SAUER 303

Handling and Safety Instructions
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.
Manual cocking at the upper wrist

Detachable box magazine

Crisp single-stage trigger
The new standard for semi-automatic rifles

Four bolt lugs engage directly into the barrel

Silent Cocking System:
The ergonomic button allows silent cocking and decocking

Intra Lock
Integrated automatic firing pin safety

The barrel free-floats from this point forward

Smart Tube:
Gas block, bolt counterweight, guide and fore-end mount in one

15 Mount:
The lowest scope mount on the market 100% solid with repeatable accuracy. Eye relief adjustable in two motions without affecting point of impact
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1 General instructions

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

Understanding these instructions and the technically correct implementation of the information contained therein are imperative for the correct preparation and safety during handling, maintenance and care of this SAUER gun. Do not use the gun until you have fully understood all safety instructions and 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.

Be aware that this gun, like all firearms, is dangerous. The gun accompanying these Handling and Safety Instructions has been sold under the express understanding that the manufacturer and the importer of the gun decline any responsibility for consequences of manipulations on the gun or use of the gun. 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-charged or recharged ammunition,
- inadequate care of the gun (e.g. corrosion, damage),
- disregard of malfunctions,
- resale in contradiction of regional legislation and regulations, other circumstances beyond our direct and immediate control
- other circumstances beyond our direct and immediate control.

These limitations 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 importer 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

- Never use the gun under the influence of alcohol or drugs, during illness or other complaints; they may influence your judgement and reflexes.
- Always treat the gun as loaded and unlocked until you have made sure to the contrary by unloading it.
- During all manipulations, keep the muzzle of the gun pointed in a safe direction. Safe directions are defined as areas where there are no people, other living creatures or other people's property.
- Never point the gun at doors, window panes, walls, concrete, stones or other flat surfaces (including water). Shots can penetrate such surfaces or be deflected into unsafe directions by them.
- Never aim at yourself or other people.
- Never rely on safety mechanisms. They are never a substitute for careful and correct handling of the gun.
- Always handle your gun as if the safety mechanisms were not functional. The best safety device is the correct, well-exercised and secure handling of the gun.
• Never shoot a gun into which there has been ingress of water, sand, dirt or other foreign bodies.

• Never release the tension on the firing pin merely by pulling the trigger.

• Never let a loaded gun out of your hands.

• Always unload the gun immediately after shooting, before putting it down, putting it in its case or handing it to another authorised person.

• Never hand the gun to any person who has not thoroughly familiarised himself or herself with the safety regulations and handling of the gun by reading the accompanying instructions.

• Never leave the gun lying around unattended. Unauthorised persons can cause damage or threaten or kill people with it, for which you might be liable.

• Never store the gun loaded, but remove the magazine and verify through unloading there is no round in the barrel chamber.

• Never store the gun together with the ammunition and verify that both is not accessible for unauthorised persons and children.

2.1 Safety instructions

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

**WARNING!**

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

**CAUTION!**

Information on risks which, if not scrupulously observed, can lead to bodily harm or damage to the gun.

**CAUTION!**

Information on technical requirements which, if not scrupulously observed, can lead to damage to the gun.

• Each safety indication consists of:
  – a header with a signal word, icon and a corresponding colour shading
  – a specification of the type and source of the risk
  – a specification of potential consequences if the safety indications are not observed
  – specifications of measures and prohibitions designed to avoid risks
### 3 Product description

#### 3.1 Main parts

##### 3.1.1 Version with removable magazine

![Figure with closed slide](image)

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<thead>
<tr>
<th>Item</th>
<th>Description</th>
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<tr>
<td>100</td>
<td>Magazine tube</td>
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<tr>
<td>200</td>
<td>Barrel</td>
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<td>300</td>
<td>Gas chamber with sights</td>
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<td>Slide</td>
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<td>500</td>
<td>Trigger mechanism</td>
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<td>600</td>
<td>Magazine</td>
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<td>700</td>
<td>Front stock</td>
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##### 3.1.2 Version with fixed fold out cover magazine

![Figure with open slide](image)

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3.2 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 gun is made available.

