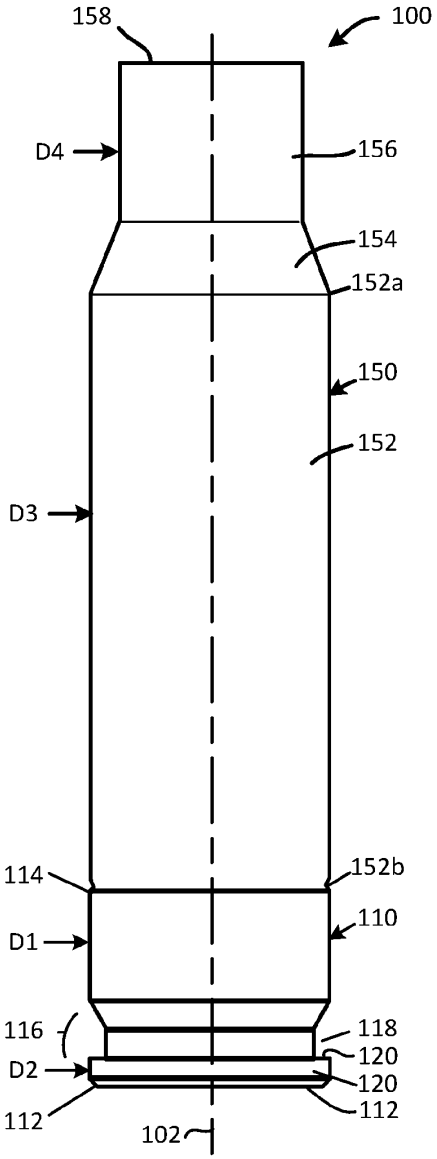


FIG. 1

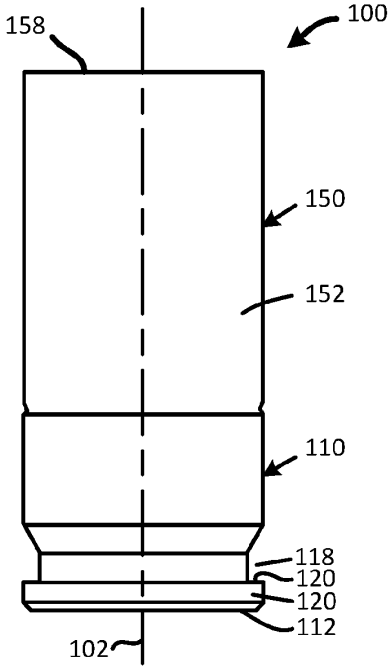


FIG. 2

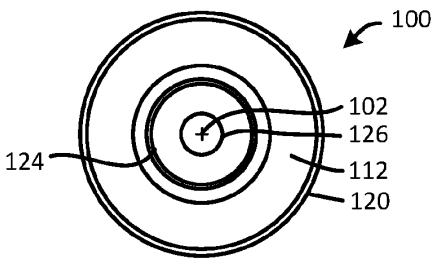


FIG. 3

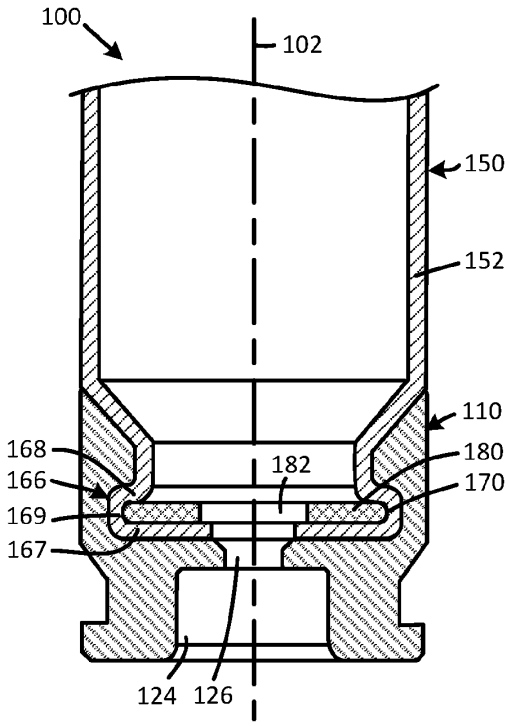


FIG. 4A

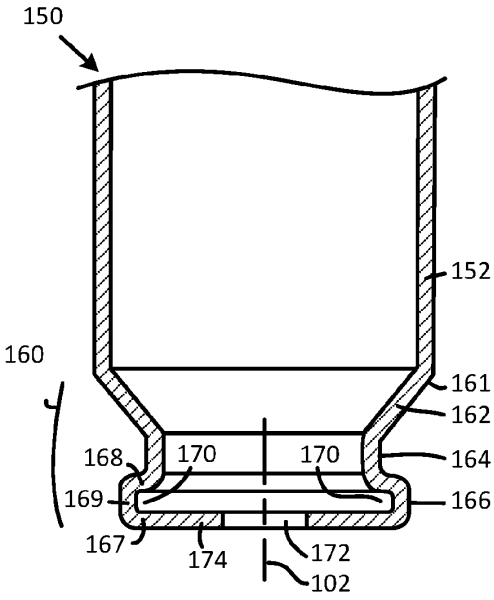


FIG. 4B

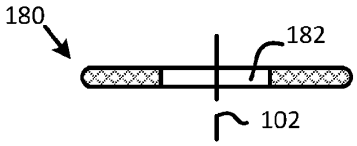


FIG. 4C

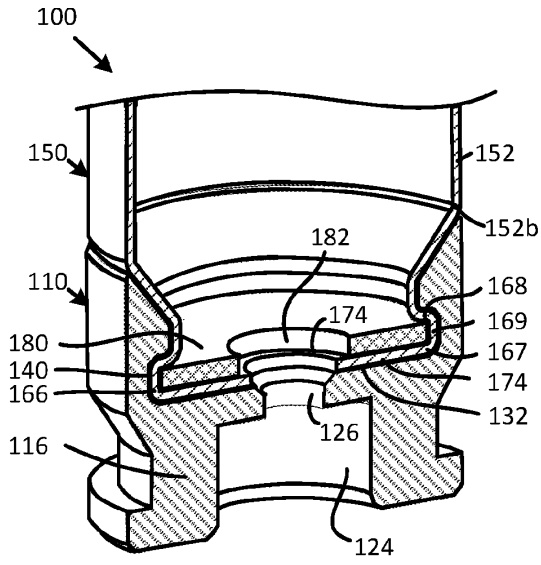


FIG. 4E

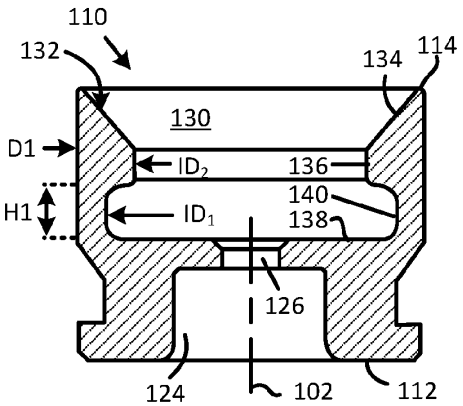


FIG. 4D

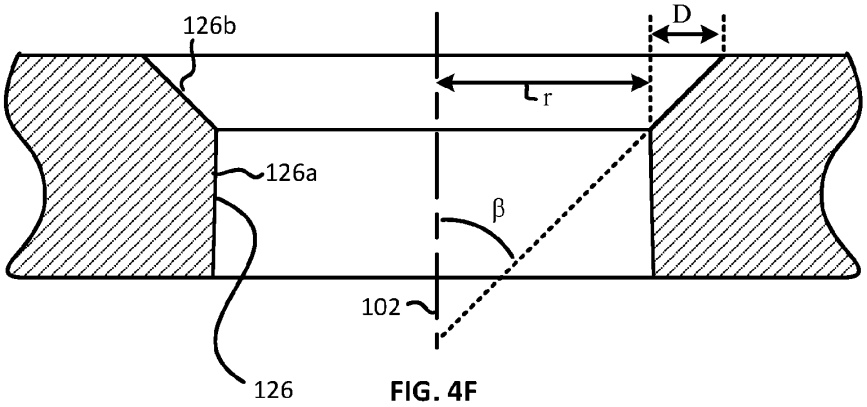


FIG. 4F

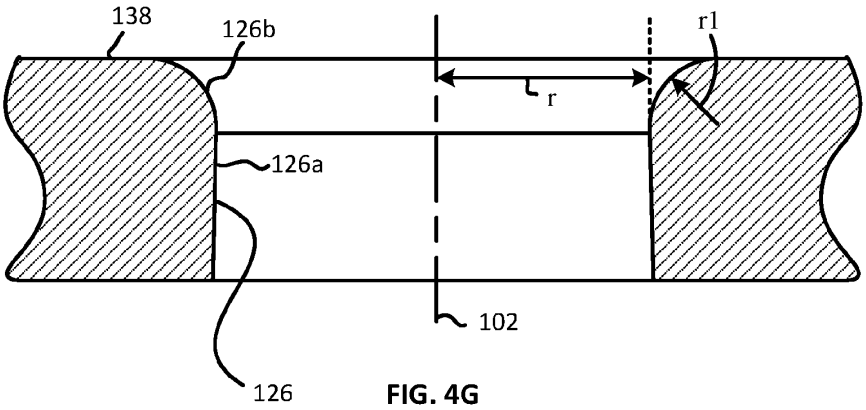


FIG. 4G

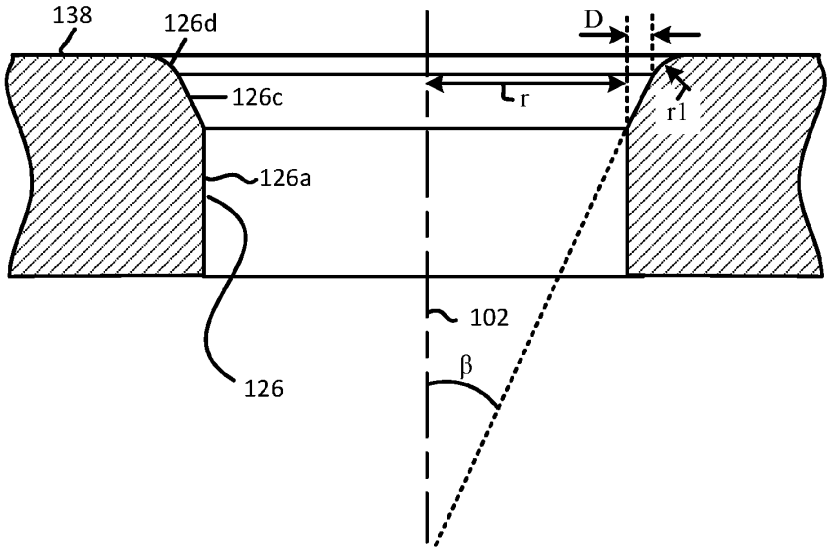


FIG. 4H

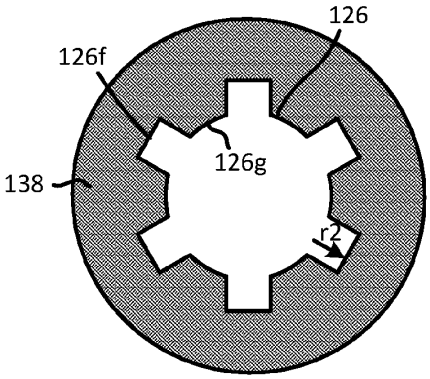


FIG. 4J

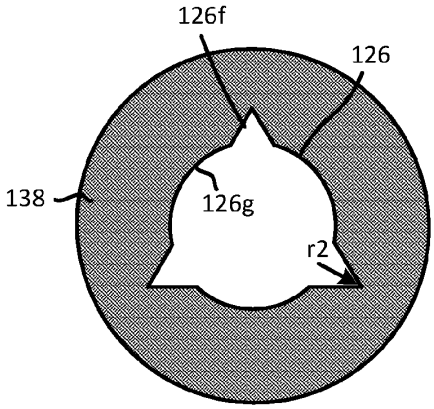


FIG. 4K

