

HAENEL

HLR 338



User Manual

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1 General

Thank you for choosing a Haenel product.





The HLR is a product that offers technical advantages of established weapon systems.

1.1 How to use this manual

1.1.1 General

Before using the weapon please read these instructions thoroughly. Use the weapon only after having understood these instructions.

1.1.2 Signs and symbols

Symbol	Meaning
 DANGER	Directly imminent danger! Non-compliance causes death or fatal injury.
 WARNING	Possibly imminent danger! Non-compliance causes death or severe injury.
 CAUTION	Dangerous situation! Non-compliance causes injury.
ATTENTION	Non-compliance causes damage of property.
	Further information about the weapon, the handling or the usage of this instruction manual.

1.2 Disclaimer

We assume no liability and provide no warranty for improper use and negligence.

We also accept no liability and provide nor warranty for physical injuries or property damages which are entirely or partly a result of:

- 1) criminal or negligent use,
- 2) improper or careless handling (forceful use),
- 3) any modifications of the weapon,
- 4) wrong, damaged, improper, self-loaded or reused ammunition,
- 5) bad care and cleaning,
- 6) as a result of other influences beyond our direct or immediate control,
- 7) accuracy of the weapon, if the scope mount was not carried out appropriately,
- 8) optics provided by the customer, etc.

Under no circumstances we accept liability for accidental or consequential damages like property damages, business loss, loss of income or profit.

For warranty claims the weapon should be handed back to the manufacturer or to an authorized service centre for further proceeding.

1.3 Safety regulations

The following safety regulations are **very important** and must be **strictly followed**.

1.3.1 Safety regulations for using firearms

The safety regulations contained in this brochure are of great importance. If you know about the dangers connected with the use of rifles and heed the safety measures described in this manual, complete safety is ensured when using your weapon.

Disregarding only one of these regulations may result in serious injuries, not only to yourself but also to others, and may cause serious damage to the weapon or other property.

10 safety rules for firearms

- 1.) ALWAYS treat a weapon as if it was loaded.
- 2.) ALWAYS check to make sure that the barrel is not clogged.
- 3.) Before shooting, ALWAYS make sure that a backstop or trap exists and what lies behind it. The safety of other people and your own person always comes first.
- 4.) ALWAYS use clean, dry and original factory-made ammunition of the right type and prescribed calibre.
- 5.) When shooting, ALWAYS use hearing protection and shooting glasses. (see below)
- 6.) ALWAYS carry the weapon in such a way that you have control of the direction in which the muzzle will point in case you fall or stumble.
- 7.) Make certain that the weapon is ALWAYS secured until you intend to shoot.
- 8.) Ensure that a loaded weapon is NEVER unattended. Weapons and ammunition are to be stored separately and if possible locked up, so that children and unauthorized persons have no access to them.
- 9.) NEVER permit anybody to use your weapon unless they have read and understood these safety regulations.
- 10.) Never aim a loaded or unloaded weapon at objects you do not intend to shoot at.

Protect your eyes and ears

When shooting, always wear suitable shooting glasses as well as ear plugs or headphone-like hearing protectors. Always make certain that persons near you are protected in the same way. Unprotected eyes can be injured by powder gas and powder smoke, lubricants, metal particles, etc. which are occasionally emitted by weapons during normal use. Without hearing protection, persons frequently exposed to shooting noises may suffer a gradual decline/ loss of hearing.

1.3.2 Securing

- 1.) Your weapon is equipped with an effective and well-constructed safety mechanism.



DANGER

NEVER RELY COMPLETELY ON A SAFETY MECHANISM!

It is NO substitute for safe handling of the rifle. NO safety mechanism, as well constructed as it may be, can be relied on completely. Like all other mechanical devices, a safety mechanism can break or fail to function or be negatively affected by wear, miss-use, dirt, corrosion, incorrect assembly, improper adjustment, and repair or lack of care. There is no safety mechanism which is truly “child-proof”, in the sense of preventing unintentional discharge caused by improper manipulation, carelessness or fooling around. The best safety mechanism is your own common sense. USE IT! Handle your weapon as if you expected the safety mechanism not to function!

- 2.) Never aim your weapon at any part of your own or another person’s body. If you heed this regulation, no bodily injury will be caused by an unintentional discharge.
- 3.) Leave the weapon secured until you intend to shoot and the weapon is aimed at the target!
- 4.) Always take your finger off the trigger and aim the barrel in a safe direction when you activate or deactivate the safety mechanism.
- 5.) When you activate the safety mechanism, make sure that it engages completely.
- 6.) Never carry a weapon with a cartridge in the chamber without having it secured.

