

**MERKEL. DIE JAGD.**

Jagdgewehrmanufaktur. Suhl. 1898.



**PORTFOLIO**



**MERKEL**



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## A FAMILY TREE FOR HUNTERS

A family tree always makes a statement. When you look at a family tree you remember your forefathers – and order your future at the same time. Merkel has done both in recent years, has reclaimed the legend of the city of Suhl.

The Merkel manufactory is unique among its type in the world. Without descending into nostalgia for the old East Germany, it is thanks to the GDR that we have this unique combination of high-tech forging and gunsmithing workshops. It was as if a cheese cloth had been cast over the country between 1949 and 1990. It kept the old traditions fresh. The situation was not exclusive to Merkel – but only in a few industrial branches did this prove to be an opportunity; to be able to continue working for 40 years, free from economic forces and virtually no technological pressure.

In these four decades we retained what was lost elsewhere. Many Suhl gunmakers left the region after the war and were re-established in West Germany.

They have almost completely done away with their gunsmithing traditions and turned to industrial manufacturing processes – which was unavoidable in the market economy system. They have undoubtedly developed outstanding products; but at what price?

Merkel stayed. And, now situated in the middle of Germany, has used the last decade to re-engineer its product range, without changing its aesthetic-functional value. And out of Suhl expertise Merkel has given birth to a new gun category: MEM.

What Merkel can offer today is unique in the world. To the delight and the benefit of hunters all around the world, we can produce handmade masterpieces, which combine centuries old expertise with artistic handcraft and cutting-edge manufacturing techniques. Or prototypes, which brilliantly combine Suhl principles and systems and exemplify hunting gun culture of the highest technological level – we call these hunting guns MEM. Merkel is the last great hunting gun

manufactory in Suhl. Together with the independent Suhl master gunsmiths, we cultivate the knowledge and the skills which have accumulated since 1490 – and make hunting guns out of it.

MEM and Meisterstück are the two poles of the Merkel hunt. They have developed from the love of a pastime which has always been part of human life. And from a totally innate sense of aesthetic.



■ Olaf Sauer  
Managing Director of the Merkel company.



## HISTORY

# THE GERMAN DAMASCUS

There are regions and cities that cultivate a legacy: mechanical watches in Glashütte, lace in Brussels, red wine in Bordeaux. Suhl's legacy is guns – since 1490 according to the latest findings. And the knowledge of making fine guns is deeply rooted in the collective memory of the people of this region.

The old city of Suhl is the gateway to the Thuringian Forest. Iron ore and the wood used to fire the ironworks are easily accessible here. Legend has it that gunsmiths from Nuremberg recognised

the advantages of the location and settled here. At the time guns for defence and protection were produced. Since the Middle Ages Suhl has been looked upon as the gunmaking city of Europe.

Nevertheless the arts and crafts were not neglected in Suhl: the rifles were engraved on all sides and beautifully finished. The city soon earned the nickname "German Damascus" – the guns were richly decorated. The people of Suhl are proud of this name, because it brings to mind the great tradition of the

Damascus gunsmiths. They elevated engraving and manufacturing to high art in the Arabian world.

In Suhl there was always a demarcation between military production and hunting guns. The "fine gun" remained the preserve of hunting – richly adorned and elegantly designed.



■ Suhl rifles, 17th and 18th century.

## THE FORMATIVE YEARS

The industrial revolution made Germany the third largest industrial nation in the world. And in Suhl the craftman's workshops turned into manufactories and later into gun factories. The Merkel brothers wanted to be part of the unprecedented transformation of the national economy at the turn of the 19th Century.

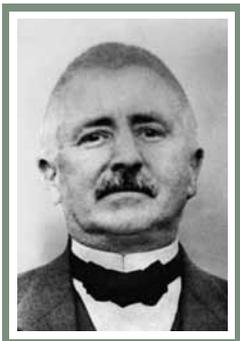
Albert Oskar, Gebhard and Karl Paul Merkel came from a long line of engravers, stock makers and gunsmiths – and a family with many children. All eleven sons of the family found their way into the gunmaking trade. Albert Oskar and Gebhard Merkel were master gunsmiths. Karl Paul Merkel followed as a master stock maker – they founded a trading

company “for the purpose of joint manufacture of firearms and other articles.” On 1st September 1898 the company started work in the second district. This was the start of a development that is remarkable even in the gunmaking town of Suhl.

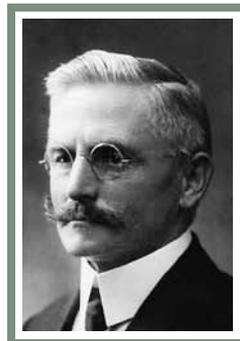
During the formative years of the company the manufacture of hunting, sporting and luxury guns was booming in the old gunmaking town. The mechanical design of these guns was more elaborate and technically variable than military rifles. Merkel was committed to the “fine gun” at all times; even in wartime it was never more than a parts supplier for military production. While the two great wars of the 20th Century

turned some gunmakers into industrial enterprises, the Merkel workforce hardly ever rose above 350 employees during the war. Instead, the export-oriented company twice lost its important foreign markets.

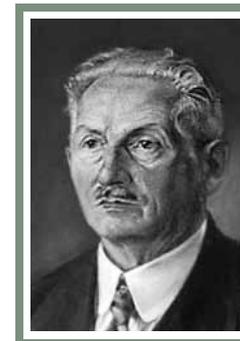
From the outset the Merckels pinned their hopes on innovation. The Bock over-and-under gun with the two barrels lying upon one another originates from Suhl, and Merkel registered the “Bock” as a trademark. Merkel revolutionised sporting shooting and hunting with these rifles.



**ALBERT OSKAR MERKEL**  
Master gunsmith



**GEBHARD MERKEL**  
Master gunsmith



**KARL PAUL MERKEL**  
Master stock maker

## HISTORY

# BETWEEN THE WARS

From a business point of view, the First World War was a huge setback for Merkel. Merkelesque aesthetic is not sought after on the battlefield. The company – renowned for luxury and perfectly balanced hunting rifles – lost many foreign markets. Nevertheless, shortly after the war, Merkel rifles were again being exported to 28 countries around the world, although the company did not fully recover from the consequences of the war until 1924. In 1931 Merkel registered a trademark: from now on the rights to the term “Bock” (over-and-under) for hunting and sporting rifles were reserved for Merkel.

The ingenious gun designer Gebhard Merkel died in 1933. He did not have the opportunity to witness one of the company’s greatest triumphs. In 1937 Merkel was awarded the “Grand Prix”

at the World Exhibition in Paris for its range of hunting rifles. The World Exhibition, which was held under the motto “Art and technology applied in modern life”, honoured the aesthetic of the Merkel product range.

In 1938 the second generation assumed office: Ernst Merkel together with the adept businessman Adolf Schade, son-in-law of Karl-Paul Merkel, took over the management of the company. The Grand Prix boosted the export business. The company’s order books include the names of crowned heads of state, diplomats, maharajahs and industrial magnates. Famous big game hunters and explorers also ordered their rifles from Merkel in Suhl. Even the world boxing champion Max Schmeling favoured hunting rifles made by Merkel



Advertisement with the “Grand Prix” from the 1937 World Exhibition.

## HISTORY

## WAR AND THE POSTWAR PERIOD

Before the start of Second World War the company ran its own sales offices in many countries around the world. Merkel's sales network spread from Argentina to Bessarabia to France, Greece, Norway, Rumania, Spain and the USA. This network was again broken up by the Second World War.

Hunting guns played a subordinate role in the war production from 1939. Merkel became a parts supplier for carburettor engines, carbines and rangefinders – and the number of employees rose to 350 in peak periods. Even in the anti-training atmosphere of wartime Germany, the Merkel company took the initiative to restructure the job specifications of the gunmaking trades, thereby ensuring the continuation of handcrafted gunmaking.

The war ended in Suhl on 3 April 1945 at 8.30 in the morning – of all the factories in the city, only Merkel was to escape dismantlement. The good reputation of the precious hunting guns spared Merkel this fate – the machine workshops, which were hi-tech for the time, were kept in Suhl.

By the end of 1945 hunting guns were being manufactured again; by 1947 almost 700 rifles had been sent to Eastern Europe as reparation payments. Merkel developed into a showcase company of the German Democratic Republic.

The dispossession of the founding families followed in 1948 – under disastrous conditions, the descendants of the Merkels lost everything to Socialism; everything the brothers has built up and the second generation had developed. In 1952 the state-owned company again had 200 employees manufacturing hunting guns. The company was integrated into a state combine, but the brand and the products remained independent.

In 1953 the GDR government presented Merkel hunting rifles to the two most powerful men on earth at that time, Dwight D. Eisenhower and Nikita S. Chruschtschow. And in 1963 the first man in space, the cosmonaut Juri Gagarin, was honoured with a Merkel Drilling.



Postwar production at Merkel.

## HISTORY

# THE GERMAN DEMOCRATIC REPUBLIC – AND REUNIFICATION

The socialist workers' and farmers' state cultivated its export hit. In the 1970s a range of luxury guns was developed and sold around the world. The gun card archives include the names of illustrious personalities such as Gamal Abdel Nasser, Josip Broz Tito and Mao Tse Tung. Even Franz Josef Strauß, the Bavarian Minister President and enthusiastic hunter, ordered his rifles from Suhl. Between 1945 and 1987, production of Merkel over-and-under guns alone reached 150,000. The GDR celebrated the success of Merkel rifles with a set of special postage stamps.

With hunting and sporting gun production flourishing after the war, Suhl became an important sports shooting centre. Around 100,000 visitors came to Thuringia for the world championships in 1986. For a few days the city with a long tradition of making firearms was the undisputed centre of world shooting sports. In his enthusiasm for the Merkel product range, the Mexican president of the International Shooting Sport Federation, Olegario Vázquez

Raña, proclaimed: "I think these are the most perfect hunting rifles in the world." He thought the Merkel over-and-under shotgun to be, "the queen of hunting rifles". And he should know – not only did Vázquez Raña hold the highest sports shooting office in the world, he was also world famous as a practicing trick shot artist. Between 1954 and 1989 sporting shooters using Merkel rifles won 45 titles at world and European championships.

In 1989 the German Democratic Republic came to end – the revolution came from below. It was unprecedented in its courageousness and its bloodlessness. With the slogan "We are the nation", the people of the GDR freed themselves from the ruling powers.

Reunification was accompanied by considerable turmoil – many jobs were lost in Suhl. Nevertheless, the Suhl combine remained the largest producer of hunting guns in Europe. This is where the coveted Merkel rifles were manufactured – however, they were still at the technical level of the 1950s.



Merkel BDF 303ET | BDF 203ES

## THE TECHNOLOGICAL BREAKTHROUGH

Uncertain ownership status accompanied Merkel to the end of the millennium – then the traditional brand found its feet again. Investors provided the backing which laid the foundations for new products and the continuation of the Suhl gunmaking tradition.

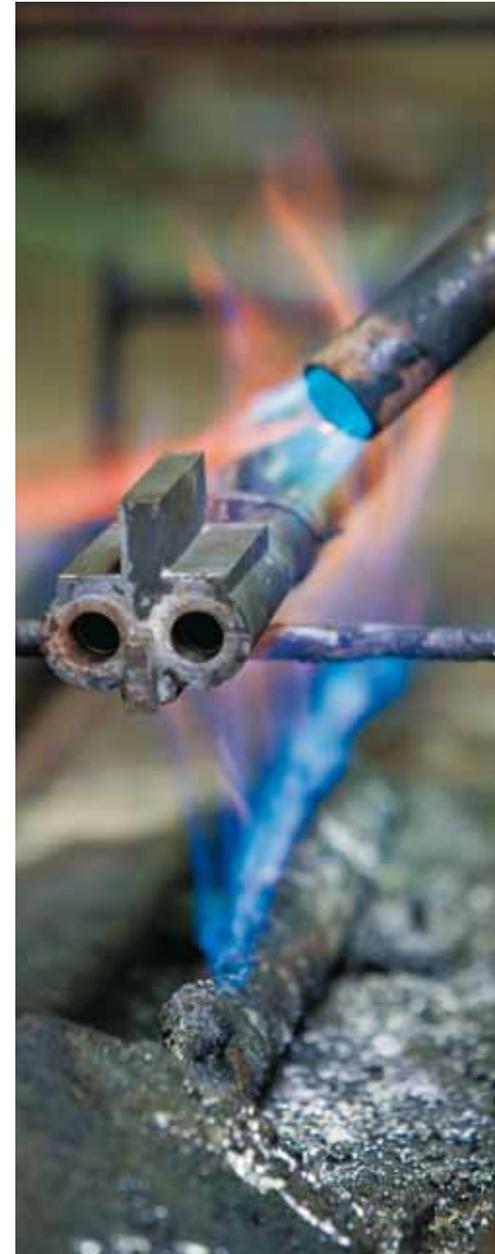
At the time of the change it became clear that there would be no future without maintaining the values of the past. Industrial precision cannot exist without handcraft skills. Merkel was always and remains today a major promoter of the different professions of the gunmaking art – because the company knows, needs and fosters its roots and skills. Merkel is very aware of the heritage of Suhl gunmaking.

The last great manufacturer of the old gunmaking town still sees itself as a manufactory in the image of the Merkel brothers. The Merckels were children of the Industrial Revolution – and understood how to adapt to these enormous leaps in technology. Despite the machinery, which was hi-tech at the time, they preserved the individual and hand-

crafted character of their rifles. As early as the mid 1990s, the complete range of Merkel hunting guns underwent careful reengineering. Where technical advancement increased the safety of the riflemen, it was used. Where state-of-the-art technology improved the precision and prolonged the service life of a rifle, it was applied.

The visual appearance of a Merkel 303 made in 1924 differs only in details from a modern 303 over-and-under shotgun. And in 1924, as in 2008, these wonderful hunting guns were at the cutting edge of gun technology.

From the outset the Merkel brand was characterised by the work of specially trained craftsmen; by employees who know how to make a gunlock with only simple tools and without machines. And this, although they know how to handle computer-controlled machines and the most up-to-date surface finishing systems. Technology by tradition.



■ Craftsmanship: hand soldered barrels.

## HISTORY

# MERKEL TODAY

Merkel's only production site is in Suhl – we view the location as a guarantee of quality that is recognised in many countries around the world. The Suhl manufactory is an exceptional combination of hunting gun manufacturing and high-tech forging. Merkel combines the traditional manufacturing methods of handcrafted hunting guns with the highest standards of quality and safety – all achieved in what is, for this day and age, an unusually deep in-house range of manufacture, from cold forged barrels to hand engraving. With every part of a Merkel gun, careful consideration is given to whether, from the customer's point of view, it should be handmade or machine produced.

Today Merkel exports to more than 40 countries all over the world and has close to 200 employees – each one a highly qualified specialist. They often come from families that have worked in the gunmaking trade for generations. They bring to us the manufacturing skills and expertise to find unusual solutions. Merkel employees define themselves and their work on the basis of

the long tradition of Suhl gunsmithing. Merkel is one of the very few factories that can manufacture both modern firearms and handcrafted hunting guns. No matter which category a customer chooses, a Merkel carries the Suhl genes: reverence to and the heritage of the German Damascus. And this has its own basic principles.

■ **MERKEL TOP-DOWN:** Merkel guns offer the customer the power reserves of the unique Merkel top-down principle. This means that the highest calibre of every gun class defines the breech of all the underlying versions. The breech of the Africa side-by-side rifle thus sets the standard for all the other side-by-side guns.

■ **STEEL ON STEEL:** With Merkel locking mechanisms, the principle applies that steel is always locked on steel.

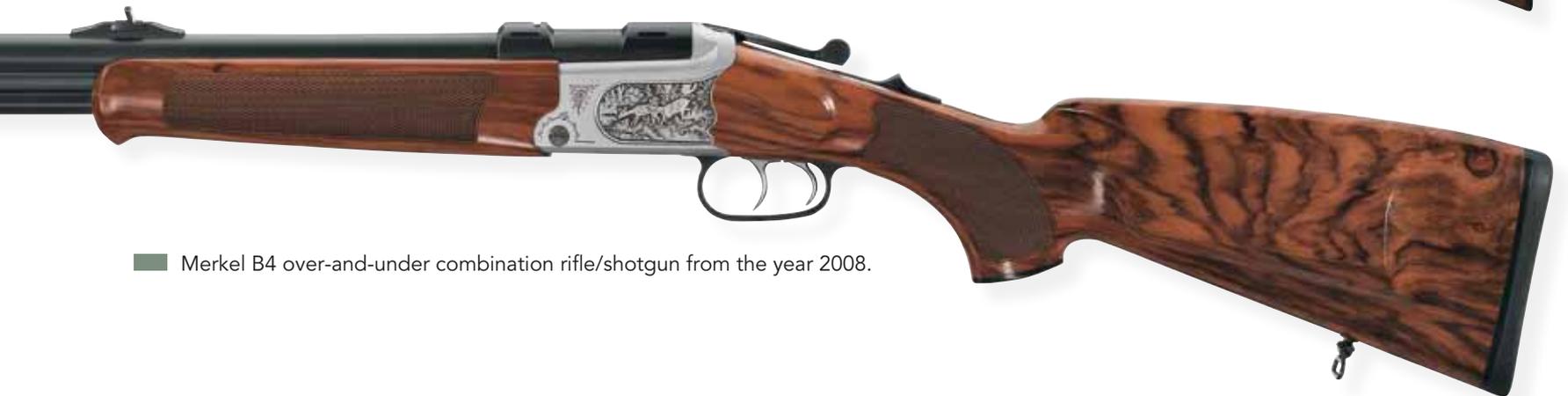
■ **HANDED-DOWN QUALITY:** We have mastered the traditional manufacturing methods, which even today produce unequalled quality – we hand

them down and develop them further. For example, we continue to practice the time-consuming process of brush oxidation because it provides extra quality for our customers.





■ Merkel 'Taube' over-and-under combination rifle/shotgun from the year 1927.



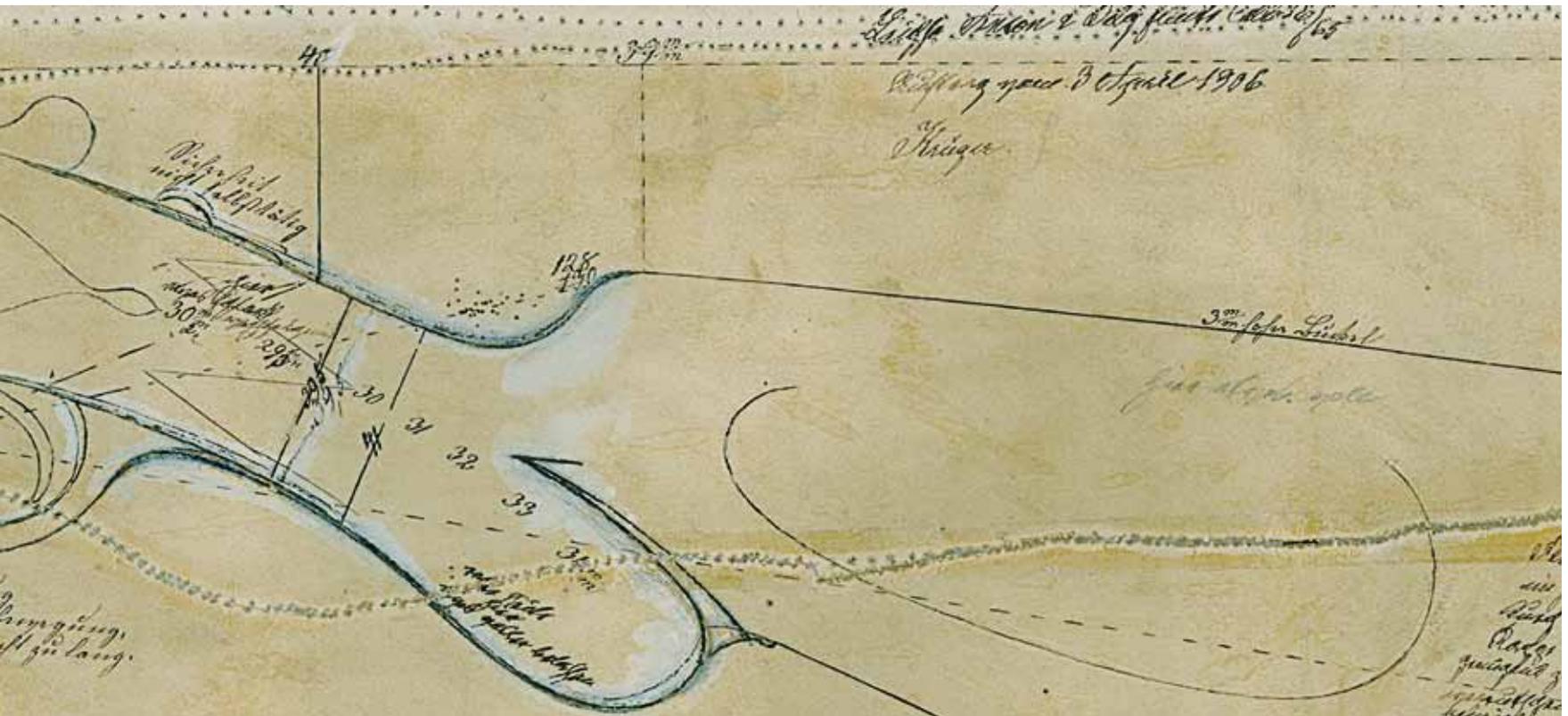
■ Merkel B4 over-and-under combination rifle/shotgun from the year 2008.

