

Barrels and lumps coupling on a side by side gun.

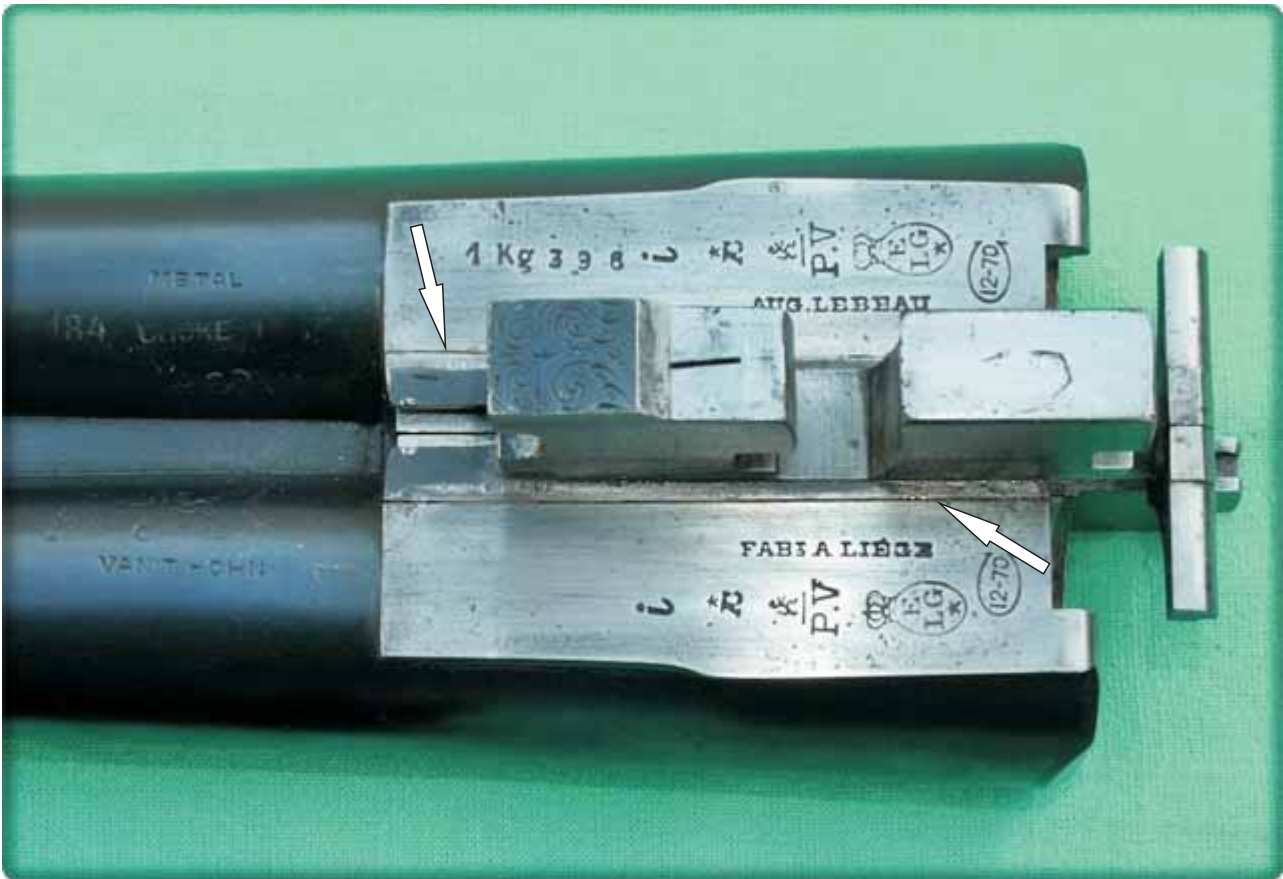
Industrially the most convenient system is the one called monobloc. The two barrels are plugged and welded to a monoblock, which has flats, lumps and two holes for the tubes. Finally the ribs are welded. It is immediately recognizable because the join between the tubes and the monoblock, the breech, is visible. A thin circular line sometimes masked by a decorative pattern. Beretta taught that this method works fine. As an example we show here below a Darne, as a demonstration that in certain cases monobloc and fineness can live together.



It is possible to find side by side guns that bring highly visible the mark of the union between breech and tubes, at the beginning of the action flats. The tubes, worn, have been substituted while maintaining the original breech, flats and lumps. It is not a monobloc when the lumps are welded to the barrels or together.

Another construction method is the one we believe should be called entire barrels with welded lumps. There are two versions: 1) the barrels flats are obtained from solid tubes. 2) the flats are welded to the barrels after the lathe.

In both cases the lumps are welded to the barrels. A Lebeau and a Sauer & Sohn show the two solutions.



The demibloc system is the most challenging. Barrel, flat and half (longitudinally) of the first and second lump are machined from solid. The two halves are joined.

In some cases the final part of the top rib is machined from solid too, altogether with the rest. In this way a possible third closure becomes even stronger. A Zanotti and an Ideal Manufrance as an example.



We hear talking about integral demibloc, but we don't understand what's the meaning. Either it is monobloc, or the lumps are welded (after) to the barrels, or the two halves demibloc are joined. Otherwise, "demi" what does it mean? In the first and second cases, "demi" of what? If you think we are wrong, explanations and reasoned different opinions are welcome.

By Paolo Tebaldi