1.3.3 Ammunition

- 1.) Use only high-quality, original factory-made ammunition. Do not use cartridges which are dirty, wet, corroded, bent or damaged. Never oil cartridges. Never spray aerosol-type lubricants, preservatives or cleaning agents directly onto cartridges or onto other parts of the weapon from which surplus spray could run off onto cartridges.
- 2.) Use only ammunition of the appropriate calibre for your weapon. The right calibre is engraved on the barrel. Never attempt to use ammunition of another calibre.
- 3.) The use of reloaded, "modified", self-reloaded or other ammunition not according to standards will result in the loss of all guarantee services. Reloading is a science in itself and improperly hand-loaded cartridges can be extremely dangerous. Great damages to the weapon and severe injuries of the shooter or other persons may be the result.
Always use ammunition which corresponds to industrial standards.
- 4.) Due to excessive pressures which may build up inside of the barrel when shooting, the weapon can be damaged and the shooter or other persons severely injured. Excessive pressure can arise due to blockage of the barrel, too great a propellant load, or the use of wrong or incorrectly loaded cartridges. Also, when shooting with dirty, corroded or damaged cartridges the cartridge casing may explode. As a result of the sudden release of high-pressure propellant gas within the weapon, the weapon may be damaged or persons may be injured.
- 5.) Shooting must be stopped immediately and the barrel must be checked for potential clogging if:
 - you have difficulties inserting a cartridge into the chamber or you feel an unusual resistance
 - a cartridge misfires (the bullet doesn't leave the barrel),
 - the bolt mechanism does not extract and eject an empty casing,
 - unburned grains of propellant are found dispersed in the bolt mechanism, or
 - a shot sounds weak or abnormal.In such cases a bullet could be stuck somewhere in the barrel.
Firing off a further round into the blocked barrel can destroy the weapon and severely injure the shooter or persons standing nearby.
- 6.) Bullets can get stuck in the barrel if:
 - the cartridge has been improperly loaded; without powder or if the powder does not ignite, (while ignition of the primer will merely propel the bullet out of the cartridge casing it usually does not produce enough energy to propel the bullet completely out of the barrel),
 - the bullet has not been seated properly and firmly in the casing. If such a round is removed from the chamber without being fired, the bullet may remain in the barrel at the point where the rifling begins. Chambering another round can push the first bullet even farther into the barrel.
- 7.) If you have reason to assume that the bullet is stuck in the barrel, the weapon must be unloaded immediately and the barrel must be visually inspected from the muzzle end. A mere glance into the chamber of the barrel does not suffice. The bullet can be stuck in a section of the barrel where it may not be seen easily. If it is possible to remove the bullet with the aid of a cleaning rod; then the bore, chamber and bolt mechanism must be cleaned before shooting the weapon again.

However, if the bullet cannot be removed like this, the weapon must be taken to an authorized gunsmith or must be sent to our company.

- 8.) Dirt, corrosion or other foreign substances on the cartridges may prevent the proper insertion into the chamber and may result in an explosion of the casing when the round is fired. The same applies to damaged or bent cartridges.
- 9.) Cartridges must not be oiled. In any case, clean the chamber of any oil or preservative substance before shooting. Oil has a negative influence on the necessary friction between the cartridge casing and walling of the chamber and produces a kind of strain similar to that caused by high pressure.
- 10.) Lubricants should be used sparingly on the movable parts of your weapon. Avoid excessive use of aerosols, especially on parts which could come into contact with ammunition. All lubricants, but especially aerosol products, can penetrate the priming compound of the round and thereby cause misfires. A few types of easily penetrating lubricants may even reach inside the casing and ruin the propellant; this can cause the propellant not to ignite, with the possible result that the bullet gets stuck in the barrel.

2 Description and handling

2.1 General description / Specific characteristics

The HLR is a precision rifle with the following characteristics:

- Bolt action rifle with rotating bolt head with aperture angle of 60°
- Carrier current system made of high-strength aluminium for holding the system (barrel and case)
- Barrel is tightly screwed together with the receiver in order to guarantee highest system stability
- Generously designed bolt handle and trigger guard for good, safe handling, even when wearing gloves
- Ammunition is fed by 10-shot magazine
- Cartridge ejection – to the right
- Integrated Picatinny-rail in the receiver for adaptation of optical target systems
- Thread beginning at the muzzle for muzzle break or a silencer
- Corrosion prevention for all fundamental parts

2.2 Technical data

	HLR
Caliber	.338 Lapua Magnum
Length (with muzzle break)	ca. 1280 mm
Width (with bolt handle)	ca. 74 mm
Height (without scope)	ca. 197 mm
Barrel length	690 mm
Muzzle diameter	22 mm
Weight (with muzzle break and unloaded magazine)	ca. 6,7 kg
Magazine capacity	10
Trigger pull	adjustable from approx. 10 – 20N

