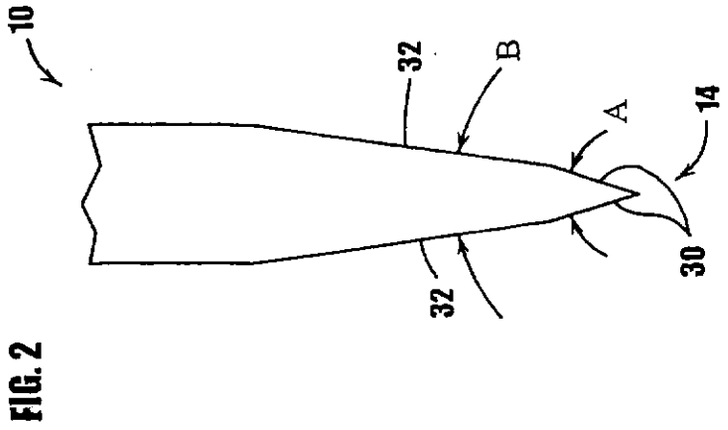


FIG. 2

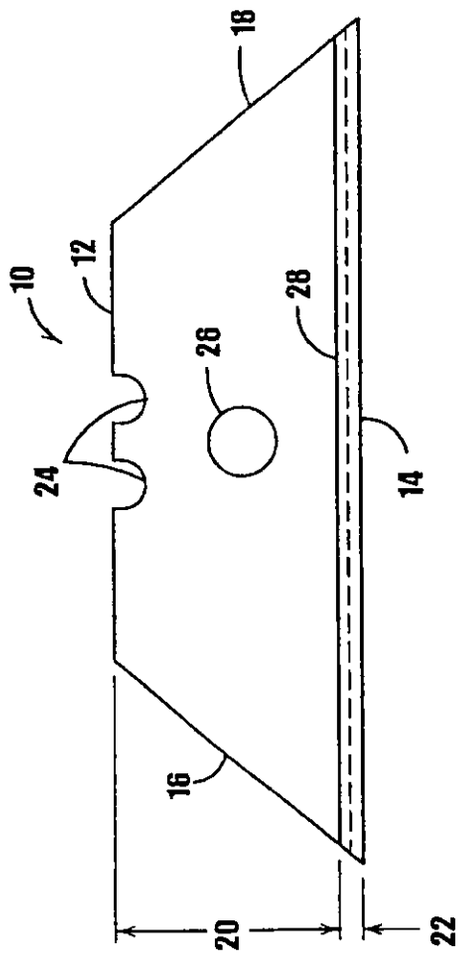


FIG. 1

FIG. 3A

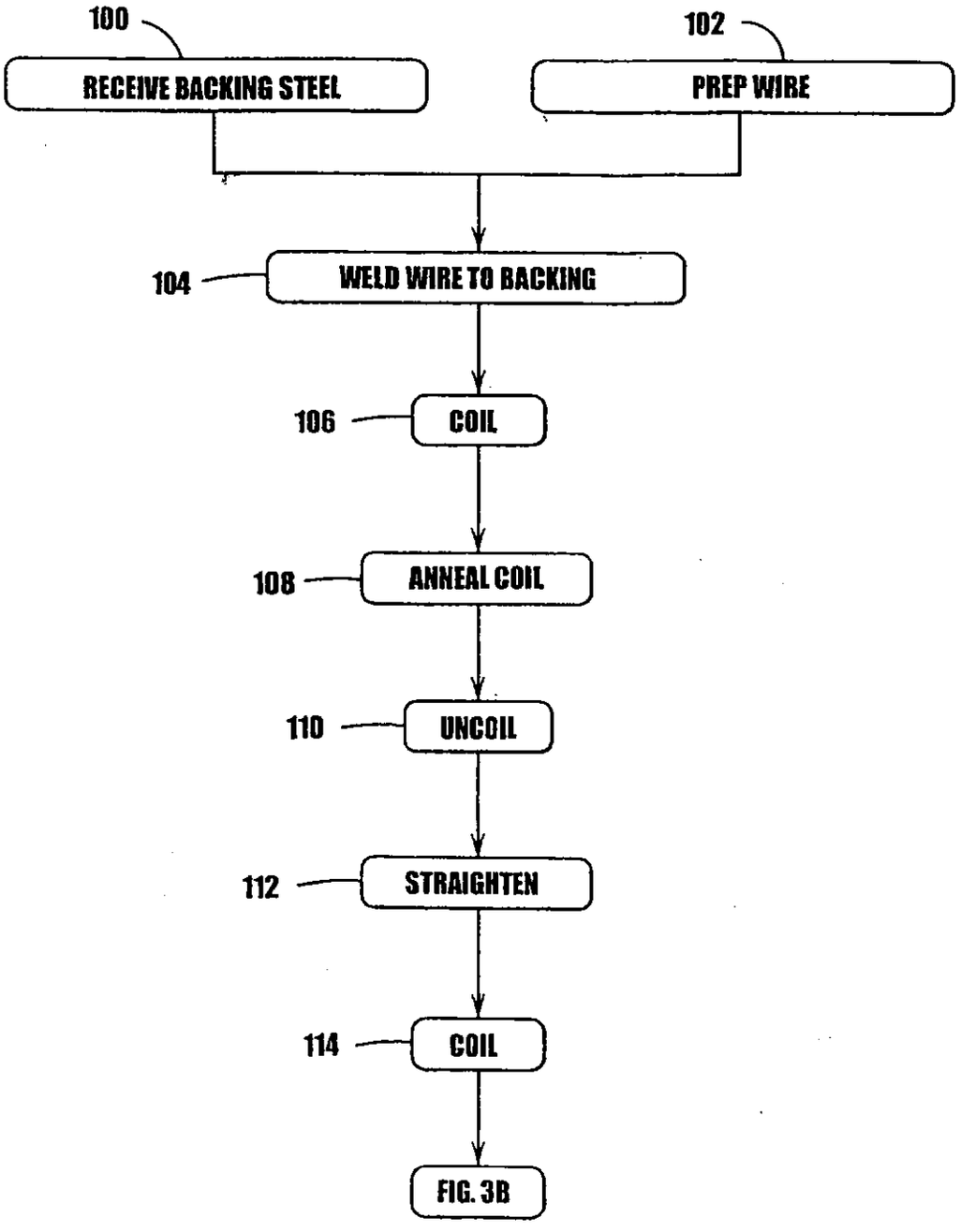

100
RECEIVE BACKING STEEL
102
PREP WIRE
104
WELD WIRE TO BACKING
106
COIL
108
ANNEAL COIL
110
UNCOIL
112
STRAIGHTEN
114
COIL
FIG. 3B

