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(54) **SOUND SUPPRESSOR**

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CPC ***F41A 21/30*** (2013.01); *F01N 1/083* (2013.01)

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See application file for complete search history.

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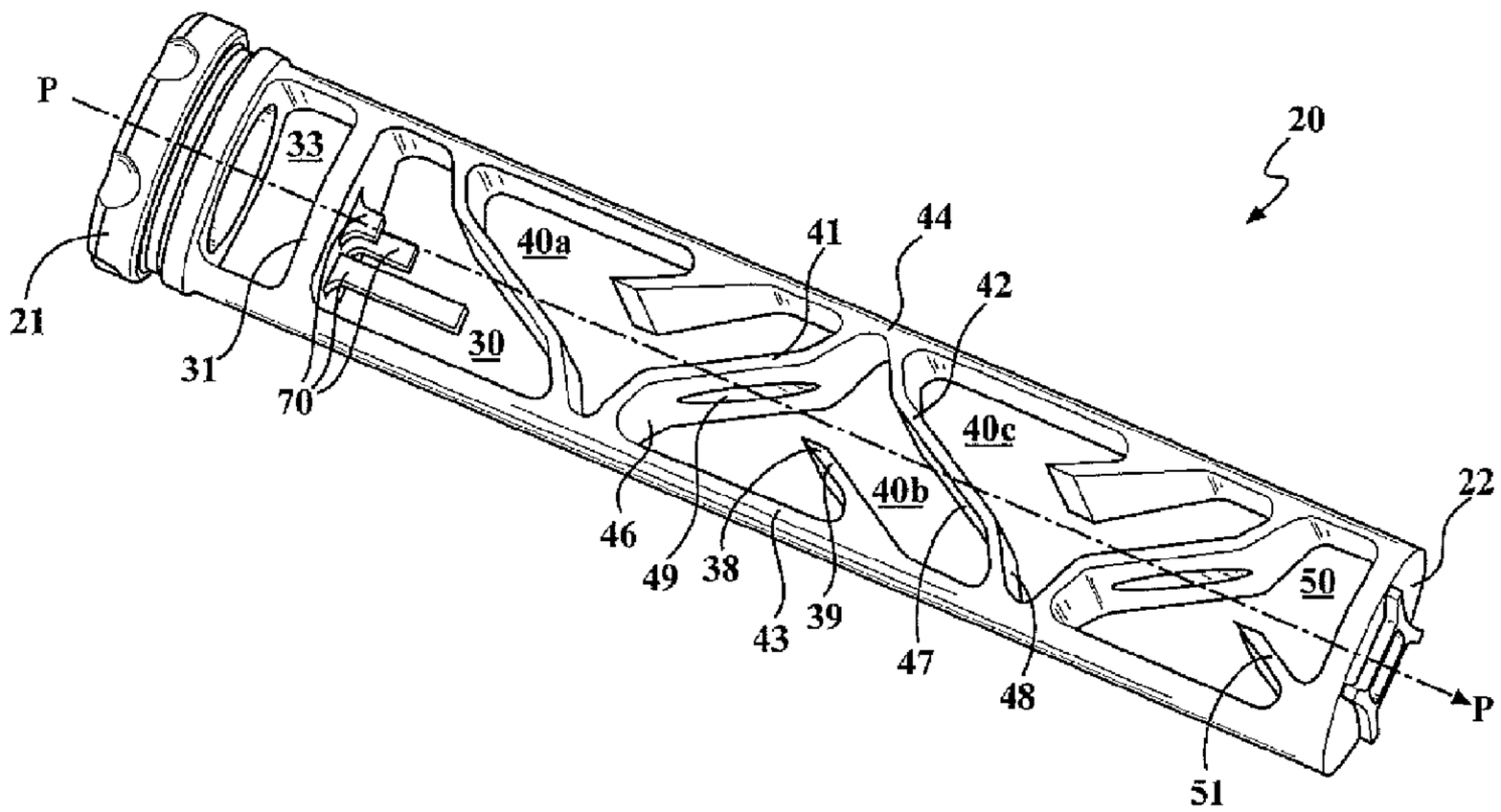
(57) **ABSTRACT**

A monocore for a sound suppressor that significantly enhances the trapping and delay of the gases exiting from the sound suppressor due to the design, location, and configuration of slanted baffles and angled half-baffles, and a plurality of rods. The slanted baffles help define the blast chamber, expansion chambers, and exit chamber of the monocore. The plurality of rods may be positioned in the blast chamber or the expansions chambers. The plurality of rods may vary in length. The plurality of rods may also replace the angled half-baffles.

43 Claims, 4 Drawing Sheets



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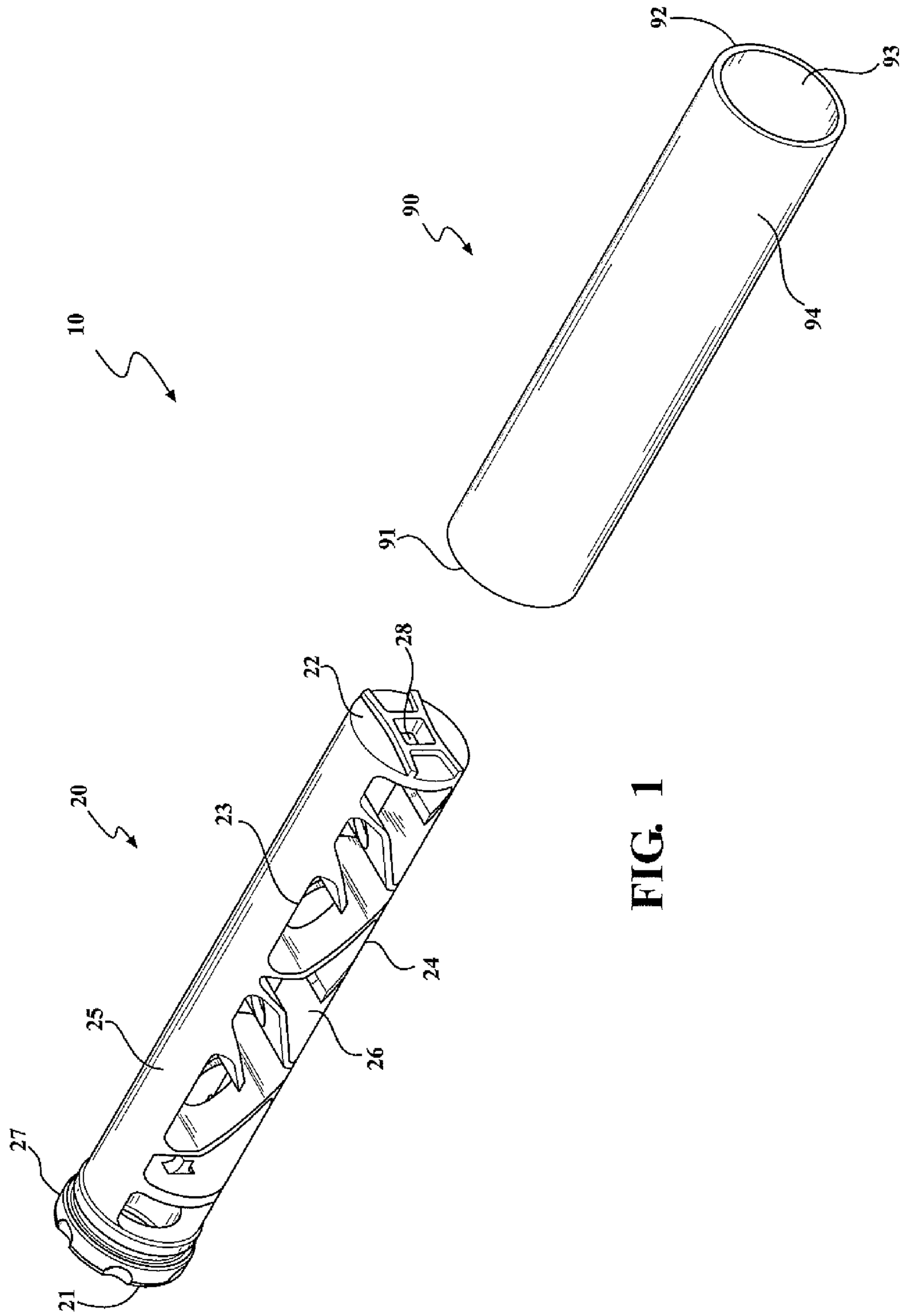