MANUFACTORY









same care as Meisterstücke – very often on the same machines and by the same people.

The manufactory is a living organism and the finished goods are products of the experience, the skill and (even if it

sounds overstated) the pride of those that manufacture them. This applies just as much to a modern Merkel rifle of the MEM category as to a traditionally manufactured Meisterstück.

■ An old Merkel design drawing of a side-by-side shotgun on goatskin parchment. The material is pieced together and sewn – it depicts a rifle on a scale of 1:1.

## MANUFACTORY

# MORE THAN JUST PURE HANDWORK

Merkel was always a promoter of the gunmaking handcraft – that is still the case today. And of course we hold in high regard purely handmade hunting guns, made from solid metal, that do not use any industrially produced parts. But we also know the technological limits of these guns.

Merkel manufacturing goes one step beyond the boundaries of handwork. Every Merkel MEM and every Merkel Meisterstück is the result of a process that compliments the traditional handcrafts with the most up-to-date tools, if this benefits the product and the customer. Innovation is not an empty cliché for us; it has been the mainspring of our success since the very beginning.

Electrical discharge machining and the CNC production of workpieces are part of this modern process, that helps produce time-honoured Merkel hunting rifles or modern MEM rifles of the highest quality. Electroerosive wire-cutting works with minimum tolerances in a range of 0.005 to 0.01 millimetres. Die sinking produces sharp edges with al-

most the same precision – for example, the guides of the bottom bites of break open guns are made this way.

Computer-controlled 5-axis milling centres work with tolerances from  $\pm 0.01$  millimetres – these are the values required for the manufacture of mechanical wristwatches. We use them for processing steel or duralumin parts as well as for wood. Thanks to CNC milling we produce stocks with perfectly flush joints to the steel parts of the barrel and receiver.

That such precision parts are subsequently fitted by hand or finished with a traditional coating is no contradiction for us. It all goes to improve the quality of the finished product. Our employees have all learned the classical gunsmith's craft – and refined it with knowledge of high-tech production processes. This is exactly where Merkel offers more.



Shotgun barrels in the production line.



Unique, handmade: white 303 action.

## MANUFACTORY

## FROM ONE-OF-A-KIND TO SERIES PRODUCTION

The wide range of in-house production is typical of Merkel manufacturing. All key processes are carried out in our manufactory. Merkel makes all the essential components of a gun itself: barrels, stocks, lock components, locking mechanism parts and barrel sets. Assembly, ballistic testing and final inspection – we only rely on ourselves to carry out these processes.

There are product groups where Merkel makes no more than a single hunting gun per year. There are others where several thousand units are produced. This flexibility in production quantities is characteristic of Merkel manufacturing. At the request of a customer we can offer highly individualised hunting guns – right down to the single item. At the same time we produce Meisterstücks in series, where this series production seemed infeasible before the turn of the millennium.

There is hardly another hunting gun manufacturer in the world that covers such an extensive product range. This

stretches from traditional hunting rifles – our Meisterstücks – right through to semiautomatic rifles of the MEM category. Or from the massive Africa side-by-side rifle to the modern bolt action rifle.

One example: in our manufactory we combine the classical handcraft of the colour case hardening of a side-by-side shotgun receiver with scientific methods of material and surface research. With three-dimensional computer simulations or controlled shooting with the aid of high-speed cameras, we draw nearer to the ideal rifle. According to the Merkel definition, the ultimate aim of the ideal rifle combines functional aesthetic, high precision, the highest quality and a service life that will last for generations.

Even if they are distinguished by a perfect finish and enjoy great popularity among collectors, our rifles are all made for contemporary hunting. And even if we work with cutting-edge technology, every Merkel rifle remains an individual one-of-a-kind.



## MANUFACTORY

# FROM THE IDEA TO THE PRODUCT

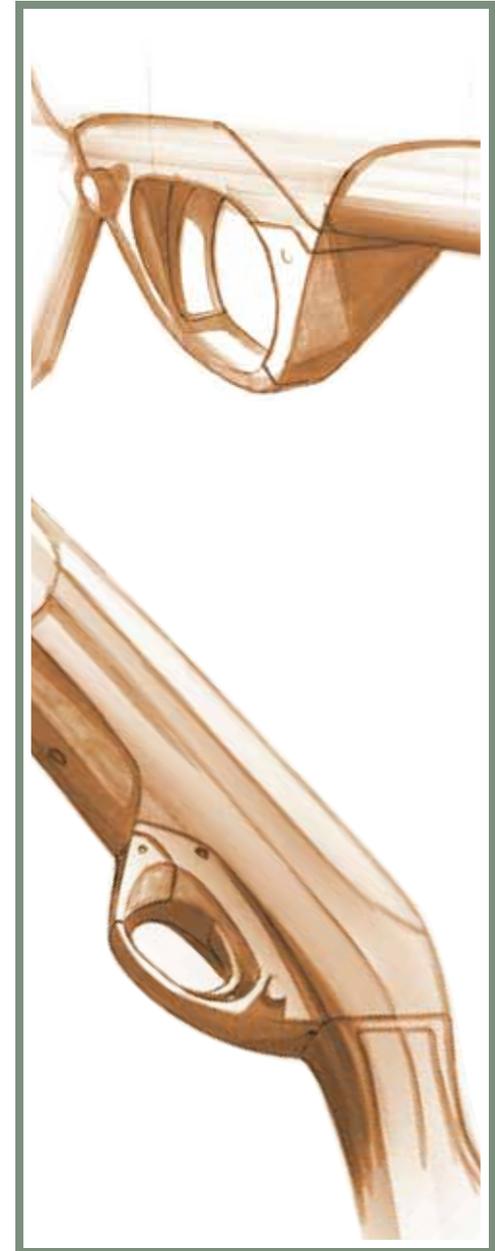
Merkel employees discuss the requirements profile of a new hunting gun in informal working groups which include gunsmiths, engineers and hunters. The first question is always, what should it be able to do? The decisive impulse often comes from the market. A company that exports to over 40 countries in the world knows that there is no such thing as "the hunt".

Different hunting cultures, gun legislation and hunting laws, changes in hunting conditions and game population as well as hunting fashion influence which gun sells in which market – and which does not. In discussion groups with importers, dealers and hunters, Merkel is continually discussing what the market needs – and how Merkel can cover and serve this demand.

Merkel manufacturing is also subject to certain basic principles: to apply the best possible technology for the respective purpose and product, to lock steel against steel, to guarantee the Merkel top-down principle and to always find the optimal combination of handcraft and machine production.

Once the requirements profile is defined, the work begins with a specifications sheet and the development assignment. The aesthetic must keep pace with the functionality. That is why the Merkel development team is backed up by a team of designers from the outset. This enables the technology and form to grow together – in the same way that traditional hunting guns come into being.

The development process is an interplay of structured, unstructured and creative components – one could also simply call it creativity. This can take several years. But the time is well invested: at the end of the day a hunting gun should emerge that lasts a lifetime and is still functional even after 50 or 100 years. That's how we see sustainability: a rifle that our grandchildren will be able to enjoy.



Design studies of a Merkel SR1.

## MANUFACTORY

## QUALITY – AT MINUS 20 DEGREES

Quality is a word that's often used. It becomes much clearer if you imagine the hunt at minus 20 degrees. A prime wild boar, 60 meters shooting distance, the best light for shooting and a ghostly silence over the hunting ground. Now it's all down to you; and so that even in this bleak hunting ground you can depend on your Merkel, we have been thinking far ahead.

The Merkel quality management system MQM goes far beyond the requirements of ISO 9001. MQM is a process oriented, holistic quality management system for all Meisterstück and MEM rifles. Quality is primarily a question of perfect planning and organisation.

At Merkel the developers think far into the future. They define load limits and extreme situations – and their effect on every single component of the gun. The production process and the materials are derived from this index of maximum demands.

These findings form the basis of MQM. This includes process accompanying

testing of individual parts on the site of their production, permanent error detection and the quickest possible corrective action.

We are one of the few manufacturers of hunting guns that make all the important components ourselves – including the barrels. We only purchase supply parts from companies who have committed to our quality code. We verify their products in the incoming goods department on the basis of internationally valid statistical procedures.

During and after assembly we test every single manufactured gun for function, precision, handling, operability, appearance and finish; these tests go far beyond the requirements of the legal regulations. Merkel has a field office of the State Proof House in the factory – proof of the confidence and status of our manufactory. No hunting gun leaves the manufactory without the state seal. All this for that single moment, because we know: quality is quality at minus 20 degrees.

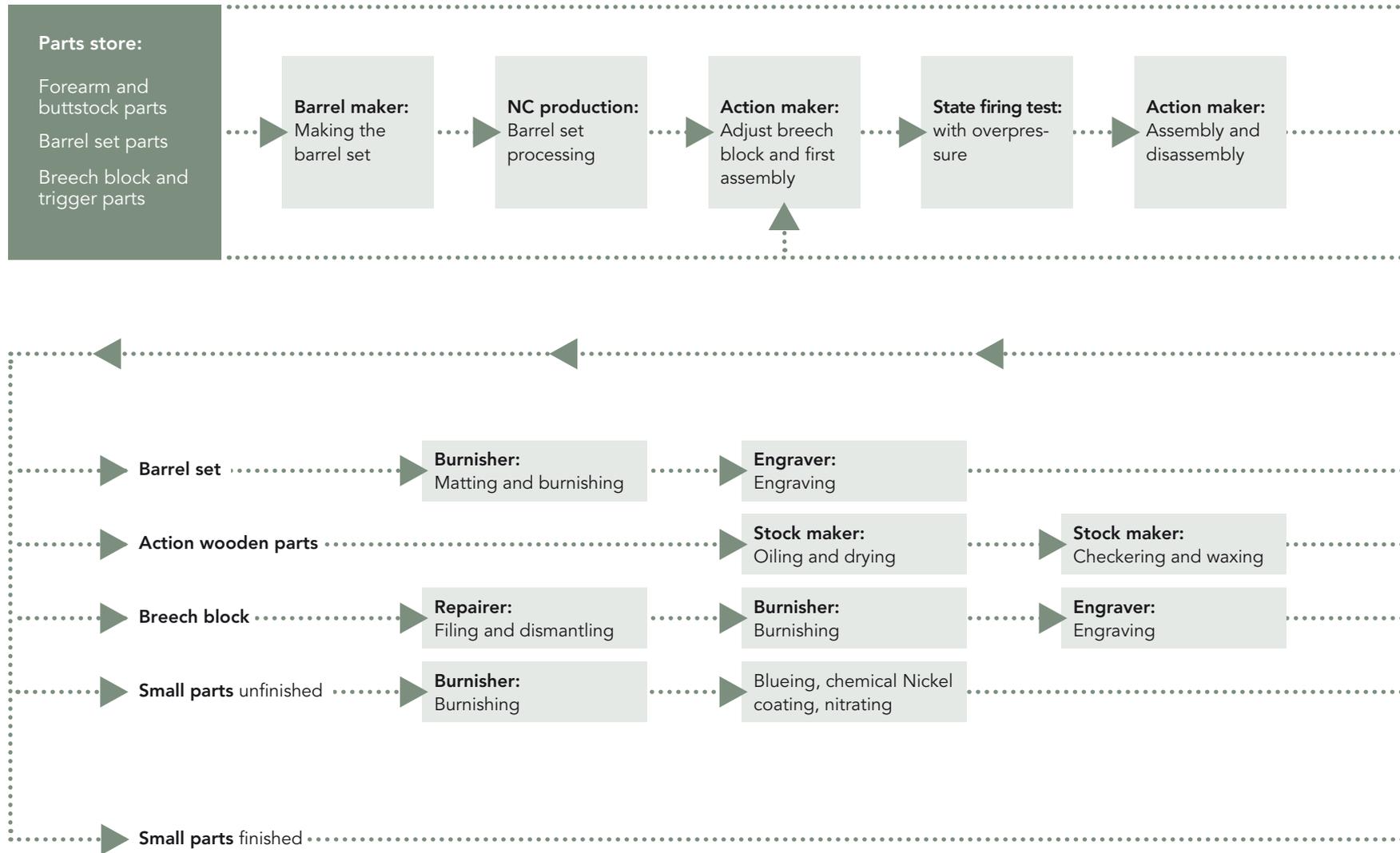


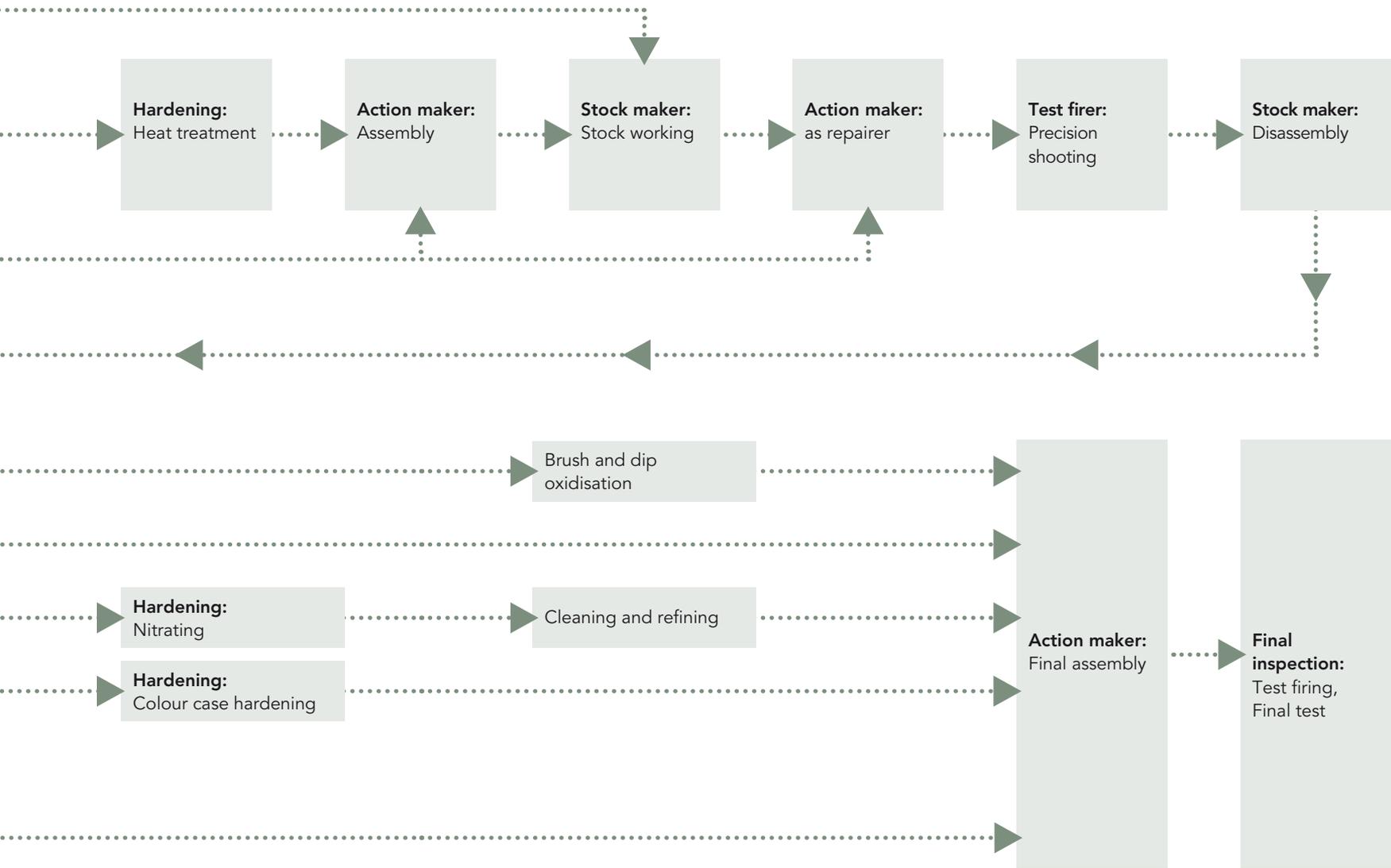
Quality with certificate.



SR1 continuous firing test with certificate.

# THE PROCESS – MAKING A MEISTERSTÜCK





## MANUFACTORY

# HIGH-GRADE PARTS

The finest recipes require the best ingredients. We make no differentiation when it comes to manufacturing parts. The components of our hunting rifles are all made to the same quality criteria and often from the same materials – no matter whether they are for MEM or Meisterstück rifles. The intended use and demands placed on the guns determine which material is used and how it is processed.

A hunting gun consists of 130 component parts – and we manufacture every important part in our Suhl manufactory. The whole is more than the sum of its parts – but we know that the whole comes down to every part. It is often a matter of a hundredth of a millimetre.

When a shot is fired, a bite plate on the receiver absorbs the thrust load – and must close perfectly and run smoothly. Or it is a question of materials that have special properties: V-springs of spring steel, which accelerate the hammer with unequalled vehemence.

The basic manufacturing of every part follows its own laws and requires specific expertise. There is one essential difference in the dimensional tolerances of the parts of Merkel's two manufactured gun categories: Meisterstück parts are made to a required oversize, to allow more play when they are fitted and aligned to each other. MEM parts are made to exactly defined manufacturing tolerances.



Ejector hammers for side-by-side guns.



Forging blanks for SR1 housing.

## MANUFACTORY

## THE MODERN WIRE CUTTER

The stage where the mechanical processing of difficult to machine materials reaches its limits is the stage where electrical discharge machining (EDM) comes into play. We use this technology to make traditional rifle parts such as cocking rods, set triggers and auxiliary levers for our Meisterstücks.

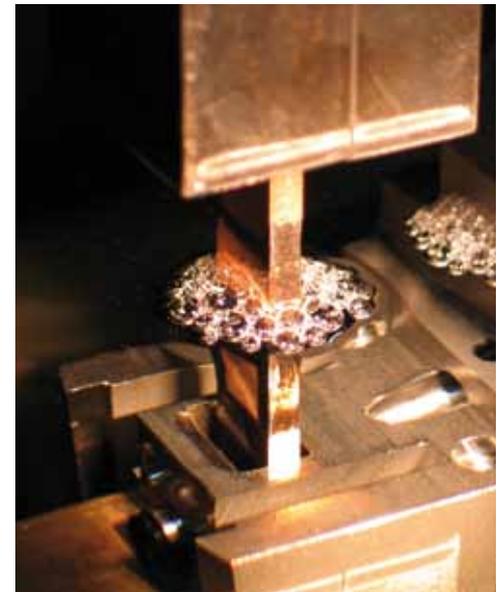
Many MEM parts are also produced in this way. A major advantage of the electro-erosive processing is the very high level of dimensional accuracy; even extremely hard materials such as hardened steel, titanium or hard metal can be processed. It is also possible to produce edge-free edges and sharp-edged geometric shapes. The erosive processes used by Merkel are

computer controlled die-sink EDM and wire-cut EDM. With wire-cut EDM a very fine brass live wire cuts parts from the workpiece in a non-conductive fluid (dielectric). Temperatures from 1,000 to 5,000 °C are reached in a discharge channel, which lead to melting and evaporation of the material particles. The achievable manufacturing tolerances are in the micrometer range.

With die-sink EDM, sparks are generated via a conducting tool (electrode) onto the workpiece to be processed. These sparks remove tiny particles of material. The electrode is programmed with the negative form of the workpiece surface to be created.



Computer controlled wire-cut EDM.



Electroerosive wire cutter.



## MANUFACTORY

# CNC PROCESSING

The term CNC “computer numerical control” – describes a world in which lathes and milling machines are controlled by computer programs. The high level of investment in production with multi-axis machining centres and in highly qualified staff is rewarded with the highest quality.

