



H-S PRECISION®

PRO-SERIES® RIFLES

OWNER'S MANUAL

Firearms Safety & Instruction

IMPORTANT

READ THIS BOOK BEFORE USING YOUR FIREARM



H-S PRECISION®

NOTICE

RIFLES BEING RETURNED FOR REPAIR, OR ANY OTHER REASON, MAY BE SENT DIRECTLY TO H-S PRECISION. IF RIFLE IS SHIPPED FROM AN FFL HOLDER, IT MUST BE RETURNED TO THE FFL HOLDER.

ALL RETURNS OR REPAIRS MUST BE SHIPPED PRE-PAID. COLLECT SHIPMENTS WILL BE REFUSED AND RETURNED. NO CREDIT WILL BE GIVEN FOR SHIPPING CHARGES.

1301 TURBINE DRIVE | RAPID CITY, SD 57703

WARRANTY

We will consider requests for service or repair of H-S Precision firearms without charge on a case-by-case basis. A determination will be made taking into consideration such things as the age and condition of the firearm, and the circumstances surrounding its malfunction or other problem.

H-S Precision will not be responsible for damage resulting from ordinary wear and tear, alterations by unauthorized persons, accidents, misuse, use of incorrect or other than factory loaded ammunition, or failure to provide reasonable and normal maintenance.

Should any H-S Precision product require service or repair under this policy, please contact our offices to receive a Return Authorization Number.

EMAIL: info@hsprecision.com **PHONE:** 605-341-3006

WE ARE H-S PRECISION

The Pro-Series® line of semi-custom bolt action rifles have been called “the best firearms value on the market.” H-S Precision manufactures every component of the Pro-Series® – testing each firearm in our state-of-the-art, underground, 100-yard range for guaranteed accuracy.

All Pro-Series® firearms, 30 caliber and smaller, are guaranteed to shoot 1/2" MOA or better at 100 yards. A target and load data are provided with each firearm.

There is not a firearm manufacturer in the world today that builds a more accurate and reliable rifle than H-S Precision.

Welcome to our community of Pro-Series® owners. Join us on Facebook, YouTube, and Instagram for updates and company announcements.



Tim Houghton
VP & COO



Photo: Pro-Series® HTR in Black-Tan/Bronze Cerakote™

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Top 10 Rules of Safety

Only you can prevent accidents

Before using your firearm, read these basic safety rules. Learn how to handle your firearm safely. Failure to follow these rules of safety may result in serious personal injuries or death. To use your firearm correctly and safely, read and know the instructions enclosed in this safety booklet and instruction manual.

TREAT EVERY FIREARM AS IF IT WERE LOADED

Do not rely on the safety lever alone. The safety may not prevent an accidental discharge due to dropping, jarring, or bumping a rifle.

NEVER MAKE ADJUSTMENTS

Do not make changes or alterations to any part of a firearm. Only use H-S Precision parts on your Pro-Series® rifle. Never make an adjustment to the trigger or change the shape/size of the sear, sear notch, or modify any other parts.

MAKE YOURSELF SAFE

Wear eye protection such as shooting glasses and hearing protection. Repeated exposure to shooting noise can cause permanent hearing loss. Never drink alcohol or use drugs that may cause impairment during shooting.

TAKE CARE OF YOUR FIREARM

Keep the barrel clean and free of obstructions. Clean and have the firearm checked periodically by H-S Precision or an authorized gunsmith to make sure it is mechanically correct. Worn, damaged, or missing parts may be dangerous and may cause the firearm to malfunction.

BE AWARE OF THE MUZZLE DIRECTION

Always keep the firearm pointed in a safe direction. If the firearm fails to fire, keep it pointed in a safe direction, then unload carefully (avoiding exposure to breech). If the firearm fires but report or recoil seems weak, unload and then make sure the barrel is not obstructed.

NEVER USE THE WRONG AMMUNITION

Only use ammunition that matches the caliber markings on your firearm exactly. Handloads can be dangerous. H-S Precision is not responsible for accidents or damage caused by handloads.

KNOW YOUR TARGET

Before you pull the trigger, make sure you can see the target clearly, as well as the path of the bullet beyond the target. Never shoot at water, rocks, or any surface that will not absorb the impact of a bullet. Bullets may glance off such surfaces and cause injury.

KNOW THE RANGE OF YOUR FIREARM

Rimfire bullets can travel more than 1.5 miles. Centerfire bullets can travel up to 5 miles.

