rotary bolt lock, locking in barrel
Calibre	Medium: 7x64; .30-06; 8x57 IS; 9.3x62 Magnum: .300 Win. Mag.
Length, overall	approx. 1065 mm (with barrel length 510 mm) approx. 1115 mm (with barrel length 560 mm)
Barrel length	Medium: 510, 560 mm Magnum: 510, 560 mm
Stock length (Monte Carlo stock)	approx. 355 mm
Stock indentation (Monte Carlo stock); from top edge of receiver	Front: 32 mm Center: 25 mm Back: 50 mm
Stock offset	5 mm
Trigger weight	approx. 13 N - 15 N
Magazine content	Medium: 2 rounds Magnum: 2 rounds
Replacement magazine	Medium: 5 rounds / 2 rounds Magnum: 5 rounds / 2 rounds Magnum:
Weight without telescopic sights, 510 mm barrel length and Monte Carlo stock.	Medium: approx. 3,25 kg Magnum: approx. 3.25 kg

Subject to change without notice

Product description

3.3 Main features

The SAUER 303 is a high precision hunting rifle built to the latest technology. It is a self-loading rifle with manual clamping mechanism and flint trigger that is simple and safe to operate.

The housing is prepared for the installation of the new SAUER telescopic sight **isiMount**. In addition the modular design allows the installation of various main stocks, as well alternative rear sight devices or optical sight correction.

The SAUER 303 is also available with left-hand stocks, so that by its ability to be operated from both sides and the controlled case ejection, which is oblivious to left-hand shooters, a "real" left hand rifle is made available.

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 Torx spanner to dismantle the front stock and barrel.
- 1 x Operating and Safety Instructions manual
- 1 x Warranty card



Fig. 3, Standard scope of delivery

3.5 Accessories

Your SAUER 303 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). There you will also find all telescopic sight assemblies, 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 (www.sauer.de).

3.6 Extras

Hunting track - Battue

For instinct shooting using the open sight, the hunting track -Battue is offered which can be retrofitted on every SAUER 303.

Procedure:

1. Remove front stock (see section 7.3).
2. Remove the barrel (see section 7.4).
3. Unscrew the slotted screw on the sight base in front of the rear sight and slide the rear sight out of the base from the side (see Fig. 4).

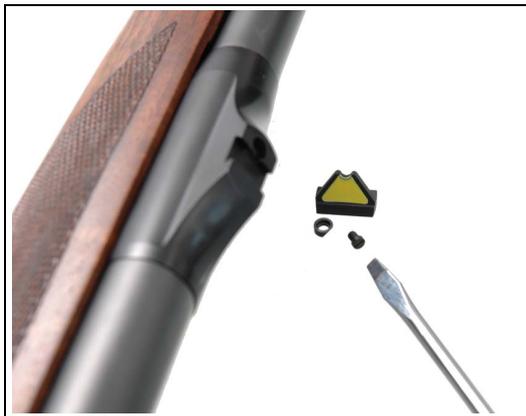


Fig. 4

4. Slide the hunting track in the base from the side and attach using the screw on front of the track with the correct SW 1.5 mm Allen key (see Fig. 5).



Fig. 5

5. Mount the barrel (see section 9.1). Be careful that the rear end of the hunting track enters the groove of the housing (see Fig. 6).



Fig. 6

6. Shoot the rifle using the open sight (see section 5.10).

3.7 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

4 Transporting, storing and shipping the rifle

4.1 Transporting the rifle



WARNING!

Careless actions may cause uncontrolled discharge of shot

May lead to death or severe injuries

- For your own safety and for the safety of others, always transport the rifle in the **unloaded** condition, **and decocked**.
- 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 unauthorized 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. Decock the rifle (see section 6.2).
2. Remove / open the magazine and empty if necessary (see section 5.8.1).
3. Unload the rifle (see section 5.6).
4. For models with fixed fold out cover magazine, close the empty magazine (see section 5.8.2).
5. Remove the sling attachment if necessary (see section 7.1).
6. Clean the rifle (see section 8).

4.1.2 Transport in the carrying case

Procedure:

1. Decock the rifle (see section 6.2).
2. Remove/open the magazine and empty if necessary (see section 5.8.1).
3. Unload the rifle (see section 5.6).
4. For models with fixed fold out cover magazine, close the empty magazine.
5. Remove the sight correction (see section 10.2).
6. Remove the sling attachment (see section 7.1).
7. Clean the rifle (see section 8).
8. 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.
3. Do not include any accessories in the shipment.
4. To prevent the rifle being recognised as such during shipping, wrap the original packaging in a second outer layer.
5. 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.
6. 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 magazine must not be installed or flipped in 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.