In the Merkel manufactory, this occasionally leads to apparently bizarre combinations of this technology and the gunmaking handcraft. Once the barrel maker has constructed and justified his barrel set with tongs and torch, solder and wire, this handmade semi-finished part is clamped onto the high-tech CNC machines. For example, the computer controlled milling centre processes the hooks of the barrel set of break open gun, which later bind the barrels and the action into one part. Thus a single unit comes into being that can withstand the enormous pressure of a gunpowder explosion – with an unparalleled combination of handcraft intuition and computer precision.



Handwork meets high-tech: the forged barrel is clamped in the CNC milling machine.

## MANUFACTORY

## THE ART OF THE BARREL MAKER

When the Merkel brothers founded their company in 1898, the ingenious gunsmith Gebhard Merkel brought an idea into the partnership. It concerned an innovative technology for soldering gun barrel sets – which was later patented.

According to this process, neither exclusively hard solder nor exclusively soft solder should be used, but a combination of both. However, and this is the art of the barrel maker, the required temperatures must not be allowed to damage the structure of the material. Hard solder joints guarantee the highest stability, where locking forces have to be absorbed. And soft solder improves the heat dissipation through its high level of flexibility. Our barrel makers say: the barrel can breathe – so it has room to expand. This terminology also indicates the understanding that our staff members have of their prod-

uct. They breath life into the barrel set with skilled hands and centuries of Suhl experience.

Tension-free and elegant, stable but aesthetically slim and light – these contrary objectives can only be achieved with barrel sets soldered in this way. The secret of Merkel precision is the experience of the employees in assembling the barrels. Despite high manufacturing precision, the components require caliber-specific fine tuning by hand, to ensure the hunting rifle hits the target precisely. The intersection of the barrels, that point where the barrel axes of multi-barrel hunting rifles meet, is individually determined according to the respective caliber combinations.



Soft soldering the sight rail.

## MANUFACTORY

# BARREL MAKING

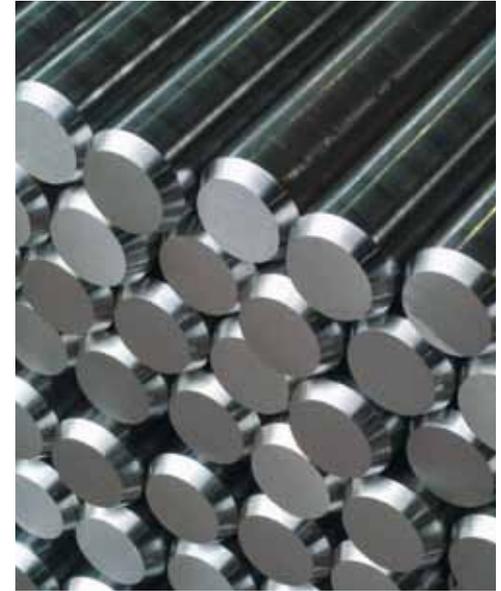
Merkel is one of the very few hunting gun manufacturers in the world that makes its own gun barrels. What is more: many renowned hunting gun manufacturers in Europe place their trust in Merkel and buy their shotgun and rifle barrels from the Suhl manufactory.

The hammer mills are the heart of the Merkel manufactory. Two elaborate cold forging machines process steel for the barrels of MEM and Meisterstück guns. The barrel blanks are made of hardened and tempered, high-strength chrome-vanadium or chrome-molybdenum steel. This process produces barrels with calibre diameter tolerances of under 15 thousandth of a millimetre. The barrel blanks are hammered into shape by the four hammerheads of the cold forging machine with the force of four times 1.25 million Newton – equivalent to four times 125 tonnes. A plug gauge is inserted into the barrel blank, which bears the negative profile of the fields and grooves – and transfers these to the inside of the barrel during the forging process. The result is cold forged

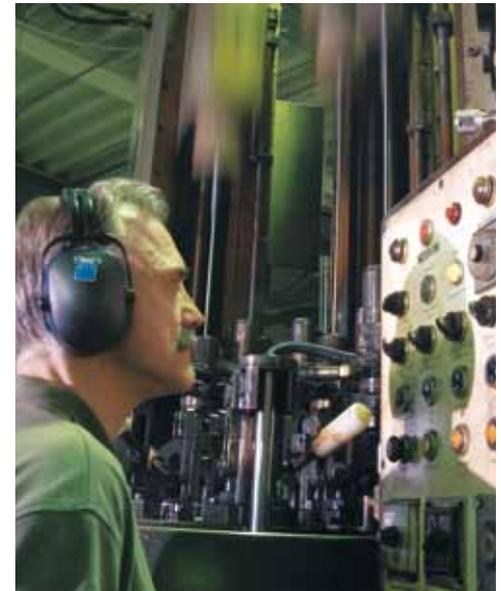
barrel as opposed to a conventionally made barrel.

Characteristic of Merkel barrels is the tapered form: the barrel narrows from the receiver to the muzzle by approximately ten thousandth of a millimetre. This prevents premature wearing of the barrel and enhances the precision of the shot. Merkel cold forging is based on four key technologies: deep-hole drilling, grinding, honing and annealing. Once the hole has been bored the grinding and honing follow, which produces extremely smooth inner surfaces in readiness for forging. These technologies, which are used in engine construction to finish the sliding surfaces of the cylinder, smooth the Merkel barrels to two thousandth millimetre exactitude, significantly increasing the service life and the precision of the barrel.

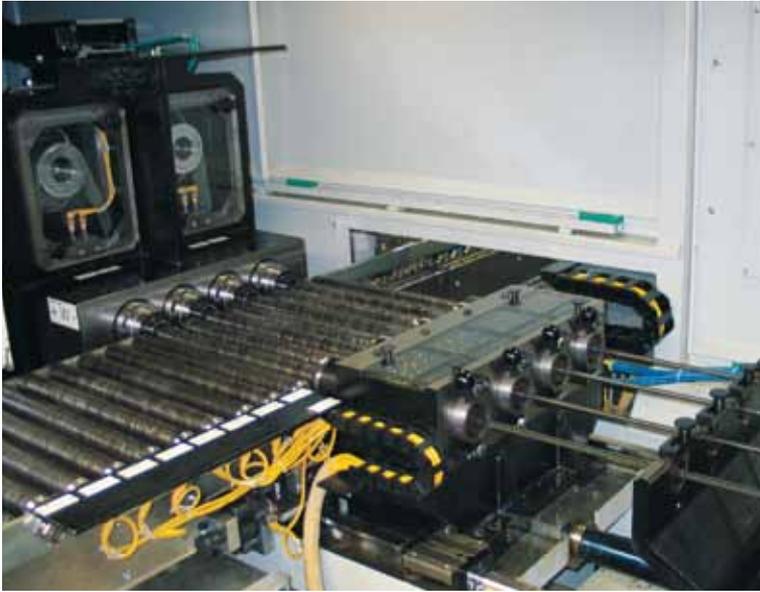
Forging is followed by stress-free annealing in a vacuum furnace. Inevitable stresses build up in the steel during forging, which are dissipated by this heat treatment over a period of several hours.



High quality barrel steel.



Everything running smoothly: honing.



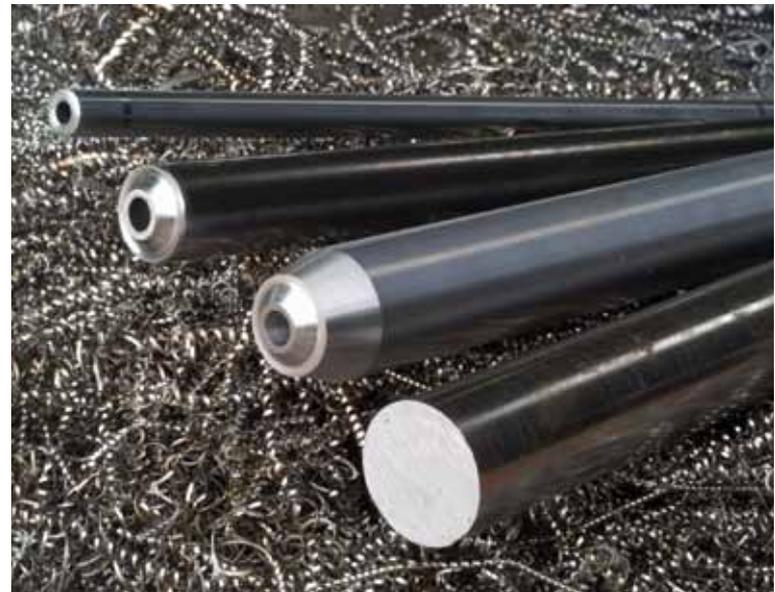
■ Deep-hole drilling: making a barrel from a steel rod.



■ Cold forging with an elemental force hammer mill.



■ Annealing dissipates the stresses in the steel.



■ Different stages in the barrel process.

MANUFACTORY

## ZERO T ASSEMBLY

Traditionally manufactured hunting guns – Merkel Meisterstücks – are assembled twice. The first time, the “white fitter” assembles the steel parts. These are white parts, i.e. tempered parts with untreated surfaces. These individual parts have been made to a certain tolerance in the prefabrication stage – now the white fitter makes fine adjustments by hand and aligns the tolerances to each other. Merkel Meisterstücks are assembled without tolerances: this is what “Zero T” stands for. A fully functional hunting rifle is assembled; only to be dismantled again, surface treated and further processed.



The perfect fit: a Drilling action assembled without tolerances.

## MANUFACTORY

## THE BRILLIANCE OF WOOD

The stock is an essential functional element of a rifle – but the optical and haptic qualities must also be right. To achieve this Merkel uses the best walnut woods of each category.

It is not only the task of the stock to provide the rifleman with a supporting structure for shoulder, cheek and hands. The butt stock also absorbs the repulsion power of the shot. The dimensions and the design of the stock affect the precision, appearance and the aesthetics of the rifle – as well as its ergonomics.

It is a question of bringing the cast, drop, length of the stock wrist and the stock into equilibrium. This requires great skill on the part of the stock maker. The functional dimensions are transferred to the unprocessed stock by means of the state-of-the-art machines

before experienced craftsmen get to work on the stock. Iron and wood are perfectly aligned by hand. This can sometimes take several hours.

Then comes the stock finish: the surfaces of the stock woods are perfected. The stock is watered and ground and the process repeated until open pores are no longer visible. The stock can then be finished in either silk-matt, gloss or pore-filled. This is followed by oiling, which accentuates the finest nuances of the grain.

Finally, the checkering is cut by hand or with a laser beam; this enhances both the grip and the elegance of the stock.



Checkering – cut by hand.

## MANUFACTORY

# THE ART OF THE ENGRAVER

The engraver's work on the hunting gun is where art and handcraft overlap. Merkel engravers have fashioned hundreds of classical patterns and found thousands of individual solutions since the company was founded.

The Suhl nickname "German Damascus" is both a claim and an obligation of Merkel engravers. The artistry of its engravers is one of the great strengths of the Merkel manufactory. The animal or the nature motif on the hunting gun is a piece of hunting culture – it relates directly to the archaic cave drawings of the original hunters. It is both decoration and an invocation of hunting fortune. It also gives expression to the magic of the hunt.

Merkel employs more than 15 engravers – each and every one a specialist

in his trade. Engravers pass through a classical apprenticeship and then many years of vocational adjustment, until they are ready for all-round deployment in the manufactory. Nevertheless, every engraver is a specialist in his motifs – there are masters of arabesque patterns with stylised tendrils and masters of animal motifs. They work on a rotating vice. With graver, chisel and hammer they decorate the metal parts of the Merkel rifles with delicate filigree work.

The artistry of the decoration is achieved by a combination of colour case hardening, engraving, stock cutting and inlay work, right through to the hand engraved signature.



Receiver engraving with fantasy foliage.

## MANUFACTORY

## COLOUR CASE HARDENING

created on steel surfaces with the aid of leather carbon. The purely empirical experience of Suhl colour case hardening has been handed down from generation to generation. Even today, the chemical and physical processes of colour case hardening have not been completely researched. The wide range of influencing factors make every result unique.

With colour case hardening, a steel surface is hardened by enrichment with carbon. The play of colours ranges from blue to brown and yellow to different shads of red. The steel surface is heat treated: leather carbon releases tannic acid, which produces the individual colours.

Merkel leather carbon for colour case hardening is produced according to an old formula – a modern paint coating of the resultant fine surfaces offers additional corrosion protection and assures the finished surface lasts. This tradition is permanent.



Colour case hardening with the gunsmith – certified Suhl production.

## MANUFACTORY

# MASTER OF SURFACES

It is the surfaces that make for the fascination of a Merkel hunting gun. Traditionally, a range of professions are engaged in producing immaculate finishes in the Suhl manufactory.

The skilled burnishers with their acute sense for hard steel ensure the perfect surface. Burnishing is hard graft – but what counts is the result. There is no alternative to the quality of the handwork – particularly with Meisterstücks. After burnishing, the metal surface is sensitive and short-lived.

Now it's the turn of the masters of blueing: separate parts are heat blued. But the high art is the brush oxidisation. This may be somewhat old fashioned and time-consuming, but it's worth it to us to achieve the results of the gun-metal gloss on the steel parts of our Meisterstücks. Conventional heat blueing of the barrel would place a strain on the soft solder joints on the Meisterstück barrel set and possibly give rise to symptoms of corrosion.

Brush oxidisation: these are the pots, crucibles, standard containers filled with different fluids, which – if applied correctly – impart a fine surface to the hunting guns.

Our masters of blueing keep their cards close to their chests. For the outsider it is also hard to comprehend this sequence of over 30 work steps that takes almost a whole working week. The brushwork is done at a defined moisture level. And the steels are given time to achieve a specified level of oxidisation. This is where the expert hand ensures a perfect finish. The masters of blueing invest more than eight hours handwork in every Merkel Meisterstück.

But the time is well invested in a hunting gun made for generations and protected by a permanent black-oxide finish.



Hot baths, secret formulas.

## MANUFACTORY

## MAN WITH FINE FEELING

The name “black fitter” is somewhat misleading. He is the gunsmith for precision work. He fits together components that have undergone diverse finishing processes and acquired perfect surfaces. In the process he smooths out any possible distortions of the material which occurred during hardening.

In the meantime the barrel set has been matt coated, burnished, then engraved and blued. The receiver and many small parts have been burnished and engraved, nitrified or colour case hardened. Now all the parts are fitted together. The black fitter is at the end of a process which is based on quality, perfection and durable products. He proudly holds what the manufactory has produced.



The black fitter tensions the V-spring of the sidelock.

## MANUFACTORY

# PRECISE SHOT

The finishing touch to make a Merkel hunting gun a precision instrument, is the test firing at the manufactory shooting range. Our specialists test the gun using an open sight at 50 metres or with a with a scope at 75 or 100 metres. Here the reference ammunition of well-known manufacturers is used, the point of impact corrected and the shot precision defined.

When test-firing with the scope, the height and side adjusters are exactly positioned. The result is precise shot grouping. These are electronically documented and archived – a form of birth certificate and a certification of precision for every Merkel gun. The test firing is a celebratory moment – now the Merkel rifles and shotguns are ready for use in the hunting ground or on the shooting range.



Precise test firing at 100 metres distance.

## MANUFACTORY

## THE FINAL INSPECTION

At the final inspection the new hunting gun is examined from various points of view: Two hearts are beating in the breast of the inspector. The eyes of the gunmaker see the components and functionality of the rifle. He opens the breech, checks the action, function and fit of all the parts of the gun. Nothing escapes this stringent examination. Then the new gun is observed "through the customer's eyes". Nothing should spoil the customer's enjoyment of the new hunting rifle, or detract from the aesthetic of the gun. "Test the rifle as if you were going to buy it yourself," is the guiding principle that makes for satisfied hunters or sports shooters.



Opening the masterpiece: the inside of the receiver fulfils the promise of the outside.

# MEISTERSTÜCK

This is a hunting gun comprising more than one hundred components – but it is not an industrial product. It is manufactured according to old concepts with a great deal of handcraft – nevertheless, contemporary technology makes the Meisterstück a modern gun. It is made to last for generations – a Merkel Meisterstück.

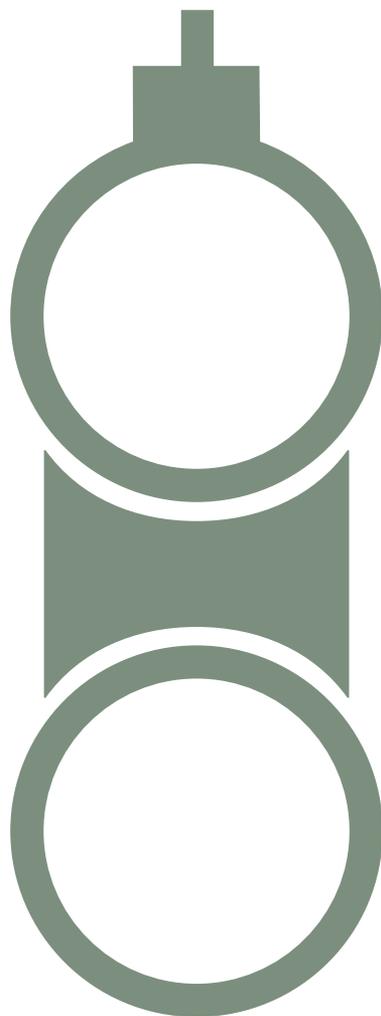




## OVER-AND-UNDER GUNS



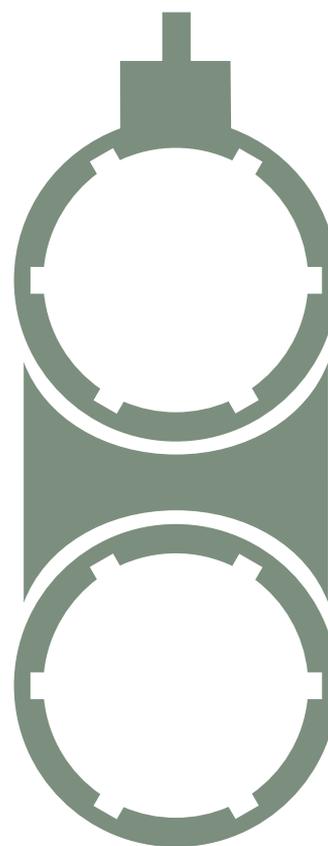
Many of the specifications from the formative years still apply today: Extract from a Merkel catalogue of the 1930s.



■ OVER-AND-UNDER  
SHOTGUN



■ OVER-AND-UNDER  
COMBINATION GUN



■ OVER-AND-UNDER  
EXPRESS RIFLE



■ BERGSTUTZEN

SIDELOCK OVER-AND-UNDER GUN 303 SERIES



OVER-AND-UNDER SHOTGUN 303E  
ENGLISH ARABESQUE | MEDIUM SCROLLS



SIDELOCK OVER-AND-UNDER GUN 303 SERIES

## CHARACTERISTICS



OVER-AND-UNDER  
SHOTGUN 303E  
*ENGLISH ARABESQUE*



V-spring sidelocks – detachable – with precious finishing.



Elaborate ejector locks – for the 303, a matter of course.



The articulated trigger prevents injury when shooting.



Three piece forearm for an elegant, slim appearance.



The Kersten cross bolt: classic over-and-under locking mechanism.



The tie on the pistol grip: precious detail on the stock of high-grade wood.

SIDELOCK OVER-AND-UNDER SHOTGUN 303E

## MADE TO LAST GENERATIONS



Since 1924 – and probably for as long as hunters exist: the 303 is the over-and-under classic among the Merkel Meisterstücks. In 1932 this rifle cost around 1550 Reichsmarks; more than the Opel P4, which cost 1400 Reichsmarks at that time. No question about it: the 303 was and is a luxury product. Its functional principles and its appearance still correspond to the original idea of the perfect over-and-under gun – but the materials used and the performance of this gun have been constantly adapted to the current state of technology. Is there a better form of sustainability than being made to last for generations?





OVER-AND-UNDER SHOTGUN 303E  
ENGLISH ARABESQUE | WOODCLASS 7

■ **OVER AND UNDER SHOTGUN 303E:** sidelocks with V-springs and concealed lever for tool-less detach from the receiver | Kersten cross bolt with double conventional bottom bite | double trigger with an excellent characteristic | front trigger articulated | optional selective single trigger | manual trigger safety with intercepting safety sear | hammer ejectors with V-springs | engraving English arabesque | highly figured luxury grade walnut, pistol grip or English styled stock | handcrafted stocks to individual specifications | three-piece forearm for a slim line | optional pairs

**CALIBER:** 12/76 and 20/76 **CHOKE:** 1/4-1/2 (steel-shot proofed), 1/4-3/4, 1/2-1/1 **BARREL-LENGTH:** 71 cm (cal. 12), 68 cm (cal. 20) **OVERALL LENGTH:** app. 114 cm (cal. 12), app. 111 cm (cal. 20) **WEIGHT:** app. 3,2 kg **WOODCLASS:** basic wood class 7

OVER-AND-UNDER COMBINATION GUN 313E | OVER-AND-UNDER RIFLE 323E

## OVER-AND-UNDER CLASSICS

Merkel sidelock over-and-under guns leave many options open. The 12 and 20 calibre receivers can accept combination gun or double rifle barrel assemblies. Interchangeable barrel assemblies can also be installed retroactively.

