

**SAUER** 

# ***SAUER 202 Take Down***



***Operating and  
Safety Instructions***  
(Version 10.06)

# S 202

Take Down

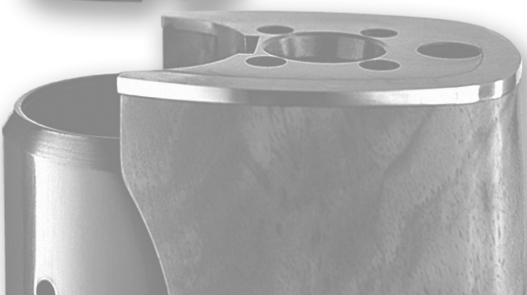


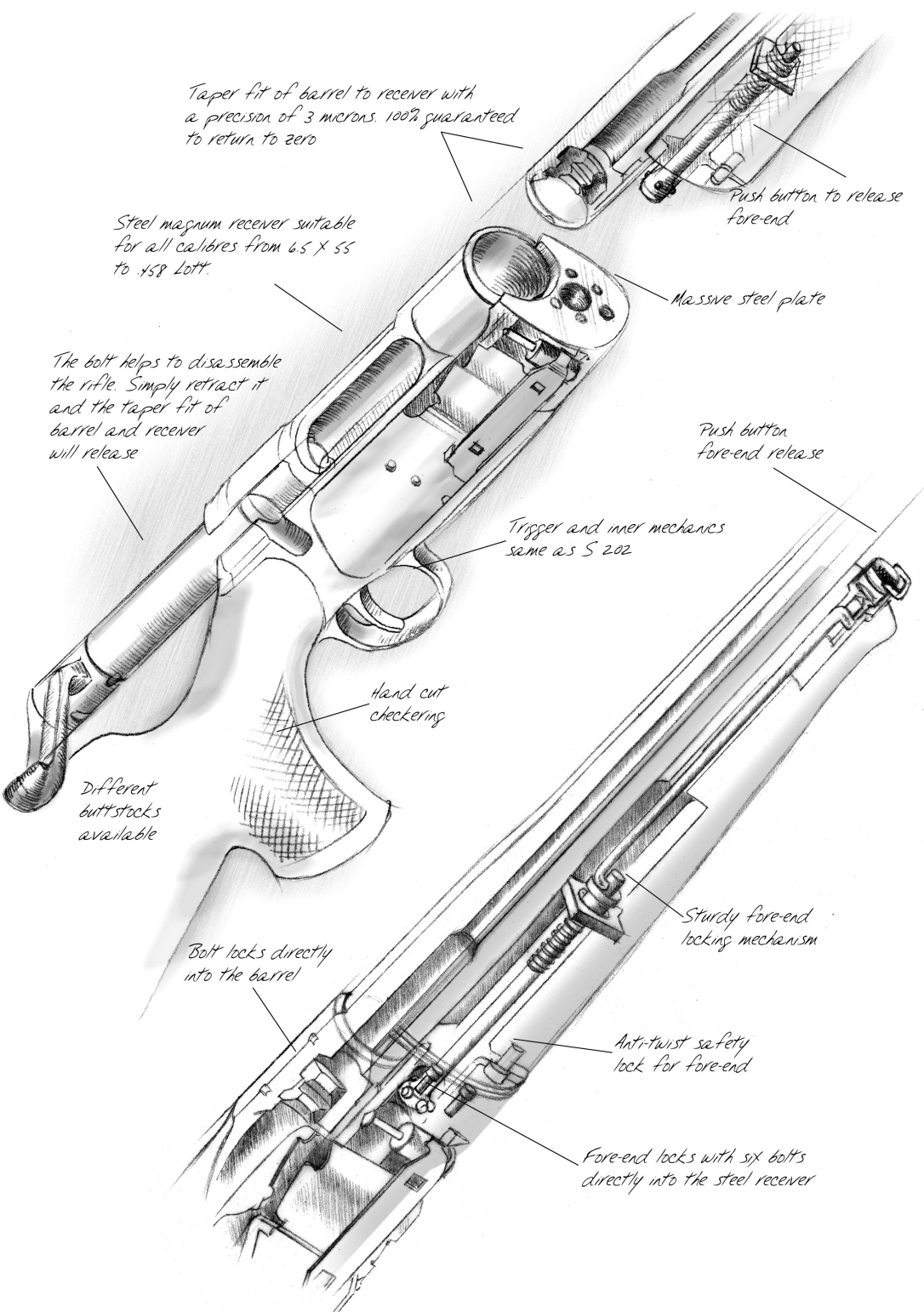
## *Non Plus Ultra*



The Take Down rifle – synonymous with perfect gunmaking and dream of the ambitious hunter. Only the world's best gunsmiths have been able to custom-build it for a few professionals. By blending advanced technology with masterful workmanship, SAUER has succeeded in bringing the Take Down legend into serial production. The result is a complete rifle action that offers uncompromising and repetitive accuracy as well as maximum flexibility for any hunting, anywhere.