NEVER CARRY/STORE A LOADED FIREARM

Unload your firearm whenever you are not shooting. Unload your firearm before climbing up (or over) a fallen tree, fence, slippery area, or other obstacles. Unload your firearm before storing it in a building, safe, or vehicle.

STORE YOUR FIREARM SAFELY

Keep firearms and ammunition away from children. Lock unloaded firearms and ammunition securely in separate locations.

ENGINEERED FOR ACCURACY®

Accuracy is one of the most important aspects when selecting a rifle that will yield results – whether on the shooting range seeking steel or in the field hunting. The line of custom bolt-action rifles we have proudly named the H-S Precision Pro-Series® is built with accuracy at its core. The precision and attention to detail that goes into every step of manufacturing our rifles is second to none.

Since 1978, we have engineered, designed, and manufactured every single component of our Pro-Series® rifles in house at our factory in the USA. From the complete action (including the floor metal, magazine, and trigger), the barrel, and synthetic stocks – H-S Precision is proud to produce innovative products using world-class techniques, proprietary technology and state-of-the-art equipment.

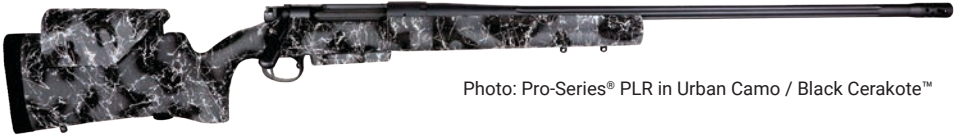
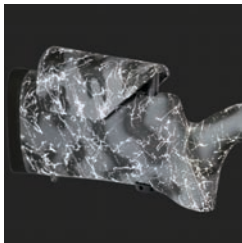


Photo: Pro-Series® PLR in Urban Camo / Black Cerakote™

EVERY H-S PRECISION RIFLE IS A SUM OF ITS PERFECT PARTS.

In combination, these features yield a strong, reliable, and accurate shooting platform worthy of the H-S Precision name.



STOCK

Hand-laminated synthetic featuring Kevlar®, fiberglass, carbon fiber, and a full-length 7075-T7 aluminum bedding block.



BEDDING BLOCK

The foundation of the barreled action, CNC machined to the exact dimensions of the action.



ACTION

Our actions are machined in from 17-4 stainless steel bar stock. Every component of the action is made at our factory in South Dakota, ensuring that we will have perfect fit and interface from bolt, to action, to barrel.



BARREL CROWN

The crown of a rifle barrel allows a clean exit from the bore. H-S Precision barrels are precision crowned on a CNC lathe with an 11° target recess to protect the barrel and enhance accuracy.

IMPORTANT FEATURES OF YOUR PRO-SERIES® FIREARM

SAFETY LEVER

The safety lever provides protection against any accidental or unintentional discharge under normal usage when properly engaged. The safety on any H-S Precision firearm is located on the safety shroud. (See Figures 1A, 1B, and 1C)

To engage the safety lever, move the lever to either safe position. (See Figure 1B & 1C) Always engage the safety lever when the firearm is loaded and not ready for firing. When you are ready to fire the rifle, move the lever to fire position. (See Figure 1A)

Never pull the trigger when the safety lever is engaged. Do not touch the trigger when moving the safety lever. The firearm will fire when the trigger is pulled and the safety lever is disengaged.

! EVEN WHEN THE SAFETY LEVER IS ENGAGED, CARELESS HANDLING CAN CAUSE THE FIREARM TO FIRE.

BOLT

The bolt handle is used to open the action by pulling the bolt rearward. (See Figures 2A, 2B, and 2C)

To remove the bolt, pull the bolt handle up and rearward; push the bolt stop release and remove the bolt. (See Figure 2B and 2C)

The firearm can be fired when the bolt handle is forward and down. The action is then closed.

TRIGGER

Pulling the trigger fires the firearm. The trigger is adjusted at the factory. Any adjustments to the trigger must be made by H-S Precision or an authorized gunsmith.

! NEVER PUT YOUR FINGER ON THE TRIGGER UNLESS YOU ARE GOING TO FIRE THE FIREARM.

BARREL

The inside of the barrel must be clean and free of obstructions.

To check the inside of the barrel follow the directions below.