The exclusive features of 313E und 323E correspond to the over-and-under shotgun of this series. Both have a double trigger with articulated trigger. The stock has a pistol grip, a German cheek piece and hogback comb.



■ **OVER-AND-UNDER COMBINATION 313E:** RIFLE CALIBER: 6,5x57R, 7x57R, 7x65R, .308 Win., .30-06, .30R Blaser, 8x57IRS, 9,3x74R **SHOTGUN CALIBER:** 12/76 or 20/76 **BARREL LENGTH:** 60 cm **OVER ALL LENGTH:** 103 cm **WEIGHT:** app. 3,5 kg **ENGRAVING:** game scene engraving Jagd **WOOD CLASS:** basic wood class 7

■ **OVER-AND-UNDER EXPRESS 323E:** CALIBER: 7x57R, 7x65R, .308Win., .30-06, .30R Blaser, 8x57IRS, 9,3x74R, .375 H&H **BARREL LENGTH:** 60 cm **OVERALL LENGTH:** 103 cm **WEIGHT:** app. 3,7 kg **ENGRAVING:** game scene engraving "JAGD" **WOOD CLASS:** basic wood class 7

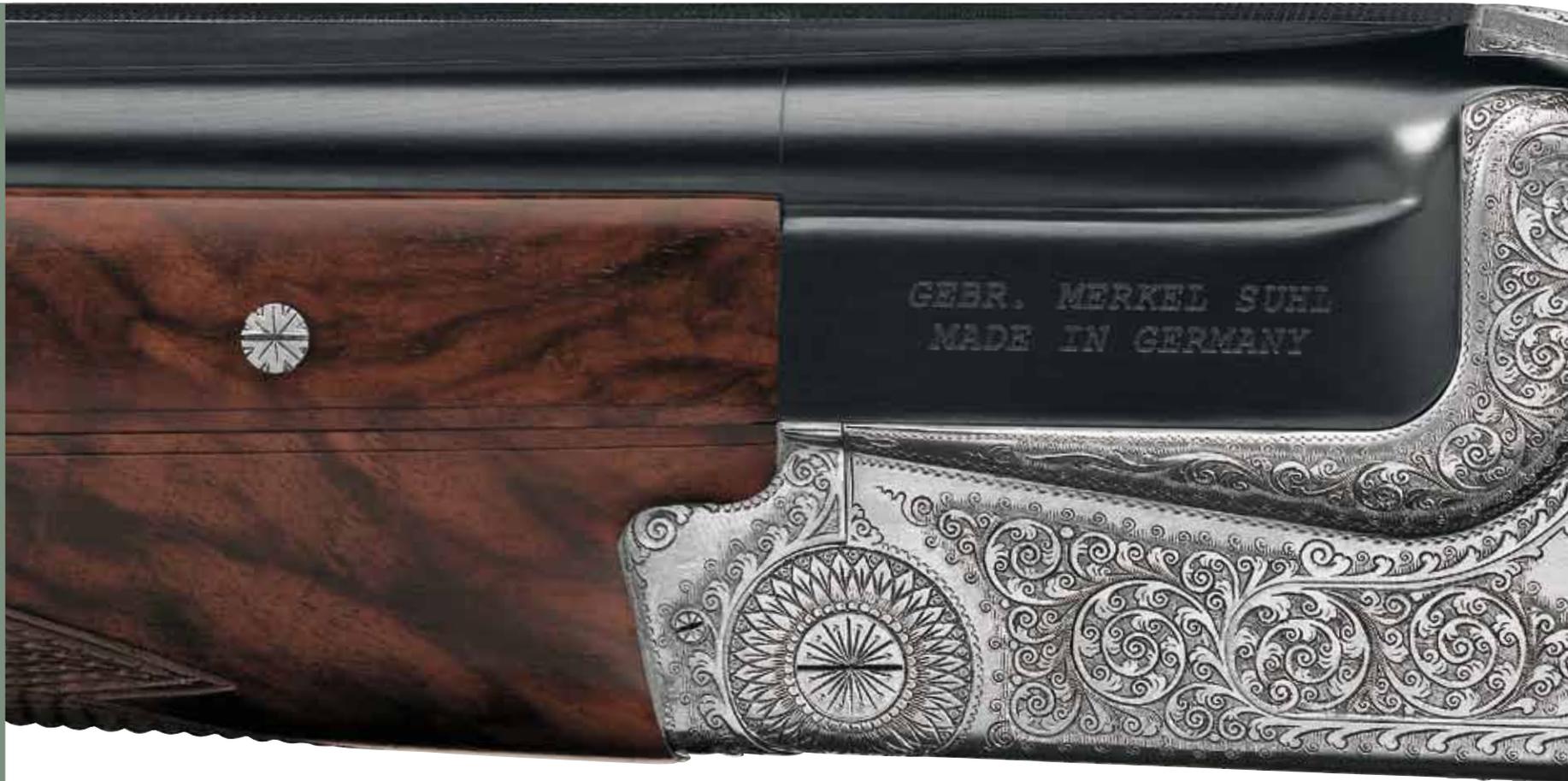


OVER-AND-UNDER COMBINATION GUN 313E  
JAGD DESIGN | WOODCLASS 8



OVER-AND-UNDER RIFLE 323E  
CUSTOM MODEL | WOODCLASS 8

OVER-AND-UNDER GUNS 2000 SERIES



OVER-AND-UNDER SHOTGUN 2003E  
JAGD DESIGN



OVER-AND-UNDER GUNS 2000 SERIES

## CHARACTERISTICS



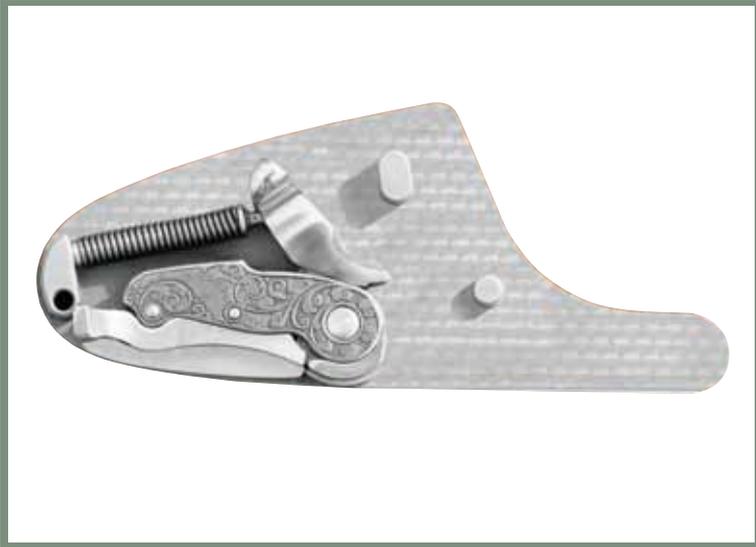
Typical of Merkel over-and-under guns: the solid Kersten cross bolt locks the steel receiver. Disconnectable ejectors, as standard.



Precision detail for all 2000 series guns: single selective trigger.



OVER-AND-UNDER  
SHOTGUN 2003C  
JAGD DESIGN



■ Pure precision engineering: detachable sidelock via lever of a 2003 over-and-under shotgun.



■ Slim and elegant forearm, assembled from three wooden parts: standard with 2002C, 2003C, 2012 and 2022.



■ The over-and-under shotguns with multi-chokes, as standard. The over-and-under rifles are equipped with muzzle adjustment.



■ All options: multi-chokes for the 2000 o/u shotguns.

OVER-AND-UNDER SHOTGUN 2000C

## GAME SHOTGUNS: COMPLETELY FITTED OUT



The over-and-under shotgun 2000 series has a long hunting tradition and has achieved a great deal of sporting success. Besides the dominant 12 calibre, Merkel also makes lightweight shotguns in the 2000 series. The 20 caliber is characterised by its light weight, excellent responsiveness and comfortable recoil. The "C" in the in type designation signifies the complete fitting out of the gun: C stands for "Complete". From a technical point of view, complete fitting out means: steel-shot capability and interchangeable chokes, selective single trigger, adjustable in the length. A convenient detail: the shotguns are equipped with disconnectable ejectors as standard. Optically, the 2000C gleams with rich arabesque engraving.





OVER AND UNDER SHOTGUN 2000C  
DESIGN ENGLISH ARABESQUE

■ **OVER AND UNDER SHOTGUN 2000C:** modified Anson & Deeley locks in steel receiver | Kersten cross bolt | selective single trigger, adjustable in the length | manual safety with intercepting safety sear | disconnectable ejectors | engraving English arabesque | stock with pistol grip and cheek piece (other stock available) | interchangeable chokes steel-shot proofed (2 chokes included)

**CALIBER:** 12/76 or 20/76 **CHOKE:** 1/4-1/2 (steel-shot proofed), 1/4-3/4, 1/2-1/1 **BARREL LENGTH:** 71 cm (cal. 12), 68 cm (cal. 20) **OVERALL LENGTH:** app. 112 cm (cal. 12), app. 109 cm (cal. 20) **WEIGHT:** app. 3,1 kg **WOOD CLASS:** basic wood class 2

OVER-AND-UNDER SHOTGUN 2001C

## GAME SCENE ENGRAVING AS STANDARD

The C version of the 2001 is characterised by high-grade wood and extensive game scene engraving with arabesque trimming on the steel receiver assembly. Even the forearm catch, trigger and locking lever are richly decorated with Merkel engraving.



■ **OVER AND UNDER SHOTGUN 2001C:** modified Anson-Deeley locks in steel receiver | Kersten cross bolt | selective single trigger, adjustable in the length | manual safety with intercepting safety sear | disconnectable ejectors | game scene engraving Jagd | stock with pistol grip and cheek piece (other stock available) | interchangeable chokes steel-shot proofed (2 chokes included)

**CALIBER:** 12/76 or 20/76 **CHOKE:** 1/4-1/2 (steel-shot proofed), 1/4-3/4, 1/2-1/1 **BARREL LENGTH:** 71 cm (cal. 12), 68 cm (cal. 20) **OVERALL LENGTH:** app. 112 cm (cal. 12), app. 109 cm (cal. 20)

**WEIGHT:** app. 3,1 kg **WOOD CLASS:** basic wood class 4



OVER-AND-UNDER SHOTGUN 2001C  
JAGD DESIGN



OVER-AND-UNDER SHOTGUN 2001C  
PRINCE OF WALES PISTOL GRIP | THREE-PIECE FORARM

OVER-AND-UNDER SHOTGUN 2002C

## SIDE PLATES – ROOM FOR DECORATION

The long side plates are a traditional feature of fine hunting guns. They offer room for decorative engraving and optically extend the receiver. Merkel has produced the 2002C for lovers of these guns. The prismatically inset side plates make an impression with their perfectly handcrafted workmanship. A stock of class 5 walnut, a "Jagd" (game scene) engraving and the three-piece forearm with engraved screws bring the 2002C to "complete" perfection.



**OVER AND UNDER SHOTGUN 2002C:** modified Anson & Deeley locks in steel receiver | Kersten cross bolt | selective single trigger, adjustable in the length | Manual safety with intercepting safety sear | disconnectable ejectors | game scene engraving Jagd | Stock with pistol grip and cheek piece (other stock available) | three-piece forearm | interchangeable chokes steel-shot proofed (2 chokes included)

**CALIBER:** 12/76 or 20/76 **CHOKE:** 1/4-1/2 (steel-shot proofed), 1/4-3/4, 1/2-1/1 **BARREL LENGTH:** 71 cm (cal. 12), 68 cm (cal. 20) **OVERALL LENGTH:** app. 112 cm (cal. 12), app. 109 cm (cal. 20) **WEIGHT:** app. 3,1 kg **WOOD CLASS:** basic wood class 5



OVER-AND-UNDER SHOTGUN 2002C  
JAGD DESIGN | WOODCLASS 8



OVER-AND-UNDER SHOTGUN 2002C  
CUSTOM MADE | COLOUR CASE HARDENED  
AND GOLD INLAY | WOODCLASS 8

OVER-AND-UNDER SHOTGUN 2003C

## WITH FINE SIDELOCKS



The 2003C version is the flagship of the 2000 series – it relates to a forerunner from the previous century, the 203, which was the link between the 200 and 303 series. Like its predecessor, the 2003C makes an impression with its special Merkel sidelocks. The precision engineered parts draw their energy from powerful compression springs, which combine optimised shot development time and excellent trigger pull, with extreme robustness for everyday use. A functional gun for the hunt – and also for the fireplace room, because the sidelocks are removable.





OVER-AND-UNDER SHOTGUN 2003C  
JAGD DESIGN | WOOD CLASS 8

■ **OVER AND UNDER SHOTGUN 2003C:** steel receiver | detachable Sidelocks with compression springs | Kersten cross bolt | double trigger with an excellent characteristic – typical for side locks | manual safety with intercepting safety sear | disconnectable ejectors | game scene engraving Jagd | highly figured luxury grade walnut, pistol grip and cheek | three-piece forearm for a slim line | interchangeable chokes (steel-shot proofed)

**CALIBER:** 12/76 **CHOKE:** 1/4-1/2 (steel-shot proofed), 1/4-3/4, 1/2-1/1 **BARREL LENGTH:** 71 cm (cal. 12) **OVERALL LENGTH:** app. 112 cm (cal.12)  
**WEIGHT:** app. 3,1 kg **WOOD CLASS:** basic wood class 6

OVER-AND-UNDER COMBINATION GUNS 2010D | 2011D | 2012D

## UNIVERSALIST IN THE HUNTING GROUND



OVER-AND-UNDER COMBINATION GUN 2011D  
JAGD DESIGN | WOOD CLASS 3

The over-and-under combination rifle/shotgun is a patented universal gun for well mixed hunting grounds. The 2010D has its roots way back in the beginning of the previous century. At the time it was considered to be a robust tool with no airs and graces – but with all sorts of technical finesses. A further one was the Duo manual cocking system – this is what the “D” signifies in the model designation. These combination guns are manual cocking guns before the first shot is fired: the gun can be decocked and safely carried until just before the shot. If the gun is immediately reloaded, the rifle becomes a classical self-cocking gun and rapid following shots are possible without recocking. If no shot is fired, the lock can simply be decocked again. The over-and-under combinations gun models varies in wood grade and long side plates.

■ **OVER-AND-UNDER COMBINATION GUN 2010D | 2011D | 2012D:** modified Anson & Deeley locks in steel receiver | Kersten cross bolt | selective single trigger, adjustable in the length | manual safety with intercepting safety sear | disconnectable ejectors | pistol grip, cheekpiece and hogsback comb | picture shows a prepared swing mount

**CALIBER:** 6,5x57R, 7x57R, 7x65R, .308 Win., .30-06, .30R Blaser, 8x57IRS, 9,3x74R **SHOTGUN CALIBER:** 12/76, 20/76 **BARREL LENGTH:** 60 cm **OVERALL LENGTH:** app. 101 cm **WEIGHT:** app. 3,4 kg **WOOD CLASS:** basic wood class 2

OVER-AND-UNDER DOUBLE RIFLE 2020D | 2021D | 2022D

## THE RAPID SECOND SHOT



OVER-AND-UNDER RIFLE 2022D  
CUSTOM MODEL | WOOD CLASS 5

The over-and-under double rifle 2000 series are fast-action and precise rifles – classical driven hunt specialists. Merkel has further refined the characteristics of the gun with a combination of various details. The single trigger allows a rapid second shot. The Merkel Duo manual cocking system combines high-level safety when carrying the decocked gun with the option of quick reloading and shooting without further cocking. The set trigger finally comes into operation when the precision shot is fired from the high seat. All this, with an elegance and responsiveness which has been the trademark of Merkel rifles for more than a century. The over-and-under rifle models varies in wood grade and long side plates.

**OVER AND UNDER RIFLE 2020D | 2021D | 2022D:** modified Anson & Deeley locks | rugged steel action | Kersten cross bolt | non selective single trigger, with set trigger | manual safety with intercepting safety sear | with ejectors | pistol grip, cheek-piece and hogsback comb | horizontal and vertical muzzle adjustment | picture shows a prepared claw mount

**CALIBER:** 7x57R, 7x65R, .30-06, .30R Blaser, 8x57IRS, 9,3x74R **BARREL LENGTH:** 60 cm **OVERAL LENGTH:** 101 cm **WEIGHT:** app. 3,5 kg

**WOOD CLASS:** basic wood class 2

## SIDE-BY-SIDE GUNS



**Doppelflinten in allen Kalibern**  
und verschiedenen Modellen laut unserem Doppelflinten-Prospekt

  
*Gebrüder Merkel*  
*Genewehre*

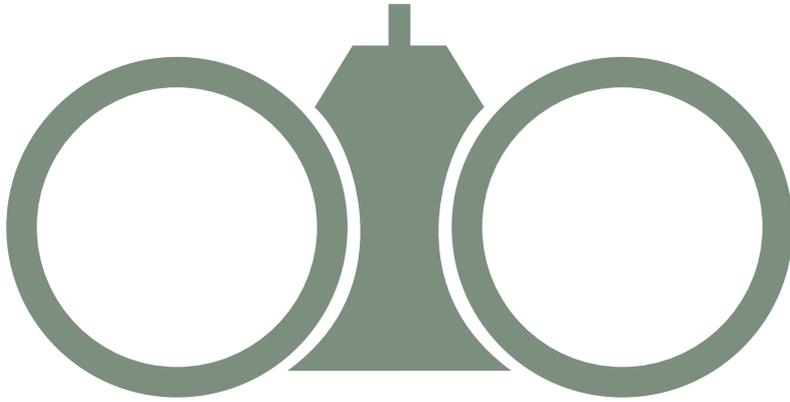
Unsere Gewehre tragen unsere  
volle Firmenbezeichnung und außerdem auf Lauf,  
Basküle, Vorderschaft nebenstehende Schutzmarke

  
ges. gesch.

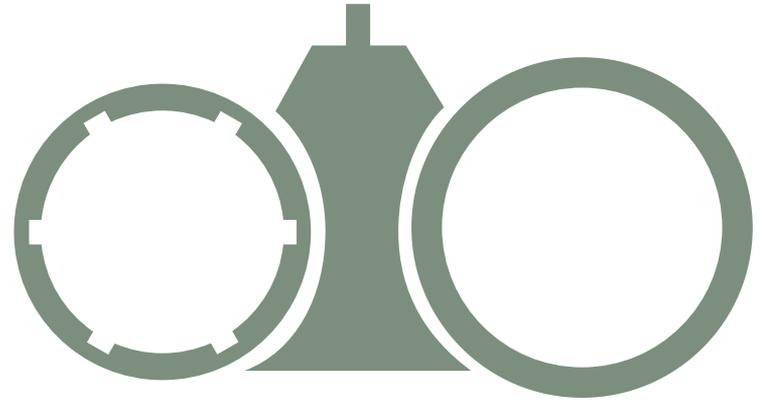
**Suhler Waffenwerk Gebrüder Merkel, Suhl**

Gegründet 1898

A passion for side-by-side guns – an early poster from the gun manufactory of the Merkel brothers.



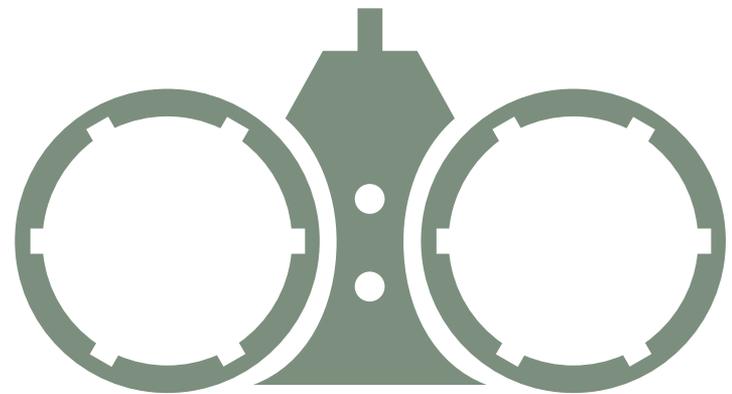
■ SIDE-BY-SIDE SHOTGUN



■ SIDE-BY-SIDE COMBINATION GUN



■ SIDE-BY-SIDE RIFLE



■ SIDE-BY-SIDE RIFLE WITH MUZZLE ADJUSTMENT

SIDE-BY-SIDE SHOTGUNS



SIDE-BY-SIDE SHOTGUN 60E  
CUSTOM MODEL | SILVER INLAYS | BARREL ENGRAVING



SIDE-BY-SIDE SHOTGUNS

## CHARACTERISTICS



Simply beautiful, simply good: Anson & Deeley locks.