2.3 Cleaning assembly groups (Figure 1)

1. System with barrel
2. Bolt
3. Support with shoulder support
4. Magazine
5. Handguard

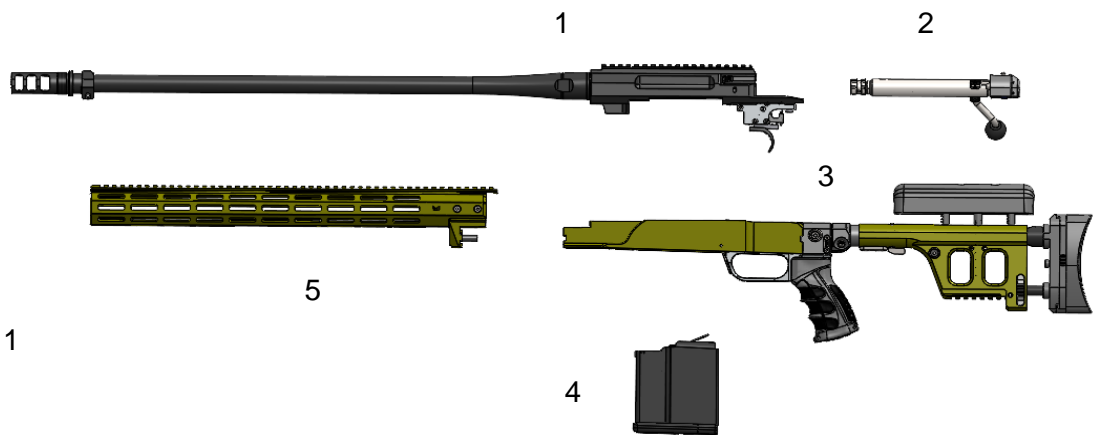


Figure 1

2.4 General view with operating and functional parts (Figure 2)

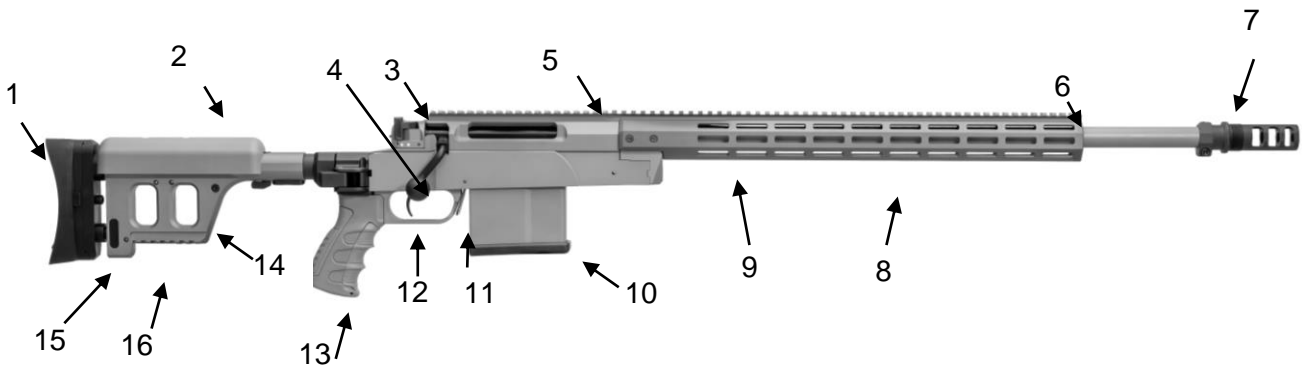


Figure 2

1. Adjustable recoil pad
2. Adjustable cheek piece
3. Firing-pin-safety
4. Bolt handle
5. Picatinny-rail (NATO STANAG 4694)
6. Barrel
7. Thread for muzzle silencer / suppressor
8. NAR-Rail (NATO STANAG 4694)
9. Hand guard
10. Magazine
11. Magazine catch
12. Trigger
13. Pistol grip
14. Ergonomic hand-support device
15. Foldable stock
16. Monopod mount

2.5 Operating

2.5.1 Buttstock adjustment

1.) Adjustment of the length of the buttstock (Fig. 3)

- By turning the adjusting wheel "1", the required length of the buttstock can be adjusted

2.) Adjustment of the recoil pad

- Push latches (2) together
- Adjust required position
- Release latches and let it click into respective position

3.) Rotating of recoil pad

- Rotate recoil pad into required position
- Release recoil pad

4.) Adjustment of the cheek piece

- Press lever "3" (handling from both sides possible)
- Adjust required position of cheek piece
- Release lever "3"