- Based on the SAUER 202 design, the receiver is the supporting element of the rifle. Immune from stock bedding issues, the action practically supports itself.
- The barrel and receiver are connected by a snug-fitting cone plug that is free of play and compensates for wear. The state-of-the-art manufacturing process ensures minimum tolerances and maximum precision.
- Six lugs lock the bolt directly in the barrel. This guarantees perfect headspace after every disassembly and assembly and prevents wear and tear at the plug connecting barrel and receiver.
- With the press of a button, six lugs lock the fore-end directly into the steel receiver.
- The S 202 Take Down can be disassembled without tools to a length of 70 cm and re-assembled within seconds for immediate action. There is no tool to forget or lose, no screw that is too tight or too loose – the rifle is reduced to pure perfection and that leads to successful hunting.
- After assembly, the point of impact remains 100% consistent. There is no need for testfiring.
- The unlimited flexibility of the S 202 Take Down allows for changing of barrels and calibres from 6.5 x 55 to .458 Lott with a wide range of barrel lengths and contours.
- Trigger, safety, sights, stock options and, of course, the absolutely slick bolt action have all been adopted from the proven SAUER 202.
- All models are available for left-handers with left-handed action and buttstock.





Taper fit of barrel to receiver with a precision of 3 microns. 100% guaranteed to return to zero

Steel magnum receiver suitable for all calibres from 6.5 x 55 to .458 Lott

The bolt helps to disassemble the rifle. Simply retract it and the taper fit of barrel and receiver will release

Push button to release fore-end

Massive steel plate

Push button fore-end release

Trigger and inner mechanics same as S 202

Hand cut checkering

Different buttstocks available

Sturdy fore-end locking mechanism

Bolt locks directly into the barrel

Anti-twist safety lock for fore-end

Fore-end locks with six bolts directly into the steel receiver

# Table of contents

<b>1</b>	<b>General instructions</b>	<b>2</b>	<b>5.7</b>	<b>Bolt</b>	<b>17</b>
<b>2</b>	<b>Safety regulations</b>	<b>3</b>	5.7.1	Cocking the bolt	17
2.1	Safe handling of the rifle	3	5.7.2	Removing the bolt	18
2.2	Risks for the user and how to avoid them	3	5.7.3	Inserting the bolt	18
2.3	Risks for other people and how to avoid them	3	5.7.4	Uncock the firing pin	18
2.4	Ensure proper use	4	5.8	Magazine	19
2.5	Personal protective equipment	4	5.8.1	Removing the magazine	19
2.6	Graphical representation of safety indications	4	5.8.2	Inserting the magazine	19
			5.8.3	Loading the magazine	19
<b>3</b>	<b>Product description</b>	<b>5</b>	5.9	Trigger	19
3.1	Main parts	5	5.9.1	Rifle trigger	20
3.2	Technical specifications	6	5.9.2	Rifle trigger with rear set trigger	20
3.3	Main features	7	5.9.3	Match trigger	21
3.4	Scope of delivery	7	5.10	Sights	22
3.5	Modular principle	8	<b>6</b>	<b>Safety lock</b>	<b>23</b>
3.5.1	Caliber change retrofit table	8	6.1	Unlocking	23
3.6	Accessories	9	6.2	Locking	24
3.7	Installation of optics and accessories	9	<b>7</b>	<b>Dismantling</b>	<b>25</b>
3.8	Extras	10	7.1	Removing the sling attachment	25
3.8.1	Muzzle brakes	10	7.2	Remove magazine	25
3.8.2	Magazine lock MagLock	10	7.3	Front stock removal	25
3.8.3	Express sights	11	7.4	Barrel removal	26
3.9	Spare parts	11	7.5	Removing the bolt	27
<b>4</b>	<b>Transporting, storing and shipping the rifle</b>	<b>12</b>	7.6	Remove main stock (optional)	27
4.1	Transporting the rifle	12	<b>8</b>	<b>Care</b>	<b>28</b>
4.1.1	Transport in assembled condition	12	8.1	General	28
4.1.2	Transport in the carrying case	12	8.2	Cleaning the barrel	28
4.2	Storing the rifle	13	8.3	External metal and wood surfaces	29
4.3	Shipping the rifle	13	<b>9</b>	<b>Assembly</b>	<b>30</b>
<b>5</b>	<b>Handling the rifle</b>	<b>14</b>	9.1	Fitting the main stock	30
5.1	Initial preparation	14	9.2	Fitting the barrel	30
5.2	Ammunition	14	9.3	Inserting the bolt	31
5.3	Loading the rifle (ready to fire)	15	9.4	Fitting the front stock	31
5.4	Discharging a shot	15	9.5	Inserting the magazine	32
5.5	Reloading during shooting	16	9.6	Fitting the sling attachment	32
5.6	Unloading the rifle	17	<b>10</b>	<b>Malfunctions</b>	<b>33</b>
			10.1	Detecting a malfunction	33
			10.2	Cause and remedy of malfunctions	34
			<b>11</b>	<b>Spare parts</b>	<b>35</b>

## 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 persons.
- 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 recognized target.
- Also make sure what lies behind your target.
- Point out any dangers from noise, empty cartridges and gunpowder smoke to those present. Stop shooting immediately if such dangers occur.