FIG. 3B

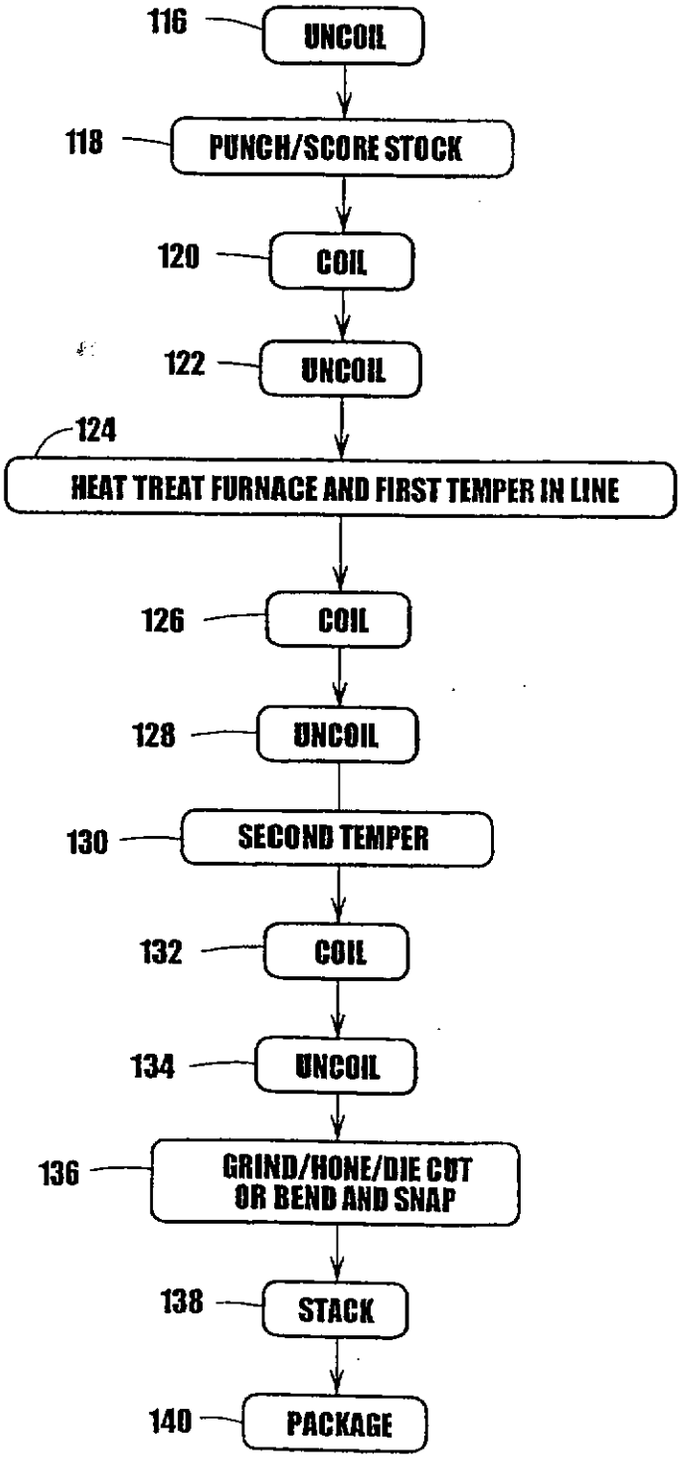

116
UNCOIL
118
PUNCH/SCORE STOCK
120
COIL
122
UNCOIL
124
HEAT TREAT FURNACE AND FIRST TEMPER IN LINE
126
COIL
128
UNCOIL
130
SECOND TEMPER
132
COIL
134
UNCOIL
136
GRIND/HONE/DIE CUT OR BEND AND SNAP
138
STACK
140
PACKAGE