FIG. 1

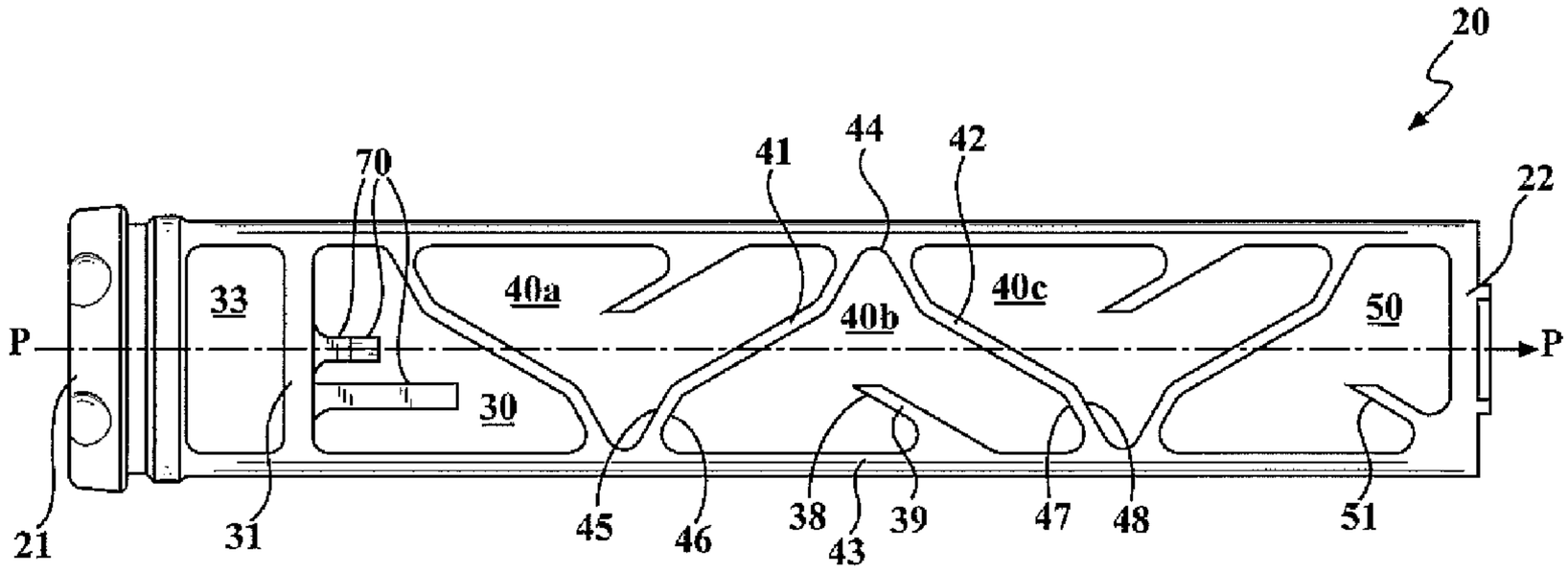

FIG. 2

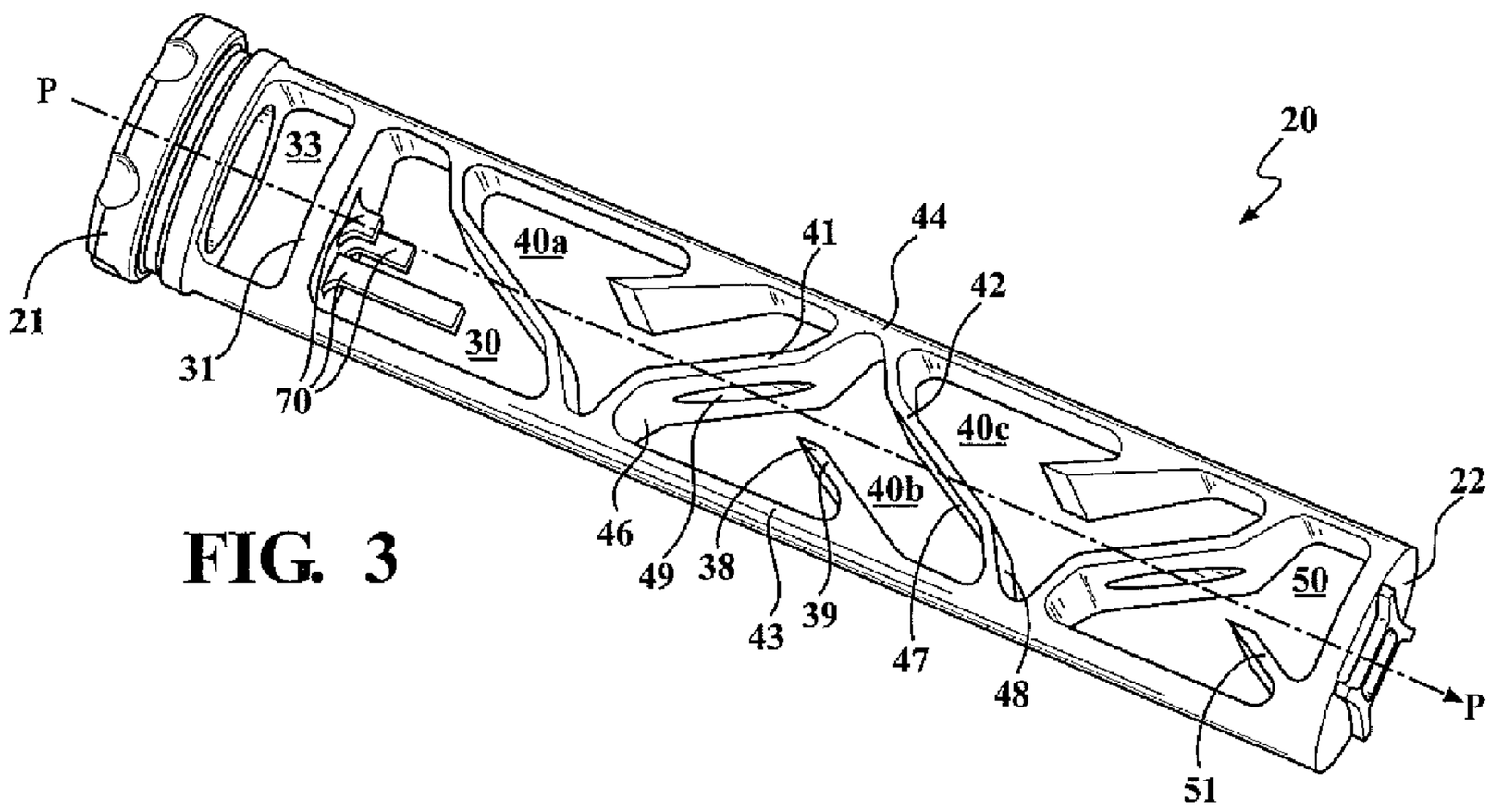

FIG. 3

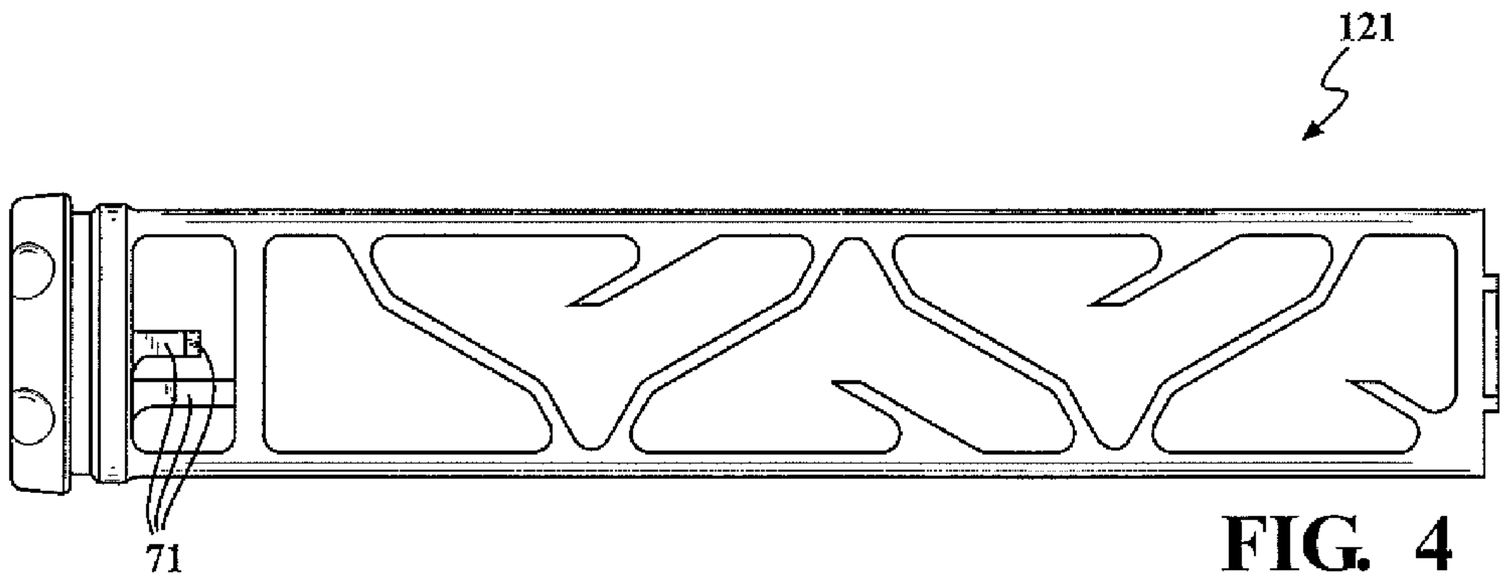

FIG. 4

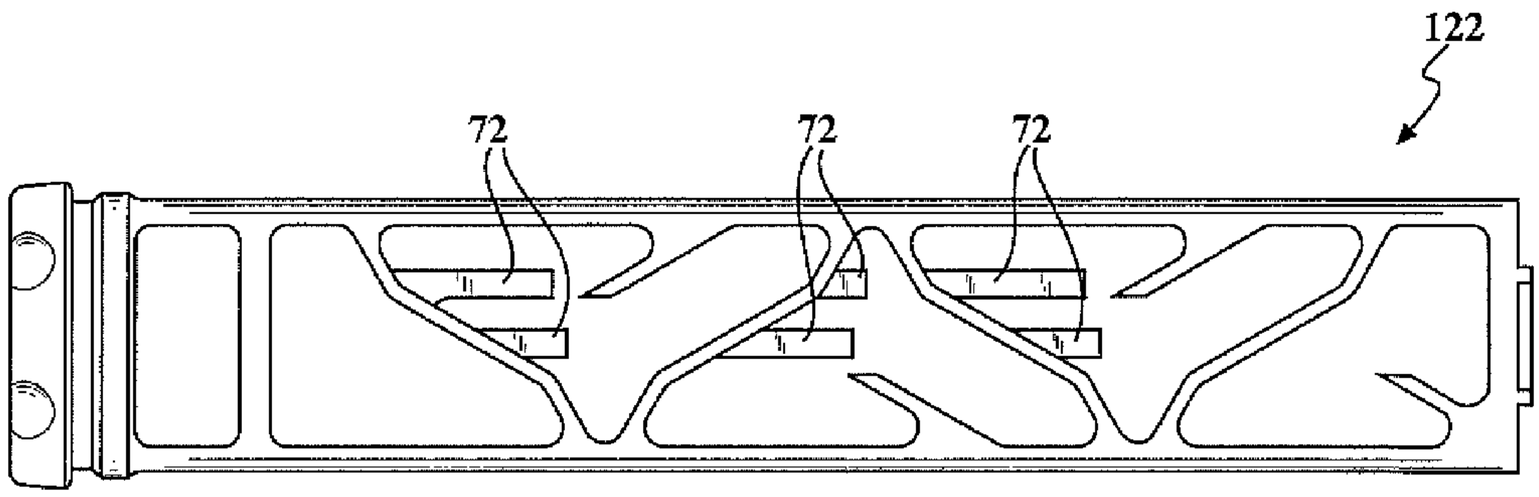

FIG. 5

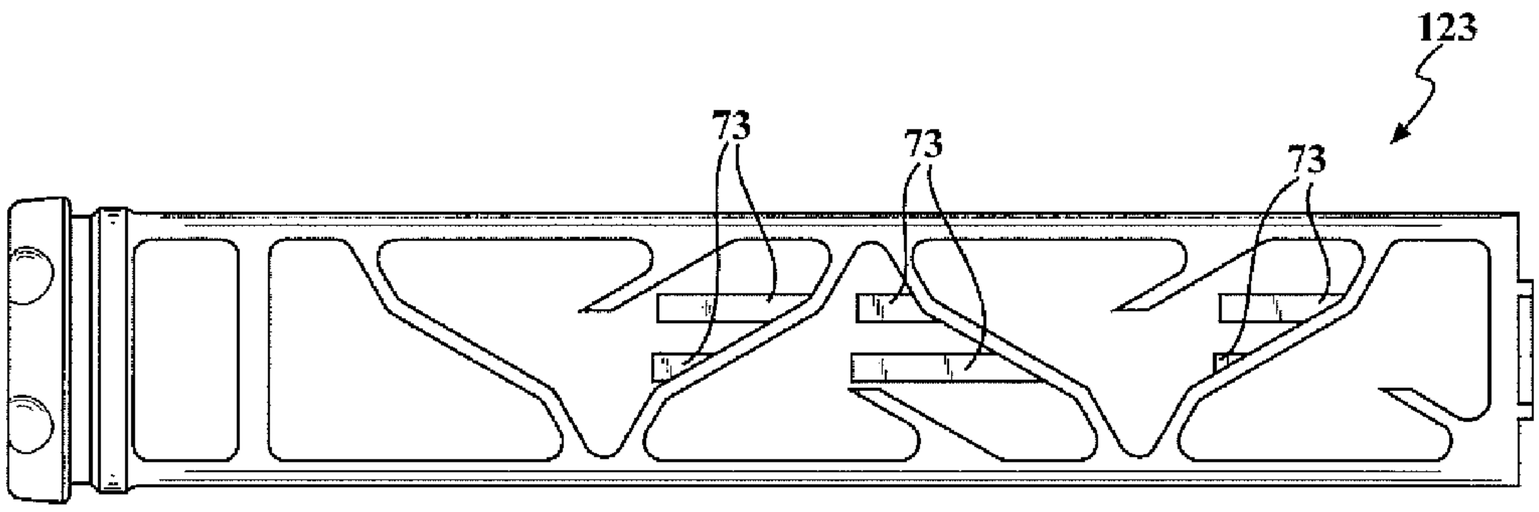

FIG. 6

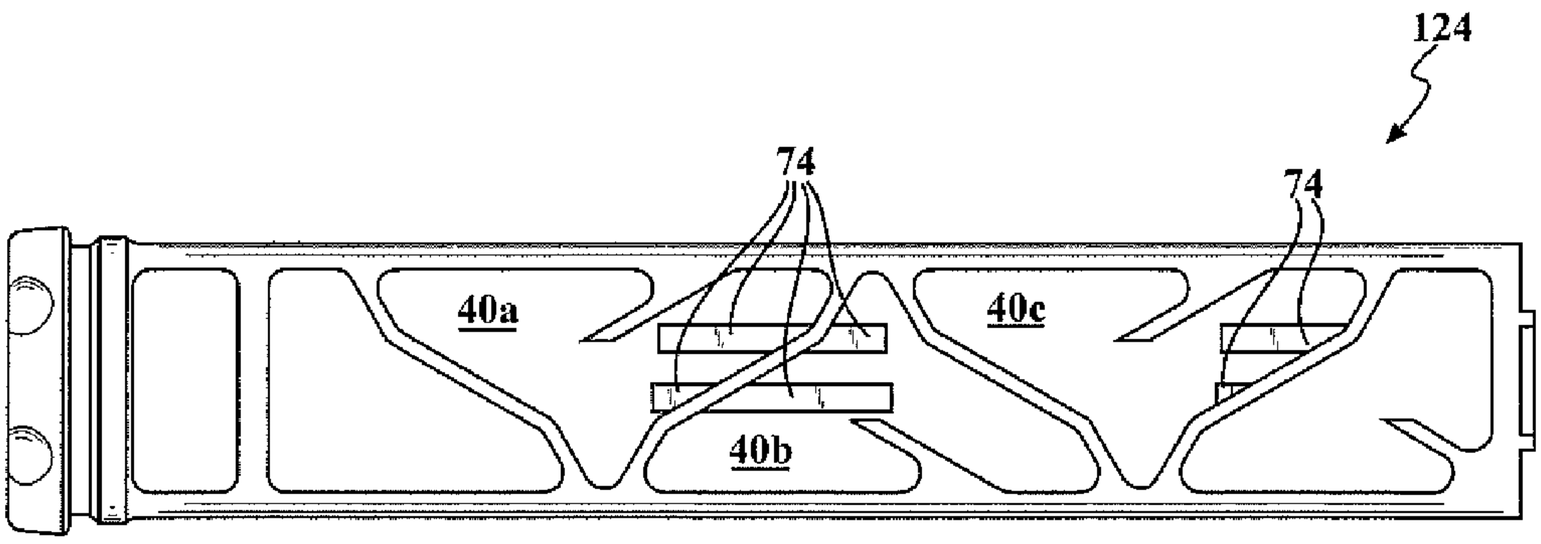

FIG. 7

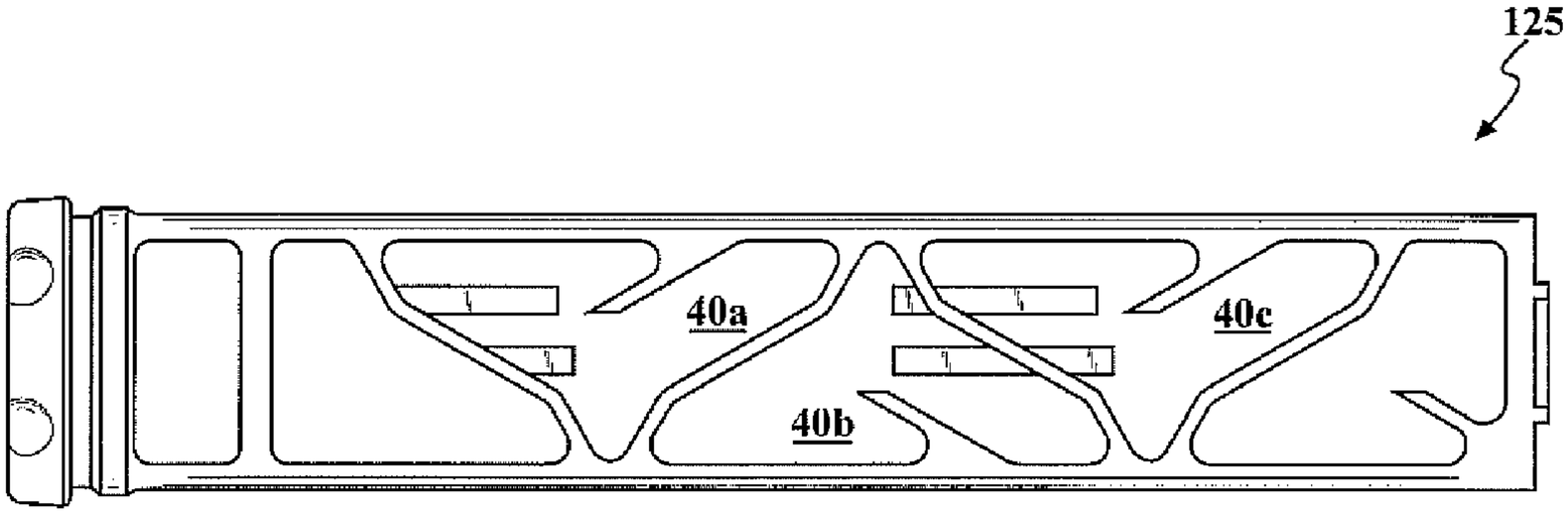

FIG. 8

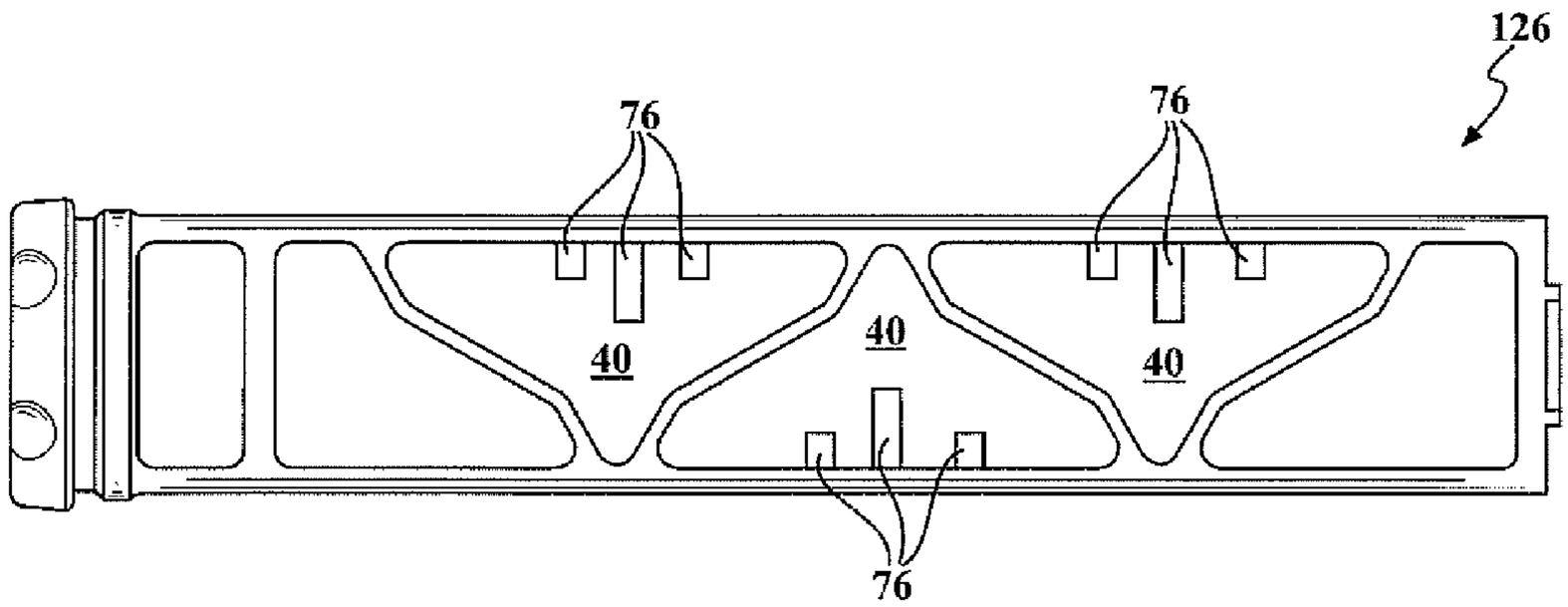

FIG. 9

SOUND SUPPRESSOR

Matter enclosed in heavy brackets [ ] appears in the original patent but forms no part of this reissue specification; matter printed in italics indicates the additions made by reissue; a claim printed with strikethrough indicates that the claim was canceled, disclaimed, or held invalid by a prior post-patent action or proceeding.

CROSS-REFERENCE TO RELATED APPLICATIONS

This application claims benefit of U.S. Provisional Application Ser. No. 61/838,382, filed on Jun. 24, 2013, which is incorporated herein in its entirety by reference.

TECHNICAL FIELD

This disclosure relates generally to sound suppressors. More particularly, it relates to sound suppressors for firearms featuring a monocore construction.

BACKGROUND

The field of firearm sound suppressors has seen many improvements resulting in higher sound reduction levels and a reduction in size. Firearm sound suppressors work by trapping and delaying the exit of the high pressure muzzle gases from a firearm when the firearm is discharged. Creation of turbulence is one technique used to enhance the trapping of the gases with a subsequent delay in the exit of the gases from a sound suppressor. If a sound suppressor is very effective at trapping and delaying the exit of the gases, this results in a lower sound level coming from the firearm.