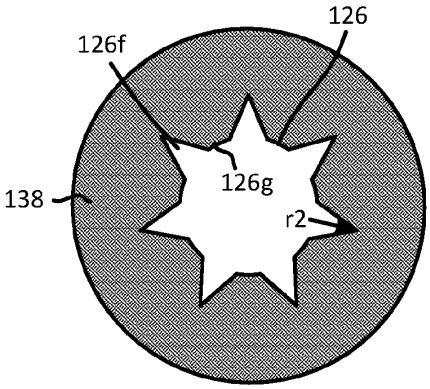


FIG. 4L

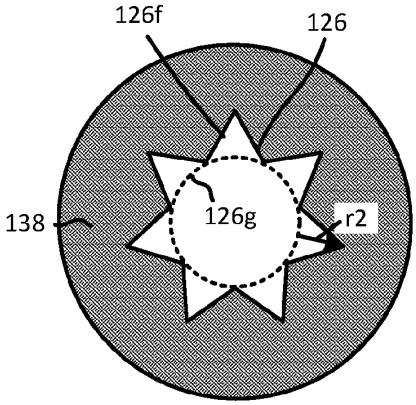


FIG. 4M

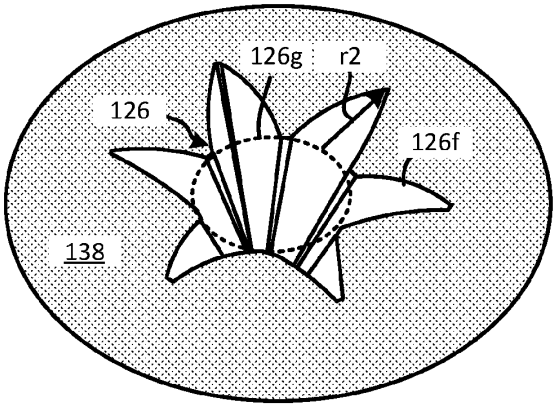


FIG. 4N

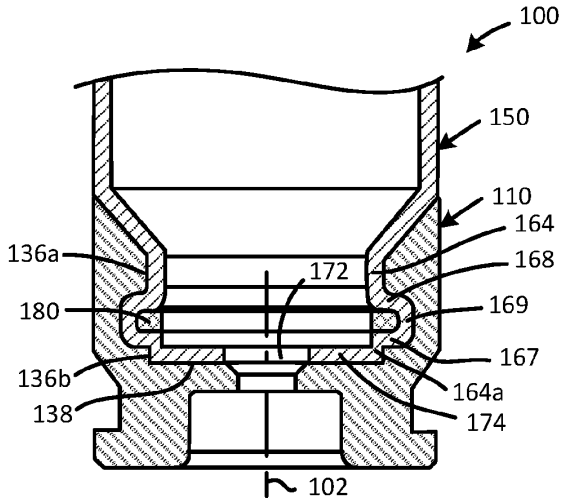


FIG. 5

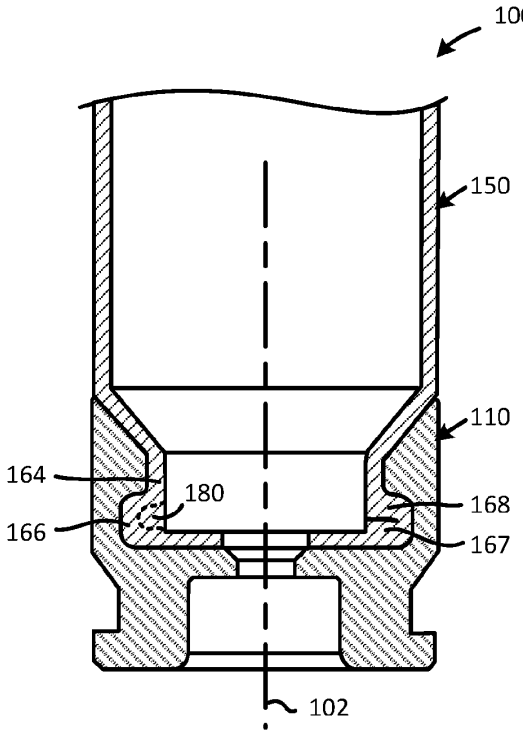


FIG. 6

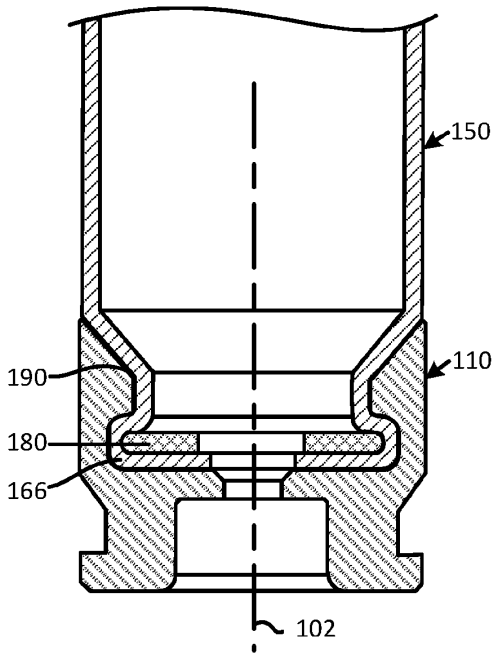


FIG. 7

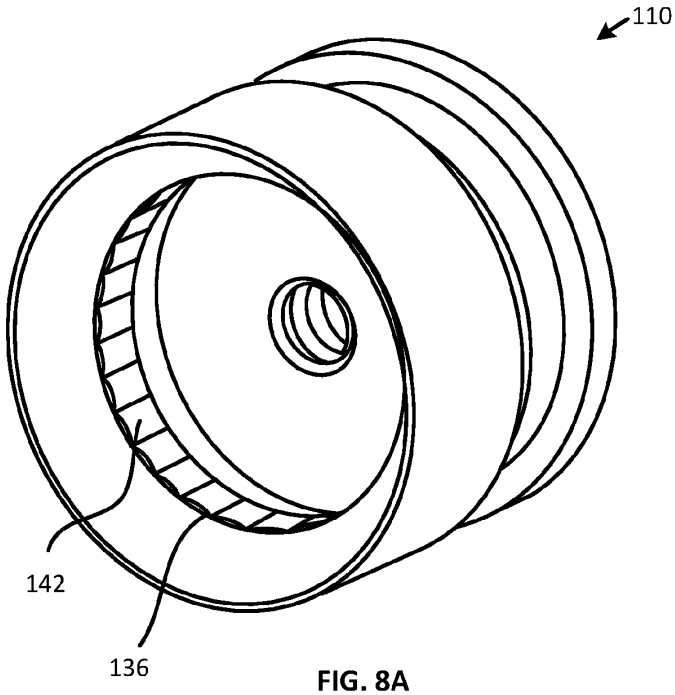


FIG. 8A

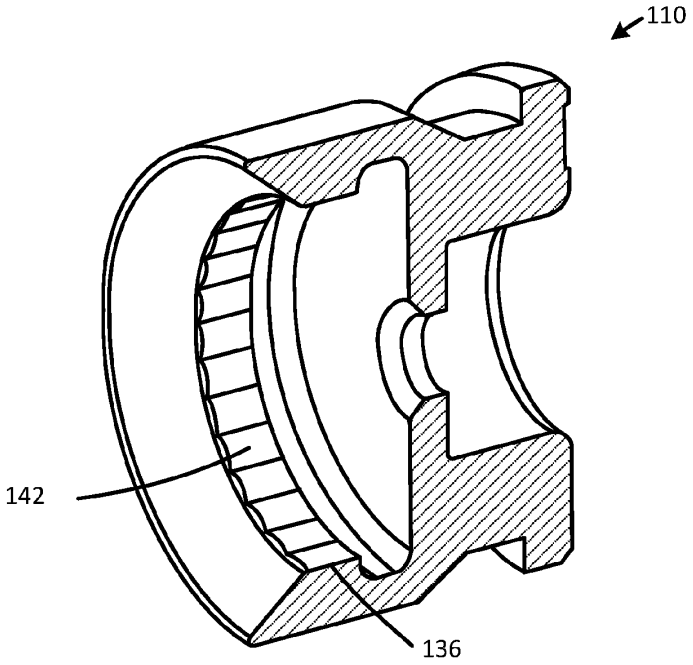


FIG. 8B

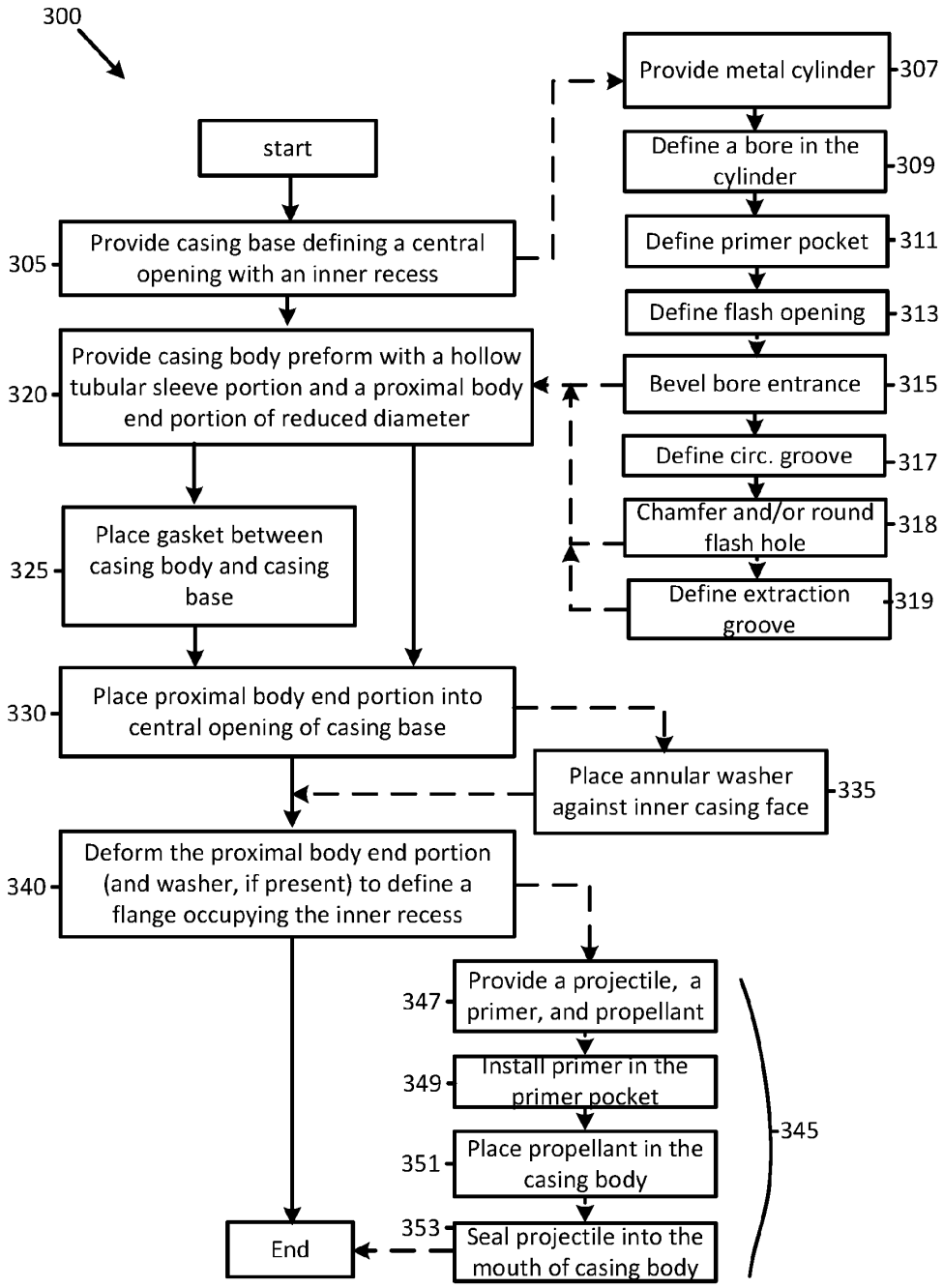

300
start
Provide casing base defining a central opening with an inner recess
305
Provide casing body preform with a hollow tubular sleeve portion and a proximal body end portion of reduced diameter
320
Place gasket between casing body and casing base
325
Place proximal body end portion into central opening of casing base
330
Deform the proximal body end portion (and washer, if present) to define a flange occupying the inner recess
340
End
Provide metal cylinder
307
Define a bore in the cylinder
309
Define primer pocket
311
Define flash opening
313
Bevel bore entrance
315
Define circ. groove
317
Chamfer and/or round flash hole
318
Define extraction groove
319
Place annular washer against inner casing face
335
Provide a projectile, a primer, and propellant
347
Install primer in the primer pocket
349
Place propellant in the casing body
351
Seal projectile into the mouth of casing body
353
345