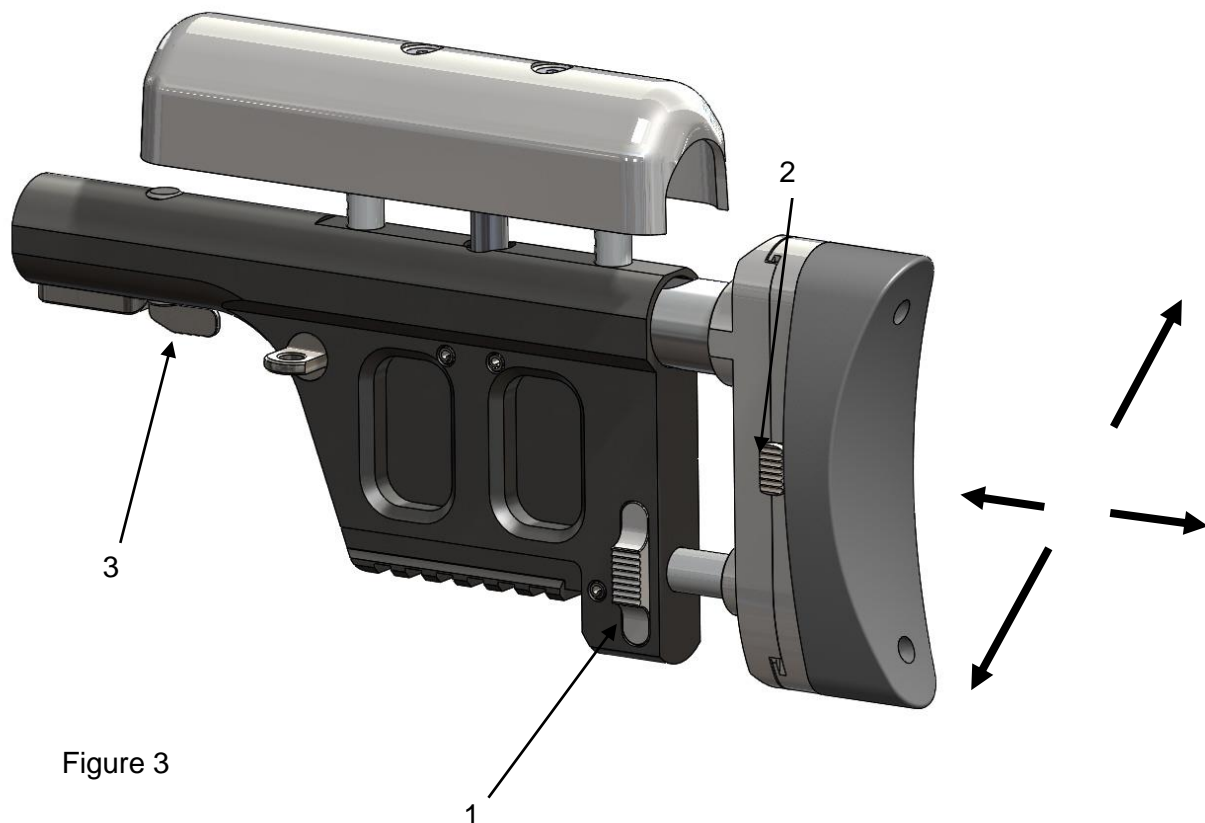


Figure 3

2.5.2 Trigger adjustments



DANGER

The weapon must be uncocked and unloaded before any trigger adjustment.



CAUTION

Only disassemble the weapon to the level described in this manual.

ATTENTION

Always work with great care when disassemble the weapon because of very close tolerances and fittings.



WARNING

After adjustment, the trigger must be tested with at least one shot.



WARNING

The breaking point must be clearly noticeable before the firing pin is released!
If necessary, the breaking point has to be extended!

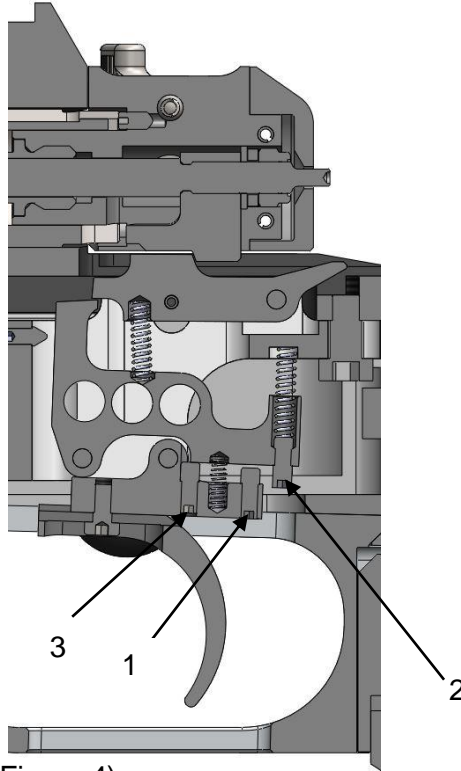


Figure 4

2.5.2.1 Adjusting trigger take-up (Figure 4)



To adjust the trigger take-up, disassemble the receiver from the support (see section 3.1) and turn adjustment screw "3".
- For safety reasons, the trigger take-up has been optimally pre-adjusted by the manufacturer and does not require any further adjusting.



DANGER

By reducing the pre-adjusted trigger take-up, the danger of accidental firing increases!

2.5.2.2 Adjusting breaking point (Figure 4)



The optimal breaking point has been pre-adjusted by the manufacturer.



Trigger blade must be in rear position.

- Cock firing pin
- Turn adjustment screw "1" out until the required breaking point is reached and is clearly noticeable when pulling the trigger.

2.5.2.3 Adjusting trigger pull (Figure 4)

- Cock firing pin
- Turn trigger pull adjustment screw "2" with hex wrench until the required trigger pull is reached



-
- Turning clockwise increases the trigger pull
 - Turning counter-clockwise decreases the trigger pull
-

2.6 Safety



DANGER

NEVER RELY COMPLETELY ON A SAFETY MECHANISM! (see section 1.3.2)

The safety mechanism allows three positions.