When firearm sound suppressors are used, a phenomenon known as "First Round Pop" occurs when a shot is fired through the sound suppressor for the first time. The first shot is louder than second or subsequent shots due to the presence of oxygen in the sound suppressor. Once the oxygen is burnt up, the subsequent shots are quieter. What is needed is a sound suppressor that minimizes the sound of the first shot that is fired through the sound suppressor.

Firearm sound suppressors usually feature either use of discrete or individual components or a monolithic construction where the main structure is of one piece. The latter method of construction has become more popular over the last decade due to the use of Computer Numerically Controlled (CNC) machinery to produce a one-piece core, referred to herein as a "monocore," that has the baffle structure machined from one piece of metal. Until recently, the discrete technology suppressor has produced better sound reduction than the monocores. Current monocores are close to the discrete technology suppressor in efficiency and sound reduction levels but do not meet or exceed the efficiency levels of the discrete technology suppressor.

SUMMARY

A monocore for a firearm sound suppressor has a first side, a second side, a first portion, a second portion, a projectile passageway, an exit chamber, and at least one expansion chamber. The first side is configured for engagement with the firearm. The second side is spaced a longitudinal distance from the first side. The exit chamber is positioned near the second side. The first portion extends longitudinally between the first side and the second side. The second portion is spaced a width direction from the first portion and extends longitudinally between the first side and the second side. The projectile passageway extends longitudinally from the first side to the second side for a projectile from the firearm to travel through. The at least one expansion chamber is formed by two oppositely opposed slanted baffles and at least one of either the first portion or the second portion. An angled half baffle is positioned within the at least one expansion chamber. The angled half baffle extends from the at least one of either the first portion or the second portion toward the projectile passageway.