WARNING!

**Undefined condition of the rifle may cause uncontrolled discharge of shot
May lead to death or severe injuries**

- If the shooter takes possession of the rifle in any other condition it must be treated as loaded.

Procedure:

1. Unload the rifle (see section 5.6).
2. Check whether ammunition is still in the barrel chamber or in the magazine.
3. Clean the barrel (see section 8.2).

4. In addition during first commissioning:

- Clean external metal surfaces (see section 8).

5. If supplied in compact case:

- Fit the main stock (see section 9.2).

5.2 Ammunition



WARNING!

**Malfunction due to inadmissible ammunition
May lead to death or severe injuries and damage to the rifle**

- 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.
- Never use recharged, "reconditioned", hand-charged or non-standard ammunition in your rifle.
- Never use dirty, wet, corroded, bent, damaged or oiled ammunition.
- Never spray lubricants, preservatives or cleaning agents directly onto the rounds.
- Never leave the ammunition lying around unattended.

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.

5.3.1 Loading from the magazine

Procedure:

1. Decock the rifle (see section 6.2).
2. Remove/open magazine (see section 5.8.1/ 5.8.2).
3. Open slide (see section 5.7.1).
4. Fill the magazine (see section 5.8.3).
5. Install magazine or close (see section 5.8.1/ 5.8.2).
6. Close slide (see section 5.7.2).

Condition of the rifle:

The rifle is loaded and ready to fire.

5.3.2 Loading from your hand

Procedure:

1. Decock the rifle (see section 6.2).
2. Remove/open magazine (see section 5.8.1/ 5.8.2).
3. Open slide and lock (see section 5.7.1).
4. Hold the rifle with the muzzle pointing down.
5. Slide the round through the ejector window in the barrel chamber.
6. Close slide.

Condition of the rifle:

The rifle is loaded and ready to fire.



Fig. 7

5.3.3 Silent loading

Procedure:

1. Depending on the procedure, complete Steps 1 to 5 from section 5.3.1 or 5.3.2.
2. Close slide silently (see section 5.7.3).

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 not 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. Cock the rifle (see section 6.1).



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.
5. Place finger on trigger tongue and pull back the trigger tongue to discharge the shot.
 6. Keep the rifle aimed at the target and fire further shots as required.
 7. If the magazine is empty, reload the rifle (see section 5.5).
 8. Uncock the rifle 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 uncock and 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. Decock the rifle (see section 6.2).
2. Remove or open the empty magazine (see section 5.8.1 / 5.8.2).
3. Fill the magazine (see section 5.8.3).
4. Install or close full magazine and check the catch (see section 5.8.1 / 5.8.2).
5. Close the slide.

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. Decock the rifle (see section 6.2).
2. Aim the rifle at a stop-butt.
3. Remove or open the magazine (see section 5.8.1 / 5.8.2).
4. Open slide (see section 5.7.1) and lock. The cartridge is pulled out of the barrel chamber and is ejected.
5. Check that the round has been ejected and that there are no further rounds in the barrel chamber.
6. Empty magazine.
7. 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 Slide



WARNING!

Uncontrolled discharge of shot as the rifle is ready to fire

May lead to death or severe injury

- The rifle must be decocked before every manipulation on the slide!

5.7.1 Open slide

Procedure:

1. Decock the rifle (see section 6.2).
2. Remove/open magazine (see section 5.8.1 / 5.8.2).
3. Hold loading lever **416**.
4. Pull the slide straight back out until the stop (see Fig. 8).
5. Hold the slide tight and pull the slide lock **106** down.



Fig. 8

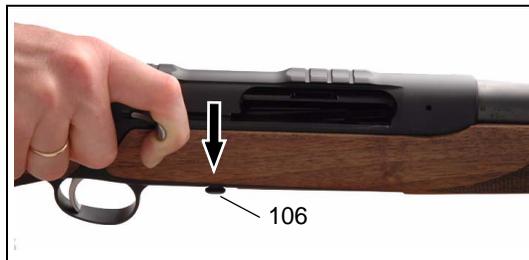


Fig. 9

5.7.2 Close the slide



WARNING!

Careless actions may cause uncontrolled discharge of shot

May lead to death or severe injuries

- The rifle must be unloaded.