1. Point the firearm in a safe direction.
2. Engage the safety lever.
3. Pull the bolt fully rearward; push the bolt stop release and remove the bolt.
4. Remove the magazine box.
5. Insert a cleaning rod into the breech. Push the rod completely through the barrel until the rod can be seen at the muzzle end.

To remove object from inside the barrel follow the directions below.

1. Using the correctly sized cleaning rod, insert the rod into the muzzle and lightly tap rod to free the object(s).
2. Push rod completely through the barrel until the rod can be seen in the ejection port.
3. If an object cannot be easily pushed out of the barrel with a cleaning rod, return the firearm to the factory or an authorized gunsmith for removal.

! NEVER TRY TO REMOVE AN OBJECT FROM THE BARREL BY LOADING ANOTHER CARTRIDGE AND FIRING.

FIGURE 1A: Ready to Fire



FIGURE 1B: Safe



FIGURE 1C: Safe (Bolt Locked Down)



FIGURE 2A: Down Bolt Position



FIGURE 2B: Bolt Stop Release



FIGURE 2C: Open Bolt Position



Barrel Break-In & Cleaning

H-S Precision Pro-Series® Instructions

Your new H-S Precision Pro-Series® rifle has gone through its initial break-in process during accuracy testing at the factory. For the first 50 rounds you put through your rifle, clean it after every 3 to 5 rounds following the cleaning procedures below.

WARNING: DO NOT USE ABRASIVE/GRITTY CLEANERS TO CLEAN YOUR BARREL. DOING SO COULD AFFECT THE ACCURACY AND LONGEVITY OF YOUR CUT-RIFLED BARREL.

STEP 1

First clear the weapon, put the safety in the "safe" position (See *Figure 1B*; page 5), remove the magazine box and check the chamber to make sure there are no cartridges in the rifle.

STEP 2

Remove the bolt assembly following instruction on page 4. Insert the cleaning rod guide in place of the bolt assembly.

STEP 3

Attach a bronze bore brush to the cleaning rod using the adaptor.

STEP 4

Saturate the brush with Bore Tech Eliminator and slowly push through the bore from the chamber and completely out the muzzle; repeat two to three times. This will get the bulk of the powder fouling out of the barrel.

STEP 5

Remove the brush from the rod, attach spear point jag with patch, soak patch with Eliminator, and push through the bore. Repeat several times using a new, clean patch each time.

STEP 6

Remove jag from the rod and attach the brush. Saturate the brush with Eliminator and slowly push through the bore two to three times. Let the Eliminator soak in the barrel for a few minutes. Follow with two to three saturated patches.

STEP 7

Inspect the barrel; if copper fouling still remains in the barrel, repeat step 5.

STEP 8

Use a patch wet with Rem Oil to remove any Eliminator. Follow this with two to three dry patches or until one comes out clean.

STEP 9

Wipe the muzzle of the barrel to remove any excess solvent that has come out of the barrel.

STEP 10

If the rifle is going to be stored for a period of time, oil the barrel from the chamber end by running a soaked patch through the barrel followed by two dry, clean patches. Always make sure your barrel is clean and dry before using it. A clean, dry barrel is desirable for sighting in your rifle.

LOOKING FOR MORE?

Visit hsprecision.com or subscribe to our YouTube channel for shooting tips and instructional tutorials.



 OfficialHSPrecision

CLEANING & MAINTAINING PRO-SERIES® RIFLES



Photo: Pro-Series® PHL in Shadow Camo / Gray Cerakote™

The chamber should be cleaned before loading and firing your firearm for the first time. Follow the cleaning instructions below.

CLEANING THE CHAMBER

Check the chamber to make sure there are no cartridges in the firearm before cleaning. Use the instruction and the equipment provided in your cleaning kit in conjunction with the steps below.

1. Pull the bolt rearward; push the bolt stop release and remove the bolt.
2. Apply cleaning solvent to chamber mop.
3. Push the mop into the chamber and clean in a back-and-forth motion several times.
4. Using a cleaning rod with a cleaning patch, dry the chamber. Repeat several times using a clean patch each time until the patch returns clean.

CLEANING THE FIRING PIN ASSEMBLY

Remove the firing pin assembly following the instructions below.

1. Engage safety lever to the "safe" position. (See *Figure 1B*; page 5)
2. Pull the bolt rearward; push the bolt stop release and remove the bolt.
3. Unscrew the firing pin assembly by twisting it counter-clockwise and remove it from the bolt body. (See *Figure 3A*; page 8)

Note: For left-handed receivers, unscrew the firing pin assembly by twisting it clockwise.