In an alternative embodiment, a monocore for a firearm sound suppressor has a first side, a second side, a first portion, a second portion, a projectile passageway, an exit chamber, a blast chamber, at least one expansion chamber, and a plurality of rods. The first side is configured for engagement with the firearm. The second side is spaced a longitudinal distance from the first side. The exit chamber is positioned near the second side. The blast chamber is positioned near the first side. The first portion extends longitudinally between the first side and the second side. The second portion is spaced a width direction from the first portion and extends longitudinally between the first side and the second side. The projectile passageway extends longitudinally from the first side to the second side for a projectile from the firearm to travel through. The at least one expansion chamber is formed by two oppositely opposed slanted baffles and at least one of either the first portion or the second portion. An angled half baffle is positioned within the at least one expansion chamber. The angled half baffle extends from the at least one of either the first portion or the second portion toward the projectile passageway. The plurality of rods are axially oriented and positioned around the projectile passageway.

In another alternative embodiment, a monocore for a firearm sound suppressor has a first side, a second side, a first portion, a second portion, a projectile passageway, an exit chamber, at least one expansion chamber, and a plurality of rods. The first side is configured for engagement with the firearm. The second side is spaced a longitudinal distance from the first side. The exit chamber is positioned near the second side. The first portion extends longitudinally between the first side and the second side. The second portion is spaced a width direction from the first portion and extends longitudinally between the first side and the second side. The projectile passageway extends longitudinally from the first side to the second side for a projectile from the firearm to travel through. The at least one expansion chamber is formed by two oppositely opposed slanted baffles and at least one of either the first portion or the second portion. The plurality of rods are positioned between the oppositely opposed slanted baffles and extend from at least of either the first portion or the second portion toward the projectile passageway.

BRIEF DESCRIPTION OF THE DRAWINGS

The description herein makes reference to the accompanying drawings, in which:

FIG. **1** is an exploded perspective view of a sound suppressor for a firearm;

FIG. **2** is a side view of a first embodiment of a monocore;

FIG. **3** is a side perspective view of the monocore of FIG. **2**;

FIG. **4** is a side view of the monocore in a second embodiment;

FIG. **5** is a side view of the monocore in a third embodiment;

FIG. **6** is a side view of the monocore in a fourth embodiment;

FIG. **7** is a side view of the monocore in a fifth embodiment;

FIG. **8** is a side view of the monocore in a sixth embodiment; and

FIG. **9** is a side view of the monocore in a seventh embodiment.

DETAILED DESCRIPTION

The disclosure herein relates to sound suppressors for firearms. The sound suppressors discussed herein have monocores with unique features that significantly enhance the trapping and delay of the gases exiting from the sound suppressor when a bullet is fired from the firearm to which the sound suppressor is attached.