FIG. 9

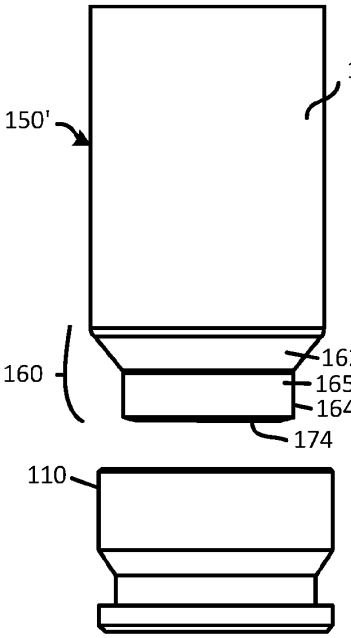


FIG. 10A

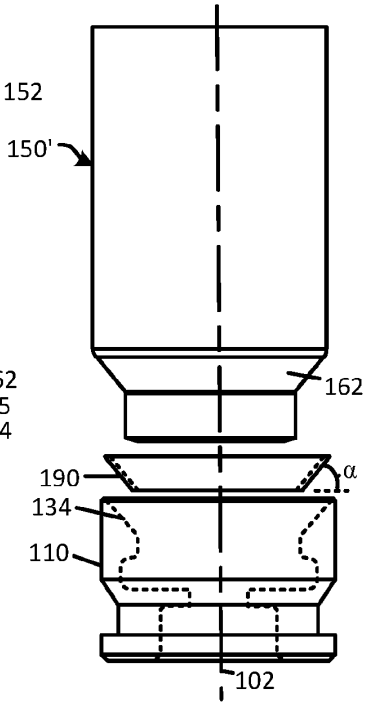


FIG. 10B

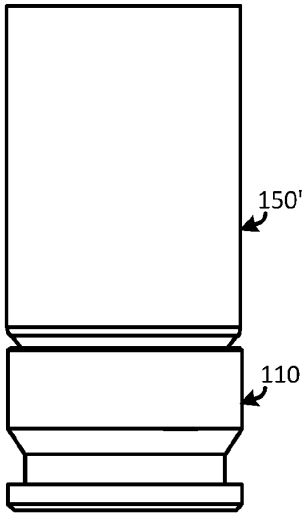


FIG. 11

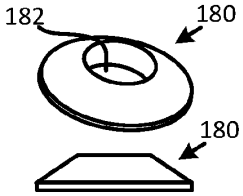


FIG. 12

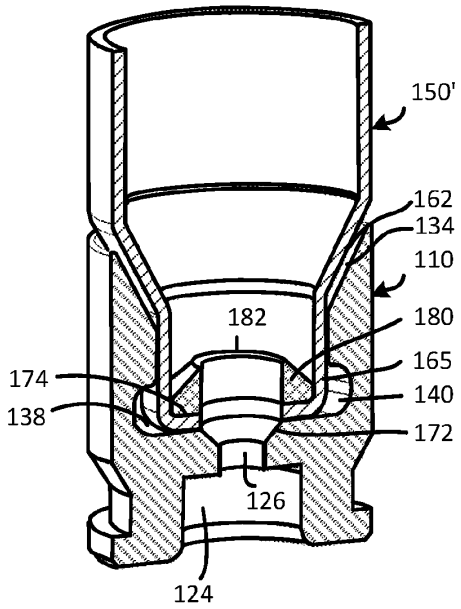


FIG. 13

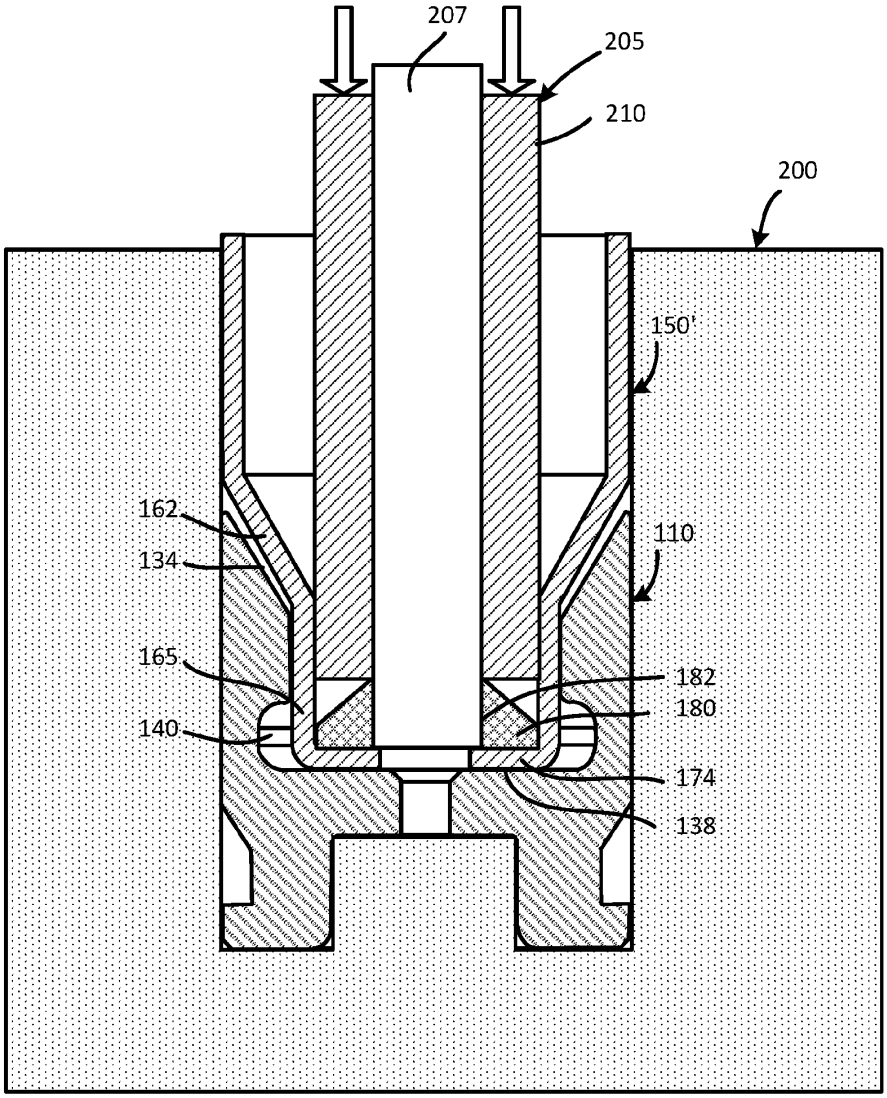