3.3 Scope of delivery
The standard scope of delivery includes:
- 1 x gun
- 1 x magazine
- 1 x special socket spanner (2 parts)
- 1 x Torx spanner to dismantle the front stock and barrel.
- 1 x Handling and Safety Instructions manual
- 1 x 10 g SAUER Premium gun grease
- 1 x SAUER plastic case
- 1 x Warranty card

Fig. 3, Standard scope of delivery in plastic case
4 Transporting the gun

4.1 Transport in assembled state

Procedure:
1. Decock the gun (see section 6.2).
2. Remove / open the magazine and empty if necessary (see section 5.8.1).
3. Unload the gun (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 gun (see section 11).

4.2 Transport in the compact case

Procedure:
1. Decock the gun (see section 6.2).
2. Remove / open the magazine and empty if necessary (see section 5.8.1).
3. Unload the gun (see section 5.6).
4. For models with fixed fold out cover magazine, close the empty magazine.
5. Remove the sight correction (see section 9.2).
6. Remove the sling attachment (see section 7.1).
7. Clean the gun (see section 11).
8. Remove the main stock (see section 7.2).

WARNING!

Uncontrolled discharge of shot
May lead to death or severe injuries

- For your own safety and for the safety of others, always transport the gun in the unloaded condition (see section 5.6), and decocked.
- Never carry a cocked gun which is already cocked and contains a round in the barrel chamber.
- Always carry the gun in such a manner that, should you fall or otherwise slip, you are able to control the direction of the muzzle.
- Transport the gun separate from the ammunition in a locked carrying case.
- The gun 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.
5 Handling the gun

5.1 Preparing the gun

Note:
The gun is supplied with a protective and preserving oil and grease coating, and excessive protective oil and grease must be removed prior to first commissioning.

The SAUER 303 is supplied in a shock-proof durable plastic case.

For safety reasons the magazine must not be installed or flipped in during:
- first commissioning and
- taking possession of the gun.

Procedure:
1. Unload the gun (see section 5.6).
2. Check whether ammunition is still in the barrel chamber or in the magazine.
3. Clean the barrel (see section 11.2).
4. In addition during first commissioning:
   - Clean external metal surfaces (see section 11).
5. If supplied in compact case:
   - Fit the main stock (see section 8.2).

5.2 Ammunition

WARNING!

Incorrect ammunition
May lead to death or severe injuries and damage to the gun

- For your gun, use only commercial grade ammunition in the original packaging, which corresponds to the caliber of the gun.
- Only use high quality brand ammunition in your gun. Only then is problem-free function and precision guaranteed.
- Never use recharged, "reconditioned", hand-charged or non-standard ammunition in your gun.
- Never use ammunition with steel shells or other shell material besides brass.
- 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.

WARNING!

Undefined condition of the gun
May lead to death or severe injuries
- If the shooter takes possession of the gun in any other condition it must be treated as loaded.
5.3 Loading the gun (ready to fire)

**WARNING!**

Insufficient awareness of the dangers May lead to death or severe injuries

- Never load or unload the gun inside a vehicle, inside a building or any other confined space (except in a designated firing range).
- Before loading, always wipe off any excess grease and oil and check that there is no obstruction in the bore of the barrel.
- Always keep the muzzle of the gun pointed in a safe direction.
- Do not place your finger onto the trigger tongue, but outside the trigger guard.
- Do not load the gun by inserting the magazine until immediately before shooting.
- Never rely on safety mechanisms. They are never a substitute for careful and correct handling of the gun.
- Never let a loaded gun out of your hands.

### 5.3.1 Loading from the magazine

**Procedure:**
1. Decock the gun (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).

The gun is loaded and ready to fire.

