Patent claims

1. A process of manufacturing a sabot (2) for a sub-caliber projectile (3), wherein bionic structures (5, 6) are provided in the sabot (2) defined by a 3D manufacturing process and purposefully are created in the manufacturing of the sabot (2), such that the bionic structures are left out in the production.

2. The manufacturing process according to claim 1, **characterized in that** the size, shape and/or volume of the bionic structures (5, 6) are predeterminable.

3. The manufacturing process according to claim 1 or 2, **characterized in that** the number of bionic structures (5, 6) is predeterminable.

4. The manufacturing process according to one of claims 1 to 3, **characterized in that** the 3D manufacturing process is a 3D printing process.

5. The manufacturing process according to one of claims 1 to 3, **characterized in that** the 3D manufacturing process is an SLS.

6. The manufacturing process according to one of claims 1 to 3, **characterized in that** the production takes place by means of 3D cocooner, wherein the bionic structures are created from a handling spinneret.

7. The manufacturing process according to one of claims 1 to 6, **characterized in that** geometric data of the sabot (2) and the sabot segments (2.1, 2.2) are in a three dimensional-form for this and are stored in as layer data.

8. The manufacturing process according to one of claims 1 to 7, **characterized in that** the bionical structures (5, 6) are honeycombs, struts, voids, spherical cavities and combinations thereof.

9. The sabot (2), manufactured according to one of claims 1 to 7.

10. The sabot (2) according to claim 9, **characterized in that** the material of the sabot (2) is a lightweight metal, a metal and/or plastic.

11. The sabot (2) according to one of claims 9 or 10, **characterized in that** the sabot (2) consists of a plurality of segments (2.1, 2.2).

12. The sabot (2) according to claim 11, **characterized in that** the sabot (2) consists of at least two sabot segments (2.1, 2.2).

13. Ammunition (1) with a sabot (2) according to any one of claims 9 to 12 and a sub-caliber projectile (3).