- | | |
|-------------------------------------|--|
| Safety lever pulled back | = "safe" and chamber locked (Figure 5) |
| Safety lever middle position | = "safe" for unloading (Figure 6) |
| Safety lever pushed forward | = "fire" (Figure 7) |

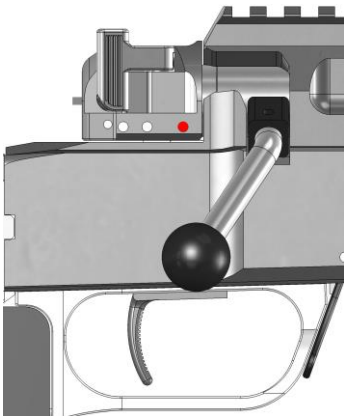


Fig. 5

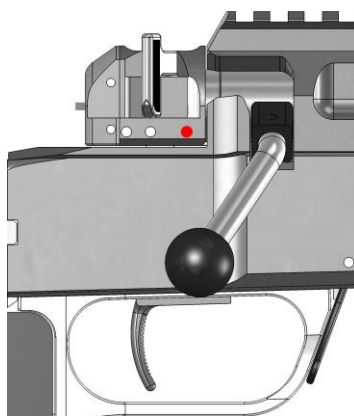


Fig. 6

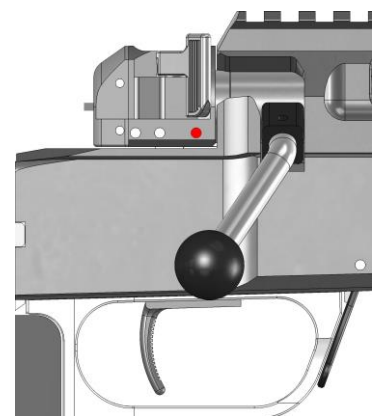


Fig. 7

2.7 Preparation for firing



WARNING

Remove oil from the barrel with a dry cleaning wick before loading and firing. Make sure that the barrel is free from any foreign substances.

2.7.1 Functional checks

ATTENTION

Before each firing you should do the following functional checks to assure functional reliability.

1) Check bolt for mobility and functionality/ Loading procedure

- Remove magazine and fill in a dummy cartridge
- Re-insert magazine again
- Unlock bolt with bolt handle and pull back the bolt until it hits the bolt stop
- Push bolt forward and lock it

The dummy cartridge has to be fed perfectly and the bolt must lock correctly.

- Open bolt again and pull back until it hits the bolt stop

The dummy cartridge must be extracted and ejected perfectly.

(2) Trigger mechanism and safety function

- Remove magazine
- Unlock bolt with bolt handle and pull back the bolt until it hits the bolt stop
- Push bolt forward and lock it
- Put on safe

The safety must slide smoothly to its 3 positions:

- Push safety to position "safe"
- Pull the trigger

It must be possible to pull the trigger without releasing the firing pin.

- Push safety to position "fire"

The firing pin must not be released.

- Pull the trigger

The trigger must release the firing pin

(3) Magazine

- It must be possible to push the follower by hand to the bottom of the magazine housing. After releasing it should be driven back to the top position by the follower spring.
- The magazine must not be jammed in the magazine guide and the magazine catch must hold it properly. When pushing the magazine catch, the magazine should release easily.

2.8 Filling and emptying of magazine



DANGER

The right calibre is engraved on the barrel!

- In order to fill the magazine, push the cartridges one after another below the magazine lips. The bottom of the cartridge case has to touch the rear magazine wall.
- In order to empty the magazine, push the cartridges individually forward and out of the front of the magazine.

2.9 Loading the weapon



DANGER

Follow the safety regulations in section 1.3.



DANGER

- 1.) Make sure that the barrel is pointed in a safe direction!
- 2.) Never attempt to load or unload a weapon inside a vehicle, building, office, or other confined spaces (with the exception of properly established shooting ranges). Closed rooms hardly offer a safe direction in which to aim the weapon; if a round is accidentally discharged, there is always great danger of injuring a person or damaging property.
- 3.) Before loading, any grease and oil must be thoroughly removed from the bore and chamber. Also, always check whether the barrel is clear of obstructions. Foreign substances in the barrel can cause the barrel to bulge or even explode, resulting in severe injury of the shooter or other persons.



CAUTION

Remove oil from bore and chamber with dry patches and check whether it is free from foreign objects.



DANGER

The right calibre is engraved on the barrel !



WARNING

A weapon with a round in the chamber is always a potential source of danger. Therefore, only load a weapon immediately before firing and unload it immediately after firing.

- Push/Pull safety to the middle position “safe” for unloading.
- Insert a filled magazine into magazine well until the magazine catch engages.
- Unlock bolt with bolt handle and pull it back until it hits the bolt stop.
- Push bolt forward and lock it.
- Push safety to the rear, into “safe” position.



The weapon is now loaded, locked and on “safe”!



In order to use the full capacity of cartridges, please proceed as follows:

- Push/Pull safety to the middle position “safe” for unloading.
- Unlock bolt with bolt handle and pull it back until it hits the bolt stop.
- Insert one cartridge manually in the chamber.
- Push bolt forward and lock it.
- Push safety to the rear, into “safe” position.
- Insert filled magazine into magazine well until the magazine catch engages.