### 5.3.2 Loading from your hand

**Procedure:**
1. Decock the gun (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 gun with the muzzle pointing down.
5. Slide the round through the ejector window in the barrel chamber.
6. Close slide.

The gun is loaded and ready to fire.

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Fig. 4
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 dangers*
  *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 your hands or any other parts of the body are located in front of, over or adjacent to the barrel muzzle or the ejection port.
  - Never allow other persons to stand beside you where they might be struck by ejected cartridge cases.
  - Always wear ear protection and safety glasses when shooting. Alert bystanders to the importance of wearing ear protection.
  - Immediately stop shooting and unload the gun 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.

- **WARNING!**
  
  *Gun is ready to fire*
  *May lead to death or severe injuries*

  - If you decide to end the shooting session, immediately uncock and unload the gun.

Procedure:
1. Aim the gun at a safe target.
2. Cock the gun (see section 6.1).
3. Place finger on trigger tongue and pull back the trigger tongue to discharge the shot.
4. Keep the gun aimed at the target and fire further shots as required.
5. If the magazine is empty, reload the gun (see section 5.5).
6. Uncock the gun and unload (see section 5.6).
5.5 Reloading during shooting

**WARNING!**

Insufficient awareness of the dangers  
May lead to death or severe injuries

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

**Procedure:**
1. Decock the gun (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. 
The gun is loaded and ready to fire.

5.6 Unloading the gun

**WARNING!**

Gun is ready to fire  
May lead to death or severe injuries

- Never let the gun out of your hands before it is unloaded.
- The gun 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 gun (see section 6.2).
2. Aim the gun 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 ejected.
5. Check that the round has been ejected and there are no more rounds in the barrel chamber.
6. Empty magazine.
7. Pick up ejected round and clean the gun.

**WARNING!**

Gun has not been cleaned sufficiently  
May lead to death or severe injuries and damage to the gun

- The gun must be cleaned after every shooting session (see section 11).

The gun is unloaded.
5.7 Slide

5.7.1 Open slide

**Procedure:**

1. Decock the gun (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. 5).
5. Hold the slide tight and pull the slide lock 106 down.

**WARNING!**

Gun is ready to fire
May lead to death or severe injury
- The gun must be decocked before every manipulation on the slide!

**CAUTION!**

Possible injury or damage to the gun
- 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.

Fig. 5

5.7.2 Close the slide

**WARNING!**

Uncontrolled discharge of shot
May lead to death or severe injuries
- The gun must be unloaded.

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

**CAUTION!**

Possible injury or damage to the gun
- 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.

Fig. 6
5.7.3 Closing the slide silently
In some situations it can be an advantage to close the slide silently.

Procedure:
1. Decock the gun (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. 7).

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.

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.

5.8.3 Loading the magazine
Procedure:
1. Open magazine upwards, until the magazine audibly catches.

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!
Uncontrolled discharge of shot
May lead to death or severe injuries
- The weight of the flint trigger must not be changed for safety reasons.
5.9.2 Sights
Depending on the selected model, the SAUER 303 is supplied with various sight devices. In each case the gun is shot in the factory with open sight at 50 meters. A subsequent change of the sight device is possible.

5.9.3 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. 11).

   • Turn the screw with click-stop clockwise: Front sight moves higher, firing sits lower.
   • Turn the screw with click-stop counterclockwise: Front sight moves lower, firing sits higher.

5.9.4 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. 12).

   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. 13).
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 gun 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 gun 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 gun

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. 15).
2. Press the cocking slide forward to the stop.
3. Lift the tip of the thumb so that the cocking slide pin 117 leaves the cocking slide silently (see Fig. 16).
4. Remove the thumb from the cocking slide.

Note:
Gun 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. 16).
6.2 Decocking gun

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. 15).
2. Press the cocking slide slightly forward and simultaneously press in the cocking slide pin 117 with the tip of the thumb (see Fig. 15).
3. Move the cocking slide slowly backwards.
4. Remove the thumb from the cocking slide.