Bird's eye view: unsurpassed slim-line aesthetic.



SIDE-BY-SIDE  
SHOTGUN 65E  
GAME SCENE  
JAGD DESIGN



For fine side-by-side guns: detachable V-spring sidelocks.



Greener style cross bolt with double bottom bite.



Double trigger as standard – with optional single trigger.



Handsome stock: fine checkered butt plate for the 45E and 65E.

## SIDE-BY-SIDE SHOTGUN 40E

# SWINGING ALONG

The 40E is the basis Meisterstück of the side-by-side shotgun range. Light and elegant, it sets the standard in terms of responsiveness. As with all Meisterstücks, custom-made stocks are optional with the 40E – but Merkel 40E standard stocks also have that made-to-measure feel. The shotguns are perfectly balanced when swinging and have a comfortable recoil. Equipped with totally reliable Anson & Deeley locks.



■ **SIDE-BY-SIDE SHOTGUN 40E:** Anson & Deeley locks | steel action | Greener-style cross bolt and double bottom bite | double trigger, optional single trigger | automatic safety | with ejectors | pistol grip and cheek piece

**CALIBER:** 12/76 , 20/76 **CHOKE:** 1/4 - 1/2 (steel-shot proofed), 1/4 - 3/4, 1/2 - 1/1 **BARREL LENGTH:** 71 cm (cal. 12), 68 cm (cal. 20) **OVERALL LENGTH:** app. 113 cm (cal. 12), 110 cm (cal. 20) **WEIGHT:** app. 2,8 kg **WOOD CLASS:** basic wood class 2



SIDE-BY-SIDE SHOTGUN 40E  
MODEL ARABESQUE | WOOD CLASS 3



SIDE-BY-SIDE SHOTGUN 40E  
CUSTOM MODEL | WOOD CLASS 5

## SIDELOCK SIDE-BY-SIDE SHOTGUN 60E

# A REAL COLLECTOR'S PIECE

This functional Meisterstück is the collector's piece among the shotguns. Special feature: sidelocks made in Suhl by Merkel combine precision engineering with the explosive power of the intricately made V-springs – gems of the gunmakers art. The pay-back with these steel-propelled masterpieces is minimum shot development times and the fascination of detachable, refined sidelocks. Wood and steel are masterfully combined to form the whole unit. The overall impression is enhanced by the hand rubbed oil finish, which adds an additional lustre to the stock.



**SIDE-BY-SIDE SHOTGUN 60E:** detachable sidelocks | steel action | Greener-style cross bolt and double bottom bite | excellent double trigger | automatic safety | with ejectors | pistol grip and cheek piece

**CALIBER:** 12/76, 20/76 **CHOKE:** 1/4 - 1/2 (steel-shot proofed), 1/4 - 3/4, 1/2 - 1/1 **BARREL LENGTH:** 71 cm (cal. 12), 68 cm (cal. 20) **OVERALL LENGTH:** app. 113 cm (cal. 12), app. 110 cm (cal. 20) **WEIGHT:** app. 3,1 kg (cal. 12), app. 2,8 kg (cal. 20) **WOOD CLASS:** basic wood class 5



SIDE-BY-SIDE SHOTGUN 60E  
GAME SCENE JAGD MODEL



SIDE-BY-SIDE SHOTGUN 60E  
CUSTOM MODEL | ENGLISH ARABESQUE | ENGLISH STOCK | WOOD CLASS 6

SIDE-BY-SIDE SHOTGUN 45E

## THE VERY BRITISH



The 45E side-by-side shotgun combines Suhl quality and precision with English style – in the stock as well as in the metal surfaces. English stock finished with fine hand-cut checkering at the butt plate and monogram plate in silver. The steel action is grey nitrated – as are the trigger guard, locking lever and safety slide.





**SIDE-BY-SIDE SHOTGUN 45E**  
GAME SCENE JAGD MODEL

■ **SIDE-BY-SIDE SHOTGUN 45E:** Anson & Deeley locks | steel action | Greener-style cross bolt and double bottom bite | double trigger | automatic safety | with ejectors | English stock

**CALIBER:** 12/76, 20/76 **CHOKE:** 1/4 - 1/2 (steel-shot proofed), 1/4 - 3/4, 1/2 - 1/1 **BARREL LENGTH:** 71 cm (cal. 12), 68 cm (cal. 20) **OVERALL LENGTH:** app. 113 cm (cal. 12), 110 cm (cal. 20) **WEIGHT:** app. 2,8 kg **WOOD CLASS:** basic wood class 4

SIDELOCK SIDE-BY-SIDE SHOTGUN 65E

## BRITISH BEAUTY



The sidelocks make the 65E side-by-side shotgun even more elegant than its sister, the 45E with the boxlock. Otherwise this shotgun is also made in the English style: the steel action assembly is in discreet grey nitrate – as are the trigger guard, locking lever and safety slide. English stock with hand-cut checkering at the butt plate. The selected wood enhances the elegant overall impression. Removable sidelocks and monogram plate are also features of this refined shotgun – British beauty.





**SIDE-BY-SIDE SHOTGUN 65E**  
GAME SCENE JAGD MODEL

■ **SIDE-BY-SIDE SHOTGUN 65E:** detachable sidelocks | steel action | Greener-style cross bolt and double bottom bite | excellent double trigger | automatic safety with intercepting safety sear | with ejectors | English stock

**CALIBER:** 12/76, 20/76 **CHOKE:** 1/4 - 1/2 (steel-shot proofed), 1/4 - 3/4, 1/2 - 1/1 **BARREL LENGTH:** 71 cm (cal. 12), 68 cm (cal. 20) **OVERALL LENGTH:** app. 113 cm (cal. 12), app. 110 cm (cal. 20) **WEIGHT:** app. 3,1 kg (cal. 12), app. 2,8 kg (cal. 20) **WOOD CLASS:** basic wood class 5

## VERSATILE AND LIGHT

The rifle/shotgun with its combination of shot and bullet is a traditional form of gun in European hunting culture. Combinations were the first combined hunting guns, offering a versatility to match the diversity of game on the old continent. Not only hunting enthusiasts value this gun: this Meisterstück enables professionals to use interchangeable barrels. With the option of conversion to a side-by-side shotgun or a side-by-side rifle, this hunting gun is an all-rounder. The exclusive features of the 40E and 60E are also incorporated in the combination of this series. Both have a double trigger with forward set trigger.



■ **COMBINATION RIFLE/SHOTGUN 240:** RIFLE CALIBER: 6,5x57R, 7x57R, 7x65R, 8x57IRS  
SHOTGUN CALIBER: 20/76 CHOKE: 1/2 for steel shot, 1/1 BARREL LENGTH: app. 60 cm  
OVERALL LENGTH: app. 102 cm WEIGHT: app. 3,3 kg WOOD CLASS: basic wood class 4

■ **COMBINATION RIFLE/SHOTGUN 260:** Technical specifications the same as the Combination 240, except removeable sidelocks and wood class starts from class 5



COMBINATION GUN 240  
GAME SCENE JAGD MODEL



COMBINATION GUN 260  
GAME SCENE JAGD MODEL

SIDE-BY-SIDE RIFLES



SIDE-BY-SIDE RIFLE 160  
GAME SCENE JAGD MODEL



SIDE-BY-SIDE RIFLES

## CHARACTERISTICS



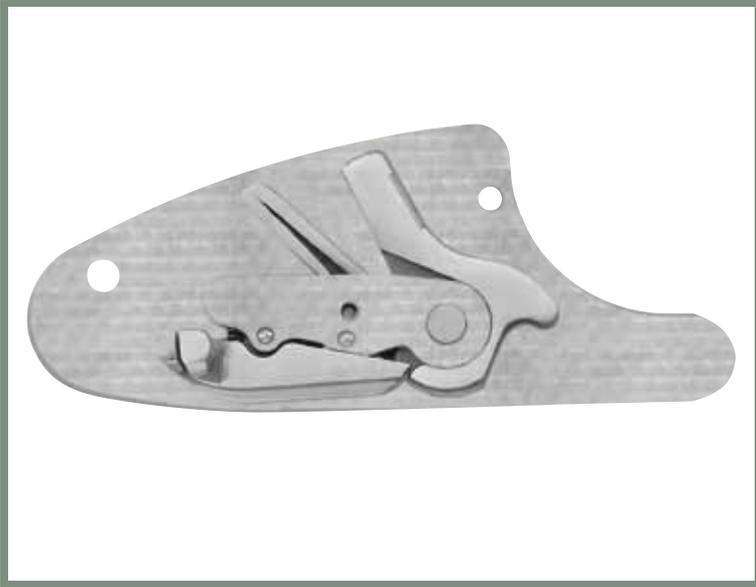
Simply beautiful, simply good: Anson & Deeley locks.



Hard soldered: the barrels of the side-by-side rifles 140 and 160.



SIDE-BY-SIDE RIFLE 140  
CUSTOM MODEL



V-springs in the sidelock: powerful energy storage system.



Greener style cross bolt with double bottom bite.



Muzzle adjustment for side-by-side rifles 141 and 161.



Models 141 and 161: prepared for swing mount and driven hunt sights.

SIDE-BY-SIDE RIFLE 140

## THE MOVING DOUBLE



A special offer for aficionados of soldered barrel sets: classically designed Merkel side-by-side rifles. The soldered barrels and the adapted 20 calibre receiver ensure an agreeable recoil due to the greater weight. Side-by-side shotgun barrels of calibre 20/76 and rifle/shotgun barrels are available as interchangeable barrel options. The forward trigger has a set prepared base for the swing mount,; thus the side-by-side rifle also excels with the precision shot. That means an extended range of use for this Meisterstück. The pivot mount, which is a standard fixture, enables flexible use of different scopes. Driven hunt sight, as standard.





**SIDE-BY-SIDE RIFLE 140**  
GAME SCENE JAGD MODEL

■ **SIDE-BY-SIDE RIFLE 140:** Anson & Deeley locks | steel action | Greener-style cross bolt and double bottom bite | double trigger with front set trigger, optional single trigger | automatic trigger safety | optional with ejectors | hard soldered barrels with muzzle adjustment, horizontal and vertical | engraving English arabesque or game scene "Jagd" | pistol grip, cheek piece and hogback comb | rubber butt plate

**CALIBER:** 7x65R, .30-06, .30R Blaser, 8x57IRS, 9,3x74R **BARREL LENGTH:** 60 cm **OVERALL LENGTH:** app. 102 cm **WEIGHT:** app. 3,4 kg  
**WOOD CLASS:** basic wood class 4

## SIDE-BY-SIDE RIFLE 141

### THE SLIM VERSION

The 141 model is a variation of the 140 side-by-side rifle. The particularly narrow receiver and the short barrels make this gun one of the lightest side-by-side rifles in the world. The option of vertical and horizontal muzzle adjustment facilitates retrofitting a scope or changing to ammunition with a different load or bullet weight. The rifle is prepared for the fitting of a pivot mount; a driven hunt sight is supplied as standard. This compact action is the result of masterly gunmaking expertise – and rewards future owners with an exceptionally slim and responsive hunting gun.



■ **SIDE-BY-SIDE RIFLE 141:** Anson & Deeley locks | steel action | Greener-style cross bolt and double bottom bite | double trigger with front set trigger, optional single trigger | automatic trigger safety | optional with ejectors | hard soldered barrels with muzzle adjustment, horizontal and vertical | engraving English arabesque or game scene "Jagd" | pistol grip, cheek piece and hogback comb | rubber butt plate

**CALIBER:** 7x65R, .30-06, .30R Blaser, 8x57IRS, 9,3x74R **BARREL LENGTH:** 55 cm **OVERALL LENGTH:** app. 97 cm **WEIGHT:** app. 3,0 kg **WOOD CLASS:** basic wood class 4



SIDE-BY-SIDE RIFLE 141  
MODEL ARABESQUE



SIDE-BY-SIDE RIFLE 141  
CUSTOM MODEL WITHOUT CHEEK PIECE

SIDE-BY-SIDE RIFLE 160

## MOVING DOUBLE WITH SIDELOCKS

The side-by-side rifle with the finest sidelocks stands out in terms of technology and aesthetics. The locks work with V-springs, which guarantees short shot development times. The steel surfaces provide plenty of space for decorative illustration at the hands of experienced engravers. Precision shooting from the high seat is facilitated by the set trigger on the forward trigger blade. The classical sidelocks of the side-by-side rifle make for excellent trigger pull. The sidelocks can be removed without tools – for cleaning or just to appreciate the workmanship.



■ **SIDE-BY-SIDE RIFLE 160:** removeable V-spring sidelocks with intercepting sear | steel action | Greener-style cross bolt and double bottom bite | excellent double trigger with front set trigger | optional with ejectors | pistol grip, cheek piece and hogback comb | rubber butt plate

**CALIBER:** 7x65R, .30-06, .30R Blaser, 8x57IRS, 9,3x74R **BARREL LENGTH:** app. 60 cm

**OVERALL LENGTH:** app. 102 cm **WEIGHT:** app. 3,4 kg **WOOD CLASS:** basic wood class 5



SIDE-BY-SIDE RIFLE 160  
MODEL ARABESQUE



SIDE-BY-SIDE RIFLE 160  
CUSTOM MODEL I GAME SCENE ENGRAVING

## SIDE-BY-SIDE RIFLE 161

# SLIM VERSION WITH SIDELOCKS

This gun is the sidelock version of the 141 side-by-side rifle. It combines the typical characteristics of a timeless sidelock rifle with impressive elegance and responsiveness. The refined transitions between steel and stock signalise a high proportion of handcraft. Again, short barrels are used, combined with a driven hunt sight and an a prepared base for swing mounts. The horizontal and vertical muzzle adjustment by means of slot wedges is the sort of handcrafted work of art that you can only find at Merkel.



■ **SIDE-BY-SIDE RIFLE 161:** removeable V-spring sidelocks with intercepting sear | steel action | Greener-style cross bolt and double bottom bite | excellent double trigger with front set trigger | automatic trigger safety | optional with ejectors | pistol grip, cheek piece and hogback comb | rubber butt plate

**CALIBER:** 7x65R, .30-06, .30R Blaser, 8x57IRS, 9,3x74R **BARREL LENGTH:** 55 cm **OVERALL LENGTH:** app. 97 cm **WEIGHT:** app. 3,0 kg **WOOD CLASS:** 5



SIDE-BY-SIDE RIFLE 161  
MODEL ARABESQUE



SIDE-BY-SIDE RIFLE 161  
CUSTOM MODEL I | GAME SCENE ENGRAVING | WOOD CLASS 5

SAFARI SIDE-BY-SIDE RIFLES



SAFARI SIDE-BY-SIDE RIFLE 160AE  
CUSTOM MODEL I GAME SCENE ENGRAVING



SAFARI SIDE-BY-SIDE RIFLES

## CHARACTERISTICS



SAFARI SIDE-BY-SIDE  
RIFLE 140AE  
CUSTOM MODEL



Indestructible classic: the Anson & Deeley locks.



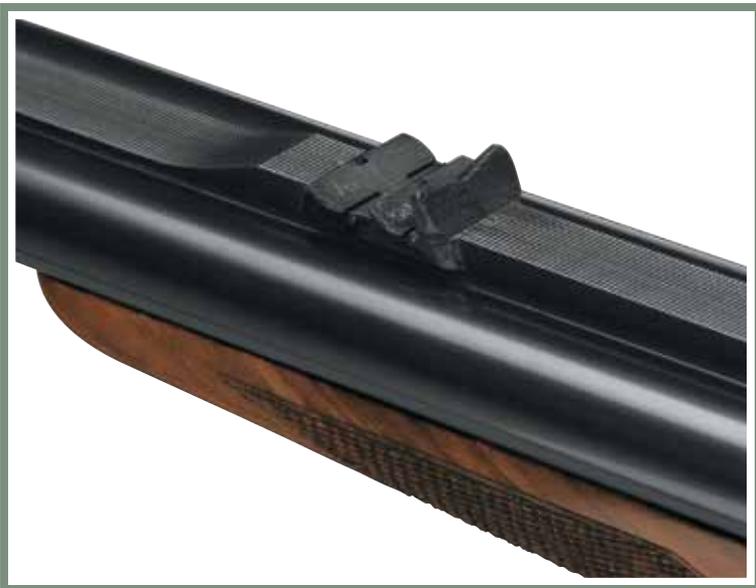
The hinged trigger prevents injury to the trigger finger.



Detachable sidelocks – surfaces for fine engraving.



Greater safety: Greener cross bolt with double bottom bite.



Express sight with sight leaf: shooting at variable distances.



Power in form: muzzle silhouette of the large calibre Africa gun.

SAFARI SIDE-BY-SIDE RIFLE 140AE

## THE WORKHORSE

The basis version of the Africa rifles is the favoured gun of many professional hunters. The Merkel version of the Anson & Deeley boxlock is traditionally valued for its unrivalled reliability for big game hunting. An uncomplicated workhorse, based on the experience of over 100 years of rifle development for big game hunting. All the mechanical systems are doubled and can thus function autonomously – this is particularly important in dangerous situations, where life and limb are at risk.



■ **SAFARI SIDE-BY-SIDE RIFLE 140AE:** Anson & Deeley locks | steel action | Greener-style cross bolt and double bottom bite | double trigger with articulated front trigger | manual safety with intercepting sears | with ejectors | African express sight | pistol grip, cheek piece and straight stock | rubber recoil pad

**CALIBER:** .375 H&H Mag., .416 Rigby, .470 N. E., .500 N.E. **BARREL LENGTH:** 60 cm **OVERALL LENGTH:** app. 102 cm **WEIGHT:** app. 4,6 kg **WOOD CLASS:** 4 to 7



SAFARI SIDE-BY-SIDE RIFLE 140AE  
CUSTOM MODEL WITH COLOUR CASE HARDEND AND GOLD INLAYS | WOODCLASS 5



SAFARI SIDE-BY-SIDE RIFLE 140AE  
MODEL ARABESQUE | WOODCLASS 5

SAFARI SIDE-BY-SIDE RIFLE 160AE

## THE SIDELOCK AFRICA RIFLE

The precision and reliability of Merkel safari rifles has delighted big game hunters and heads of state for generations. The 160 version combines the largest calibre with sidelocks – which also offers our engravers additional scope of decorating the long sidelocks. One of the most beautiful rifles – for the most exciting form of hunting.



■ **SAFARI SIDE-BY-SIDE RIFLE 160AE:** removeable V-spring sidelocks with intercepting sear | steel action | Greener-style cross bolt and double bottom bite | excellent double trigger with articulated front trigger | manual safety with intercepting sears | with ejectors | Safari express sight | pistol grip, cheek piece and straight stock | rubber recoil pad

**CALIBER:** .375 H&H Mag., .416 Rigby, .470 N. E., .500 N.E. **BARREL LENGTH:** 60 cm  
**OVERALL LENGTH:** app. 102 cm **WEIGHT:** app. 4,6 kg **WOOD CLASS:** from 5 to 7





SAFARI SIDE-BY-SIDE RIFLE 160AE  
CUSTOM MODEL



SAFARI SIDE-BY-SIDE RIFLE 160AE  
CUSTOM MODEL | GAME SCENE ENGRAVING | WOOD CLASS 5

DECORATIVE STANDARDS

## ENGRAVING EXAMPLES



SIDE-BY-SIDE  
SHOTGUN 45E  
GAME SCENE  
"JAGD" MODEL



Arabesque engraving on a Anson & Deeley gun.



Arabesque engraving on a sidelock gun.



Game scene "Jagd" engraving on a Anson & Deeley shotgun.



Game scene "Jagd" engraving on a Anson & Deeley rifle.



Game scene "Jagd" engraving on a sidelock shotgun.

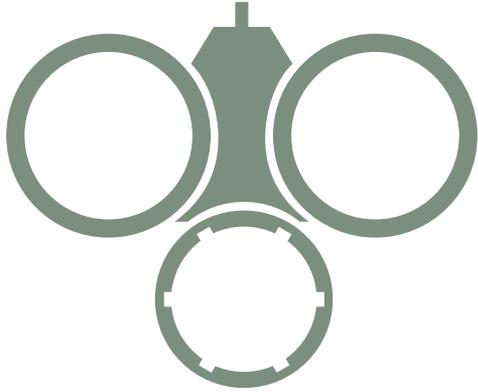


Game scene "Jagd" engraving on a sidelock rifle.