FIG. 4

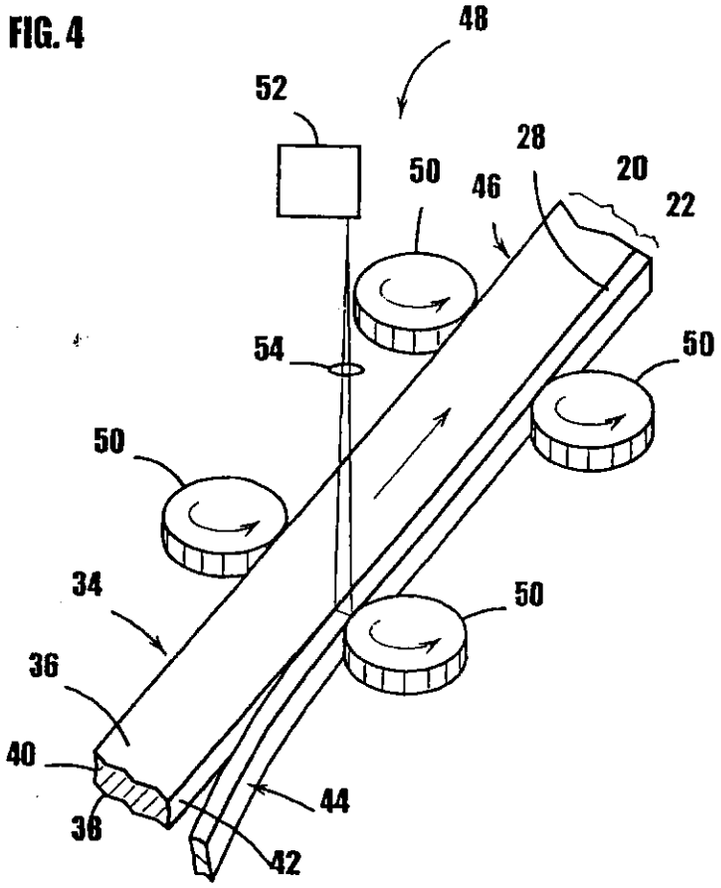


FIG. 5

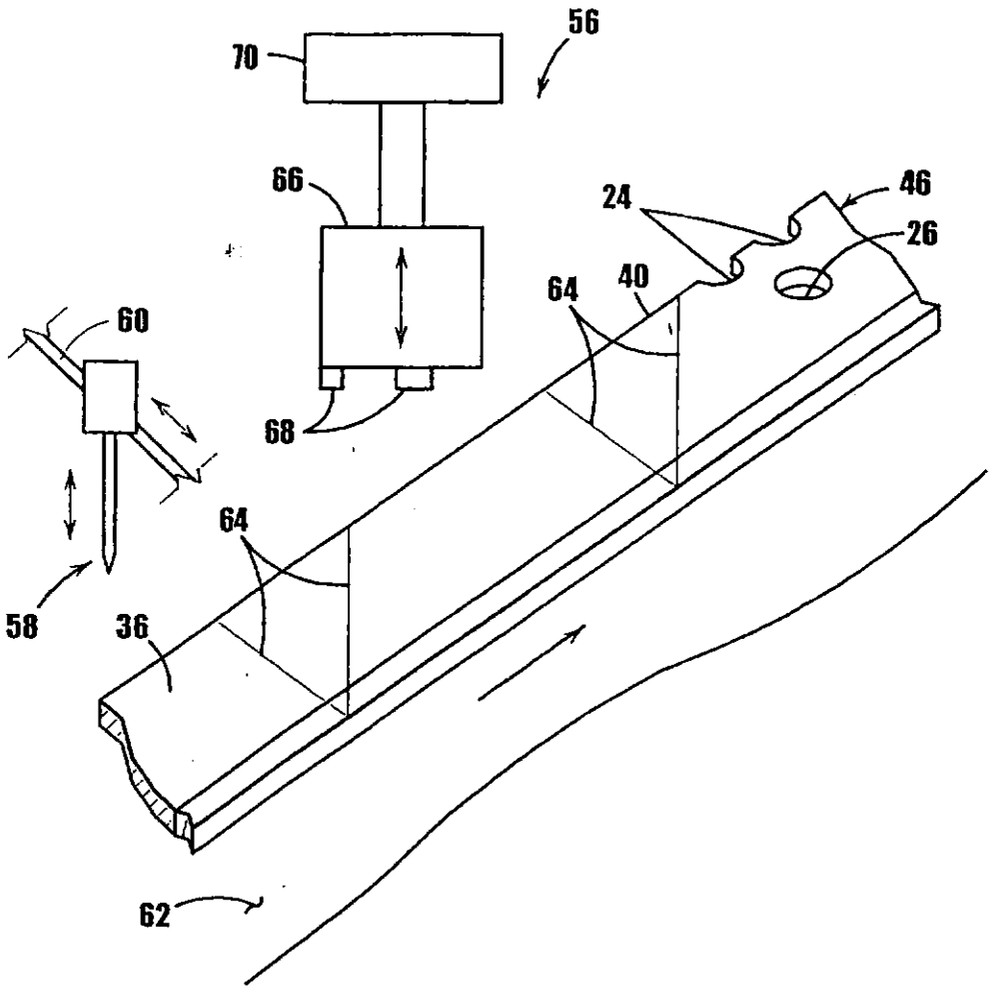