The weapon is now loaded, locked and on “safe”!

2.10 Firing



DANGER

Follow the safety regulations in section 1.3.



DANGER

- Keep the muzzle pointed in a safe direction and take your finger off the trigger when cocking the weapon.
- Never carry around a weapon that is cocked and ready to fire; leave the weapon unattended at no time! As soon as it is cocked, a slight pressure on the trigger suffices to discharge a round. An unintended discharge can easily happen when you stumble or drop the weapon, or if the weapon is hit or set off by someone else.
- Never fire a weapon as soon as a finger, hand, face or another part of the body is close to the ejection port or when one could be hit by the reverse movement of the bolt.
- Make sure that nobody is standing on that side where they could be hit by ejected cartridge casings.
The casing is hot and can be ejected at a speed which suffices to produce a burn or cut, or to injure the unprotected eye. Consequently, make sure that there is sufficient room for the safe ejection of cartridge casings. Do not forget that the casing can bounce off any object nearby and hit you or other persons.
- As soon as ANY mechanical failure or jamming of the weapon occurs while shooting, if it “spits out” powder gas, if the cartridge casings are bent or cracked, or if the muzzle blast does not appear to be right, STOP SHOOTING AT ONCE! Further shooting can be dangerous. UNLOAD THE WEAPON and DO NOT attempt to fire off “another shot”.
Have the weapon and the ammunition checked by an authorized gunsmith or by us in

the factory.

- Incidents in which the barrel swells near the muzzle or bursts are surprisingly frequent. In practically all cases this is the result of careless handling, when soil, snow or plant remains get into the muzzle and clog up the bore. As soon as the muzzle of your weapon comes into contact with soil or when you have reason to believe that foreign substances are in the muzzle, you must unload the weapon and look into the barrel from the rear. It is not enough to glance into the muzzle, because dirt, snow, etc. may have gotten farther into the barrel where it is not easy to determine.

As soon as anything in the barrel that could potentially cause malfunction, it must be thoroughly cleaned before trying to shoot. Never attempt to shoot such foreign substances out! Shooting a weapon with a clogged bore can cause the barrel to explode and hurt you or other persons in your vicinity.

Load the weapon according to section 2.10



The weapon is now loaded, locked and on “safe”!



DANGER

Be sure of your target and what is behind or around it in order to avoid any kind of danger or accident.

After taking aim, you can release the safety as described in section 2.6.

You can fire a shot by pulling the trigger now.



WARNING

The weapon's recoil can cause serious injury.

- When firing, pull the weapon firmly into your shoulder.
- Keep your eye at least 6 cm away from the scope when firing.

2.11 Unloading the weapon



DANGER

- 1.) Make sure that the muzzle is pointed in a safe direction!
- 2.) Do not forget to look into the chamber after the magazine has been removed.
- 3.) Never assume that your weapon is unloaded unless you have yourself personally convinced of this!

- Push/ Pull the safety mechanism to the middle position “safe” for unloading.
- Press magazine catch and remove magazine.
- Unlock bolt with bolt handle and pull back the bolt until it hits the bolt stop.
- Check whether the chamber is empty.
- Close the bolt and lock it.
- Pull the safety back to the “safe” position.



The weapon is now cocked, safe and not loaded

2.12 Folding shoulder stock

Push the lock button (Figure 8). Fold the shoulder stock to the right side of the rifle. The lock pin must audibly click into place.

Push the lock pin down (Figure 9) to swing out the shoulder stock. You can swing out the shoulder stock now. The folding lever should audibly click into place.



WARNING

Take care to keep away parts of your body, like fingers etc., from the mechanism when opening and closing the folding hinge. There is a danger of getting caught.



To reduce the noise when opening or closing the shoulder stock you may use the folding lever or rather the lock pin when folding or swinging out, to minimize the sound of the folder lever clicking into place.



The folding hinge is arranged in such a way that it is not necessary to change the user adjustments for folding.

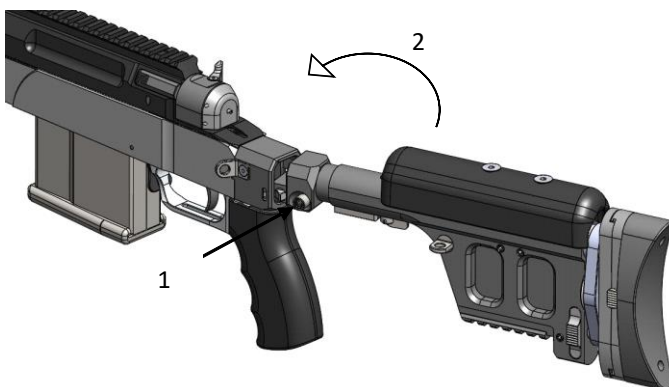


Figure 8

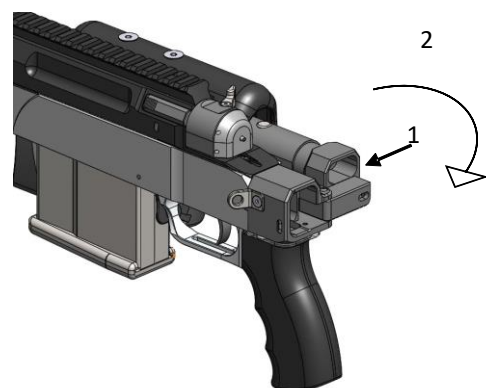


Figure 9

3 Disassembly and reassembly of the weapon

3.1 Disassembling into cleaning assembly groups



DANGER

The weapon must be unloaded before disassembling: check both, barrel bore and chamber, to be empty!