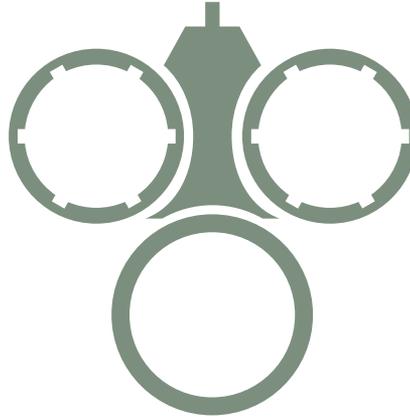
## DRILLINGS



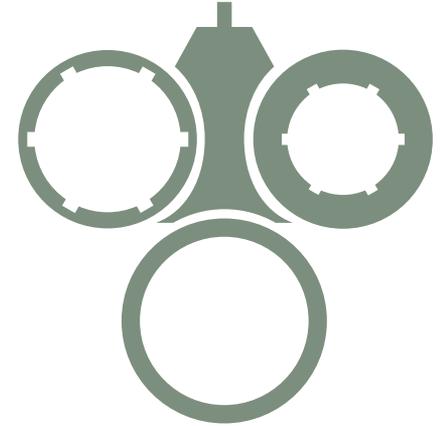
Company founder Gebhard Merkel always had a heart for drillings – the universal gun was manufactured in the Merkel manufactory from the beginning.



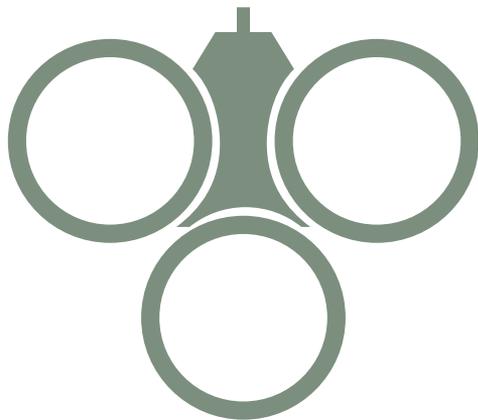
■ DRILLING



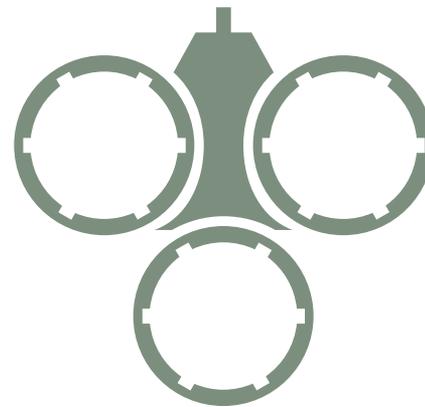
■ DOUBLE RIFLE DRILLING



■ BERGSTUTZEN DRILLING



■ SHOTGUN DRILLING



■ RIFLE DRILLING

DRILLINGS



DOUBLE RIFLE DRILLING 961 LS  
CUSTOM MODEL I WITH GOLD INLAY



## DRILLINGS

# CHARACTERISTICS

### ■ EXECUTION 96:

The three-position cocking slide is the control element of the Merkel drilling. **REAR:** In the rear position the locks of the 2 upper barrels are safe (3 lock is uncocked). **MIDDLE:** The locks of the 2 upper barrel are unsafe, the lock of the bottom barrel is unlocked. In this position the front and the rear trigger fires the upper right and left barrel. **FRONT:** Is the safety slide in the front position the lock of the bottom barrel is cocked. In this position the front trigger fires the lower barrel and the rear trigger the upper left barrel.

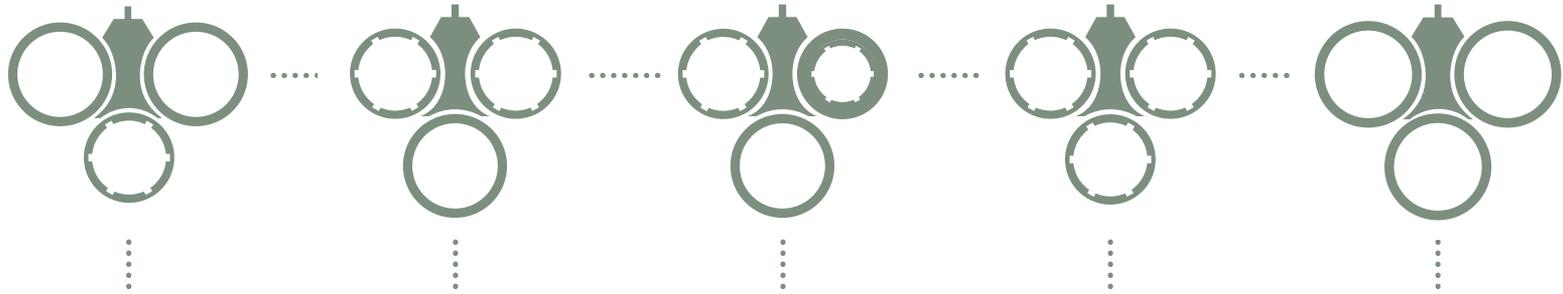
### ■ EXECUTION 961:

In this execution all three locks of the drilling are cocked automatically with breaking down gun. When the safety slide is in the rear position both triggers are safe. In firing position (in the front) the drilling is ready to fire and the front trigger works as single trigger for the locks of the right and the left upper barrels. The rear trigger exclusively operates the lock of the lower barrel.



■ Three-position cocking slide: safety and manual cocking system in one.

# MERKEL: THE SUHLER DRILLING



**DRILLING 96K/96KS**  
(drilling)

Execution 96

**Trigger/function:**

- 1. trigger \* right shotgun barrel
- 2. trigger left shotgun barrel
- cocking slide: 1. trigger \* lower rifle barrel

\* = set trigger

**DB-DR 96L/961L 96LS/961LS**  
(double rifle drilling)

Execution 96

**Trigger/function:**

- 1. trigger \* right rifle barrel
- 2. trigger left rifle barrel
- cocking slide: 1. trigger lower shotgun barrel

Execution 961

**Trigger/function:**

- 3 locks self cocking system
- 1. trigger both rifle barrels
- 2. trigger lower shotgun barrel

**BS-DR 96LD/96LDS**  
(Bergstutzen-Drilling)

Execution 96

**Trigger/function:**

- 1. trigger \* right rifle barrel (large)
- 2. trigger left rifle barrel (small)
- cocking slide 1. trigger lower shotgun barrel

**B-DR 961L/961LS**  
(rifle drilling)

Execution 961

**Trigger/function:**

- 3 locks self cocking system
- 1. trigger both rifle barrels
- 2. trigger lower rifle barrel

**DRILLING 961**  
(shotgun drilling)

Execution 961

**Trigger/function:**

- 3 locks self cocking system
- 1. trigger both shotgun barrels
- 2. trigger lower shotgun barrel

**Execution 96:**

trigger system with set trigger/s for the high seat hunt

**Execution 961:**

fast trigger system with single trigger for the driven hunt

**L** = slim 28 gauge receiver

**K** = cocking slide

**S** = long side plates

**D** = double set trigger

DRILLING 96K | 96KS

## DRILLING WITHOUT CONFUSION

The basis Merkel drilling is built around the 96K three-lock system; this gun is the all-rounder in the small game hunting ground. The system is a technical delicacy, which makes drillings as elegant as they are efficient. The Blitz locks are controlled via the three-position cocking slide on the stock tang. The front trigger is fitted with a set trigger for the precision shot. Depending on the position of the cocking slide, the right barrel or lower barrel can be fired in the engaged position. The 96KS version is fitted with long side plates.



■ **DRILLING 96K | 96KS:** three lock system (Blitz locks) with manual cocking slide | steel receiver | Greener style cross bolt and double bottom bite | double trigger with set trigger | pistol grip; cheek piece and hogsback comb | rubber butt plate

**SHOTGUN CALIBER:** 12/76, 20/76 **RIFLE CALIBER:** .223 Rem., 243. Win., 7x57R, 7x65R, .308 Win., .30R Blaser, .30-06, 8x57IRS, 9,3x74R **CHOKE:** improved cylinder - 1/2 (steel-shot proofed), 1/4 - 3/4, 1/2 - 1/1 **BARREL LENGTH:** cal. 12 (55 cm and 60 cm), cal. 20 (55 cm) **OVERALL LENGTH:** 98 cm or 103 cm **WEIGHT:** app. 3,1 kg **WOOD CLASS:** basic wood class 2



DRILLING 96K  
GAME SCENE JAGD MODEL



DRILLING 96KS  
CUSTOM MODEL | GAME SCENE ENGRAVING | WOOD CLASS 9

DOUBLE RIFLE DRILLING 961L | 961LS | 96L | 96LS

## DRILLING WITH RAPID SHOT OPTION

The new development of a particularly slim drilling receiver (28 caliber) makes the current generation of Merkel drillings ever lighter and more elegant. One version of this light species is the double rifle drilling 961L, with a driven hunt trigger. The front trigger serves as a single trigger for the two upper rifle barrels. This enables a rapid second shot without the need to change grip. The rear trigger is reserved for the lower shotgun barrel. The 96LS and 961LS versions are fitted with long side plates.

The 96L/96LS models use the same locking system as the 96K/96KS drilling.



■ **DOUBLE RIFLE DRILLING 961L/ 961LS:** real three lock system (Blitz locks) with safety slide | steel receiver | Greener style cross bolt and double bottom bite | double trigger with single trigger in the front | pistol grip, cheek piece and hogsback comb | rubber butt plate

■ **DOUBLE RIFLE DRILLING 96L / 96LS:** specification as 96K/ 96KS, manual cocking for the lower shotgun barrel.

**SHOTGUN CALIBER:** 20/76 **CHOKE:** 1/2 (steel-shot proofed) **RIFLE CALIBER:** .30-06, .30R Blaser, 8x57IRS, 9,3x74R **BARREL LENGTH:** 55 cm **OVERALL LENGTH:** app. 98 cm **WEIGHT:** app. 3,2 kg  
**WOOD CLASS:** basic wood class 4



DOUBLE RIFLE DRILLING 961L  
MODEL ARABESQUE



DOUBLE RIFLE DRILLING 961LS  
CUSTOM MODEL I | GAME SCENE ENGRAVING | WOOD CLASS 5

BERGSTUTZEN DRILLING 96LD | 96LDS

## FULL RANGE DRILLINGS



The Bergstutzen drilling is a typical gun used on a high seat for a single shot. With two rifle barrels of different caliber and one shot-gun barrel, this drilling is a gun that offers every opportunity to the hunter, whatever game he encounters in the glade. The set trigger on both triggers enables a precision shot with both rifle barrels. Die 96LDS is fitted with long side plates (no illustration).





**BERGSTUTZEN DRILLING 96LD**  
GAME SCENE "JAGD" MODEL

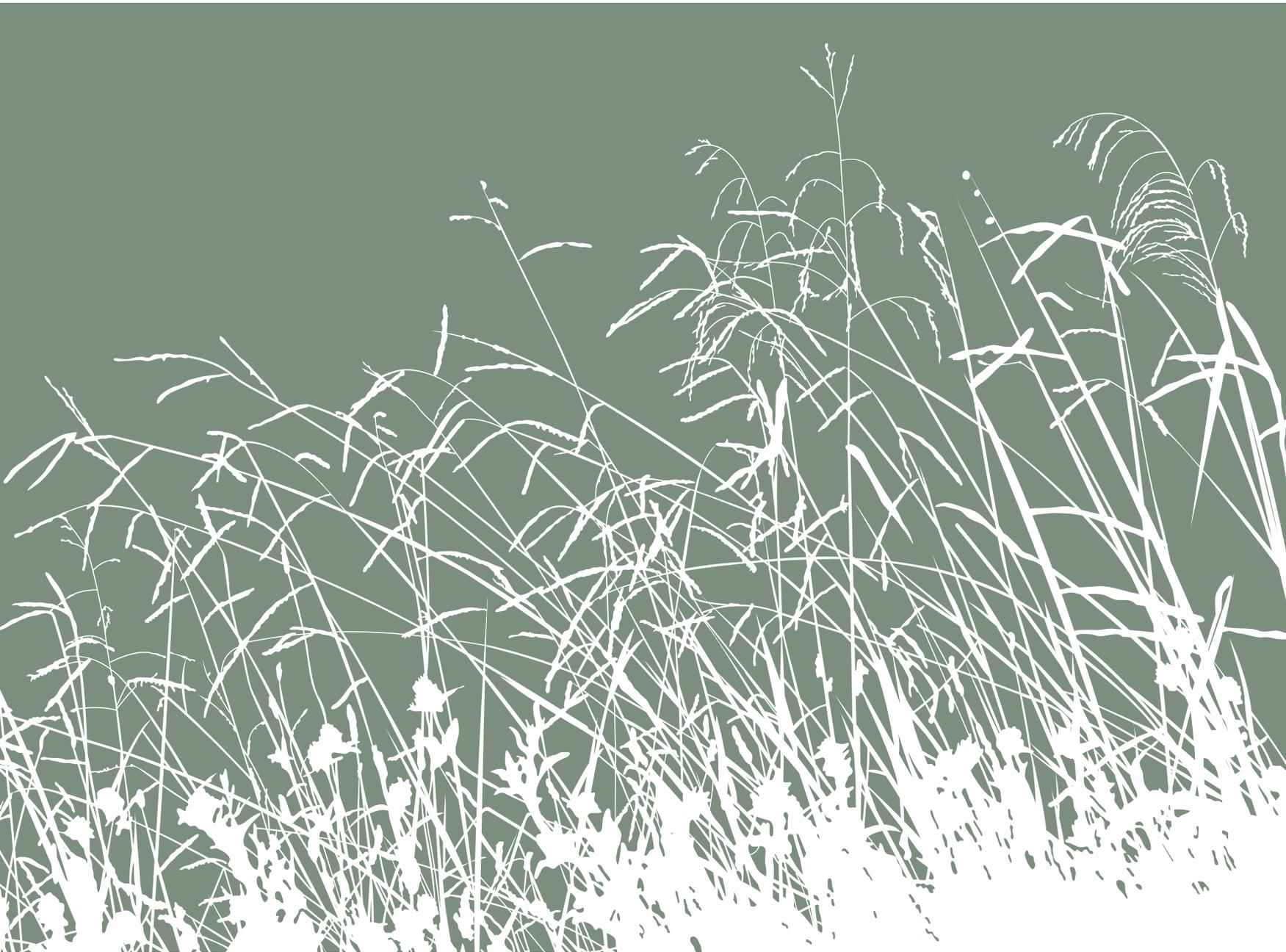
■ **BERGSTUTZEN DRILLING 96LD | 96LDS:** three lock system (Blitz locks) with manual cocking | steel receiver | Greener style cross bolt and double bottom bite | double trigger with set trigger in both triggers | pistol grip; cheek piece and hogsback comb | rubber butt plate

**SHOTGUN CALIBER:** 20/76 **LARGE CALIBER:** .30-06, .30R Blaser, 8x57IRS, 9,3x74R **SMALL CALIBER:** 5,6 x 52R, .222 Rem **CHOKE:** 1/2 steel-shot proofed **BARREL LENGTH:** 55 cm **OVERALL LENGTH:** app. 98 cm **WEIGHT:** app. 3,3 kg **WOOD CLASS:** basic wood class 4

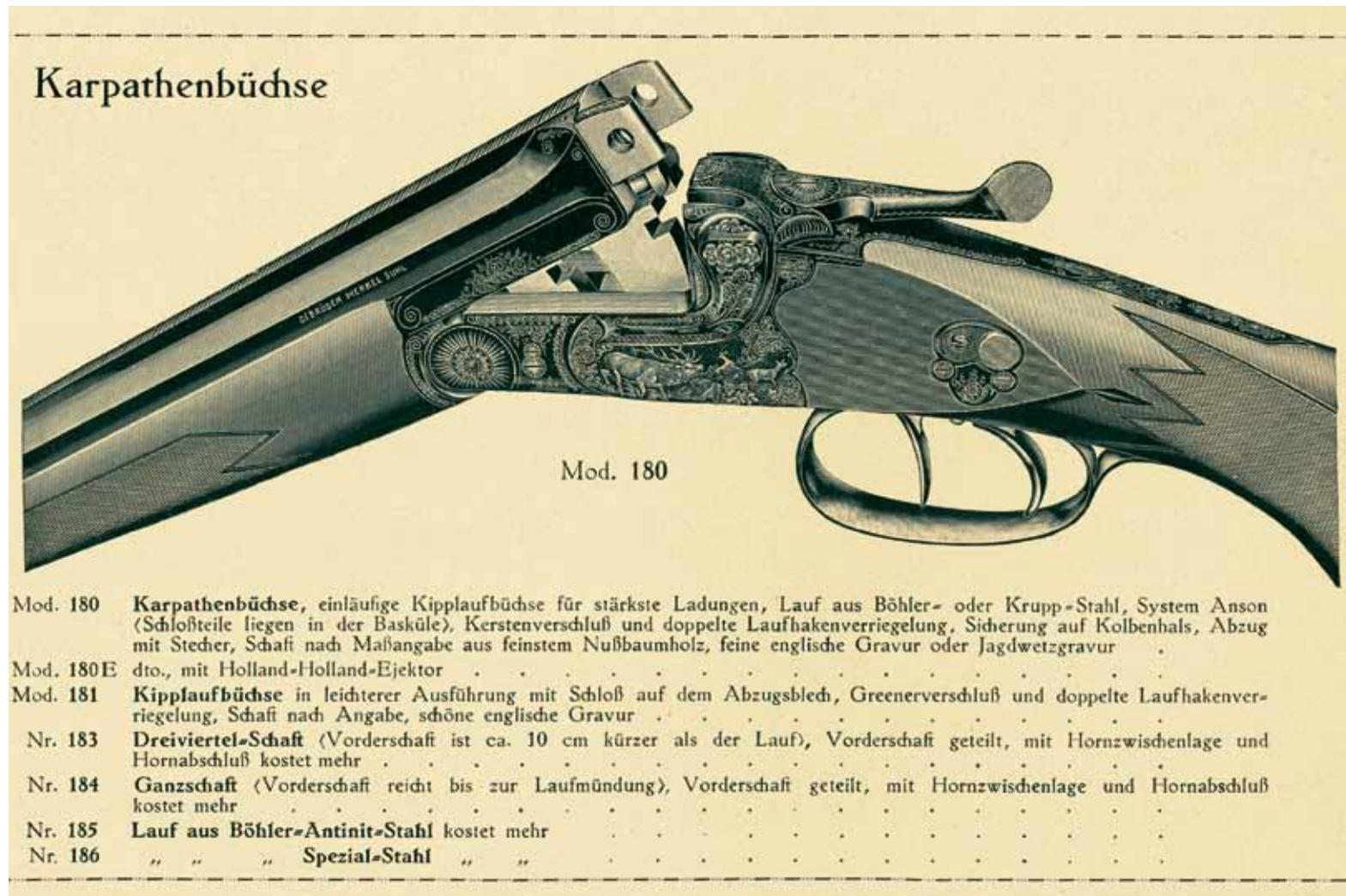
# MEM

Modern hunting guns: cutting edge technology with the genes of the Suhl gunmaking art: this is MEM. The acronym stands for Merkel Engineered Manufacturing and also alludes to the “culture gene” mem. The floral motif, an illustration of nature, symbolises this category of the Merkel brand.