1. Decock the rifle (see section 6.2).
2. Remove/open magazine (see section 5.8.1).
3. Press slide lock.



CAUTION!

Possible injury or damage to the rifle

- Never move the slide towards the front if there is a finger or foreign object in or in front of the ejection window!
- Never use force to close the slide.

5.7.3 Closing the slide silently

In some situations it can be an advantage to close the slide silently.

Procedure:

1. Decock the rifle (see section 6.2).
2. Remove/open magazine (see section 5.8.1 / 5.8.2).
3. Hold the loading lever tightly.
4. Press slide lock.
5. Move the slide slowly forward until it stops.
6. Push the slide forward with the loading lever until it is completely locked (see Fig. 10).



Fig. 10

5.8 Magazine

The SAUER 303 is available in two versions:

1. Version with removable magazine
2. Version with fixed fold out magazine (so called FM model)

5.8.1 Version with removable magazine

Removing the magazine

CAUTION!

Magazine may fall out
Magazine may be damaged

- When removing the magazine always keep your hand exactly underneath the magazine.

1. Press the stud with the pointer finger **107**.
2. Remove magazine.
3. Empty magazine.



Fig. 11

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.

5.8.2 Version with fixed fold out magazine

Open magazine

Procedure:

1. Press the stud with the pointer finger **107**.
2. Open magazine downwards.
3. Empty magazine.



Fig. 12

Inserting the magazine

Procedure:

1. Open magazine upwards, until the magazine audibly catches.

5.8.3 Loading the magazine

Procedure:

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

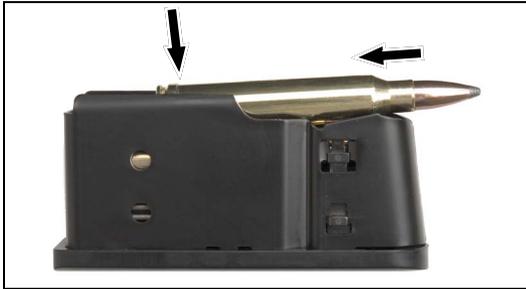


Fig. 13

5.9 Trigger

An adjusted flint trigger suitable for use is available for the SAUER 303.

5.9.1 Rifle trigger

Note:

- **The trigger weight has been set to approx. 13 N (1300 g) at the factory.**

The flint trigger is a direct trigger with a design dependent minimum stage.

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



WARNING!

Careless actions may cause uncontrolled discharge of shot

May lead to death or severe injuries

- The weight of the flint trigger must not be changed for safety reasons.

5.10 Sights

Depending on the selected model, the SAUER 303 is supplied with various sight devices. In each case the rifle is shot in the factory with open sight at 50 meters. A subsequent change of the sight device is possible.

5.10.1 Height adjustment of the sight

Procedure:

1. Place the correct 1.5 mm WAF Allen key in the screw on top of the front sight ramp before the front sight (see Fig. 14).
- Turn the screw with click-stop clockwise: Front sight moves higher, firing sits lower.
 - Turn the screw with click-stop counter-clockwise: Front sight moves lower, firing sits higher.



Fig. 14

5.10.2 Side adjustment of the sight

Procedure:

1. Place the correct Allen key in the front screw on the front sight base.
2. Loosen screw and move the front sight to the desired position.
3. Retighten screw.

Alternatively, the side adjustment can be also be done on the rear sight (only with normal rear sight slide, not with hunting track Battue) (see Fig. 15).



Fig. 15

Procedure:

1. Loosen the slotted screw on the rear sight ramp with the proper screwdriver
2. Move the rear sight to the side as desired.
3. Retighten screw (see Fig. 16).

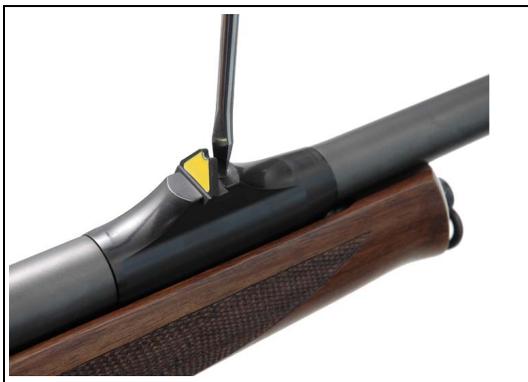


Fig. 16

6 Hand cocking

The SAUER 303 is equipped with a manual hand cocker on the stock handle. This enables the marksman to cock the lock of the rifle right before discharging a shot. In decocked condition the mainspring is relaxed, it is impossible to fire a shot.

