

Title (en)

Method of manufacturing a projectile body, as well as projectile body produced in that manner.

Title (de)

Verfahren zum Herstellen eines Geschosskörpers sowie auf diese Weise hergestellter Geschosskörper.

Title (fr)

Procédé pour la fabrication d'un projectile et projectile ainsi obtenu.

Publication

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Application

**EP 80201184 A 19801208**

Priority

NL 7908989 A 19791213

Abstract (en)

According to a method of manufacturing a projectile body (51) of heat-treated steel closely encircled by an annular guide band (61) of softer metal, the body is subjected to a heat-treatment comprising at least a quenching step preceded by a heating step and the guide band (61) is secured to the body (51) at a predetermined location thereof during the heating step, by brazing with a brazing material having a brazing temperature above about 800 DEG C, without the use of a fluxing agent, in a controlled atmosphere. The heating step extends over a period of time such that brazing is completed within said heating step. Prior to brazing, a loose annular guide band is disposed around the projectile body (51) and is fixed thereon at the predetermined location, e.g. by locally damaging the body, and an annular ring (9) of brazing material is placed around the projectile body adjacent the guide band, or the brazing material is first applied to a loose annular guide band by rolling it thereon or by electrodeposition. An apparatus for carrying out this method comprises a brazing station and associated means for atmosphere control, e.g. for the supply of an inert gas.

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