FIG. 6

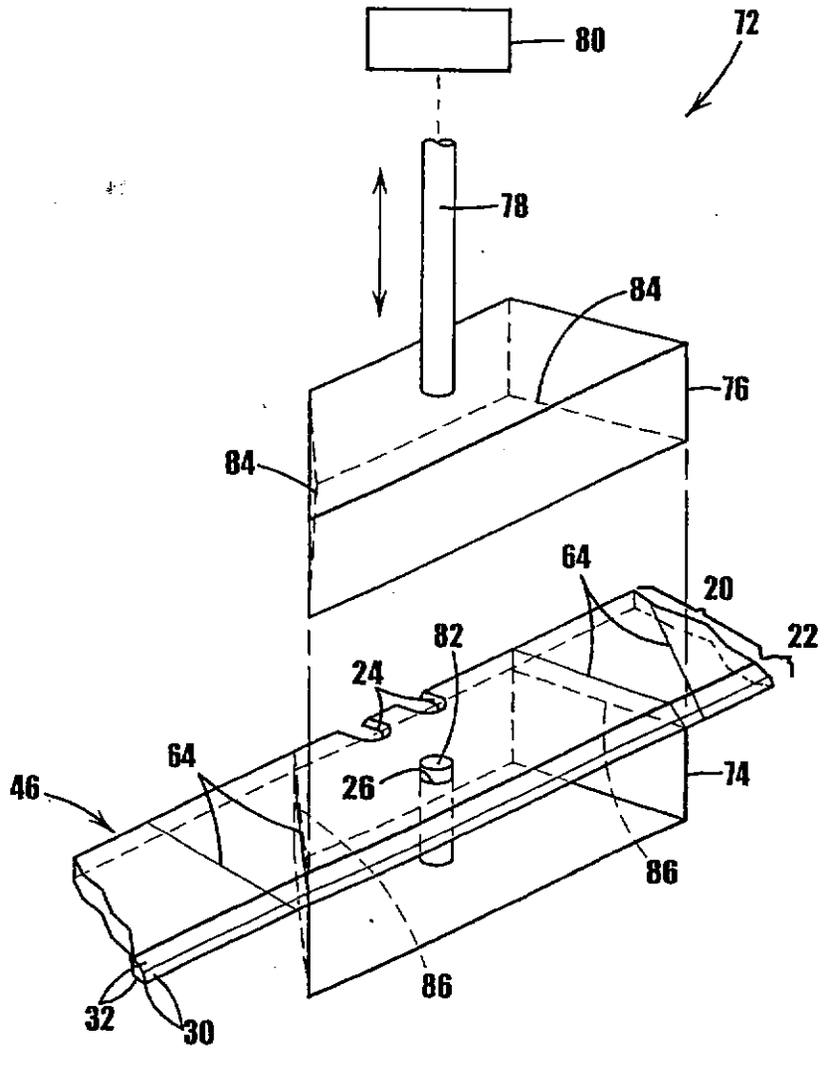
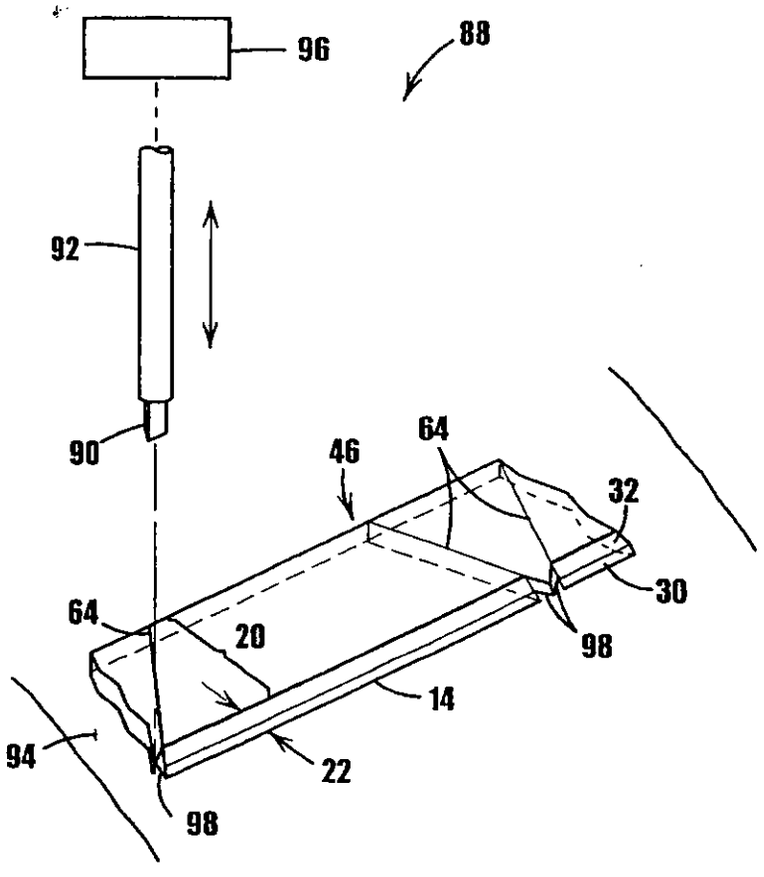