## 2.4 Ensure proper use


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


## 2.5 Personal protective equipment


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

## 2.6 Graphical representation of safety indications

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

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

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

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

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

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

# Product description

## 3 Product description

### 3.1 Main parts



Fig. 1

Item	Description
100	Bolt
200	Receiver
300	Barrel
400	Main stock

Item	Description
500	Two-part front stock
600	Magazine
700	Trigger



## Product description

### 3.2 Technical specifications

Functional principle	Take Down Repeater rifle	
Action type	Direct lug locking in the barrel	
Calibre	<b>Medium:</b> .25-06 Rem.; 6,5x55; .270 Win.; 7x64; .30-06; 8x57 IS; 9,3x62  <b>Magnum:</b> 6,5x68; .270 Wby. Mag.; 8x68 S; 7mm Rem. Mag.; .300 Win. Mag.; .300 Wby. Mag.  <b>BigGame:</b> .375 H&H Mag.; .416 Rem. Mag.; .458 Lott	
Length, overall	<b>Medium:</b> approx. 1.120 mm (with barrel length 600 mm) <b>Magnum:</b> approx. 1.170 mm (with barrel length 650 mm) <b>BigGame:</b> approx. 1.120 mm (with barrel length 600 mm)	
Barrel length	<b>Medium:</b> 510, 560, 600 mm <b>Magnum:</b> 600, 650 mm <b>BigGame:</b> 600 mm	
Stock length (Monte Carlo stock)	approx. 355 mm	
Stock indentation (Monte Carlo stock); from top edge of receiver	<b>front:</b> 32 mm <b>centre:</b> 25 mm <b>back:</b> 50 mm	
Stock offset	5 mm	
Trigger weights	<b>Pure rifle trigger:</b> approx. 15 N <b>Rifle trigger (with set trigger):</b> approx. 13 N <b>Set trigger:</b> approx. 3 N <b>Match trigger:</b> approx. 7 N	
Magazine content	<b>Medium:</b> 3 rounds <b>Magnum:</b> 2 rounds <b>BigGame:</b> 2 rounds	
Replacement magazine	<b>Medium:</b> 4 rounds <b>Magnum:</b> 4 rounds <b>BigGame:</b> 4 rounds	
Weight without telescopic sights with steel receiver, 600 mm barrel length and Monte Carlo stock.	<b>Medium:</b> 3,8 kg <b>Magnum:</b> 3,9 kg <b>BigGame:</b> 4,1 kg	

*Subject to change without notice*

## Product description

### 3.3 Main features

The SAUER 202 Take Down is a high precision hunting rifle built in accordance with the latest state of knowledge, which – based on the patent DE 102 05 503.3 held by Manfred Orth – can be disassembled without tools into its components rear stock and receiver, front stock and barrel. It is an easy to handle repeater with rifle trigger which can be fitted with a rear set trigger.

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

Both mechanical and optical aims can be fitted.

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

### 3.4 Scope of delivery

The standard scope of delivery includes:

- 1 x rifle
- 1 x magazine
- 1 x special socket spanner (2 parts)
- 1 x Allan key
- 1 x Operating and Safety Instructions manual
- 1 x Warranty card



Fig. 2, Standard scope of delivery

## 3.5 Modular principle

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

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

### 3.5.1 Caliber change retrofit table

The S 202 Take Down allows you to use all available barrels and calibers in a single rifle.

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

#### Note:

- **After changing the caliber the rifle must be recalibrated if a single sight is used for several barrels. If a separate sight is available for each barrel and has been calibrated accordingly, then only the sight needs to be changed at the time of a caliber change. Recalibrating will not be necessary.**

### Medium caliber

Barrel with caliber	Magazine	Bolt
.25-06 Rem.	Magnum for Medium	Magnum for Medium
6.5x55	Magnum for Medium	Magnum for Medium
.270 Win.	Magnum for Medium	Magnum for Medium
7x64	Magnum for Medium	Magnum for Medium
.30-06	Magnum for Medium	Magnum for Medium
8x57IS	Magnum for Medium	Magnum for Medium
9.3x62	Magnum for 9,3x62	Magnum for Medium

### Magnum and BigGame calibers

Barrel with caliber	Magazine	Bolt
6.5x68	Magnum	Magnum
.270 Wby. Mag.	Magnum	Magnum
7 mm Rem. Mag.	Magnum	Magnum
.300 Win. Mag.	Magnum	Magnum
.300 Wby. Mag.	Magnum	Magnum
8x68S	Magnum	Magnum
.375 H&H	.375 H&H	Magnum
.416 Rem. Mag.	.416 Rem. Mag.	Magnum
.458 Lott	.458 Lott	Magnum

### 3.6 Accessories

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

In addition Sauer & Sohn offers additional 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](http://www.sauer.de)).