FIG. **1** shows a sound suppressor **10** that includes a monocore **20** and a housing **90**. The housing **90** is a hollow, tubular structure that extends longitudinally from a first end **91** to a second end **92**. The housing **90** is made of a suitable material, such as metal or metal alloy. The first end **91** and the second end **92** are open, forming an inner surface **93** and an outer surface **94** that extend from the first end **91** to the second end **92**. Near the first end **91**, the inner surface **93** may be configured for attachment to the monocore **20**. An example of such a configuration is threading. The housing **90** must be slightly larger than the monocore **20**, such that when the monocore **20** is inserted into the housing **90**, the inner surface **93** of the housing **90** is in continuous contact with the monocore **20**.

The monocore **20** is a one-piece tubular structure made of a suitable material, such as metal or metal alloy, having a first side **21** (*rear end*), a second side **22** (*forward end*), a first portion **23**, a second portion **24**, an outer surface **25**, and an inner surface **26**. *A projectile passageway P extending between the first side 21 (rear end) and the second side 22 (forward end) permits a projectile to pass through the monocore 20 along a projectile axis (indicated by an arrow having a head near the second side 22).* The first side **21** is a spaced a longitudinal distance from the second side **22**. The first portion **23** is spaced a width direction from the second portion **24**. The outer surface **25** is spaced a width direction from the inner surface **26**. The first portion **23** and the second portion **24** extend longitudinally between the first side **21** and the second side **22**. The first portion **23** and the second portion **24** are formed by the outer surface **25**, the inner surface **26**, a blast chamber **30**, at least one expansion chamber **40**, and an exit chamber **50**. Near the first side **21**, the outer surface **25** may be configured for engagement with the inner surface **93** of the housing **90**. This is shown as threading **27**.

As shown, the first side **21** is an end cap, and the second side **22** is an integrally formed disc-like structure. It is anticipated that the first side **21** could be an integrally formed disc-like structure and that the second side **22** could be an end cap. The first side **21** and the second side **22** are closed except for an aperture **28**. The size of the aperture **28** will depend on the caliber of the firearm. The larger the caliber is, the larger the aperture **28** will need to be so that a bullet (not shown) may travel through it.

Shown in FIGS. **2-3**, a bore that extends longitudinally through the center of the monocore **20** from the first side **21** to the second side **22** defines a projectile passageway P. The projectile passageway P may be circular and allows for the bullet to travel through the monocore **20** from the first side **21** to the second side **22** of the monocore **20**. The size of the projectile passageway P must be large enough and free of obstructions, so that the bullet may travel without impediment through the monocore **20**. The size of the projectile passageway P will vary depending on the caliber of the firearm the sound suppressor **10** is attached to. The larger the caliber of the firearm is, the larger the projectile passageway P will need to be.

Each expansion chamber **40** is a generally triangular void formed in the monocore **20**. Each expansion chamber **40** is defined by a first slanted baffle **41**, a second slanted baffle **42**, and a base **43**. The first slanted baffle **41** and the second slanted baffle **42** are solid partitions with a circular aperture **49** that, while angled, create a barrier with the inner surface **93** of the housing **90** when the monocore **20** is inserted into the housing **90** so that fluid or air can only flow through the circular aperture **49** to move through the monocore **20**. The first slanted baffle **41** and the second slanted baffle **42** are oppositely opposed and extend from the first portion **23** to the second portion **24** of the monocore **20**. The first slanted baffle **41** is closer to the first side **21** of the monocore **20** than the second slanted baffle **42**, and the second slanted baffle **42** is closer to the second side **22** of the monocore **20** than the first slanted baffle **41**. The first slanted baffle **41** and the second slanted baffle **42** are furthest away from one another near the base **43** and closest to one another near a tip **44**. The base **43** of the expansion chamber **40** is adjacent to either the first portion **23** or the second portion **24** of the monocore **20**. When more than one expansion chamber **40** is present, each adjacent expansion chamber **40** is rotated **180** degrees so that the base **43** of each expansion chamber **40** alternates from being adjacent to the first portion **23** of the monocore **20** to being adjacent to the second portion **24** of the monocore **20**.

The first slanted baffle **41** has a first surface **45** that faces the first side **21** of the monocore and a second surface **46** that faces the second side **22** of the monocore **20**. The second slanted baffle **42** has a first surface **47** that faces the first side **21** of the monocore **20** and a second surface **48** that faces the second side **22** of the monocore **20**.

In each expansion chamber **40**, an angled half baffle **39** (*broadly, "partial baffle"*) may be positioned between the first slanted baffle **41** and the second slanted baffle **42**. The angled half baffle **39** is a solid, slanted partition that extends from the inner surface **26** of the monocore **20** toward the projectile passageway. The angled half baffle **39** may be integrally formed with the monocore **20**. The angled half baffle **39** may be located adjacent to either the first portion **23** or the second portion **24** of the monocore **20**. The angled half baffle **39** creates a barrier with the inner surface **93** of the housing **90** when the monocore **20** is inserted into the housing **90** such that fluid cannot pass through it, because the area between the projectile passageway P and the respective one of the first portion **23** or the second portion **24** from which the angled half baffle **39** extends is blocked by the angled half baffle **39**. Instead, fluid traveling through the expansion chamber **40** is forced to travel adjacent to one of the first portion **23** or the second portion **24** that is located opposite the angled half baffle **39**. *In the embodiment illustrated in FIGS. 2 and 3, the angled half baffle 39 in expansion chamber 40b extends parallel to the baffle 42, and the angled half baffle 39 slants rearwardly. The expansion chamber 40b includes a recess between the angled half baffle 39 and the second portion 24. The free end 38 of the angled half baffle 39 is spaced from the second portion 24 across the recess in a direction perpendicular to the pro-*

jectile passageway P. The angled partial baffle extends generally toward the first side 21 (rear end) such that the free end 38 points directly at the slanted baffle 41 and directly at the aperture 49 in the slanted baffle 41. The angled half baffles in the expansion chambers 40a and 40c have configurations similar to the angled half baffle 39 in the expansion chamber 40b but extend from the portion 23 rather than from the portion 24. With respect to the expansion chamber 40b, the slanted baffle 41 is located toward the first side 21 from the angled partial baffle 39 in the expansion chamber 40b, the slanted baffle 41 slants away from the portion 24 and toward the second side 22, and the angled partial baffle 39 extends from the portion 24 toward the first side 21. Furthermore, the slanted baffle 42 is located toward the second side 22 from the angled partial baffle 39, and the slanted baffle 42 slants away from the portion 24 and toward the first side 21. With respect to the expansion chamber 40c, the slanted baffle toward the second end 22 partially defining the expansion chamber 40c is connected to the portion 23 and extends from the portion 23 toward the first side 21.

A free end **38** of the angled half baffle **39** is positioned near the projectile passageway P. No portion of the angled half baffle **39** may extend into the projectile passageway P. If any portion of the angled half baffle **39** extends into the projectile passageway P, an aperture must be formed near the free end **38** so that the bullet may pass through the projectile passageway P without being impeded. The length that the angled half baffle **39** extends away from the inner surface **26** of the monocore **20** will vary depending on the caliber of the firearm, because the size of the projectile passageway P is dependent on the caliber of the firearm. The larger the projectile passageway P must be, the less distance that the angled half baffle **39** can extend away from the inner surface **26** of the monocore **20** toward the projectile passageway P.