Note:
Gun 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

7.1 Removing the sling attachment

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

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.

WARNING!
Gun is ready to fire
May lead to death or severe injuries
- There must be no magazine in the gun.
- Before stripping your gun, ensure once again that it is unloaded (see section 5.6).
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.

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.
8 Assembly

CAUTION!

Gun may be damaged
- Only assemble cleaned gun parts.
- Only tighten the screws for the stock attachment by hand (only operate the special spanner with two fingers), (see Fig. 23).

8.1 Fitting the barrel

CAUTION!

Gun may be damaged
- Do not use force when inserting the barrel into the magazine tube.
- 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 5 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. 21).
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. 22).
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 5 Nm).

Note:
After every barrel removal and installation a test shot is necessary.

8.2 Fitting the main stock

Corresponding figure, see Fig. 18.
1. Slide the main stock onto the gun.
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 8.4).

8.3 Fitting the front stock

Corresponding figure, see Fig. 23.

Procedure:
1. Slide the front stock 701 onto the gun and press the sides of the front stock into the sides of the magazine tube.
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 8.4).
8.4 Fitting the sling attachment
Corresponding figure, see Fig. 17.

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.

9 Mounting telescopic isi-Mount

CAUTION!

Gun 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. 24).

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.

9.1 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.
5. Fold down the locking lever frontwards (in firing direction).

9.2 Removing telescopic sight

**CAUTION!**

Gun 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.

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

9.3 Changing eye distance

1. Remove telescopic sight (see section 9.2).
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 9.1).
10 Extras

10.1 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. 28).

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. 29).

5. Mount the barrel (see section 8.1). Be careful that the rear end of the hunting track enters the groove of the housing (see Fig. 30).

6. Shoot the gun using the open sight (see section 5.9.2).
11 Care

11.1 General
Proper functioning and precision of the gun can only be maintained through regular and expert care. The gun 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 the corresponding instructions and must be protected against the weather.

For the optimum care for your SAUER 303 we recommend SAUER care products, e.g. the SAUER Premium gun grease.

For a normal cleaning it is sufficient to remove or dismantle the following gun parts:
- Magazine
- Rifle sling

If the gun has been exposed to extreme moisture or is heavily soiled, it is recommended to remove or dismantle the following gun components:
- Magazine
- Telescopic sights
- Rifle sling
- Main stock
- Front stock

11.2 Cleaning the barrel

CAUTION!

Gun 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 gun. Read the manufacturer's indications and warnings before using solvents or cleansers.

Procedure:
1. Unload the gun (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 gun oil or gun grease.
8. With installed barrel: Rub the barrel bore and barrel chamber dry by pulling through a suitable cleaning string several times.
9. With dismounted barrel: Rub the barrel bore and barrel chamber dry from behind with a plastic sheathed cleaning rod of the proper calibre.

WARNING!

Gun is ready to fire
May lead to death or severe injuries
- There must be no magazine in the gun.
- Before stripping your gun for cleaning, ensure once again that it is unloaded (see section 5.6).
11.3 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 gun 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.

11.4 External metal and wood surfaces
For the care and preservation of the external metal and wood surfaces we recommend SAUER Premium gun 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!

Gun may be damaged
- 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 gun prior to preservation.
12 Dealing with problems

12.1 Cause and correction of malfunctions

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

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

1. Decock gun.
2. Remove magazine or open (see section 5.8.1) and dispose of safely.
3. Open slide and lock.
   - The cartridge or cartridge case is pulled out of the barrel chamber and ejected.
4. Check that no bullet, round, cartridge case or foreign matter is in the barrel chamber or barrel. If a projectile is lodged in the bore, strip the gun (see section 7) and have the blockage removed with a suitable tool by a qualified gunsmith.
5. Remove all rounds, cases or foreign bodies. Clean, lubricate and assemble the gun (see section 11 and 8).
6. Have the gun inspected by an armourer or gunsmith.