FIG. 7



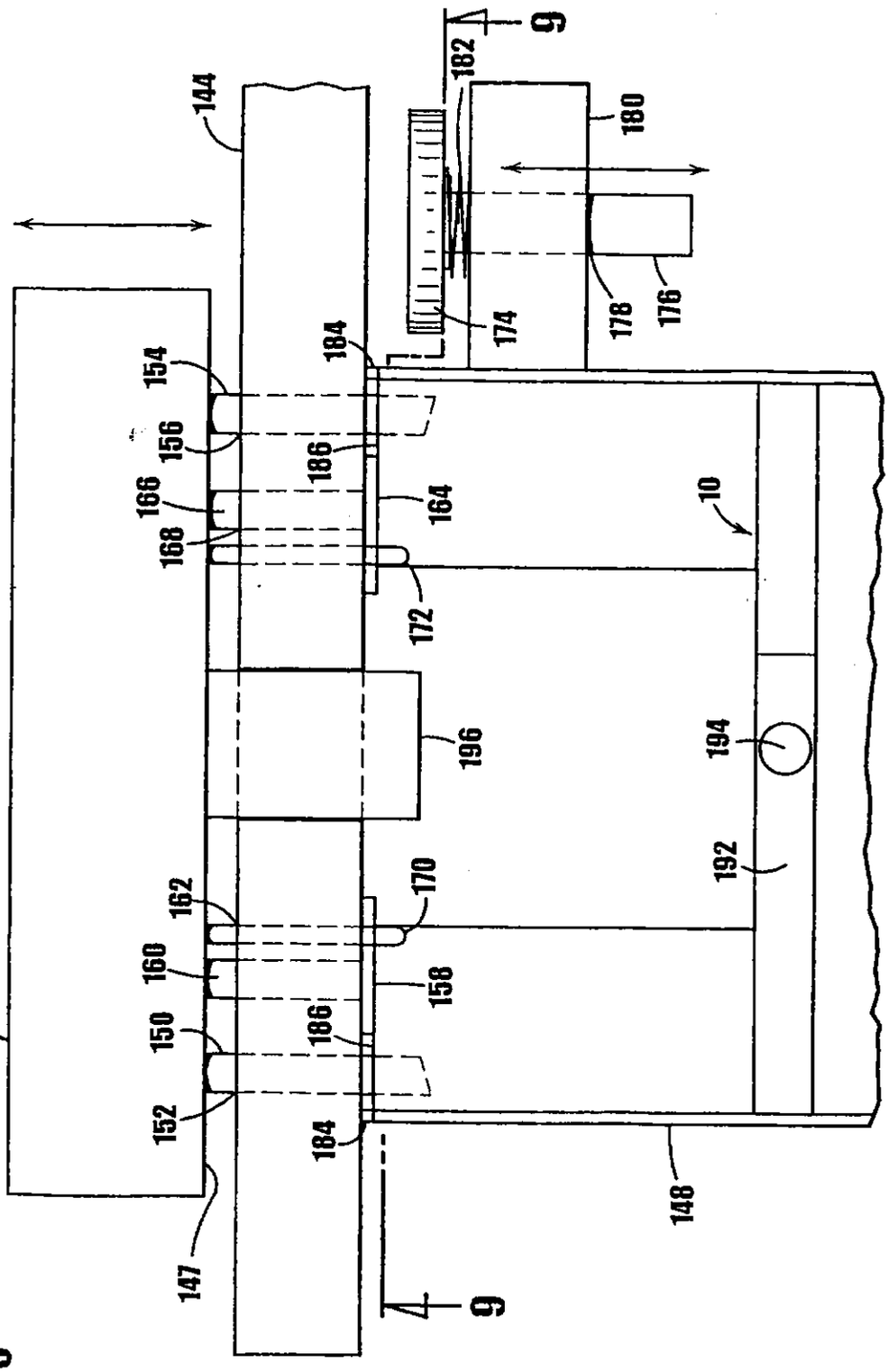

9
182
144
180
174
178
176
184
154
156
186
142
166
164
10
168
172
196
194
192
170
162
160
158
146
150
186
152
184
148
147
9