Although any number of expansion chambers **40** may be used, three expansion chambers **40**a, **40**b, **40**c are shown. The first expansion chamber **40**a is positioned closest to the first side **21** (*rear end*) of the monocore **20**, and the third expansion chamber **40**c is positioned closest to the second side **22** (*forward end*) of the monocore **20**. The second expansion chamber **40**b is positioned between the first expansion chamber **40**a and the third expansion chamber **40**c. Because multiple expansion chambers **40**a, **40**b, **40**c are present, the second expansion chamber **40**b is rotated 180 degrees from the first expansion chamber **40**a and the third expansion chamber **40**c. This results in second slanted baffle **42** of the **[**first**]** *second* expansion chamber **[40**a**]** *40b* being **[**located adjacent to**]** the first slanted baffle **[41]** of the **[**second**]** *third* expansion chamber **[40**b**]** *40c*, and the **[**second**]** *first* slanted baffle **[42]** *41* of the second expansion chamber **40**b being **[**located adjacent to**]** the **[**first**]** *second* slanted baffle **[41]** of the **[**third**]** *first* expansion chamber **[40**c**]** *40a*.

A blast plate **31** is a circular disc formed near the first side **21** of the monocore **20**. The blast plate **31** may be integrally formed with the monocore **20**. Because the projectile passageway P also extends through the blast plate **31**, the blast plate **31** has a circular aperture **[32]** that is large enough for the bullet to pass through. A hollow space **33** is formed between the first side **21** and the blast plate **31**. The blast chamber **30** is a generally triangular void formed by the blast plate **31** and the first slanted baffle **[41]** of the expansion chamber **40** that is closest to the first side **21**. *The blast chamber 30 is formed between the first side 21 and the first expansion chamber 40a.*

The exit chamber **50** is a generally triangular void formed by the second side **22** and the second slanted baffle **[42]** of the expansion chamber **40** that is closest to the second side **22**. An angled half baffle **51** (*broadly, "partial baffle"*) may be integrally formed in the exit chamber **50** and extend toward the projectile passageway P. The angled half baffle **51** is a solid, slanted partition that extends from the inner surface **26** of the monocore **20** toward the projectile passageway. The angled half baffle **[39]** *51* may be integrally formed with the monocore **20**. The angled half baffle **51** may be located adjacent to either the first portion **23** or the second portion **24** of the monocore **20**. The angled half baffle **51** may slant toward the first side **21** or the second side **22** of the monocore. As shown, the angled half baffle **51** slants toward the first side **21**. *The angled half baffle 51 extends away from the second side 22 toward the projectile passageway P and toward the expansion chambers 40a, 40b, 40c.* The angled half baffle **[39]** *51* creates a barrier with the inner surface **93** of the housing **90** when the monocore **20** is inserted into the housing **90** such that fluid or air cannot pass through it. If any portion of the angled half baffle **51** extends into the projectile passageway P, an aperture must be formed in the angled half baffle **51** so that the bullet may pass through without being impeded.

The blast plate **31** may be provided with a plurality of rods **70** that are axially oriented and positioned around the projectile passageway P. Each rod of the plurality of rods **70** may vary in length to minimize harmonic resistance. The plurality of rods **70** may be integrally formed with the monocore **20**. As shown, the cross-sectional shape of the rods **70** is rectangular, and the rods **70** extend toward the second side **22** of the monocore **20**. It is anticipated that the rods could have another shape, such as circular. While the plurality of rods **70** are shown as being positioned symmetrically around the projectile passageway P on the blast plate **31**, the positioning may be asymmetrical.

The arrangement and positioning of the plurality of rods **70** is caliber dependent and may vary from caliber to caliber. Because the pressure of muzzle gases varies from caliber to caliber and barrel length, the length and positioning of the rods **70** is dependent upon the pressure of the muzzle gases and upon the position of any slanted baffles **41**, **42** in the monocore **20**.

The plurality of rods **70** have been found to increase turbulence in the blast chamber **30**, the expansion chambers **40**, and the exit chamber **50**. The plurality of rods **70** have also been found to assist in the maximum delaying of the gases from the sound suppressor **10**. The increased surface area of the plurality of rods **70** helps provide initial gas cooling, which results in an unexpected benefit to the overall performance of the sound suppressor **10**. The plurality of rods **70** in the blast chamber **30** helps reduce the "First Round Pop" effect.

In alternative embodiments, the plurality of rods **70** may be provided elsewhere in the monocore **20**. In FIG. **4**, a plurality of rods **71** are provided in the first side **21** of a monocore **121**. The slanted baffles **41**, **42** may also be provided with the plurality of rods **70**, as shown in FIGS. **5-8**. Generally, the plurality of rods **70** on the slanted baffles **41**, **42** are positioned so that only one surface **45-48** within each expansion chamber **40** is provided with rods. In FIG. **5**, a plurality of rods **72** are shown on the surfaces **45-48** that face toward the second side **22** of a monocore **122**. In FIG. **6**, a plurality of rods **73** are shown on the surfaces **45-48** that face toward the first side **21** of a monocore **123**. In FIGS. **7-8**, a plurality of rods **[74**, **75** alternate surfaces **45-48** between each adjoining expansion chamber **40]** *are provided on different baffles* in monocores **124**, **125**. For example, in FIG. **7**, **[**the**]** rods **74** are positioned on **[**the first surfaces **47**

of the second slanted baffles **42** in] *a slanted baffle separating* the first expansion chamber **40**a *and the second expansion chamber 40b,* and *rods are provided on a baffle bounding* the third expansion chamber **40**c**[**, and the rods **74** are positioned on the second surface **46** of the first slanted baffle **41** in the second expansion chamber **40**b**]**. In FIG. **8**, **[**the**]** rods **[75]** are positioned on **[**the second surfaces **46** of the first**]** *a* slanted **[**baffles **41** in**]** *baffle bounding* the first expansion chamber **40**a, and **[**the**]** rods **[75]** are positioned on **[**the first surface **46** of the second**]** *a* slanted baffle **[42** in**]** *separating* the second expansion chamber **40**b *and the third expansion chamber 40c*.

In another, alternative embodiment, a plurality of rods **76** may replace the angled half baffles **39** in the expansion chamber **40**, as shown in FIG. **9**. The plurality of rods **76** may be integrally formed with a monocore **126**. The plurality of rods **76** are located between the first slanted baffles **41** and the second slanted baffles **42**. The plurality of rods **76** extend away from the inner surface **26** of the monocore **126** toward the projectile passageway P. The length of the plurality of rods **76** can vary; however, no rod **76** can be longer than the distance between the inner surface **26** of the monocore **126** and the projectile passageway P. Otherwise, the rods **76** would interfere with the bullet's ability to traverse the projectile passageway P. The plurality of rods **76** may be located adjacent to either the first portion **23** or the second portion **24** of the monocore **126**. *In the embodiment illustrated in FIG. 9, the rods 76 extend transverse to the projectile passageway. Some of the rods 76 extend from respective ends fixed to an upper longitudinal portion (first portion 23) of the monocore 126, and other rods 76 extend from respective ends fixed to a lower longitudinal portion (second portion 24) of the monocore.*

To assemble the sound suppressor **10**, the monocore **20** is inserted into the housing **90** and secured. The monocore **20** could be secured by twisting the threading **27** on the outer surface **25** of the monocore **20** into the threading on the inner surface **93** of the housing **90** near the first end **91**. Alternatively, the monocore **20** could be secured to the housing **90** through the use of an end cap. Once the monocore **20** is securely held inside the housing **90**, the sound suppressor **10** may be attached to a firearm. This could be accomplished through the use of a quick connect coupling, such as a bayonet Other assembly arrangements are possible and would be obvious to those skilled in the art.

While the invention has been shown and described with reference to a certain specific preferred embodiment, modification may now suggest itself to those skilled in the art. Such modifications and various changes in form and detail may be made herein without departing from the spirit and scope of the invention. Accordingly, it is understood that the invention will be limited only by the appended claims.