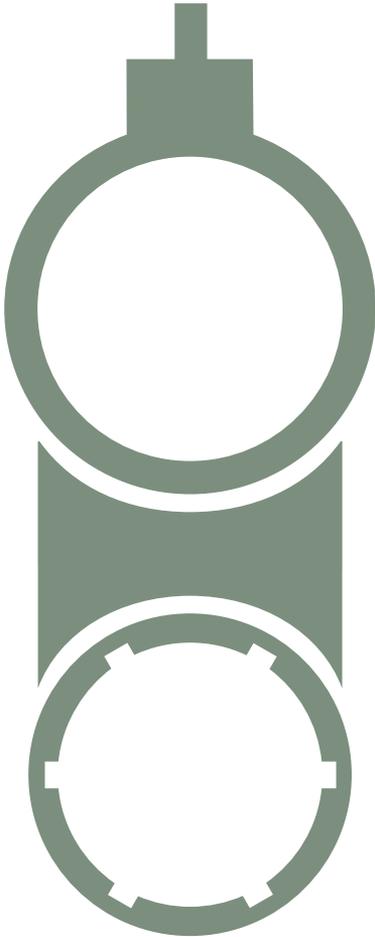




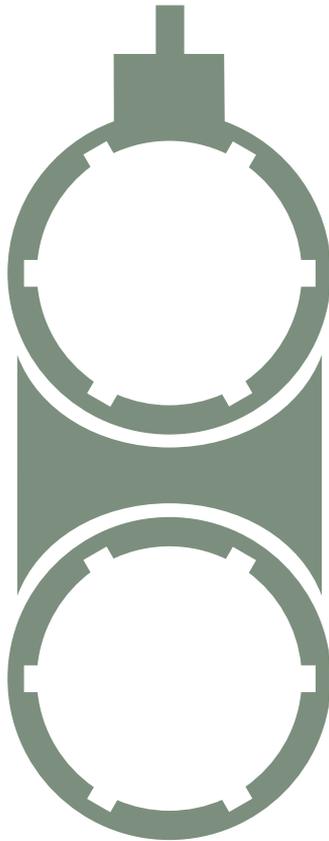
## MEM SINGLE SHOT RIFLES



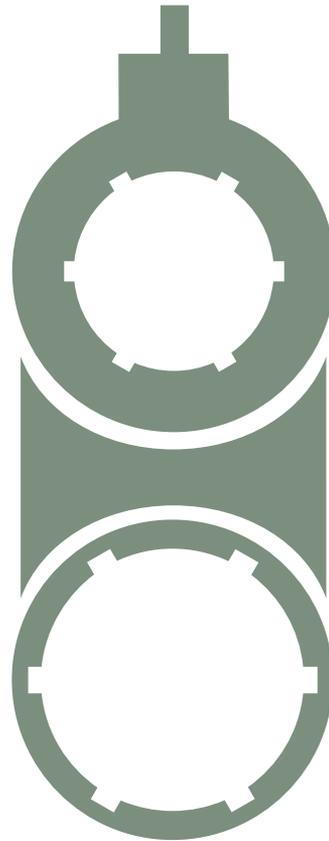
MEM single shot rifles reinterpret Suhl traditional models such as the Carpathian rifle – with modern manufacturing methods.



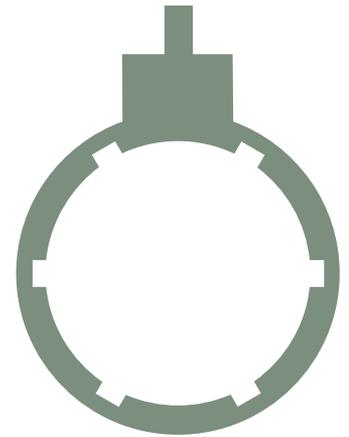
OVER-AND-UNDER  
COMBINATION GUN



OVER-AND-UNDER  
RIFLE



BERGSTUTZEN



SINGLE SHOT RIFLE

K CLASS SINGLE-SHOT RIFLES



SINGLE SHOT RIFLE K4 STUTZEN  
ERFURT DESIGN



K CLASS SINGLE SHOT RIFLES

## CHARACTERISTICS



Break open with handcocking system - the safe combination.



SINGLE SHOT RIFLE K4 STUTZEN  
ERFURT DESIGN



The muzzle: Stutzen, K3 and K4 with octagonal barrel (from the left).



The Suhl tilted block breech of a K3.



Low sight line, highly shot-proof: Suhl tilt-up mount.



Fine adjustment possible: the adjustable trigger.

SINGLE SHOT RIFLE K3 | STUTZEN K3

## FOR DEERSTALKING AND THE MOUNTAINS

The single barrel rifle is a special gun. Aficionados value its optimised shot performance to weight ratio. A special form of single-barrel rifle, the Stutzen, is mainly found in Alpine regions. The K3 single shot Stutzen is a variation on the K class, which combines the short rifle with the full barrel stock forearm. Lovers of this special gun appreciate its handiness in practice – when stalking, in the raised hide and also in transport. The K3 Stutzen combines impressive shortness with efficient gun technology.



■ **SINGLE SHOT RIFLE K3:** **KALIBER:** .243 Win., 6,5x57R, 6,5x65R, .270 Win., 7x57R, 7x65R, .300 Win. Mag., .308 Win., .30-06, .30R Blaser, 7mm Rem. Mag., 8x57IRS, 9,3x74R **BARREL LENGTH:** 60 cm **OVERALL LENGTH:** app. 101 cm **WEIGHT:** app. 2,5 kg **WOOD CLASS:** basic wood class 2

■ **SINGLE SHOT RIFLE K3 STUTZEN:** **KALIBER:** .7x57R, 7x65R, .308 Win., .30-06, .30R Blaser, 8x57 IRS, 9,3x74R **BARREL LENGTH:** 50 cm **OVERALL LENGTH:** app. 91 cm **WEIGHT:** app. 2,4 kg **WOOD CLASS:** basic wood class 4



SINGLE SHOT RIFLE K3  
DESIGN ERFURT | WOOD CLASS 10



SINGLE SHOT RIFLE STUTZEN K3  
GAME SCENE "JAGD" MODEL | WOOD CLASS 4

## SINGLE SHOT RIFLE K4

# FLORSTEDT'S CARPATHIAN RIFLE

Alexander Florstedt (1863-1929) was a famous writer on hunting at the beginning of the 20th century. The Carpathian Mountains were not only his favourite hunting grounds; he also composed the standard work on hunting in this magical mountain range in Eastern Europe. In line with his needs and according to his detailed requirements, Merkel developed the first Carpathian rifle. The current version of this traditional rifle is the K4. Its distinctive marks are the octagonal barrel and the steel receiver. The K4 thereby brings more stabilising mass to the scales – important for a steady firing position. A rifle exactly to the specifications laid down by Florstedt, an advocate of the precision single shot. The K4 is available in 'Jagd' design – also as a full-length stock version.



Finely tuned adjustable trigger | single lock hand-cocking system | automatic safety device - while opening automatically de-cock the gun | Jäger tilted block breech with steel receiver | pistol grip, bavarian cheek piece and hogback comb

■ **SINGLE SHOT RIFLE K4 STUTZEN: CALIBRE:** 6.5x65R, 7x65R, .300 Win. Mag., .308 Win., .30-06, .30R Blaser, 7 mm Rem. Mag., 8x57IRS **BARREL LENGTH:** 50 cm

**TOTAL LENGTH:** Approx. 91 cm **WEIGHT:** Approx. 2.7 kg **WOOD CLASS:** From 4

■ **SINGLE SHOT RIFLE K4 STUTZEN: CALIBRE:** 6,5x65R, 7x65R, .300 Win. Mag., .308 Win., .30-06, .30R Blaser, 7mm Rem. Mag., 8x57IRS **BARREL LENGTH:** 50 cm

**TOTAL LENGTH:** Approx. 91 cm **GEWICHT:** Approx. 2,7 kg **HOLZKLASSE:** From 4

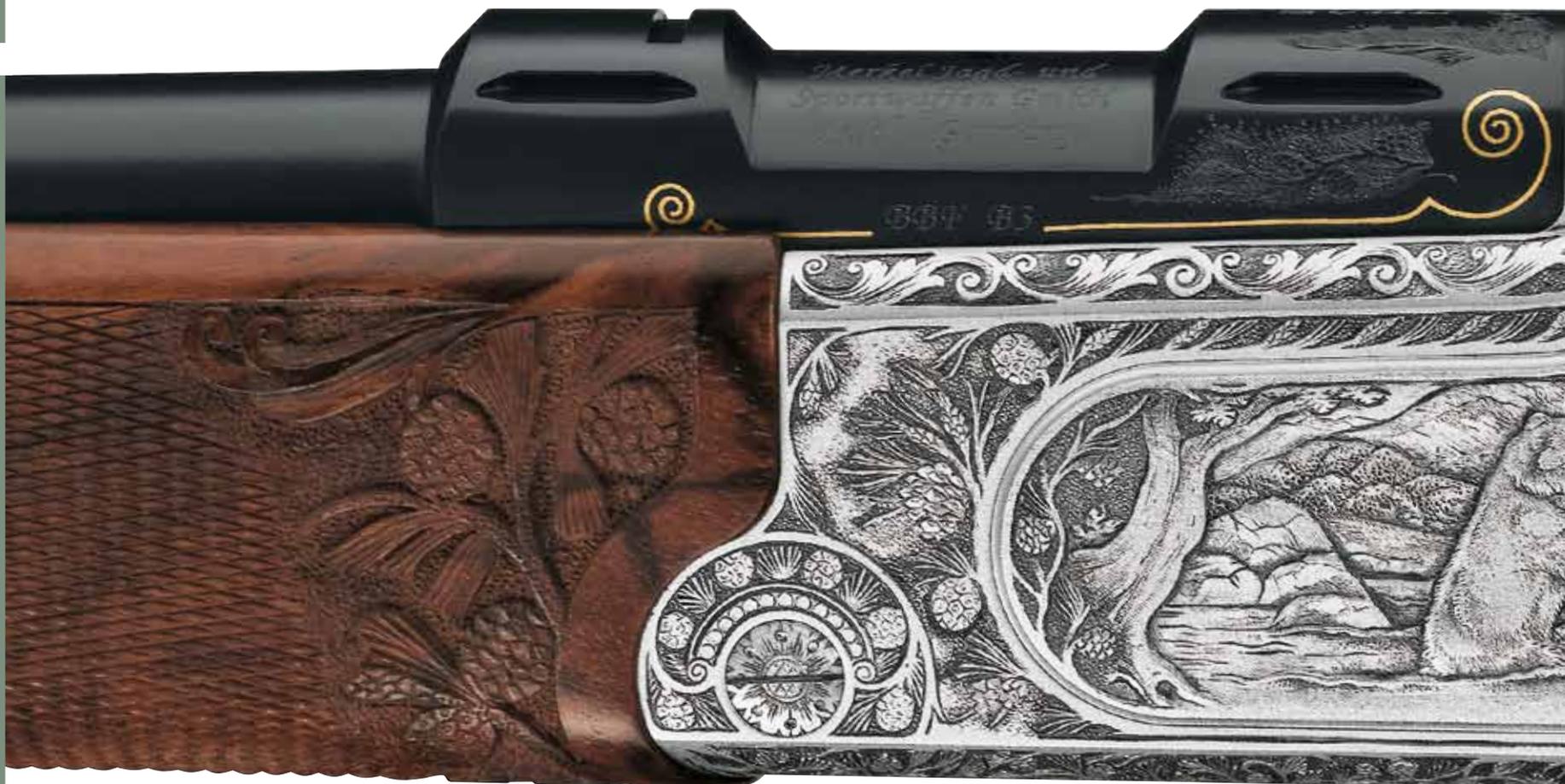


SINGLE SHOT RIFLE K4  
GAME SCENE "JAGD" MODEL I WOOD CLASS 4



SINGLE SHOT RIFLE K4 STUTZEN  
DESIGN ERFURT I WOOD CLASS 9  
STOCK WITH WOOD FILLER

B CLASS OVER-AND-UNDER GUNS

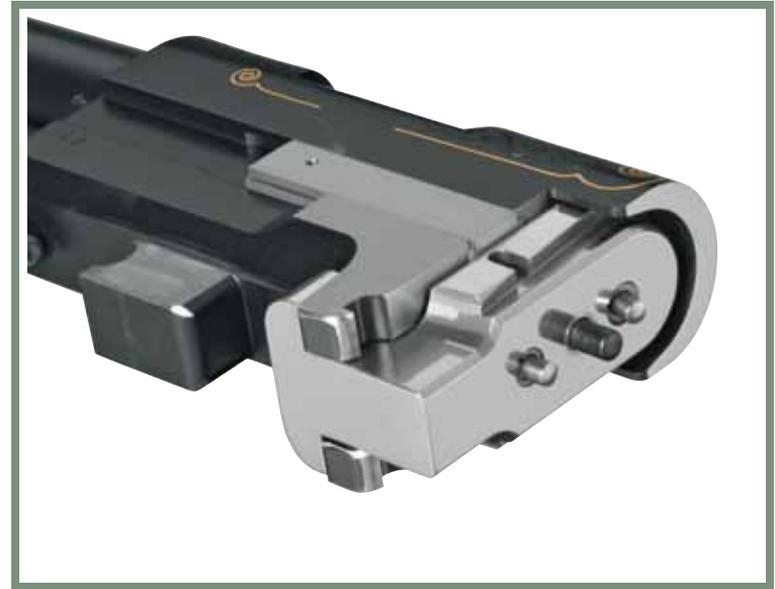


OVER-AND-UNDER COMBINATION GUN B3  
SUHL DESIGN



B CLASS OVER-AND-UNDER GUNS

## CHARACTERISTICS



Rugged Jäger tilted block breech.



OVER-AND-UNDER  
COMBINATON GUN B3  
ERFURT DESIGN



Safe manual cocking system: decocked until just before the shot.



The forearm of the B3 has the typical Merkel Schnabel.



Versatile and flexible: interchangeable barrels for the B4.



Always the identical point of impact: Suhl tilt-up mount.

## B3 OVER-AND-UNDER COMBINATION GUN

# COMBINED GUNS WITH DOUBLE LOCKS

Versatile and safe in practice: the B3 is a modern over-and-under combination rifle/shotgun of the MEM category with a double lock and manual cocking system. The tilted block breech, top sear levers and safety catches are Suhl quality products, and give this hunting gun a high level of safety in the field. The free floating cold forged rifle barrel from the Merkel manufactory guarantees precision; the shotgun barrel is steel shot capable, in line with current trends. Additional safety: when opening the breech the locks are automatically decocked. The B class shows its Suhl roots in its details: traditional stock, the side plates are fastened by means of the prism technique. The forearm is rounded off with the typical Merkel snobble-tip. Interchangeable over-and-under double rifle barrels are an optional extra.



■ **OVER-AND-UNDER COMBINATION GUN B3:** two lock hand cocking system | with safety automatic - while opening it decocked the gun | rugged Jäger tilted block breech | barrel adjustment | double trigger with front set trigger | pistol grip, bavarian cheek piece and hogsback comb | rubber butt plate

**SHOTGUN CALIBER:** 12/76, 20/76 **CHOKE:** 1/2 (steel-shot proofed) **RIFLE CALIBER:** .223 Rem., .243 Win., 6,5x57R, 7x57R, 7x65R, .308Win, .30-06, .30R Blaser, 8x57IRS, 9,3x74R **BARREL LENGTH:** 60 cm **OVERALL LENGTH:** app. 102 cm **WEIGHT:** app. 3,1 kg **WOOD CLASS:** basic wood class 2



OVER-AND-UNDER COMBINATION GUN B3  
SUHL DESIGN | WOOD CLASS 9



OVER-AND-UNDER COMBINATION GUN B3  
ERFURT DESIGN | WOOD CLASS 7

## B4 OVER-AND-UNDER COMBINATION GUN

### FINELY TUNED TRIGGER

The B4 over-and-under combination rifle/shotgun combines precision with safety. Finely tuned triggers combined with a single box lock enable high-precision shooting. The single lock manual cocking system on the stock wrist allows the gun to be carried in a decocked status, and rapidly cocked when required. The rifle barrel adjustment under the forearm is a technical delicacy. The high-grade processing right up to the steel middle barrel rail is characteristic of the gun as a whole.



**OVER-AND-UNDER COMBINATION GUN B4:** single lock hand-cocking system | with safety automatic – while opening it decocked the gun | rugged Jäger tilted block breech | barrel adjustment | fine tuned double trigger | pistol grip, bavarian cheek piece and hogback comb | rubber butt plate

**SHOTGUN CALIBER:** 12/76, 20/76 **CHOKE:** - 1/2 (steel-shot proofed) **RIFLE CALIBER:** .223 Rem., .243 Win., 6,5x57R, 7x57R, 7x65R, .308Win, .30-06, .30R Blaser, 8x57IRS, 9,3x74R **BARREL LENGTH:** 60 cm **OVERALL LENGTH:** app. 102 cm **WEIGHT:** app. 3,1 kg **WOOD CLASS:** basic wood class 2



OVER-AND-UNDER COMBINATION GUN B4  
PREMIUM DESIGN | WOOD CLASS 4



OVER-AND-UNDER COMBINATION GUN B4  
CUSTOM MODEL | WOOD CLASS 8

B4 BERGSTUTZEN

## TWO RIFLES IN ONE



Two in one: the Bergstutzen is a compact rifle, which combines two precise rifle barrels of different calibre in one gun. Thus the hunter is well armed for all sorts of hoofed game. Merkel combines the manual cocking system with two finely tuned triggers. The single lock system guarantees maximum safety – and two fine trigger blades. The calibres of the large and small rifle barrels allow a variety of combinations. Moreover, over-and-under rifle/shotgun interchangeable barrels can easily be installed retroactively. A standard feature of the B4 is the adjustable lower barrel, which can be adjusted to the height of the forearm. The barrel adjustment is protected by the forearm with the typical Merkel Schnabel.





#### BERGSTUTZEN B4

WEIMAR DESIGN | WOOD CLASS 7

■ **OVER-AND-UNDER BERGSTUTZEN B4:** single lock hand-cocking system | with safety automatic - while opening it decocked the gun | rugged Jäger tilted block breech | barrel adjustment | fine tuned double trigger | pistol grip, bavarian cheek piece and hogback comb | rubber butt plate

**LARGE CALIBER:** .222 Rem., 5,6x50R Mag., 5,6x52R **SMALL CALIBER:** 7x57R, 7x65R, .308 Win., .30-06, .30R Blaser, 8x57IRS, 9,3x74R

**BARREL LENGTH:** 55 cm **OVERALL LENGTH:** app. 97 cm **WEIGHT:** app. 3,3 kg **WOOD CLASS:** basic wood class 2

## B3 OVER-AND-UNDER RIFLE

# DRIVEN HUNT SPECIALISTS

The over-and-under is the classic Merkel hunting gun. The B3 is specially designed for the driven hunt and the rapid second shot. The features include double locks, manual cocking system, and adjustable single trigger. Merkel has brought the practical features of this MEM development up to the technically highest level. The technology is combined with the high-strength Suhl tilted block breech. The slim barrel set is constructed without an upper tube, which saves on weight; the lower barrel is free floating. The muzzle adjustment is protected by the forearm. The lines of this over-and-under rifle follow the Suhl tradition: from the Schnabel on the forearm to the curved side of the stock.



■ **OVER-AND-UNDER RIFLE B3:** double lock hand cocking system | safety automatic - gun automatically decocks while opening | detachable Jäger tilted block breech | bottom barrel free floating | adjustable in windage and elevation | single trigger- non selective, optional with double trigger with set trigger | pistol grip, bavarian cheek piece and hogsback comb | rubber recoil pad

**CALIBER:** .30-06, .30R Blaser, 8x57IRS, 9,3x74R **BARREL LENGTH:** 55 cm **OVERALL LENGTH:** app. 97 cm **WEIGHT:** app. 3,2 kg **WOOD CLASS:** basic wood class 4



OVER-AND-UNDER RIFLE B3  
GAME SCENE "JAGD" MODEL



OVER-AND-UNDER RIFLE B3  
PREMIUM DESIGN WITH SIDE PLATES

## DEKORATIVE STANDARDS

# ENGRAVING EXAMPLES

A rich selection of engraving pattern styles are available for Merkel MEM guns.

**K3 STANDARD:** simple arabesques engraving.

**K3 PREMIUM:** side plates with simple arabesque engraving. Side and bottom engraved with english style arabesque.

**K3/K4 JAGD:** side plates with game scene engraving different motives. Side and bottom engraved with english style arabesque.



■ K3 STANDARD

■ K3 PREMIUM

■ K3/K4 JAGD



■ **B3/B4 OVER-AND-UNDER GUNS STANDARD:** Grey receiver with simple engraving.



■ **B3/B4 OVER-AND-UNDER GUNS PREMIUM:** Side plates with simple arabesque. Side and bottom engraved with english style arabesque.



■ **B3/B4 OVER AND UNDER GUNS JAGD:** Side plates with game scene. Different motives. Side and bottom engraved english style arabesque.



■ **B3/B4 OVER AND UNDER RIFLE DE LUXE:** Black receiver, side plates and stock of high grade wood.

## OVER-AND-UNDER GUNS

# MEM DE LUXE

### JENA DESIGN:

Fine handmade engraving, two-animal motif on each side, arabesque, oak-leaf or "old German leaf" infill. Engraved barrel breech and trigger guard. Walnut stock with excellent grain pattern and fine checkering basic wood class 5.



### WEIMAR DESIGN:

Fine handmade engraving, two-animal motif in relief on each side. Arabesque, oak-leaf or "old German leaf" infill. Choice of infill and animals. Engraved barrel breech and trigger guard. Stock finely carved to complement the infill style. Selected highly grained walnut wood, with basic wood class 6.