Fig. 3

### 3.7 Installation of optics and accessories

#### Note:

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



#### CAUTION!

#### Improper installation of telescopic sights Rifle may be damaged

- A damage of the system sleeve results in a change of the sleeve shape which can make changing the barrel difficult or impossible on the one hand, and can have a negative impact on the firing precision on the other. The threads for the assembly screw could also be damaged or destroyed.
- For rifles assembled differently than described here, the J.P. & Sohn GmbH will not accept any warranty of the functionality and accurate firing.
- Please only install mounting bases onto the system sleeve whose radii match those of the sleeve exactly.
- It should also be ensured that the mounting base is not only screwed on but also glued widely and evenly using a **dual component adhesive**.
- J. P. Sauer & Sohn GmbH recommends the original SAUER swivel mounting.

## 3.8 Extras

### 3.8.1 Muzzle brakes

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



#### WARNING!

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

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

### SAUER muzzle brake

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

The rifle is supplied ex-factory with the protective cap attached and has been calibrated in this configuration.

To remove the protective cap unscrew it anti-clockwise from the barrel.

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



Fig. 4

#### Note:

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

### 3.8.2 Magazine lock MagLock

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

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

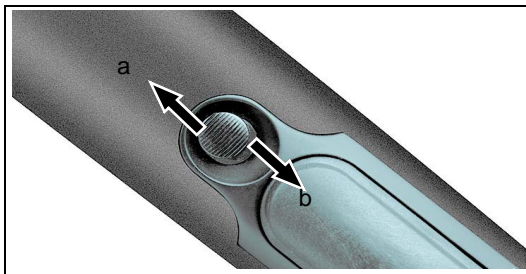


Fig. 5, a) locking, b) unlocking

### 3.8.3 Express sights

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

Rifles with these sights are always calibrated as follows:

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



Fig. 6

### 3.9 Spare parts

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

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

#### Note:

- **A table with the item numbers and designations is located on page 35 of this manual. A drawing on page 36 guides you in finding the correct item.**

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

#### 4.1.2 Transport in the carrying case

##### Procedure:

1. Remove the magazine (see section 5.8.1).
2. Unload the rifle (see section 5.6).
3. Remove the sights/accessories (see section 3.7).
4. Clean the rifle (see section 8).
5. Remove the front stock (see section 7.3).
6. Remove the barrel (see section 7.4).
7. Remove the bolt (see section 5.7.2).

## 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 bolt and the magazine must not be inserted during:

- first commissioning and
- taking possession of the rifle.

### Note:

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

### 5.1 Initial preparation

#### Note:

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



#### 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 and unlocked.

#### Procedure:

1. Unload the rifle (see section 5.6).
2. Remove the bolt (see section 5.7.2).
3. Check whether ammunition is still in the barrel chamber or in the magazine.

4. Clean the barrel (see section 8.2).
5. In addition during first commissioning:
  - Clean external metal surfaces (see section 8).
6. If supplied in compact case:
  - Mount the barrel (see section 9.1).
  - Fit the front stock (see section 9.4).

### 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.

### Procedure:

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

### Condition of the rifle:

The rifle is loaded and ready to fire.

## 5.4 Discharging a shot



### WARNING!

**Insufficient awareness of the risks may lead to careless actions**

**May lead to death or severe injuries**

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

### Procedure:

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



### DANGER!

**Shot will be fired**

**Risk of immediate death or severe injuries**

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

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



## WARNING!

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

**May lead to death or severe injuries**

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

## 5.5 Reloading during shooting



## WARNING!

**Insufficient awareness of the risks may lead to careless actions**

**May lead to death or severe injuries**

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

### Procedure:

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

### Condition of the rifle:

The rifle is loaded and ready to fire.

## 5.6 Unloading the rifle



### WARNING!

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

**May lead to death or severe injuries**

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

#### Procedure:

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

#### Condition of the rifle:

The rifle is unloaded.



### 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).

## 5.7 Bolt

### 5.7.1 Cocking the bolt

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

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

#### Procedure:

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

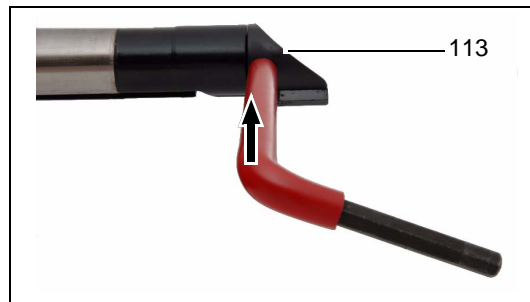


Fig. 7, Cocking the bolt



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

## 5.7.2 Removing the bolt

### Procedure:

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



Fig. 9

## 5.7.3 Inserting the bolt



### WARNING!

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

**May lead to death or severe injuries**

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

### CAUTION!

**Rifle may be damaged**

- Never use force when inserting the bolt.