Procedure:

1. Thoroughly clean the gun using suitable cloths and cleaning agents.
2. Thinly apply the grease with a cloth or sponge over the whole gun (including the stock) including all mechanical and moveable parts.
3. After a reaction time of at least 60 minutes wipe dry and polish the gun 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.
<table>
<thead>
<tr>
<th>Fault</th>
<th>Potential cause</th>
<th>Remedy</th>
</tr>
</thead>
<tbody>
<tr>
<td>No round chambered.</td>
<td>Magazine not properly inserted or closed, deformed or dirty.</td>
<td>Insert magazine completely until catch or close (see section 5.8.2).</td>
</tr>
<tr>
<td></td>
<td>Gun faulty.</td>
<td>Repair by manufacturer.</td>
</tr>
<tr>
<td>Gun is loaded and cocked. When trigger is pulled, no shot is fired.</td>
<td>Gun is not completely unlocked.</td>
<td>Close slide completely (see section 5.7.2). Pull cocking slide manually back and cock again.</td>
</tr>
<tr>
<td>Gun does not advance a new round automatically or clamps it tight.</td>
<td>Gun is not held properly in the shoulder.</td>
<td>Decock the gun (see section 6.2). Open slide (see section 5.7.1). Load new round. Pull gun tight into the shoulder.</td>
</tr>
<tr>
<td></td>
<td>Gun faulty.</td>
<td>Repair by manufacturer.</td>
</tr>
<tr>
<td>Gun decocks automatically when firing.</td>
<td>When cocking the bolt for cocking slide (117) did not emerge completely out of the cocking slide.</td>
<td>Pull cocking slide back until it engages audibly. Then cocking according to handling and safety instructions.</td>
</tr>
<tr>
<td>Cocking slide is in front position, when trigger is pulled no shot is fired and no cut off of the hammer.</td>
<td>Gun is not decocked.</td>
<td>Repair by manufacturer.</td>
</tr>
</tbody>
</table>
12.2 Shipping the gun

Note:

• Familiarize yourself fully with regional legislation governing the shipping and transportation of firearms.

Procedure:

1. Check the gun to ensure that it is unloaded and decocked.

2. Pack the gun well (if possible in its original packaging) to prevent damage in transit. To prevent the gun being recognised as such during shipping, wrap the original packaging in a second outer layer. Do not include any accessories in the shipment.

3. Enclose a letter stating the following:
   – your full name
   – your full address (state street, not P.O. Box)
   – your daytime telephone number
   – model and serial numbers of the gun
   – detailed description of the problem encountered or the service work to be performed.

4. Send the gun properly insured and carriage-paid (packages without correct postage will not be accepted) to:
   – the sales outlet from which you purchased the gun
   – 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.
### Technical Specifications

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

*Subject to change without notice*
14 **Accessories**

Your SAUER 303 is a modular hunting gun 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.sigsauer.de). There you will also find all telescopic sight assemblies, replacement magazines, sights and any other gun accessories.

In addition Sauer & Sohn offers the following accessories for the perfect transport and stylish presentation of your gun and for successful hunting: More precise information can be found in the catalogue or on the internet at (www.sigsauer.de).
## Spare Parts