FIG. 8

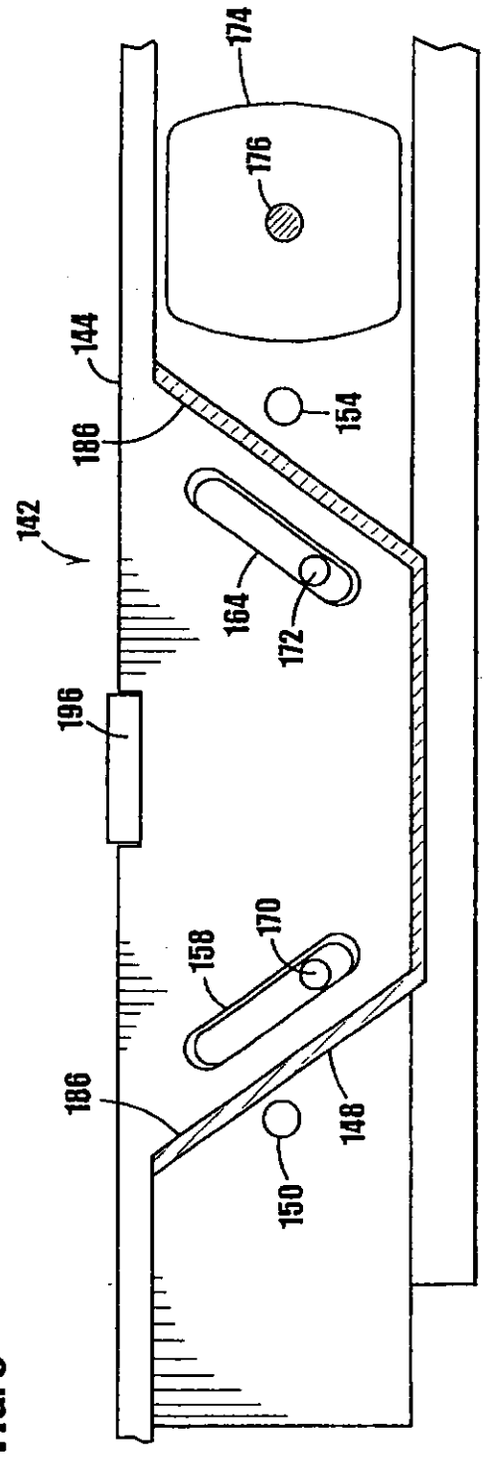


FIG. 9

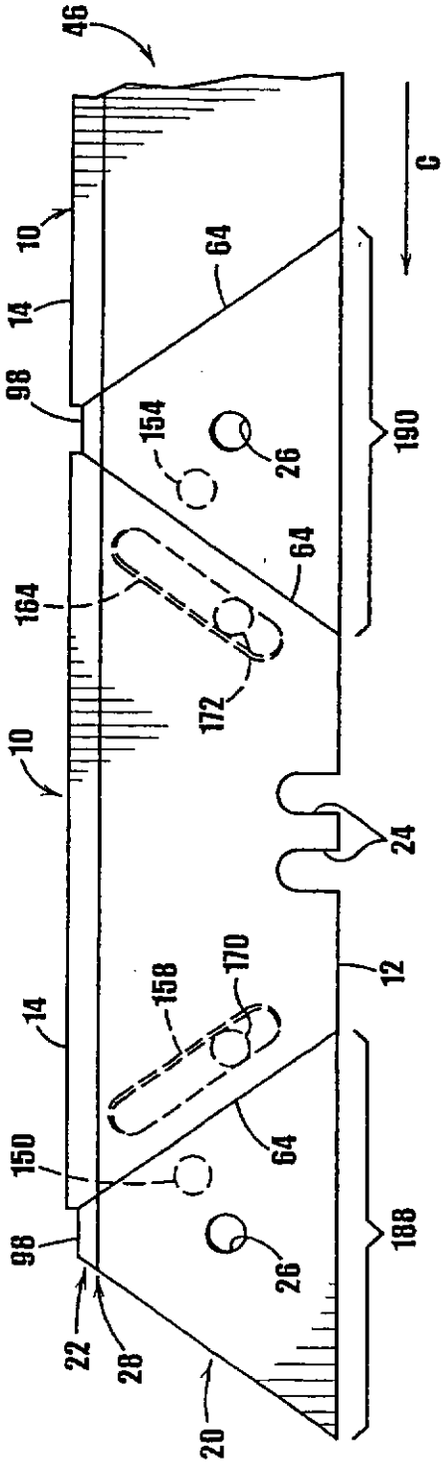

46
10
14
98
154
26
64
190
C
164
172
10
24
12
14
158
170
150
64
98
26
188
22
28
20

FIG. 10