4. As functional check: carry out a repeater action.
5. Check the safety functions with the rifle unloaded:
  - The safety and unlocking bolts must be freely moveable.
  - Firing a shot must not be possible in the locked state.
  - The bolt must not open in the locked state.
  - With the trigger set the rifle must automatically unset when the bolt is opened.
6. If problems arise during the functional check or with the safety function, remove the bolt and repeat steps 1 to 5.

## 5.7.4 Uncock the firing pin



### WARNING!

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

**May lead to death or severe injuries**

- Only uncock the firing pin with the rifle unloaded and the barrel chamber empty.

### Procedure:

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

### Note:

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

## 5.8 Magazine

### 5.8.1 Removing the magazine

#### Procedure:

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

#### CAUTION!

**Magazine may fall out**  
**Magazine may be damaged**

- When removing the magazine always keep your hand exactly underneath the magazine.
3. Press the stud **207** with the index finger of the same hand.
  4. Remove magazine.
  5. Empty magazine.



Fig. 10

### 5.8.2 Inserting the magazine

#### Procedure:

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

### 5.8.3 Loading the magazine

#### Procedure:

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

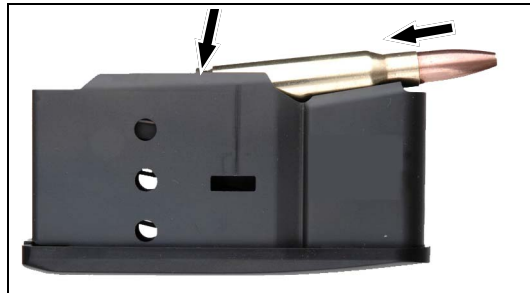


Fig. 11

## 5.9 Trigger

#### Note:

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

#### CAUTION!

**Rifle may be damaged**

- The trigger can be changed, but this must only be carried out by a gunsmith.

## 5.9.1 Rifle trigger

### Note:

- The trigger weight has been set to approx. 15 N (1.500 g) at factory.

The rifle trigger is a direct trigger without creep.

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



### WARNING!

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

**May lead to death or severe injuries**

- For safety reasons the rifle trigger weight must only be modified by the manufacturer.

## 5.9.2 Rifle trigger with rear set trigger

### Note:

- The trigger weight of the rifle trigger has been set to approx. 13 N (1.300 g) at factory.

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

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

## Priming



### WARNING!

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

**May lead to death or severe injuries**

- For safety reasons the rifle trigger weight must only be modified by the manufacturer.
- The set trigger can be triggered already by the slightest vibration. Therefore the trigger must not be set until immediately before firing the shot. Aim the rifle at a stop-butt. If the intended shot cannot be fired, immediately lock and reset the rifle.

### Procedure:

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

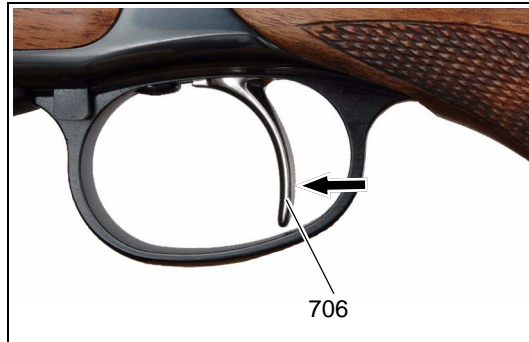


Fig. 12

## Resetting

Procedure:

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

**Note:**

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

## Modifying the trigger weight

**Note:**

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



### WARNING!

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

**May lead to death or severe injuries**

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

## Adjusting downwards:

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

## Adjusting upwards:

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

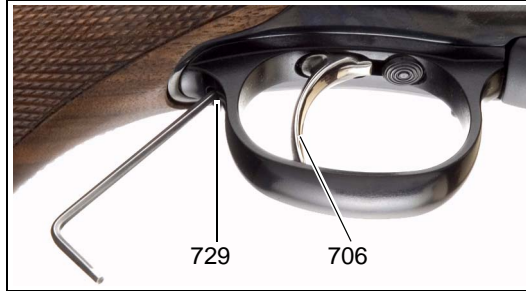


Fig. 13

## 5.9.3 Match trigger

**Note:**

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

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

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



### WARNING!

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

**May lead to death or severe injuries**

- For safety reasons the trigger weight must only be modified by a qualified gunsmith. He can adjust the trigger weight between approx. 5 N (500 g) and 10 N (1.000 g).



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

**Note:**

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

**Short creep:**

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

**Longer creep:**

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



## WARNING!

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

**May lead to death or severe injuries**

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

## 5.10 Sights

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

## 6 Safety lock

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

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

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

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

### 6.1 Unlocking

#### Procedure:

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

#### Condition of the rifle:

Rifle unlocked:

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



Fig. 14, Rifle unlocked:

## 6.2 Locking

### CAUTION!

#### Rifle may be damaged

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

#### Procedure:

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

#### Condition of the rifle:

Rifle locked:

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



Fig. 15, Rifle locked

## 7 Dismantling



### WARNING!

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

**May lead to death or severe injuries**

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

### 7.1 Removing the sling attachment

**Procedure:**

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



Fig. 16, rear sling attachment bushing

**Note:**

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

### 7.2 Remove magazine

see section 5.8.1

### 7.3 Front stock removal

**Procedure:**

1. Press and hold down the button at the tip of the front stock.
2. Pull off the front stock in a straight line forward movement.