### 15.1 Version with removable magazine

<table>
<thead>
<tr>
<th>Item designation</th>
<th>Item designation</th>
<th>Item designation</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>100 Housing assembly</strong></td>
<td><strong>300 Trigger Assembly</strong></td>
<td><strong>600 Magazine assembly</strong></td>
</tr>
<tr>
<td>101 Housing, aluminum</td>
<td>303 Pan head screw</td>
<td>601 Magazine case</td>
</tr>
<tr>
<td>102 2 clamping screws</td>
<td></td>
<td>602 Engaging piece for slide catch</td>
</tr>
<tr>
<td>103 Slide catch lever</td>
<td><strong>400 Slide assembly</strong></td>
<td>603 Magazine spring</td>
</tr>
<tr>
<td>104 Leaf spring f. slide catch</td>
<td>401 Locking head</td>
<td>604 Feeder</td>
</tr>
<tr>
<td>105 Lock f. slide catch</td>
<td>402 Extractor</td>
<td>605 Magazine floor plate</td>
</tr>
<tr>
<td>106 Magazine catch</td>
<td>403 Firing pin spring</td>
<td></td>
</tr>
<tr>
<td>107 Bolt for magazine catch</td>
<td>404 Firing pin</td>
<td></td>
</tr>
<tr>
<td>108 Locking pin</td>
<td>405 Ejection rod</td>
<td></td>
</tr>
<tr>
<td>109 Ball</td>
<td>406 Ejector pin pressure spring</td>
<td></td>
</tr>
<tr>
<td>110 Pressure spring</td>
<td>407 Bolt</td>
<td></td>
</tr>
<tr>
<td>111 Spring bolt</td>
<td>408 Control bolt</td>
<td></td>
</tr>
<tr>
<td>112 Insert with anti-squeal plate</td>
<td>409 Safety lock</td>
<td></td>
</tr>
<tr>
<td>113 Reverse recoil plug</td>
<td>410 Safety lock pressure spring</td>
<td></td>
</tr>
<tr>
<td>114 2 straight pins</td>
<td>411 Control sleeve</td>
<td></td>
</tr>
<tr>
<td>115 Action spring</td>
<td>412 2 slide rods</td>
<td></td>
</tr>
<tr>
<td>116 Cocking slide</td>
<td>413 Slide weight</td>
<td></td>
</tr>
<tr>
<td>117 Bolt for cocking slide</td>
<td>414 Slide lock</td>
<td></td>
</tr>
<tr>
<td>118 Pressure spring</td>
<td>415 Cover sleeve</td>
<td></td>
</tr>
<tr>
<td>119 Heavy adapter sleeve</td>
<td>416 Loading lever</td>
<td></td>
</tr>
<tr>
<td>120 Straight pin</td>
<td>417 Clamp for weight</td>
<td></td>
</tr>
<tr>
<td>121 Bolt for barrel position</td>
<td></td>
<td></td>
</tr>
<tr>
<td>122 Spring for magazine ejection</td>
<td></td>
<td></td>
</tr>
<tr>
<td>123 Light dowel pin</td>
<td></td>
<td></td>
</tr>
<tr>
<td>124 Color insert, red</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>200 Barrel assembly</strong></td>
<td></td>
<td><strong>700 Front stock assembly</strong></td>
</tr>
<tr>
<td>201 Barrel</td>
<td></td>
<td>701 Front stock</td>
</tr>
<tr>
<td>202 Housing for gas cylinder</td>
<td>702 Sling attachment bushing</td>
<td>703 Nut</td>
</tr>
<tr>
<td>203 Heavy adapter sleeve</td>
<td></td>
<td>704 Retainer ring</td>
</tr>
<tr>
<td>204 Bearing</td>
<td></td>
<td></td>
</tr>
<tr>
<td>205 Butt</td>
<td></td>
<td></td>
</tr>
<tr>
<td>206 Closing collet</td>
<td></td>
<td></td>
</tr>
<tr>
<td>207 Spring collet</td>
<td></td>
<td></td>
</tr>
<tr>
<td>208 Pan head screw</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>300 Rear &amp; front sight assembles</strong></td>
<td></td>
<td><strong>800 Main stock assembly</strong></td>
</tr>
<tr>
<td>301 Aligning rear sight</td>
<td></td>
<td>801 Main stock</td>
</tr>
<tr>
<td>302 Adjustable front sight</td>
<td>802 Pan head screw</td>
<td>803 Washer</td>
</tr>
<tr>
<td></td>
<td>804 Crown gear</td>
<td>805 Retention sleeve</td>
</tr>
<tr>
<td></td>
<td>806 Butt</td>
<td>807 2 rounded head screw</td>
</tr>
<tr>
<td></td>
<td>808 Sling attachment bushing</td>
<td>809 Flat head wood screw</td>
</tr>
<tr>
<td></td>
<td>519 Pin</td>
<td>514 2 mainsprings</td>
</tr>
<tr>
<td></td>
<td></td>
<td>515 Bolt for chain</td>
</tr>
<tr>
<td></td>
<td></td>
<td>516 2 nuts</td>
</tr>
<tr>
<td></td>
<td></td>
<td>517 2 chains 36.7 mm</td>
</tr>
<tr>
<td></td>
<td></td>
<td>518 2 chains 16.3 mm</td>
</tr>
</tbody>
</table>
Fig. 31, spare parts for S 303 (Version with removable magazine)
### Item designation