FIG. 14

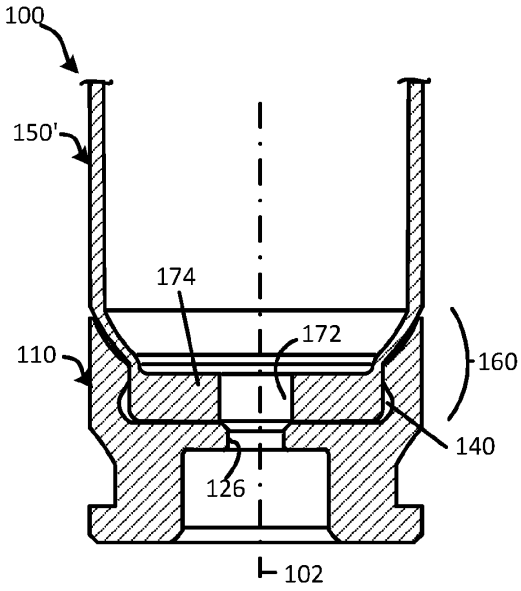


FIG. 15A

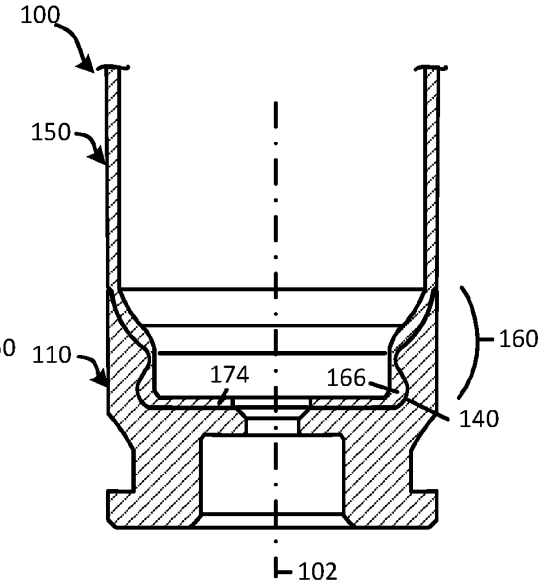


FIG. 15B

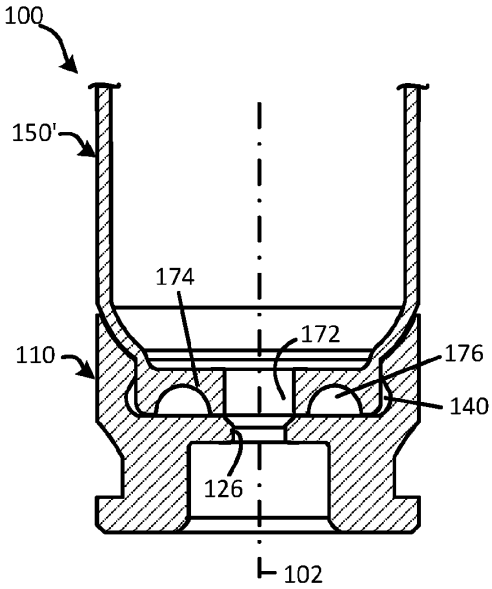


FIG. 16A

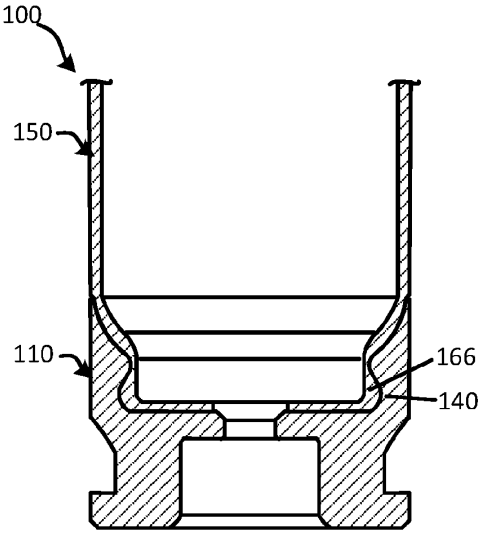


FIG. 16B

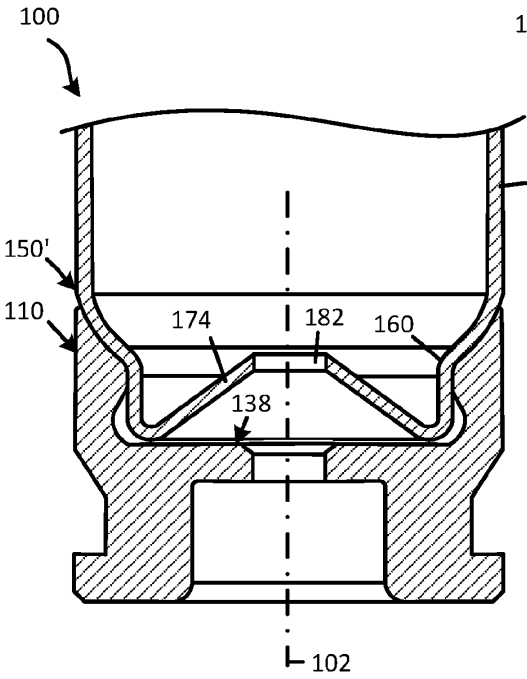


FIG. 17A