Along with the manual hand cocker, to be operated by the marksman, the SAUER 303 additionally has an internal firing pin safety lock **intraLock**, which automatically activates if the slide is not completely locked. Because of this a discharged shot is impossible with a rifle that is not completely locked. The safety lock **intraLock** can not be actively influenced by the marksman.

The cocking slide is found easily, both visually and by touch, above on the handle of the stock. The modern **Silent Cocking System SCS** allows the cocking cycle to be made without making disturbing noise.

6.1 Cocking the rifle

Procedure:

1. Lay the thumb of the ribbed surface of the cocking slide **116** so that the tip of the thumb half covers the cocking slide pin **117** (see Fig. 18).
2. Press the cocking slide forward to the stop.



Fig. 17

Hand cocking

3. Lift the tip of the thumb so that the cocking slide pin 117 leaves the cocking slide silently (see Fig. 19).



Fig. 18

4. Remove the thumb from the cocking slide.

Condition of the rifle:

Rifle is cocked:

- Red point on the stock handle under the cocking slide is visible.
- Cocking slide pin 117 protrudes visibly and by touch out of the cocking slide (see Fig. 19).



Fig. 19

6.2 Decocking rifle

Procedure:

1. Lay the thumb on the ribbed surface of the cocking slide 116 so that the tip of the thumb half covers the cocking slide pin 117 (see Fig. 18).
2. Press the cocking slide slightly forward and simultaneously press in the cocking slide pin 117 with the tip of the thumb (see Fig. 18).
3. Move the cocking slide slowly backwards.
4. Remove the thumb from the cocking slide.

Condition of the rifle:

Rifle is decocked:

- Red point on the stock handle under the cocking slide is not visible.
- Cocking slide pin 117 is level with cocking slide.

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. 20, rear sling attachment bushing

Note:

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

7.2 Removing the main stock

Procedure:

1. Remove the sling attachment (see section 7.1).
2. Unscrew the main stock screw in the hole of the main stock **800** counter-clockwise using the long end of the special spanner supplied.
3. Remove the main stock by pulling downwards.

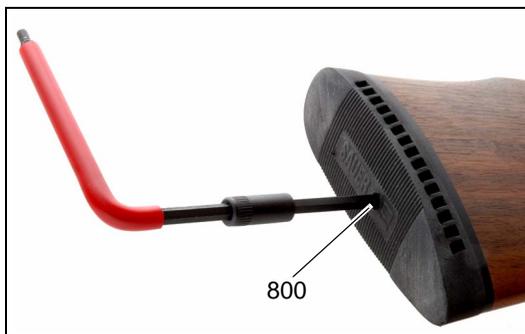


Fig. 21

7.3 Front stock removal

Procedure:

1. Remove the sling attachment (see section 7.1).
2. Insert the special Torx spanner with the short end through the sling attachment bushing **702**.
3. Turn the front stock screw with the special spanner clockwise until the resistance at the spanner disappears.
4. Remove the front stock **701** by pulling it to the front.



Fig. 22

7.4 Barrel removal

Procedure:

1. Remove/open magazine (see sections 5.8.1 / 5.8.2).
2. Open slide and lock (see section 5.7.2).
3. Remove the front stock (see section 7.3).
4. Loosen the clamping screws with the supplied Torx spanner **102** by approx. a half turn, however do not remove.
5. Turn the Torx spanner **102** with the long end in opening between the two screws until the stop, so that the housing is slightly pryed open.
6. Remove the barrel **201** from the housing **100**.



Fig. 23



Fig. 24

8 Care

8.1 General

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. The slide and the slide rail must always be cleaned and lightly lubricated 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 303 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
- 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:

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

8.2 Cleaning the barrel

CAUTION!

Rifle may be damaged

- Never clean the barrel from the front with a cleaning chain or a steel cable and do not use steel or brass brushes, because these will damage the surface of the barrel. Use a suitable cleaning string or the proper cleaning rod and brush of the proper calibre.
- Detergents can damage the surface of the rifle. Read the manufacturer's indications and warnings before using solvents or cleansers.

Procedure:

1. Unload the rifle (see section 5.6).
2. Open slide (see section 5.7.1).
3. Slide the cleaning string with a brush of the proper calibre through the ejection window in the barrel and pull it from the muzzle through the barrel.
4. When the barrel is removed clean from behind with a suitable cleaning rod.
5. Basically use only suitable cleaning agent, oil or grease.
6. 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.
7. Coat the barrel bore and the barrel chamber with a little rifle oil or rifle grease.
8. **With installed barrel:** Rub the barrel bore and barrel chamber dry by pulling through a suitable cleaning string several times.
9. **With dismantled barrel:** Rub the barrel bore and barrel chamber dry from behind with a plastic sheathed cleaning rod of the proper calibre.