CAUTION

Only disassemble the weapon to the extent described in this manual.

ATTENTION

Disassemble the weapon very accurately, because the tolerances and fittings are very narrow.

(1) Remove magazine

- Press magazine catch "1" and remove magazine (Figure 10)

(2) Remove bolt completely



In order to remove the bolt completely the shoulder stock must be folded down (see section 2.11).

- Unlock bolt with bolt handle and pull back until it hits the bolt stop
- Push bolt support "2" (Figure 10); remove bolt to the rear at the same time

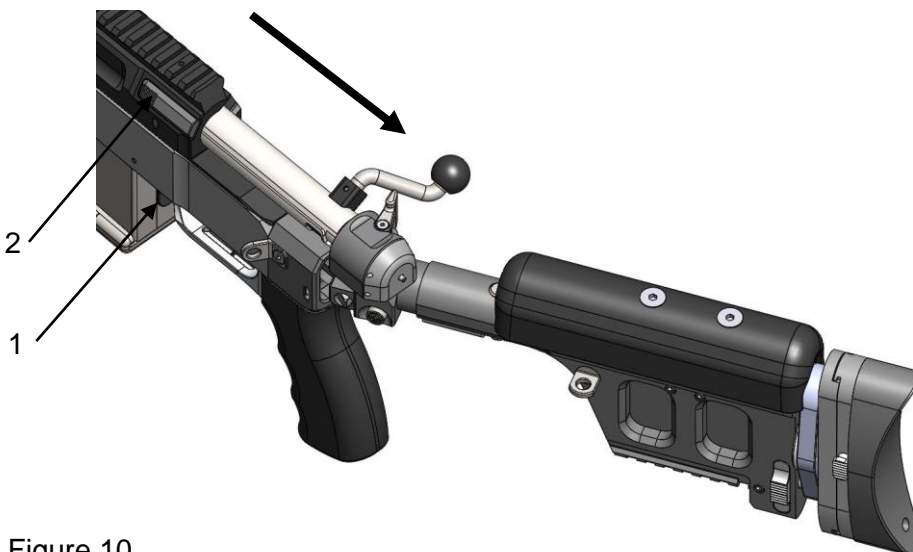


Figure 10

(3) Remove system from support completely

- Unscrew screws "1" alternately in order to avoid damages (Figure 11)
- Remove system from support completely

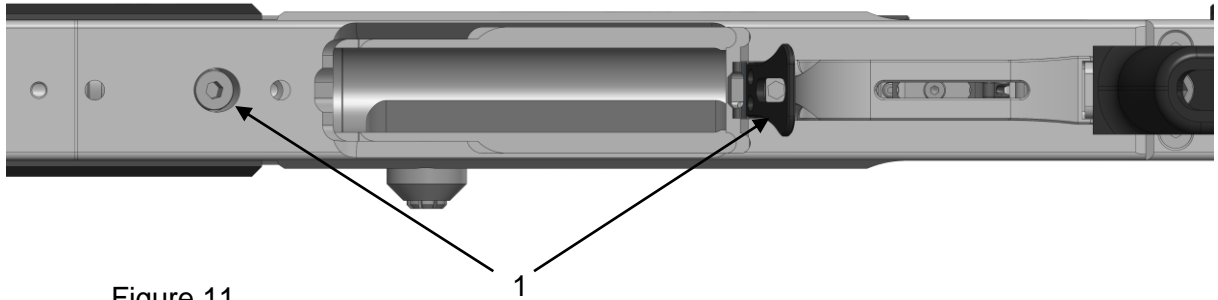


Figure 11

3.2 Disassembly and reassembly of the bolt

(1) Disassembly

Turn bolt sleeve into indicated position (Figure 12), remove bolt handle by pushing (on a solid support "1") (Figure 13). Remove bolt sleeve.

