

Title (en)  
Method for manufacturing cylinders for cartridge shells and composition

Title (de)  
Verfahren zur Herstellung von Zylindern für Patronenhülsen und Zusammensetzung

Title (fr)  
Procédé de fabrication de cylindres pour douille de cartouche et composition

Publication  
**EP 2078921 B1 20110323 (FR)**

Application  
**EP 09150097 A 20090106**

Priority  
FR 0800113 A 20080109

Abstract (en)  
[origin: EP2078921A2] The method involves supplying a composition (2) i.e. binder, of vegetal origin to cavities (3) of cylindrical molds (4) adapted to cylinders (1), where the composition comprises cellulose fibers, filler wood, microcrystalline cellulose. The composition is compressed in the cavities between lower peripheral and central punches (5, 6) and an upper punch (7), where the peripheral punch slides axially in the molds and the central punch slides axially in the punch (5). The obtained cylinders are ejected, where the distance between the punches (5, 7) defines the height of the cylinders.

IPC 8 full level  
**F42B 5/18** (2006.01); **F42B 5/26** (2006.01); **F42B 33/00** (2006.01)

CPC (source: EP US)  
**F42B 5/18** (2013.01 - EP US); **F42B 5/26** (2013.01 - EP US); **F42B 33/00** (2013.01 - EP US)

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AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV MC MK MT NL NO PL PT RO SE SI SK TR

Designated extension state (EPC)  
BA RS

DOCDB simple family (publication)  
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