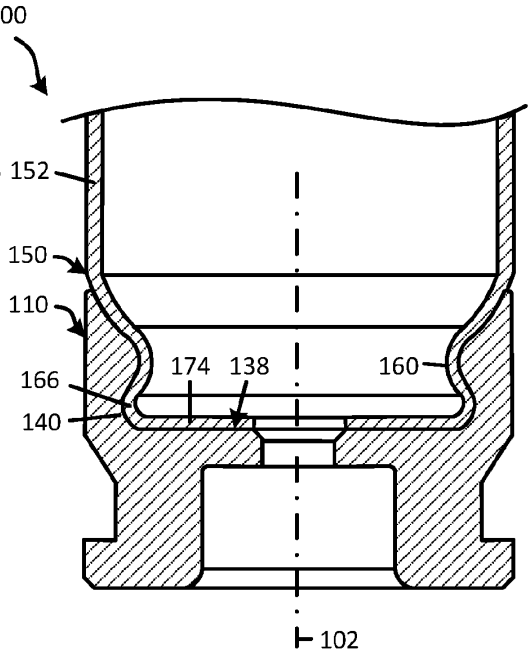


FIG. 17B

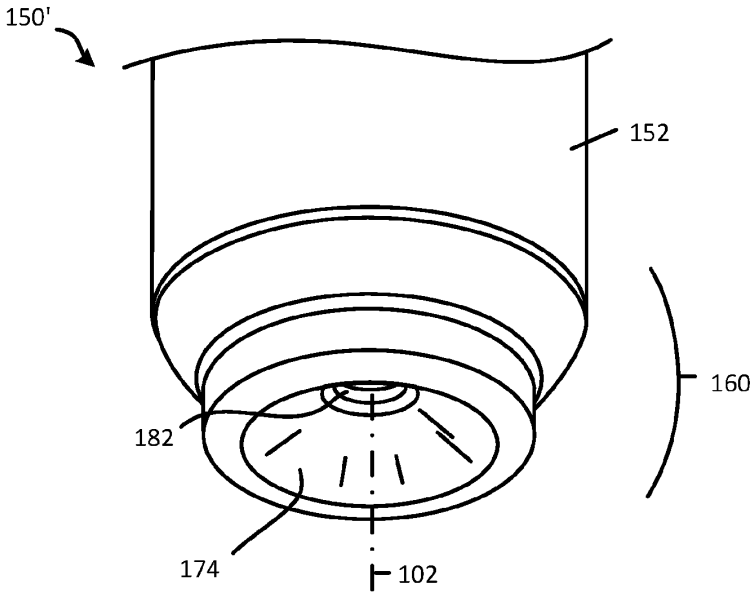


FIG. 17C

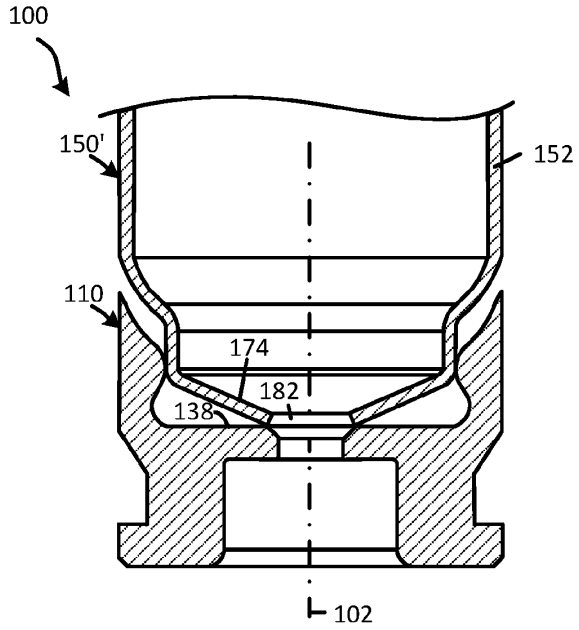


FIG. 18A

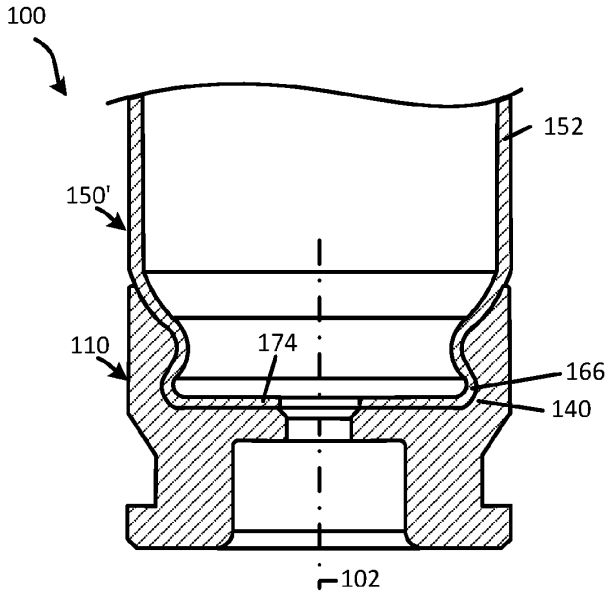


FIG. 18B

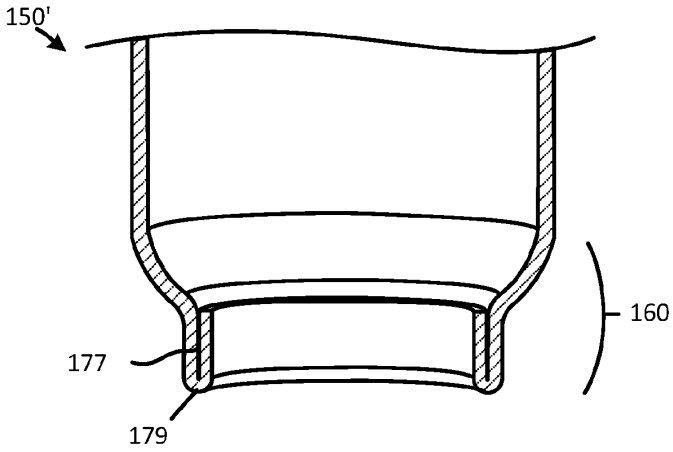


FIG. 19A

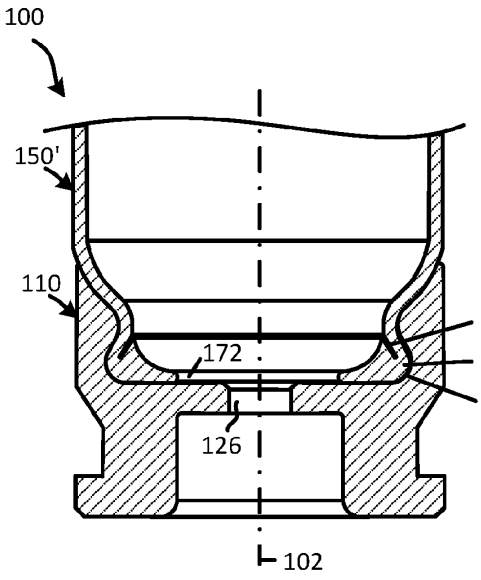


