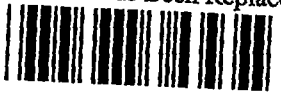
ABSTRACT OF THE DISCLOSURE

Intravenous catheter insertion devices produced by a low cost method of assembling a catheter structure and cannula holder body. Also disclosed is an extruded cannula and blood chamber securement structure. Moreover, there is also provided a novel structure for the realization of simplified extruded catheter insertion devices in which an extruded plastic element is connected with a steel cannula for attachment to a blood chamber or housing to enable a low cost construction rendering the catheter insertion device simple and inexpensive in assembly and construction for economically disposable single usage thereof.

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