#### ■ ERFURT DESIGN:

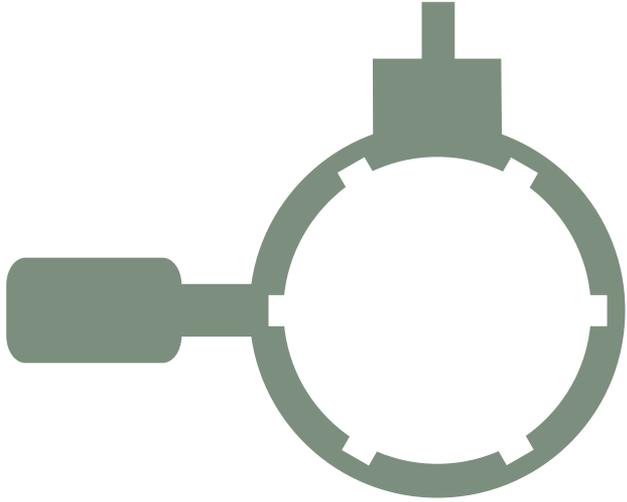
Long side plates, finely chiselled hunting scenes with up to four animal motifs on each side and one animal motif on the underside of the receiver. Choice of infill and animals. Fully engraved barrel breech and trigger guard. Stock made of highly figured walnut with fine stock carving. Basic wood class 6. Silver pistol grip cap with monogram.



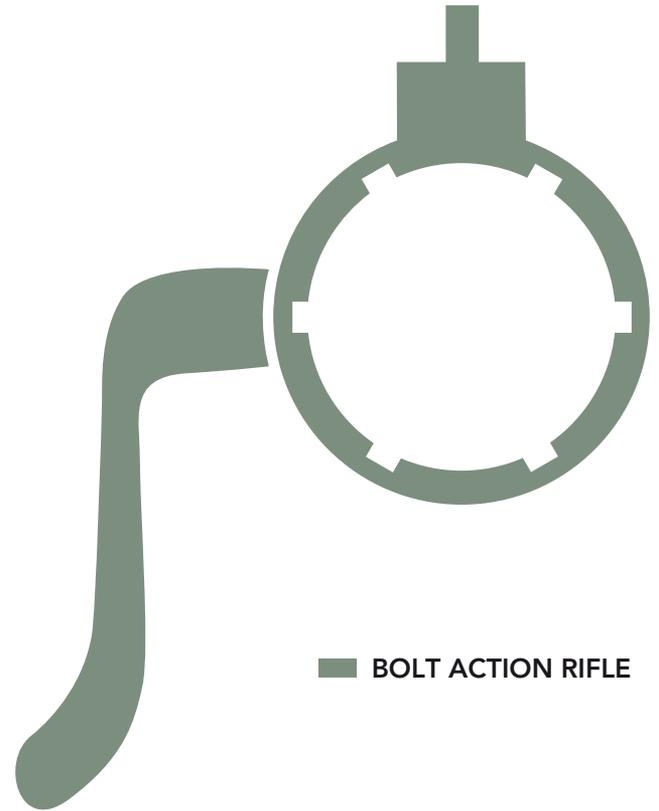
#### ■ SUHL DESIGN:

Long side plates, elaborate relief engraving with up to four animal motifs on each side and one animal motif engraved on the underside of the receiver. Choice of infill and ornamentation. Breech end of barrel fully engraved with fine gold border; gold-plated triggers. Finely carved stock highly figured with strongly contrasting grain. Basic wood class 7. Silver pistol grip cap with monogram.





■ SEMIAUTOMATIC RIFLE



■ BOLT ACTION RIFLE

SEMIAUTOMATIC RIFLE SR1



SEMIAUTOMATIC RIFLE SR1  
KEILER GOLD DESIGN



SEMIAUTOMATIC RIFLE SR1

## CHARACTERISTICS



Solid rotary bolt head with six locking lugs.



Safe handling: the slot-in magazine for rapid reloading.



SEMIAUTOMATIC RIFLE SR1  
PREMIUM DESIGN



Modular construction: easily dismantled for cleaning and transport.



Driven hunt scope rail: prepared for different mounts.



Stock wedges: cast and drop self-adjusted.



Adjustable luminous front sight for unfavourable light conditions.

## SEMIAUTOMATIC RIFLE SR1 BASIC

# A ROBUST TOOL

The SR1 uses tried-and-tested technologies – the design principle has proven itself time and time again. The self-cleaning system of the gas-pressure self-loader with rotary bolt head allows the reliable use of a wide range of ammunition. Intelligent release: The charging handle does not have to spring forwards loudly when the cartridge is fed in for the first time – instead, it is pushed quietly into the forward position. The Basic version is a robust tool for everyday hunting – with a wooden shaft either in plain or camouflage design.



**SELFLOADING RIFLE SR1:** gas selfloading system | solid rotary bolt head with 6 locking lugs | safety automatic - shot release with locked action only | free floating precision barrel | driven hunt sight | butt stock with straight stock back | rubber recoil pad

**Caliber:** .223 Rem., 7x64, .308 Win., .30-06, 8x57IS, 9,3x62, .300 Win. Mag. **MAGAZINE:** 2 and 5 shots (standard caliber), 2 rounds (Magnum caliber) **BARREL LENGTH:** 50 cm (Magnum: 51 cm) **OVERALL LENGTH** app. 106 cm (Magnum: ca. 107 cm) **WEIGHT:** app. 3,1 kg **WOOD CLASS:** basic wood class 1



SEMIAUTOMATIC RIFLE SR1  
BASIC MODEL | WOOD CLASS 2



SEMIAUTOMATIC RIFLE SR1  
BASIC MODEL | CAMOUFLAGE

SEMIAUTOMATIC RIFLE SR1 STANDARD | SR1 PREMIUM

## ESPRIT OF THE GUN MAKER

The premium version of the SR1 uses tried-and-tested technology – both in the optimised design and with the option of easy disassembly. This SR1 can be rapidly disassembled down to packing dimensions comparable with single shot rifles, and all in a few simple steps and without the need for tools. All operating elements impress thanks to their optimal ergonomics – operation with gloves also poses no problems. This is essential for a rifle that has been tested for correct functionality down to -25 °C in the cold chamber.



■ **SELFLOADING RIFLE SR1:** gas selfloading system | solid rotary bolt head with 6 locking lugs | safety automatic - shot release with locked action only | free floating precision barrel | driven hunt sight | butt stock with straight stock back | adjustable drop and cast off | rubber recoil pad

**Caliber:** .223 Rem., 7x64, .308 Win., .30-06, 8x57IS, 9,3x62, .300 Win. Mag. **MAGAZINE:** 2 and 5 shots (standard caliber), 2 rounds (Magnum caliber) **BARREL LENGTH:** 50 cm (Magnum: 51 cm) **OVERALL LENGTH** app. 106 cm (Magnum: ca. 107 cm) **WEIGHT:** app. 3,2 kg **WOOD CLASS:** basic wood class 1



SEMIAUTOMATIC RIFLE SR1  
STANDARD MODEL | WOOD CLASS 3



SEMIAUTOMATIC RIFLE SR1  
PREMIUM MODEL | WOOD CLASS 5

SR1 KEILER GOLD SEMIAUTOMATIC RIFLE | SR1 JAGD

## PRACTICALLY AESTHETIC

The SR1 sets new standards in precision. The free-floating Suhl barrel and design of the gas extraction system ensure optimal shooting performance, even when the barrel is hot. The SR1 combines this modern functionality with the use of select stock wood or hand-finished engraving. A two-tone system assembly is also available to give this high-performance hunting rifle an individual touch.



■ **SELFLOADING RIFLE SR1:** Gas selfloading system | solid rotary bolt head with 6 locking lugs | safety automatic - shot release with locked action only | free floating precision barrel | driven hunt sight | butt stock with straight back | adjustable drop and cast off | rubber recoil pad

**CALIBER:** .223 Rem., 7x64, .308 Win., .30-06, 8x57IS, 9,3x62, .300 Win. Mag. **MAGAZINE:** 2 and 5 shots (standard caliber), 2 rounds (Magnum caliber) **BARREL LENGTH:** 50 cm (Magnum: 51 cm) **OVERALL LENGTH:** ca. 106 cm (Magnum: ca. 107 cm) **WEIGHT:** ca. 3,2 kg **WOOD CLASS:** basic wood class 4



SEMIAUTOMATIC RIFLE SR1  
KEILER GOLD MODEL



SEMIAUTOMATIC RIFLE SR1  
JAGD MODEL

BOLT ACTION RIFLE KR1



BOLT ACTION RIFLE  
CUSTOM MODEL



BOLT ACTION RIFLE KR1

## CHARACTERISTICS



BOLT ACTION RIFLE KR1  
CUSTOM MODEL



■ Good traveller: compact transport dimensions, easy to disassemble.



■ Unloading pull the plate down and remove the magazine.



■ Rotary bolt head: solid and tested to 8,000 bar.



■ Easy reloading: despite the scope the loading port is free.

BOLT ACTION RIFLE KR1 BASIC | KR1 TRACKING

## PLAIN ELEGANCE

Purists value its functionality – and even the basic version of the Merkel bolt action rifle offers functionality in abundance. All technical options and functions are available. The rifle is easy to disassemble with compact transport dimensions. Changing calibres is easy by interchanging the barrel and, where necessary, the magazine and locking bolt head. The extra-short “Tracking” version is optimised for tracking in difficult terrain.



■ **BOLT ACTION KR1:** Bolt head with six locking lugs with small opening angle | three position safety on the tang | combination trigger with set | magazine capacity 3+1 (2+1 for magnum calibres) | Straight stock with pistol grip, without cheek piece | rubber recoil pad

**CALIBER GROUP Short:** .222 Rem., .223 Rem **Standard:** 6,5x55SE, .270 Win., .308 Win., .30-06, 7x64, 7mm-08 Rem., 8x57IS, 9,3x62 **Magnum:** 7mm Rem. Mag., .270 WSM, .300 WSM, .300 Win. Mag., .338 Win. Mag. **BARREL LENGTH:** 51,5; 56,5; 61,5 cm **OVERALL LENGTH:** Approx. 98 cm for 51,5 cm barrel length **WEIGHT:** app. 2,9 kg **WOOD CLASS:** basic wood class 1

■ **BOLT ACTION KR1 TRACKING:** laminated straight stock, detachable swing swivels, 45 cm short barrel with driven hunt sights, caliber .308 Win., .30-06, 8x57IS, 9,3x62



**BOLT ACTION KR1**  
BASIC DESIGN | WOOD CLASS 4



**BOLT ACTION KR1**  
TRACKING MODEL | LAMINATE STOCK

BOLT ACTION RIFLE RX.HELIX



BOLT ACTION RIFLE  
CUSTOM MODEL PARFORCE



BOLT ACTION RIFLE RX.HELIX

## CHARACTERISTICS



Barrel and calibre change without tools (Take-Down).



Solid bolt head with six locking lugs.



BOLT ACTION RIFLE RX.HELIX  
CUSTOM MODEL *UKRAINE*



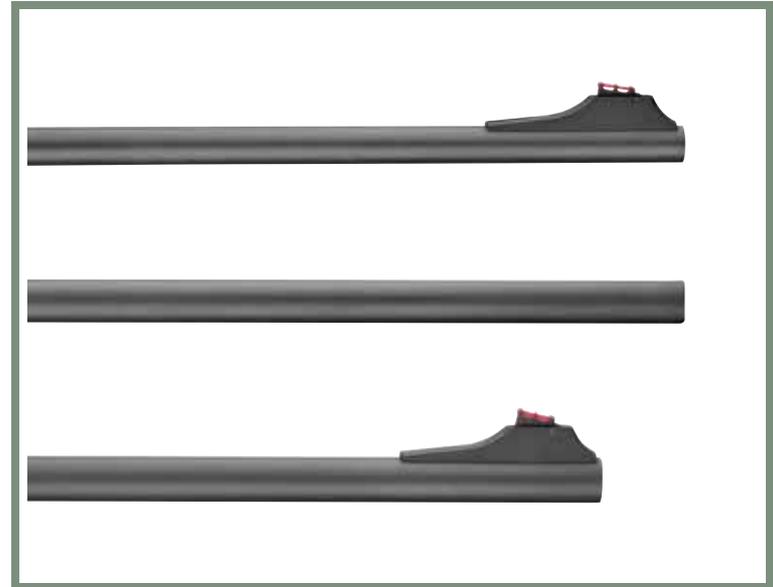
■ Linear bolt action rifle, closed system housing, manual cocking lever.



■ Integrated Picatinny rail for all standard mounts.



■ High reserves: 5+1 magazine (for std. caliber) or 3+1 magazine.



■ Cold-forged barrels – normal (top) or semi-weight.

BOLT ACTION RIFLE RX.HELIX BLACK | RX.HELIX EXPLORER

## THE INTUITIVE RIFLE

The Helix is the latest bolt action rifle in the MEM range from Merkel – it combines state-of-the-art hunting rifle construction with functions that set new standards. The true linear bolt action rifle works blindingly fast with a transmission unit. Neither the bolt handle nor the cylinder breech move towards the shooter's eye – the system housing is closed at the rear. This creates perfect conditions for bolt action shooting.



■ **BOLT ACTION RIFLE RX.HELIX BLACK:** Solid bolt head with six locking lugs | Manual cocking | Direct trigger | Magazine capacity 3+1 (standard and magnum) or 4+1 (mini) | Take-Down without tools | Straight stock with cheek piece and rubber buttpad

**CALIBRE GROUPS:** Mini: .222 Rem.; .223 Rem. **Standard:** .243 Win.; 6.5x55 SE; .270 Win.; 7x64; .308 Win.; .30-06; 8x57 IS; 9.3x62 **Magnum:** 7 mm Rem. Mag.; .300 Win. Mag.

**BARREL LENGTHS:** 56 cm Standard (Magnum: 61 cm; Short: 51 cm) **TOTAL LENGTH:** Approx. 107 cm (for barrel length of 56 cm) **WEIGHT:** Approx. 2.9 kg **WOOD CLASS:** From 2

■ **BOLT ACTION RIFLE RX.HELIX EXPLORER:** as "Black", with synthetic-compound stock



BOLT ACTION RIFLE RX.HELIX  
DESIGN *BLACK* | WOOD CLASS 4



BOLT ACTION RIFLE RX.HELIX  
DESIGN *EXPLORER* | SYNTHETIC-COMPOUND STOCK

BOLT ACTION RIFLE RX.HELIX ARABESQUE | RX.HELIX WILD BOAR

## TAKE-DOWN AS STANDARD

The Helix has been developed for modern-day hunting – and for hunting trips. Take-Down without tools is available as standard. Thanks to the bolt-barrel action, the Helix can be disassembled without tools and the calibre can also be changed without tools at the blink of an eye. The disassembled rifle is only fractionally larger than a briefcase, thus making it ideal for discreet trips to the world's most attractive hunting grounds.



■ **BOLT ACTION RIFLE RX.HELIX ARABESQUE:** Solid bolt head with six locking lugs | Manual cocking | Direct trigger | Magazine capacity 3+1 (standard and magnum) or 4+1 (mini) | Take-Down without tools | Straight stock with cheek piece and rubber buttpad | with arabesque engraving

**CALIBRE GROUPS:** **Mini:** .222 Rem.; .223 Rem. **Standard:** .243 Win.; 6.5x55 SE; .270 Win.; 7x64; .308 Win.; .30-06; 8x57 IS; 9.3x62 **Magnum:** 7 mm Rem. Mag.; .300 Win. Mag.

**BARREL LENGTHS:** 56 cm Standard (Magnum: 61 cm; Short: 51 cm) **TOTAL LENGTH:** Approx. 107 cm (for barrel length of 56 cm) **WEIGHT:** Approx. 2.9 kg **WOOD CLASS:** From 4

■ **BOLT ACTION RIFLE RX.HELIX WILD BOAR:** as "Arabesque" with wild boar engraving



BOLT ACTION RIFLE RX.HELI  
DESIGN ARABESQUE | WOOD CLASS 6



BOLT ACTION RIFLE RX.HELI  
DESIGN WILD BOAR | WOOD CLASS 6

BOLT ACTION RIFLE RX.HELIX SPIRIT | RX.HELIX DELUXE

## SAFE AND ERGONOMIC

The Helix has everything that a modern straight-pull bolt action rifle should offer – and much more besides. The Helix system is comprised of a rotary bolt head with locking lugs, thus ensuring maximum safety for the shooter. The manual cocking lever combines safety and cocking functions, and offers optimal protection against accidental shot firing. In addition, the bolt-barrel action also enables easy removal of the bolt head – and thus the highest possible protection against unauthorised use of the rifle.



■ **BOLT ACTION RIFLE RX.HELIX SPIRIT:** Solid bolt head with six locking lugs | Manual cocking | Direct trigger | Magazine capacity 3+1 (standard and magnum) or 4+1 (mini) | Take-Down without tools | Straight stock with cheek piece and rubber buttpad | with choice of two animal motifs and edging

**CALIBRE GROUPS:** **Mini:** .222 Rem.; .223 Rem. **Standard:** .243 Win.; 6.5x55 SE; .270 Win.; 7x64; .308 Win.; .30-06; 8x57 IS; 9.3x62 **Magnum:** 7 mm Rem. Mag.; .300 Win. Mag.

**BARREL LENGTHS:** 56 cm Standard (Magnum: 61 cm; Short: 51 cm) **TOTAL LENGTH:** Approx. 107 cm (for barrel length of 56 cm) **WEIGHT:** Approx. 2.9 kg **WOOD CLASS:** From 5

■ **BOLT ACTION RIFLE RX.HELIX DELUXE:** as "Spirit", but with choice of three animal motifs and edging, from wood class 6



BOLT ACTION RIFLE RX.HELIX  
DESIGN SPIRIT | WOOD CLASS 6



BOLT ACTION RIFLE RX.HELIX  
DESIGN DELUXE | WOOD CLASS 9

# ENGRAVING





## ENGRAVING

# THE MAGIC OF ENGRAVING

Hunting, magic and art have been inextricably linked from the beginning. It could be that it was hunting that inspired people to make art. And it was art that became the implement of magic during the hunt. Since then works of art have magically evoked hunting success which was a necessity of life – specialists speak of “symbolic magic”.

The result of the hunt is demonstrated and anticipated in symbols. The hunters paint the animal on the cave walls, to enchant it, so to speak. Prehistoric men symbolically threw the spear at the cave wall paintings and believed their weapons would hit the animal when the hunt was for real.

The engraving of the rifle emanates from the tradition of the symbolic magic. Two main categories of motifs can be identified: stylised tendrils – called arabesques. And the naturalistic motifs, according to Dürer, the so-called nature or animal motifs.

The first stage of the engraving work is transcribing the outline onto the

workpiece. This requires a trained eye, scribe and steel compasses. The actual engraving is a metal-shaving technique. It is performed with a light hammer and graver. Gravers are fine chisels in various thickness with shaped blades and wooden handles.

The workpiece is clamped in 360 degree rotating vice for processing. Fine shading is cut with a hand graver, used without a hammer and driven only by the strength of the engraver. In Italian this graver is called “bulino” – this gives the name to this art form with the graver.

Files in various forms and cut levels as well as abrasive cloth in different grains round off the range of tools used by the engraver. There is a diversity of other ornamentation form around engraving: colour case hardening, gold or silver inlaying, punching or chasing and inlaying with various precious materials.

Over 15 male and female engravers – each one a master of the trade and experienced in all the engraving disci-

plines – decorate Merkel hunting rifles to make them unique specimens.



Decorated pistol grip cap.



Suhl "Bulino" engraving with chiselled base.



Deep relief engraving with vivid game motifs and leaf ornamentation.



Ornamental engraving "English Arabesque".



Colour case hardening with gold inlays.

## WOOD CLASSES

# FINE WOODS IN ELEVEN CLASSES

Stock wood is a product of nature. The illustrated stocks are representative examples. Variation in colour, grain and wood structure within the quality classes are not only unavoidable, rather an expression of individuality.



WOOD CLASS 1



WOOD CLASS 2



WOOD CLASS 3



WOOD CLASS 4





WOOD CLASS 5



WOOD CLASS 6



WOOD CLASS 7



WOOD CLASS 8



WOOD CLASS 9



WOOD CLASS 10



WOOD CLASS 11

# PUBLISHING DETAILS

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- 3: Shop photo of the photo album the former managing director Kessel |
- 4: Over and under shotgun (DDR Export. Zeitschrift des Außenhandels) |
- 5: August F. Möbius ([http://de.wikipedia.org/wiki/August\\_Ferdinand\\_Möbius](http://de.wikipedia.org/wiki/August_Ferdinand_Möbius)).

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[www.suhl-arms-alliance.de](http://www.suhl-arms-alliance.de)





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