FIG. 19B

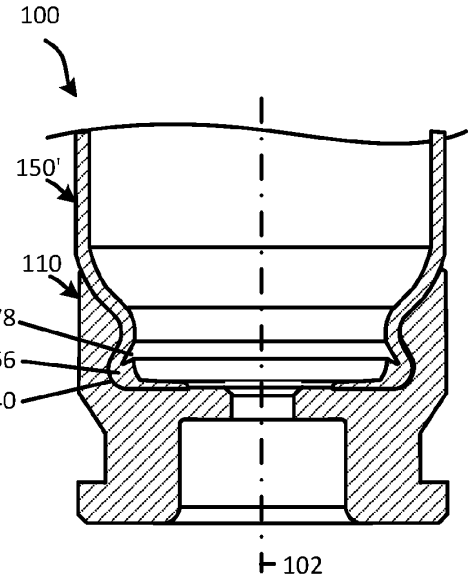


FIG. 19C

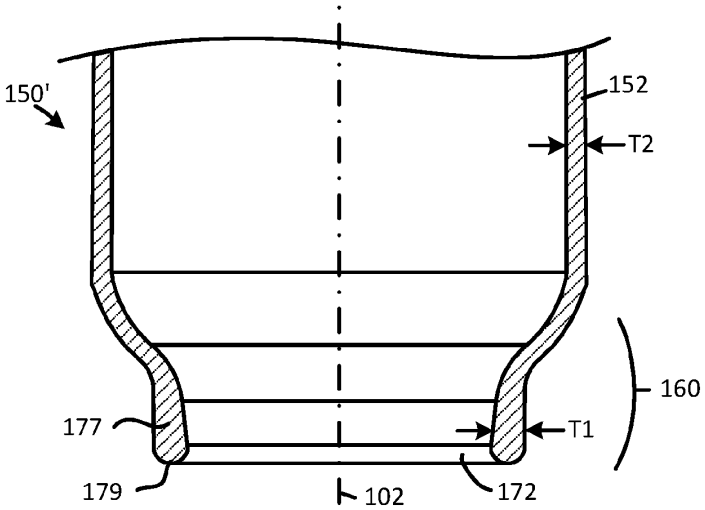


FIG. 20A

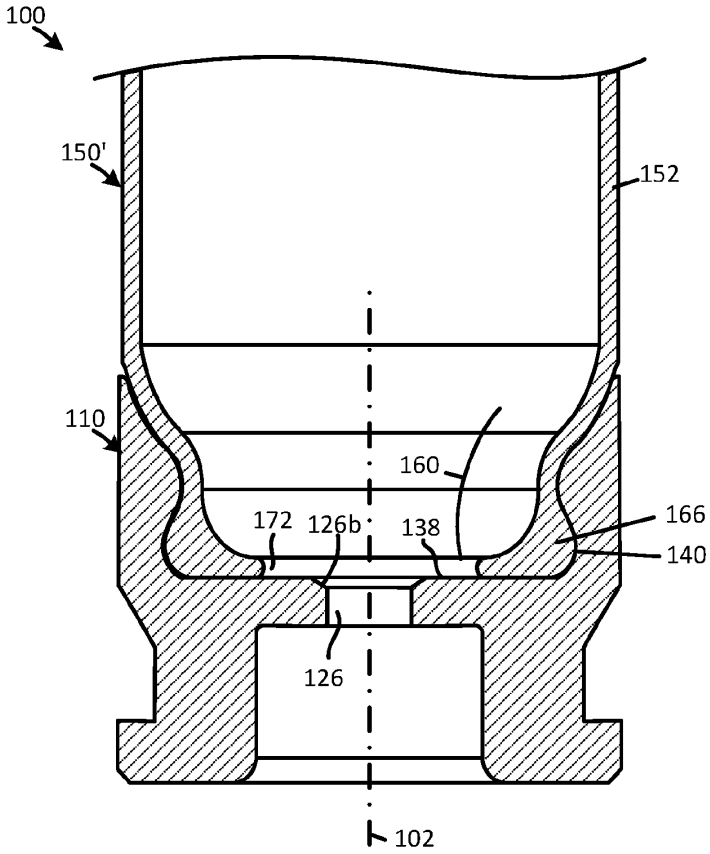


FIG. 20B

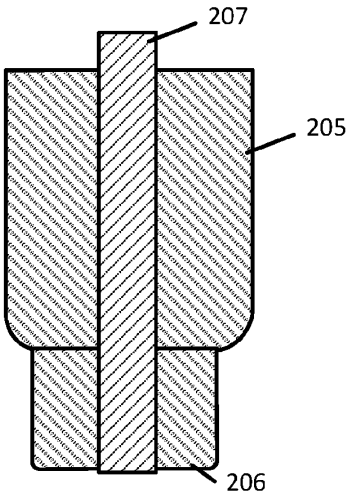


FIG. 21A

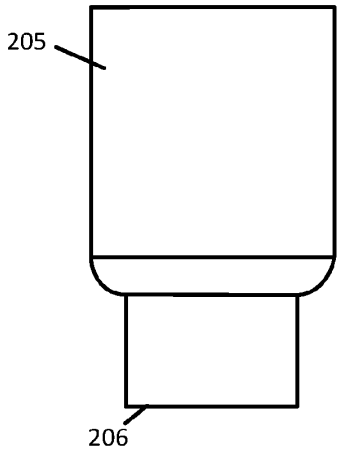


FIG. 21B