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 for cleaning, ensure once again that it is unloaded (see section 5.6).

8.3 Cleaning the slide

Proper functioning of SAUER 303 is only guaranteed when the slide and its rail are always maintained absolutely clean and lightly lubricated.

- Open slide (see section 5.7.1).
- Clean everything accessible through the ejection window with a clean cloth.
- Clean locking head and base with a clean cloth.
- Thinly apply appropriate rifle oil to the surface of the slide rail.
- Close the slide (see section 5.7.2).
- Apply few drops of oil on the slide cover in the ejection window.
- Open and close the slide several times in order to achieve an optimum lubrication.

Attention:

Only a small amount of oil is required to obtain perfect function. Too much oil can lead to malfunction and to impairment of precision.

8.4 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/cm²;
- temperature resistant from -50 to +230 °C;
- perfect protection and care for steel and wood;
- neutral smell;

CAUTION!
<p>Rifle may be damaged</p> <ul style="list-style-type: none"> • 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. • Always wipe dry the rifle prior to preservation.

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. Depending on the calcium content and dust and dirt particle content of the rain water, this phenomenon is stronger or weaker. It is not a defect in the stock finish.**

9 Assembly

CAUTION!

Rifle may be damaged

- Only assemble cleaned rifle parts.
- Only tighten the screws for the stock attachment by hand (only operate the special spanner with two fingers), (see Fig. 26).

9.1 Fitting the barrel

CAUTION!

Rifle may be damaged

- Do not use force when inserting the barrel into the receiver.
- Tighten the screws only so tight as is possible with three fingers.
- The spanner must not be extended by attaching a tube.
- When using a torque spanner tighten the screw to 8 Nm.

Procedure:

1. Turn the Torx spanner **102** with the long end in opening between the two screws until the stop, so that the housing is slightly pryed open (see Fig. 24).
2. Push the barrel **201** up to the stop in the housing so that the spring guidance rod **113** comes through the provided opening under the gas cylinder housing (see Fig. 25).
3. Twist the torx-spanner completely out of the housing.
4. Alternatively, tighten the clamping screws **102** a little more until the barrel is held without tension (alternative: tightening with a torque spanner: torque 8 Nm).



Fig. 25

Note:

- **After every barrel removal and installation a test shot is necessary.**

9.2 Fitting the main stock

Corresponding figure, see Fig. 21.

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. 26.

Procedure:

1. Slide the front stock **701** 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 short end of the special Torx spanner supplied. If you are using a torque wrench, the tightening torque should be 3 Nm.
3. Fit the sling attachment (see section 9.4).



Fig. 26

9.4 Fitting the sling attachment

Corresponding figure, see Fig. 20.

Procedure:

1. Insert the bolt of the rear sling attachment into the sling attachment bushing **808**.
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 **702**.

Note:

- **The sling attachment must be aligned exactly 90° to the orientation of the barrel.**
- **The bolts must protrude clearly above the edge of the sling attachment body.**

10 Mounting telescopic *isi-Mount*

CAUTION!

Rifle may be damaged

- Do not use force when putting on and taking off the telescopic sight.

The housing of the SAUER 303 is already prepared for the mounting of the new SAUER telescopic sight "isi-Mount" (individual, selective, integrated) (see Fig. 27).



Fig. 27

This new mount guarantees the lowest design type, highest shot strength and absolute repeatability after taking off and putting on the telescopic sight. In addition the glass can always be mounted with the proper spacing due to the availability of 3 grooves in the front area of the housing.

Also the glass can be moved from the front to the rear groove (or opposite) without point of impact relocation. In this way the marksman can adjust the eye distance to the current conditions or his clothing thickness.

10.1 Putting on the telescopic sight

Procedure:

1. Lift up the locking lever of the mounting upper section and turn counter-clockwise.
2. Guide the telescopic sight slanted from the side into the housing grooves, so that the cross ribs of the mounting upper section lies congruent with the desired groove.
3. Tip the telescopic sight in the housing grooves.
4. Turn the locking lever with the thumb counterclockwise until the stop.

Mounting telescopic isi-Mount

5. Fold down the locking lever frontwards (in firing direction).



Fig. 28

10.2 Removing telescopic sight

CAUTION!