Fig. 17

## 7.4 Barrel removal

### Procedure:

1. Hold the rifle in the left hand (for right handers) with the thumb and index finger put around the barrel just above the receiver (see Fig. 18). The rifle is pointing with the muzzle upwards. The main stock must not rest on the stock cap.



Fig. 18

2. Using the remaining fingers grip the receiver firmly and press the hand together with the thumb and index finger exerting a pulling force on the barrel (see Fig. 18 and Fig. 19).

3. Open the slide with the right hand and let it drop down vertically without stopping it (see Fig. 19 and Fig. 20).

### Note:

- **This momentum releases the firm conical plug-in attachment of barrel and receiver which can usually be felt in the fingers of the left hand, since the barrel already moves a short distance out of the receiver.**



Fig. 19



Fig. 20

4. Pull barrel out in a straight line movement to the front (see Fig. 21).



Fig. 21

## Note:

- If it can still not be pulled out, the procedure with dropping the bolt might have to be repeated once or twice until the momentum releases the firm conical plug-in attachment of barrel and receiver. Once more, make sure that the thumb and index finger of the left hand exert a noticeable pull on the barrel.
- If a rifle has several barrels, it is possible that one barrel sits more tightly in the receiver than another. This does not affect the precision or functionality of the rifle.

## 7.5 Removing the bolt

see section 5.7.2

## 7.6 Remove main stock (optional)

### Procedure:

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

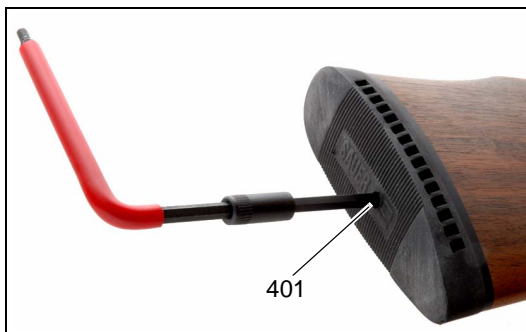


Fig. 22

## 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. Wooden stocks must be treated with a suitable agent in accordance with the corresponding instructions and must be protected against the weather.

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

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

- Magazine
- Bolt
- Rifle sling

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

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



#### 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).

### 8.2 Cleaning the barrel

#### CAUTION!

**Rifle may be damaged**

- Never clean barrel from the front end and do not use a steel or brass wire brush as it can destroy the smooth surface of the barrel. Use a suitable cleaning rod and a brush of matching 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. Remove the bolt (see section 5.7.2).
3. Instead of the bolt insert a cleaning aid ("False lock") for the exact centred guidance of the cleaning rod.

4. Clean the bore and barrel chamber from the back using suitable fluids or grease (observe the respective instructions for use) and a suitable, caliber-matched, bronze or plastic cleaning brush.
5. Check whether deposits of the rounds have collected in the sections. If necessary, clean the barrel with a commercial grade barrel cleaning agent (observe the respective instructions for use) designed for firing residue.
6. Coat the barrel bore and the barrel chamber with a little rifle oil or rifle grease.
7. Dry the barrel bore and the barrel chamber from the back using a plastic coated cleaning rod of the correct caliber.

### 8.3 External metal and wood surfaces

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

#### Benefits:

- dry surfaces - dust etc. does not adhere;
- water and salt water proof;
- absolute corrosion protection;
- perfect sliding characteristics, reduced wear;
- resistant to sweaty palms;
- pressure resistant up to 57.000 kg/cm<sup>2</sup>;
- temperature resistant from -50 to +230 °C;
- perfect protection and care for steel **and** wood;
- neutral smell;

#### CAUTION!

#### Rifle 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 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. Dependent on the dust and dirt particle content of the rain this phenomenon is stronger or weaker. It is not a defect in the stock finish.
- No oil or grease film is required for the plug-in attachment between the barrel and magazine to function properly. However, this area must be protected well against corrosion in order to ensure easy dismantling even after longer periods of rest for the rifle. As corrosion protection for the inside radius of the receiver and the rear part of the barrel inserted into it non-resin oils or grease with a high level of corrosion protection are suitable. After oiling or greasing and following the reaction time specified by the manufacturer the substance must be removed again by polishing to prevent impeding the proper action of the plug-in attachment.

**9 Assembly**

<b>CAUTION!</b>
<b>Rifle may be damaged</b>
<ul style="list-style-type: none"> <li>• Only assemble cleaned rifle parts.</li> </ul>

**9.1 Fitting the main stock**

Corresponding figure, see Fig. 22.

**Procedure:**

1. Slide the main stock onto the rifle.
2. Hand-tighten the main stock screw clockwise with the long end of the special spanner supplied (approx. 5 turns).