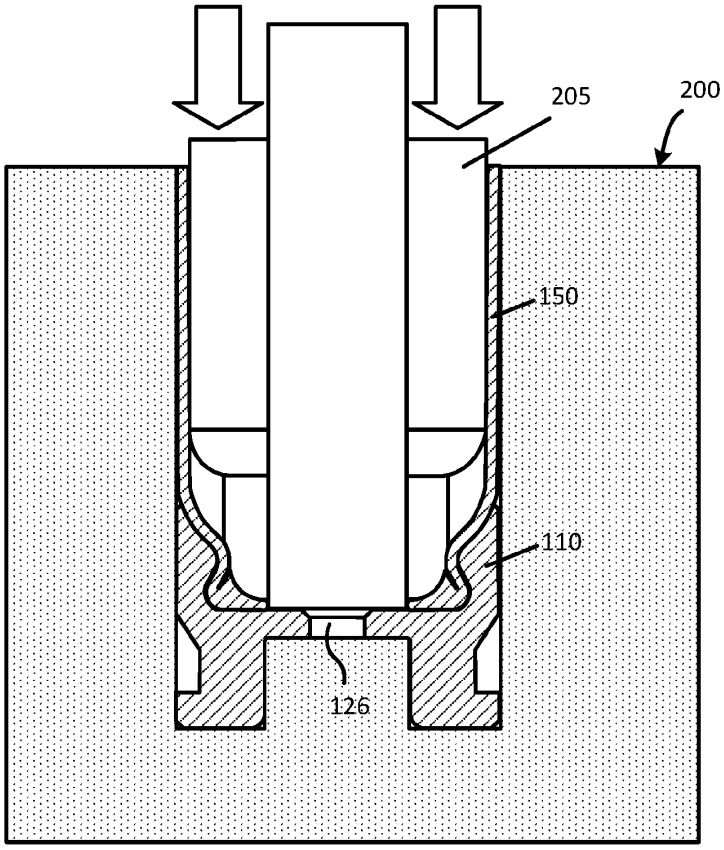


FIG. 21C

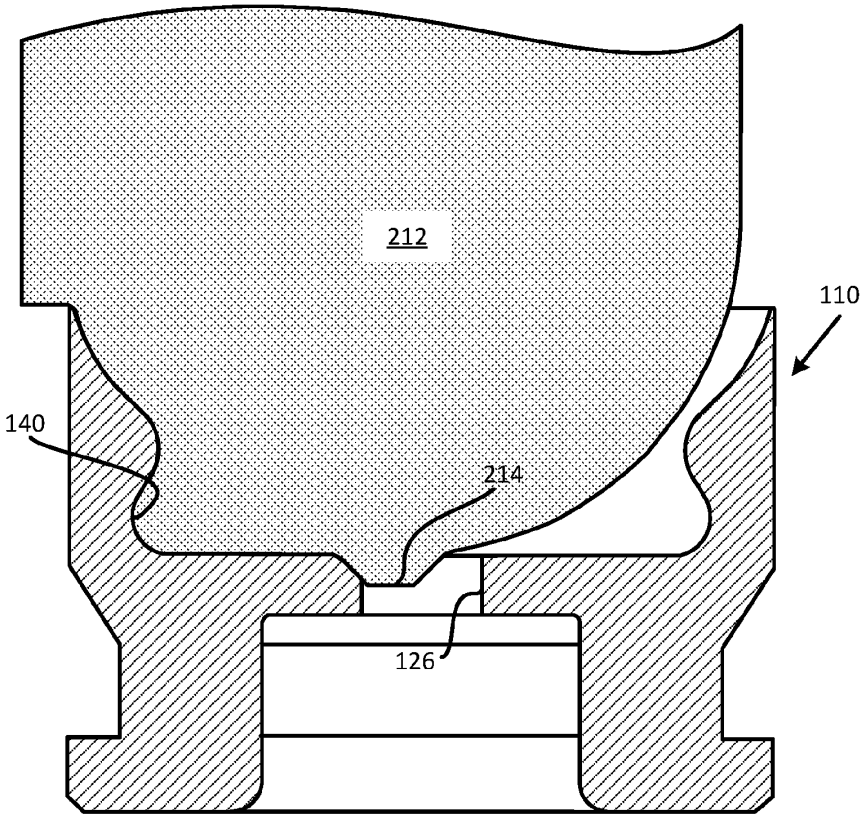


FIG. 22

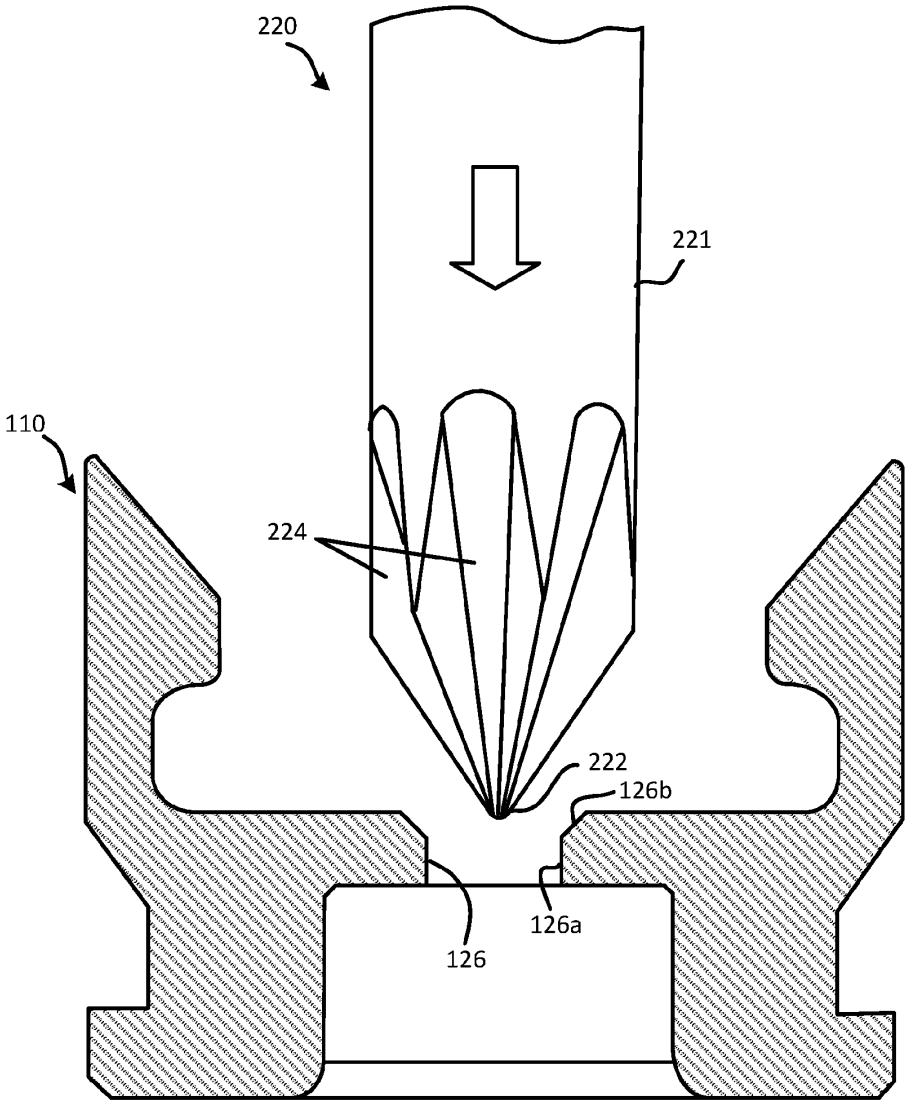


FIG. 23

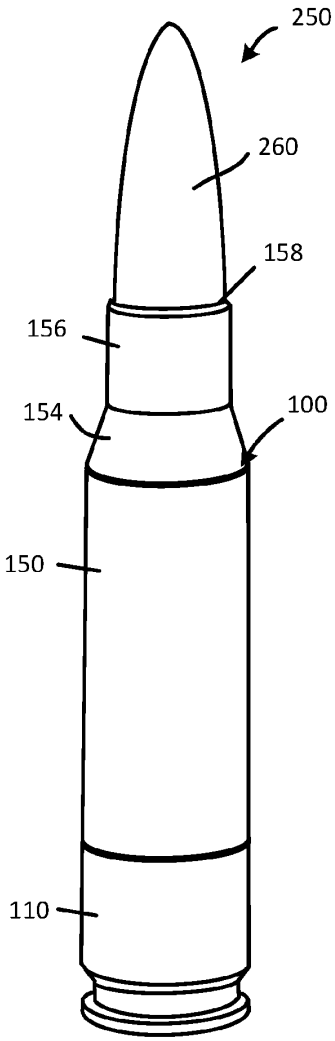


FIG. 24

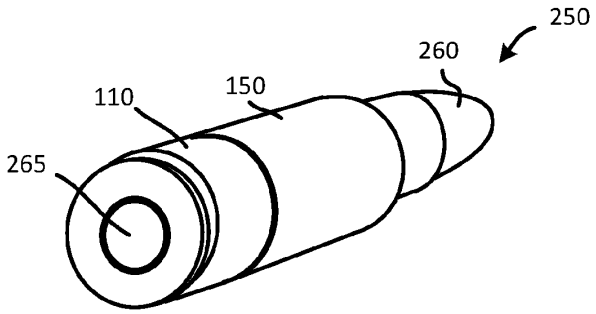


FIG. 25

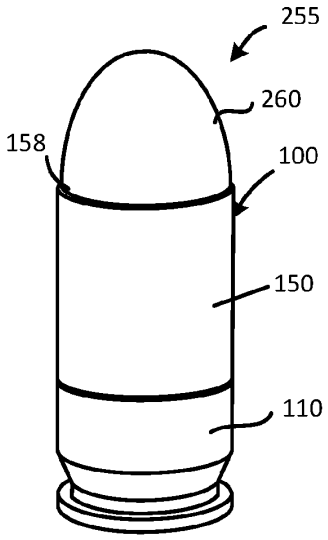


FIG. 26