Rifle may be damaged

- When taking off the telescopic sight, the hand must always be placed on the telescopic sight so that it is held after loosening the mounting and does not fall.

Procedure:

1. Lift out the locking lever of the mounting surface towards the rear (opposite to firing direction).
2. Turn the locking lever counter-clockwise to the stop.
3. Tip the telescopic sight to the side upward from the housing grooves.



Fig. 29

10.3 Changing eye distance

1. Remove telescopic sight (see section 10.2).
2. The telescopic sight is to be set on the housing so that the rear mounting top section is congruent with the other of the two back grooves.
3. Set on telescopic sight (see section 10.1).



Fig. 30

For mounting other than is described here, the J.P. Sauer & Sohn GmbH takes no guarantee for function and shooting performance.

11 Malfunctions

11.1 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.

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

6. 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.

7. Clean, lubricate and assemble the rifle.

8. 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.

11.2 Cause and remedy of malfunctions

Fault	Possible cause of malfunction	Possible remedy of malfunction
No round chambered.	Magazine not properly inserted or closed, deformed or dirty. Rifle faulty.	Insert magazine completely until catch or close (see section 5.8.2). Repair by manufacturer.
Rifle is loaded and cocked. When trigger is pulled, no shot is fired.	Rifle is not completely unlocked.	Close slide completely (see section 5.7.2). Pull cocking slide manually back and cock again.
Rifle does not advance a new round automatically or clamps it tight.	Rifle is not held properly in the shoulder. Rifle faulty.	Decock the rifle (see section 6.2). Open slide (see section 5.7.1). Load new round. Pull rifle tight into the shoulder. Repair by manufacturer.
Rifle decocks automatically when firing.	When cocking the bolt for cocking slide (117) did not emerge completely out of the cocking slide.	When cocking the cocking bolt for cocking slide must emerge completely out of the cocking slide.
Cocking slide is in front position, when trigger is pulled no shot is fired and no cut off of the hammer.	Rifle is not decocked. Rifle faulty.	Pull cocking slide back until it engages audibly. Then cocking according to handling and safety instructions. Repair by manufacturer.

12 Spare parts

Item Designation

- 1 Housing
- 2 Clamping screw M6
- 3 Colour mark red
- 4 Cocking slide
- 5 Cylinder pin 3x20
- 6 Pressure spring for cocking slide
- 7 Bolt for cocking slide
- 8 Heavy adapter sleeve 2.5x18
- 9 Bolt for knurl barrel position
- 10 Spring bolt
- 11 Pressure spring for spring bolt
- 12 Ball Ø4
- 13 Bolt for magazine holder
- 14 Magazine holder
- 15 Locking bolt
- 16 Slide catch lever
- 17 Leaf spring for slide catch
- 18 Slider for slide catch
- 19 Spring for magazine ejection
- 20 Trigger housing
- 21 Hammer
- 22 Cylinder pin 4m6 x 16
- 23 Bolt for hammer
- 24 Spring bolt
- 25 Mainspring
- 26 Bolt for chain
- 27 Nut M2.5
- 28 Catch lever
- 29 Cylinder pin 3m6 x 16
- 30 Spring bolt
- 31 Spring for magazine holder
- 32 Discharge lever
- 33 Cylinder pin 3m6 x 8
- 34 Trigger
- 35 Cylinder pin 2m6 x 14

Item Designation

- 36 Pin for tolerance compensation Ø3
- 37 Cocking lever
- 38 Chain 36.7 mm
- 39 Chain 16.3 mm
- 40 Cocking pin DIN7346 4x24
- 41 Cocking pin DIN7346 4x20
- 42 Chamber medium
- 43 Firing pin spring
- 44 Firing pin
- 45 Stop bolt
- 46 Pressure spring for lock slide
- 47 Safety insert
- 48 Pressure spring for ejector
- 49 Ejector pin
- 50 Ejector lock
- 51 Extractor
- 52 Extractor spring medium
- 53 Control sleeve
- 54 Control bolt
- 55 Slide lock
- 56 Cover plate
- 57 Loading lever
- 58 Slide rod
- 59 Slide weight part 1
- 60 Retention sleeve
- 61 Pressure spring for split slide weight
- 62 Slide weight part 2
- 63 Cylinder pin 4m6x16.9
- 64 Clamp for weight
- 65 Insert with anti-squeal plate
- 66 Spring guidance rod
- 67 Slide spring
- 68 Barrel
- 69 Housing for gas cylinder
- 70 Spiral cocking pin 2x18