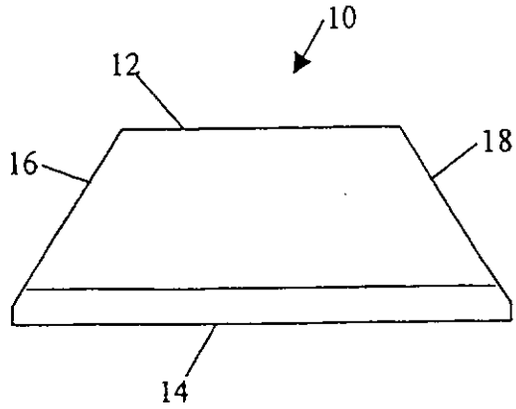


Fig. 11A

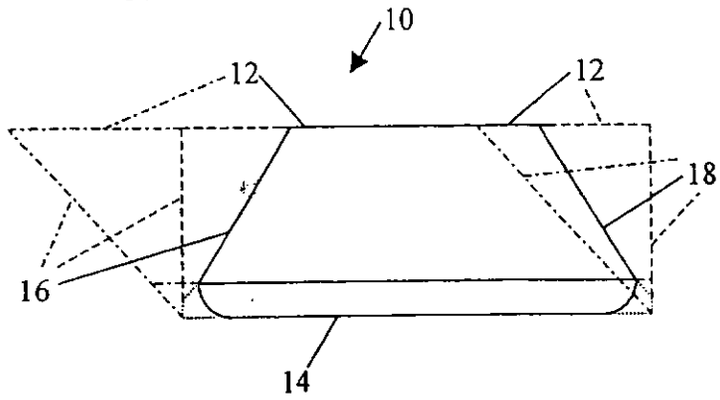


Fig. 11B

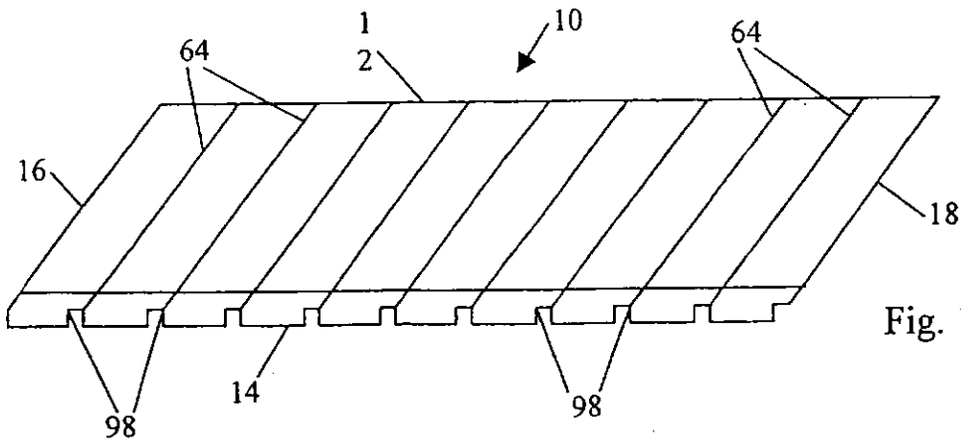


Fig. 11C

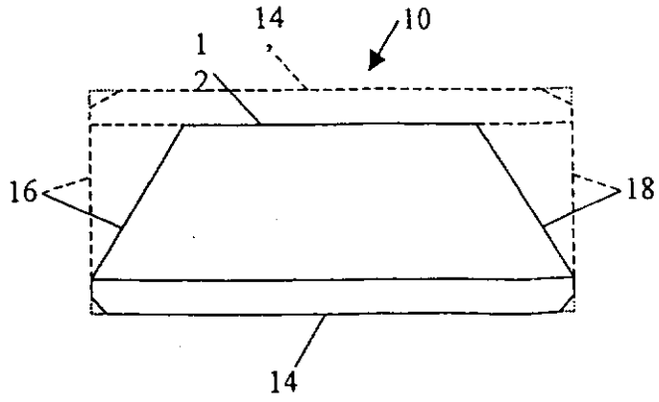


Fig. 11D