**9.2 Fitting the barrel**

<b>CAUTION!</b>
<b>Rifle may be damaged</b>
<ul style="list-style-type: none"> <li>• Do not use force when inserting the barrel into the receiver.</li> <li>• Prior to fitting ensure that the internal surfaces of the receiver and the external surfaces of the barrel near the plug-in attachment are free of foreign matter, completely clean and absolutely dry.</li> </ul>

## Procedure:

1. Insert the barrel into the receiver such that the block (S) at the bottom of the barrel next to the groove (N) rests on the metal plate of the receiver. Then press the barrel against the metal plate and simultaneously turn the groove until the barrel audibly rests on the base of the receiver.



Fig. 23

## 9.3 Inserting the bolt

see section 5.7.3

## 9.4 Fitting the front stock

Corresponding figure, see Fig. 17.

### Procedure:

1. Attach the front stock in a straight line to the system connection whilst holding the unlocking button at the tip of the front stock pressed down.
2. Release button.
3. Insert and lock bolt (see section 5.7.3).
4. Fit the sling attachment (see section 9.6).

### Note:

- **The minute radial play of the barrel and front stock in the assembled condition are due to the technical design and guarantee the easy disassembly of the rifle. This does not negatively affect the precision and stability.**

### 5. Check:

With the front stock fitted **no gap** must be visible between the two metal plates (see Fig. 24).

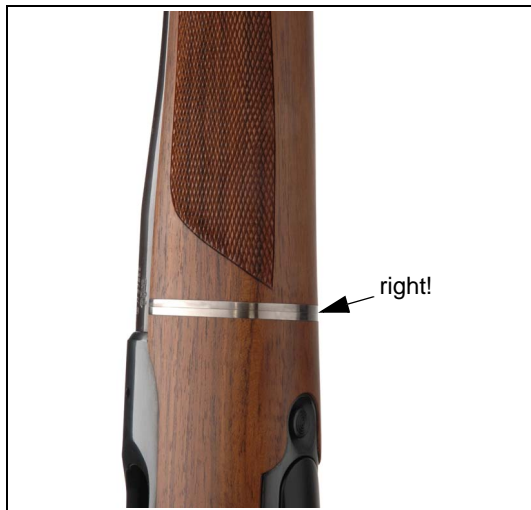


Fig. 24

If a gap is visible (see Fig. 25), the barrel is not far enough in the receiver preventing the front stock from locking fully. In this case the barrel must be removed and reinserted correctly following the instructions above.



Fig. 25

## 9.5 Inserting the magazine

### CAUTION!

#### Rifle may be damaged

- An incompletely locked front stock can come loose when shooting. It can also damage the receiver.

see section 5.8.2.

## 9.6 Fitting the sling attachment

Corresponding figure, see Fig. 16.

#### Procedure:

1. Insert the bolt of the rear sling attachment into the sling attachment bushing **407**.
2. Press in the spring bolt.
3. Gently turn the sling attachment until the bolt safety lock engages.
4. Insert the bolt of the front sling attachment into the front sling attachment bushing **48**.

#### Note:

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

## 10 Malfunctions

### 10.1 Detecting a malfunction

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

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



#### **WARNING!**

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

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

#### **Procedure:**

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

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



#### **WARNING!**

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

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

## 10.2 Cause and remedy of malfunctions

Malfunction	Possible cause of malfunction	Possible remedy of malfunction
No round chambered.	Magazine not properly inserted, deformed or dirty.  Rifle faulty.	Insert magazine all the way until it engages (see section 5.8.2).  Repair by manufacturer.
Bolt cannot be inserted into the receiver.	Bolt handle catch not pressed.  Mainspring is uncocked.  Rifle faulty.	Push in the bolt handle catch (see section 5.7.3).  Cock the belt (see section 5.7.1).  Repair by manufacturer.
Rifle trigger cannot be set.	Rifle is uncocked.  Rifle faulty.	Cock the rifle (see section 5.7.1).  Repair by manufacturer.
Rifle cannot be locked.	Rifle is uncocked.  Rifle faulty.	Cock the rifle (see section 5.7.1).  Repair by manufacturer.
Rifle can be neither unlocked nor opened.	Rifle has trigger set and is locked.  Rifle faulty.	Uncock the rifle (see section 5.9.2).  Repair by manufacturer.
Rifle trigger is set. When pulling the trigger no shot fires, instead the trigger returns to the start position.	Trigger was pulled to the side.	Reset, pull trigger back straight/linear.
Rifle disengages automatically when locking.	Set trigger is set too soft.	Set rifle harder immediately (see section 5.9.1).
Front stock comes loose when shooting.	Barrel was not fully in the receiver preventing the stock from engaging fully.	Remove and refit barrel (see section 9.2).
Barrel cannot be removed from receiver.	Cone sits too tight.	Repeat step "dropping the receiver".
Front stock difficult to move.	Dry out metal surface at the stock end.	Grease or oil stock end.