Item Designation

- 71 Gas piston
- 72 Bearing
- 73 Butt
- 74 LPA aligning sight
- 75 Spring collet
- 76 Pan head screw M2.5x3.7
- 77 20 Adjustable front sight
- 78 Pan head screw M3 x 6 - 8.8
- 79 Magazine case 2 shot 30-06
- 80 Engaging piece for slide catch
- 81 Feeder medium
- 82 Magazine spring 2 shot medium
- 83 Magazine floor 2 cartridges
- 84 Main stock MC with jaw
- 85 Washer
- 86 Crown washer DIN6797 A6,4
- 87 Pan head screw DIN912 M6x120
- 88 Retention sleeve
- 89 Butt plate compl.
- 90 Rounded head screw 4.5x30
- 91 Sling attachment bushing
- 92 Flat head wood screw 4x20
- 93 Front stock
- 94 Sling attachment bushing
- 95 Nut for front stock
- 96 Retainer ring DIN7993 - B10
- 97 Cylinder pin DIN6325 4m6x24
- 98 Grommet

Spare parts

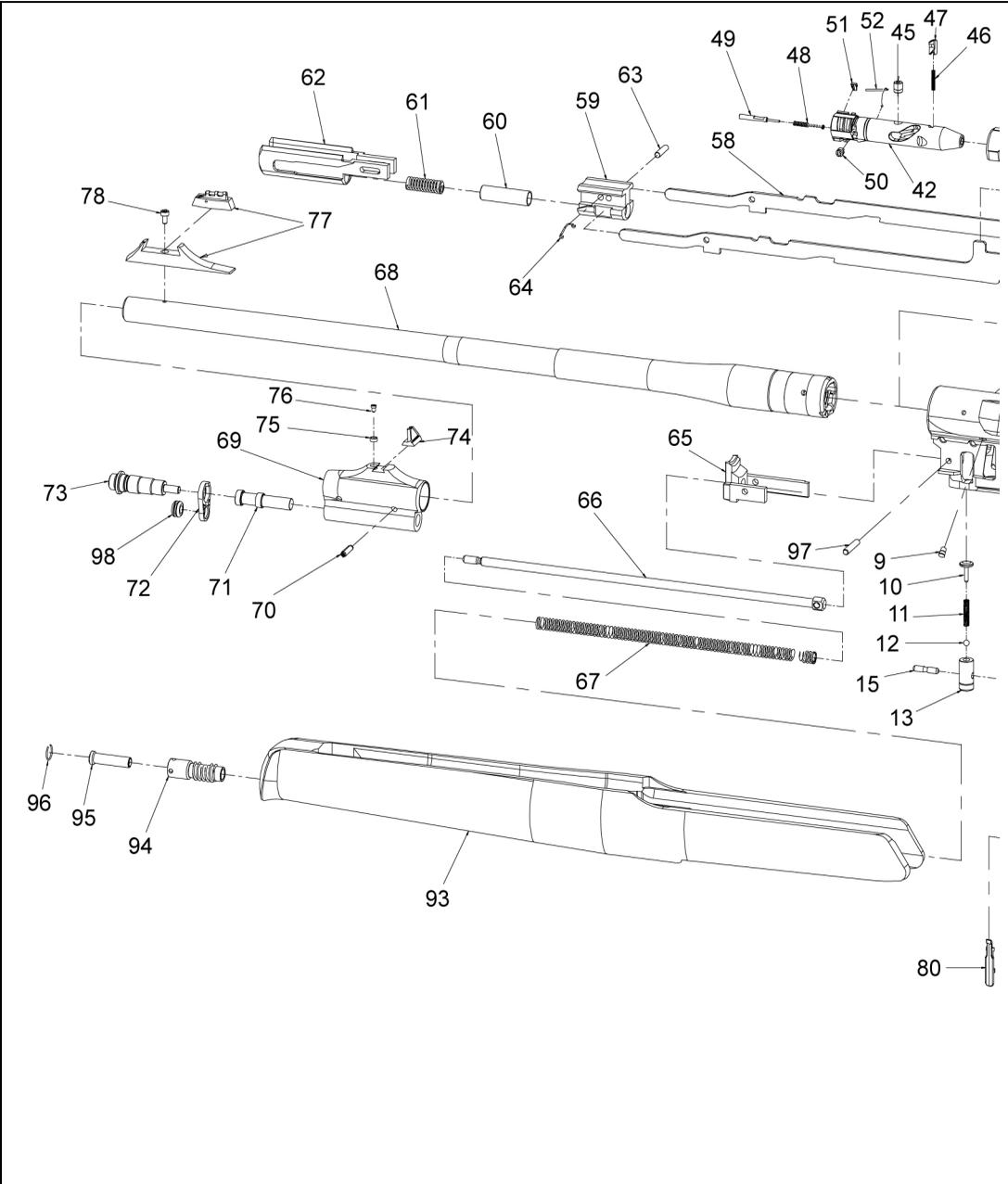
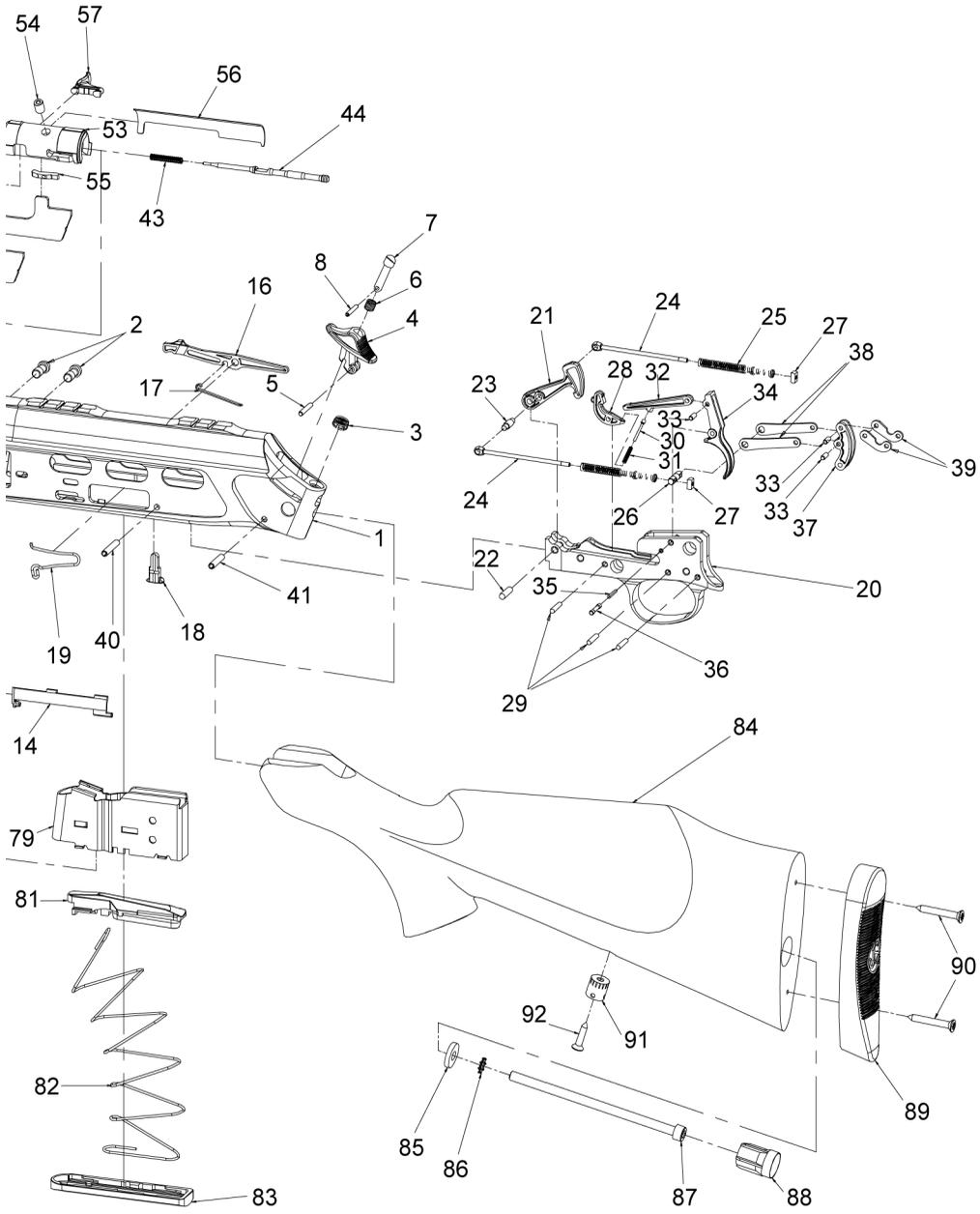


Abb. 31, Spare parts for S 303

Spare parts



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