**100 Housing assembly**
- 101 Housing, aluminum
- 102 2 clamping screws
- 103 Slide catch lever
- 104 Leaf spring f. slide catch
- 105 Lock f. slide catch
- 106 Magazine catch
- 107 Bolt for magazine catch
- 108 Locking pin
- 109 Ball
- 110 Pressure spring
- 111 Spring bolt
- 112 Insert with anti-squeal plate
- 113 Reverse recoil plug
- 114 2 straight pins
- 115 Action spring
- 116 Cocking slide
- 117 Bolt for cocking slide
- 118 Pressure spring
- 119 Heavy adapter sleeve
- 120 Straight pin
- 121 Bolt for barrel position
- 122 Spring for magazine ejection
- 123 Light dowel pin
- 124 Color insert, red

**200 Barrel assembly**
- 201 Barrel
- 202 Housing for gas cylinder
- 203 Heavy adapter sleeve
- 204 Bearing
- 205 Butt
- 206 Closing collet
- 207 Spring collet
- 208 Pan head screw

**300 Rear & front sight assemblies**
- 301 Aligning rear sight
- 302 Adjustable front sight

**400 Slide assembly**
- 401 Locking head
- 402 Extractor
- 403 Firing pin spring
- 404 Firing pin
- 405 Ejection rod
- 406 Ejector pin pressure spring
- 407 Bolt
- 408 Control bolt
- 409 Safety lock
- 410 Safety lock pressure spring
- 411 Control sleeve
- 412 2 slide rods
- 413 Slide weight
- 414 Slide lock
- 415 Cover sleeve
- 416 Loading lever
- 417 Clamp for weight

**500 TriggerAssembly**
- 501 Trigger housing
- 502 Latch
- 503 3 straight pins
- 504 Trigger
- 505 Safety lever
- 506 3 straight pins
- 507 Spring bolt
- 508 Magazine retaining spring
- 509 Hammer
- 510 Straight pin
- 511 Cocking lever
- 512 Bolt for hammer
- 513 2 spring bolts for mainspring
- 514 2 mainsprings
- 515 Bolt for chain
- 516 2 nuts
- 517 2 chains 36.7 mm
- 518 2 chains 16.3 mm

**600 Magazine assembly**
- 601 Magazine case
- 602 Engaging piece for slide catch
- 603 Magazine spring
- 604 Feeder
- 605 Magazine floor plate

**700 Front stock assembly**
- 701 Front stock
- 702 Sling attachment bushing
- 703 Nut
- 704 Retainer ring

**800 Main stock assembly**
- 801 Main stock
- 802 Pan head screw
- 803 Washer
- 804 Crown gear
- 805 Retention sleeve
- 806 Butt
- 807 2 rounded head screw
- 808 Sling attachment bushing
- 809 Flat head wood screw
- 519 Pin
Fig. 32, Spare parts for S 303 (Version with fixed fold out cover magazine)