Once the firing pin assembly is removed, follow the steps below for cleaning and reinstallation.

1. Using a clean rag, wipe off any debris and powder residue on the firing pin assembly, safety shroud threads, as well as inside and outside of the bolt body.
2. Apply grease to threads of the safety shroud, locking lugs, and cocking cam. (See *Figure 3B*; page 8)
3. Reinstall the firing pin assembly into the bolt body, making sure the cocking piece tang is positioned in the detent of the bolt body. (See *Figure 3C*; page 8)
4. Lightly apply oil over the safety lever detents and the bolt stop pivot. (See *Figure 3D*; page 8)
5. Reinstall bolt into the receiver.

! WHEN THE FIREARM IS TO BE REUSED, ALL EXCESS LUBRICANT MUST BE REMOVED. OVER-LUBRICATION SHOULD BE AVOIDED AT ALL TIMES. THE CHAMBER AND BORE MUST BE THOROUGHLY WIPED DRY.

IMAGE EXAMPLES BELOW ARE CONTINUED FROM PAGE 7 INSTRUCTION.

FIGURE 3A

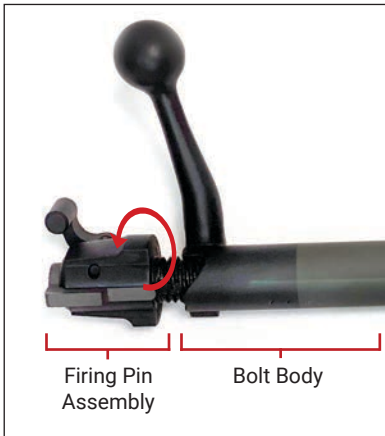


FIGURE 3B



FIGURE 3C

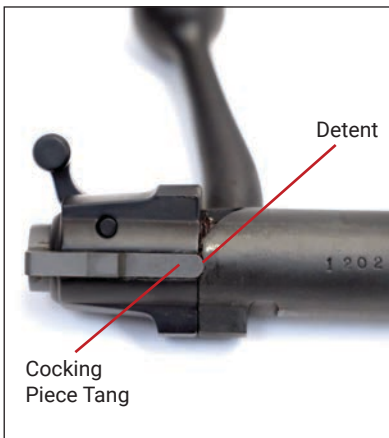
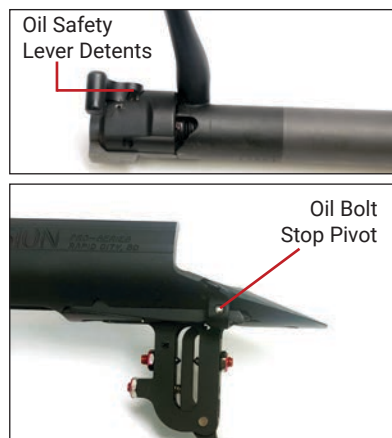


FIGURE 3D



LOADING & UNLOADING YOUR PRO-SERIES® RIFLE

Your firearm should be cleaned before loading and firing the firearm for the first time. Before loading the firearm, make sure the inside of the barrel is clean and free of dirt or other objects.

For instruction on checking your barrel, see page 4.

For instruction on cleaning your barrel, see page 6.

LOADING YOUR FIREARM

See Figure 4A and 4B for loading the rifle magazine. To remove the magazine, see Figure 5.

1. Point the firearm in a safe direction.
2. Engage the safety lever. (See Figure 1; page 5)
3. Pull the bolt fully rearward.
4. Remove the magazine by pressing the magazine release. (See Figure 5)
5. Place a cartridge in the magazine, pressing the follower down with the base of the cartridge, and slide the cartridge under the feed rails.
6. Slide the magazine into position in the firearm facing the proper direction and snap into place.
7. Do not cycle the bolt to load a cartridge into the chamber until you are certain of your surroundings and ready to fire.

If the firearm fails to fire, keep the firearm pointed in a safe direction, wait 30 seconds, then carefully unload. Follow the unloading instructions below.

UNLOADING YOUR FIREARM

1. Point the firearm in a safe direction and ensure safety is engaged.
2. Remove the magazine.
3. Cycle the bolt up and rearward to remove the cartridge from the chamber.
4. Check the chamber to make sure it is empty and there are no cartridges.

FIGURE 4A



FIGURE 4B



FIGURE 5





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IMPORTANT

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