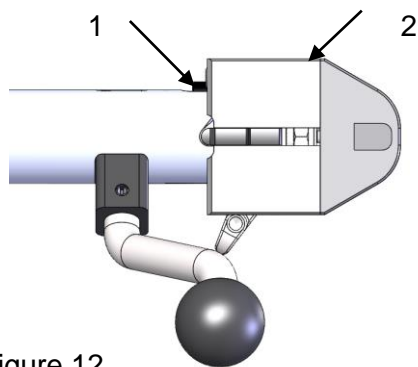


Figure 12

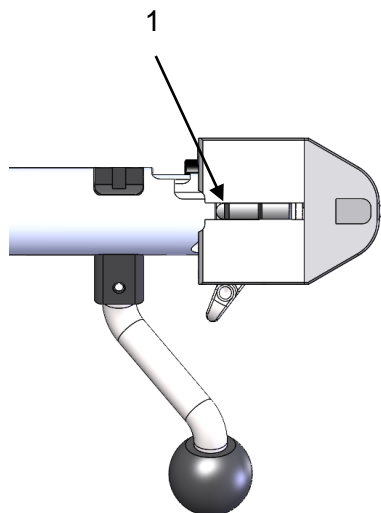


Figure 14

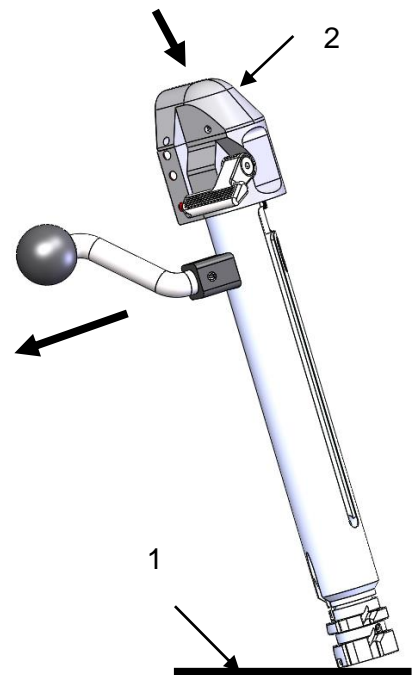


Figure 13

(2) Reassembly

Reinsert bolt sleeve into the bolt head and bring it into position (Figure 12). Reinsert bolt handle into the bolt head. Push the bolt sleeve on a solid support again (Figure 13).

Turn the bolt sleeve completely into the indicated position (Figure 14).



You may have to clamp the receiver in order to turn the bolt sleeve into the position shown in figure 14.



CAUTION

Be careful! The latching edge (see "1" in figure 14) is very sharp-edged and the power of the firing pin spring. → Danger of injury!

3.3 Reassembly of the cleaning assembly groups

The reassembly of the assembly groups is done in reversed order than the disassembly (see section 3.1).

4 Shooting performance

We produce our barrels using most modern manufacturing techniques and high-strength steel. But the accuracy depends on and may be influenced by a number of factors.

The most important influencing factor is the ammunition you use.



Principally, use the ammunition determined in the gun-passport for checking the accuracy of your weapon. Otherwise, substantial differences concerning the shooting performance are possible. Also, ammunition of equal brand and equal filling can show a differing accuracy and point of impact from weapon to weapon.

Another important factor which has a strong influence on the accuracy of your weapon is the scope you choose. Therefore, you should have the same high demands on the quality of the scope and scope mount as on the quality of the weapon itself.



If a scope is assembled later on (not by the manufacturer) the weapon has to be newly adjusted and test fired again.

Only when you are using best ammunition, scope and a suitable scope mount we guarantee an excellent shooting performance of our weapons.

Complaints concerning the accuracy of the weapon have to be sent in written form within 1 month after purchase. If a complaint turns out to be unwarranted, we reserve the right to invoice any extra costs incurred.



Ask our customer service for a special firing and cooling rhythm which is necessary for certain kinds of our weapons.

5 Maintenance and cleaning of the weapon



CAUTION

Only disassemble the weapon to the extent described in this manual.



DANGER

Be absolutely certain that the weapon is unloaded before disassembling or cleaning!

ATTENTION

- Inappropriate cleaning agents can damage the weapon. When cleaning the weapon, use only cleaning and preservative agents which are suitable for weapons. They are available in specialized retail shops.
- Do not use any metallic objects nor any plastics (nylon, etc.) to clean the weapon.

All weapons require regular maintenance, cleaning and inspection, which may lead to the necessity of readjustment or repair. Have the weapon inspected regularly by an authorised dealer or the manufacturer even if it seems to be in best shape. Broken parts, insufficient function, excessive wear or corrosion of some parts are not necessarily obvious during an external control. In case of ANY mechanical failure do not use the weapon anymore. UNLOAD the weapon and send it to an authorised dealer or to the manufacturer immediately.

ATTENTION

- The barrels have to be cleaned immediately after using the weapon to remove all burning residues of the gun powder. Oil the inside of the barrel lightly.
- All exterior steel parts have to be dried and oiled lightly.
- Particular attention has to be paid to all slide parts.

5.1 Storing the weapon



DANGER

Follow the national regulations for the storage of weapons and ammunition.

ATTENTION

Never store a cocked weapon.

6 Packaging / Shipping of the weapon

If you want or have to ship your weapon, use appropriate packaging. If required, the packaging is available in special retail shops or from the manufacturer.



WARNING

Before shipping the weapon, make absolutely sure that the weapon is unloaded.



Always ship weapon and ammunition separately. Follow national regulations for the shipping of weapons and ammunition.
