

Title (en)  
Method for producing smooth bore guns

Title (de)  
Verfahren zur Herstellung von Flintenläufen

Title (fr)  
Procédé pour la fabrication des fusils non rayés

Publication  
**EP 0614712 B1 19990602 (DE)**

Application  
**EP 94103457 A 19940308**

Priority  
DE 4307775 A 19930312

Abstract (en)  
[origin: EP0614712A1] The invention relates to a method and a device for producing high strength tubes (1), in particular barrels of shotguns and rifles. In order to reduce the number of work steps during manufacture it is proposed that a circular tube (1) as a blank is processed by means of a pressure roller method which is known per se, such that a) a mandrel (2) of a pressure roller tool (3) is inserted into the circular tube (1), the external diameter of the mandrel (2) corresponding to the internal diameter of the desired finished tube, b) the circular tube (1) is compressed with known pressure rollers (4) with a special geometry, the thickness of the wall is reduced, the length increased and, at the same time, the outer contour of the tube (1) is produced, c) after pressure rolling, the outside diameter of the finished tube (1) is partially turned and the finished tube is cut to size.  
<IMAGE>

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**B21H 7/18; B21C 37/15**

IPC 8 full level  
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Cited by  
EP0882532A3; CN102470418A; US8910409B1; US6038901A; EP2454553A4; US8997541B2; US10857580B2; US9217619B2; WO2017157556A1; US9662740B2; US10118259B1

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