## 11 Spare parts

### Item Designation

#### 100 Bolt assembly

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

#### 200 Receiver assembly

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

#### 300 Barrel assembly

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

### Item Designation

#### 400 Main stock assembly

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

#### 500 Front stock assembly

- 502a Front stock front part
- 502b Front stock rear part
- 503 Sling attachment bushing
- 504 Guide bush
- 505 Bar
- 506 Control bolt
- 507 Bush
- 508 Square nut
- 509 Support for front stock
- 510 Plate for front stock
- 511 Centering bush
- 512 Adapter for TakeDown barrel

#### 513 Pan head screw

- 514 Bearing for front stock

#### 515 Pressure spring

- 516 Locking bolt
- 517 Set screw

#### 600 Magazine assembly

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

### Item Designation

#### 700 Set trigger device

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

# Spare parts

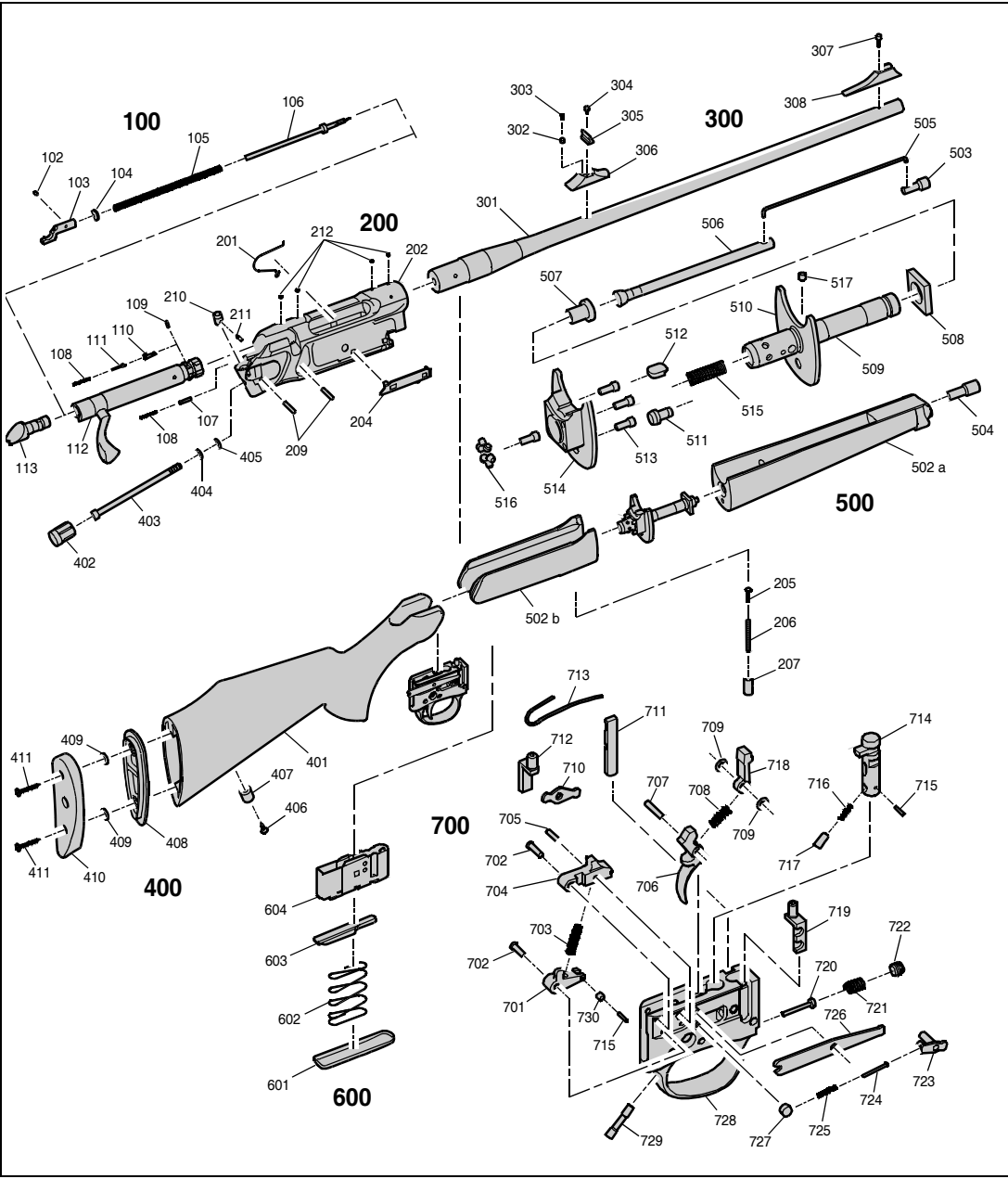


Fig. 26, Spare parts for Sauer 202 Take Down

**J. P. Sauer & Sohn GmbH**

Ziegelstadel 20

D-88316 Isny im Allgäu

Germany

Telefon +49 7562 97554 0

Telefax +49 7562 97554 801

[www.sauer.de](http://www.sauer.de)