What is claimed is:

1. A **[**monocore for a**]** firearm sound suppressor, comprising: a first side configured for engagement with the firearm; a second side spaced a longitudinal distance from the first side **[**and having an exit chamber**]**; a first portion that extends longitudinally between the first side and the second side; a second portion that is spaced a width direction from the first portion and extends longitudinally between the first side and the second side; a projectile passageway that extends longitudinally from the first side to the second side for a projectile from the firearm to travel through; and at least one expansion chamber formed by two oppositely opposed slanted baffles and at least one of either the first portion or the second portion, wherein an angled **[**half**]** *partial* baffle is positioned within the at least one expansion chamber and extends from the at least one of either the first portion or the second portion toward the projectile passageway.

2. The **[**monocore**]** *suppressor* of claim **1**, wherein the at least one angled **[**half-baffle**]** *partial baffle* is parallel to one of the oppositely opposed slanted baffles.

3. The **[**monocore**]** *suppressor* of claim **1**, further comprising: an exit chamber, the exit chamber formed between the at least one expansion chamber and the second side.

4. The **[**monocore**]** *suppressor* of claim **3**, wherein the exit chamber has an angled **[**half-baffle**]** *partial baffle* extending away from the second side toward the at least one expansion chamber.

5. The **[**monocore**]** *suppressor* of claim **1**, further comprising: a plurality of rods, the plurality of rods axially oriented and positioned around the projectile passageway.

6. The **[**monocore**]** *suppressor* of claim **5**, *wherein the suppressor comprises a monocore including the first portion, the second portion, the two oppositely opposed slanted baffles, and the angled partial baffle, and* wherein the plurality of rods are integrally formed with the monocore.

7. The **[**monocore**]** *suppressor* of claim **5**, further comprising: a blast chamber formed between the first side and the at least one expansion chamber, wherein the plurality of rods are formed within the blast chamber.

8. The **[**monocore**]** *suppressor* of claim **5**, wherein each rod from the plurality of rods has a different length than the other rods from the plurality of rods.

9. The **[**monocore**]** *suppressor* of claim **5**, wherein the plurality of rods are formed on at least one of the oppositely opposed slanted baffles.

10. The **[**monocore**]** *suppressor* of claim **5**, wherein the plurality of rods are formed on the first side of the **[**monocore**]** *suppressor*.

11. A **[**monocore for a**]** firearm sound suppressor, comprising: a first side configured for engagement with the firearm and having a blast chamber; a second side spaced a longitudinal distance from the first side and having an exit chamber; a first portion that extends longitudinally between the first side and the second side; a second portion that is spaced a width direction from the first portion and extends longitudinally between the first side and the second side; a projectile passageway extending from the first side to the second side for a projectile from the firearm to travel through; at least one expansion chamber formed by two oppositely opposed slanted baffles and at least one of either the first portion or the second portion, wherein an angled **[**half**]** *partial* baffle is positioned within the at least one expansion chamber and extends from the at least one of either the first portion or the second portion toward the projectile passageway; and a plurality of rods axially oriented and positioned around the projectile passageway.

12. The **[**monocore**]** *suppressor* of claim **11**, *wherein the suppressor comprises a monocore including the first portion, the second portion, the two oppositely opposed slanted baffles, and the angled partial baffle, and* wherein the plurality of rods are integrally formed with the monocore.

13. The **[**monocore**]** *suppressor* of claim **11**, wherein each rod from the plurality of rods has a different length than the other rods from the plurality of rods.

14. The **[**monocore**]** *suppressor* of claim **11**, wherein the plurality of rods are formed within the blast chamber.

15. The **[**monocore**]** *suppressor* of claim **11**, wherein the plurality of rods are formed on at least one of *the* oppositely opposed slanted baffles.

16. The [monocore] *suppressor* of claim 11, wherein the plurality of rods are formed on the first side of the [monocore] *suppressor*.

17. A [monocore for a] firearm sound suppressor, comprising: a first side configured for engagement with the firearm; a second side spaced a longitudinal distance from the first side and having an exit chamber; a first portion that extends longitudinally between the first side and the second side; a second portion that is spaced a width direction from the first portion and extends longitudinally between the first side and the second side; a projectile passageway that extends longitudinally from the first side to the second side for a projectile from the firearm to travel through; and at least one expansion chamber defined by two oppositely opposed slanted baffles and at least one of either the first portion or the second portion, wherein a plurality of rods are positioned within the at least one expansion chamber between the oppositely opposed slanted baffles and each extend transverse to the projectile passageway from a fixed end that is connected to at least [of] one of the first portion or the second portion toward the projectile passageway to a free end.

18. The [monocore] *suppressor* of claim 17, *wherein the suppressor comprises a monocore including the first portion, the second portion, and the two oppositely opposed slanted baffles, and* wherein the plurality of rods are integrally formed with the monocore.

19. The [monocore] *suppressor* of claim 17, further comprising: a blast chamber formed between the first side and the at least one expansion chamber.

20. A [monocore for a] firearm sound suppressor, comprising: a first side configured for engagement with the firearm; a second side spaced a longitudinal distance from the first side and having an exit chamber; a first portion that extends longitudinally between the first side and the second side; a second portion that is spaced a width direction from the first portion and extends longitudinally between the first side and the second side; a projectile passageway that extends longitudinally from the first side to the second side for a projectile from the firearm to travel through; at least one expansion chamber defined by two oppositely opposed slanted baffles and at least one of either the first portion or the second portion, wherein a plurality of rods are positioned between the oppositely opposed slanted baffles and extend from at least [of] one of the first portion or the second portion toward the projectile passageway; and an angled half baffle that extends from the second side toward the projectile passageway.

21. The suppressor of claim 1, wherein the expansion chamber includes a recess between the angled partial baffle and said at least one of the first portion or the second portion, the angled partial baffle having a free end spaced from said at least one of the first portion or the second portion across the recess in a direction perpendicular to the projectile passageway.

22. The suppressor of claim 21, wherein the angled partial baffle extends generally toward the first side such that the free end of the angled partial baffle points directly at a first slanted baffle of the two oppositely opposed slanted baffles.

23. The suppressor of claim 22, wherein said first slanted baffle includes an opening defining part of the projectile passageway, the angled partial baffle extending generally toward the first side such that the free end points directly at the opening.

24. The suppressor of claim 23, wherein the first slanted baffle is located toward the first side from the angled partial baffle, the first slanted baffle slanting away from the first portion and toward the second side, the angled partial baffle extending from the first portion toward the first side.

25. The suppressor of claim 24, wherein a second slanted baffle of said two oppositely opposed slanted baffles is located toward the second side from the angled partial baffle, the second slanted baffle slanting away from the first portion and toward the first side.

26. The suppressor of claim 25, wherein the expansion chamber is a first expansion chamber and the angled partial baffle is a first angled partial baffle, the suppressor further comprising a third slanted baffle located toward the second side from the second slanted baffle, the third slanted baffle slanting away from the first portion and toward the second side, the second and third slanted baffles bounding a second expansion chamber, the suppressor further comprising a second angled partial baffle positioned in the second expansion chamber, the second angled partial baffle being connected to the second portion and extending from the second portion toward the first side.

27. A firearm sound suppressor for use with a firearm, the suppressor comprising:

a structure having a rear end, a forward end, and a length extending therebetween;

a projectile passage extending between the rear and forward ends of the structure through which a projectile can pass along a projectile axis from the rear end to the forward end when the structure is supported by the firearm and the projectile is fired from the firearm;

an expansion chamber bounded by a first slanted baffle at a rear end of the expansion chamber and bounded by a second slanted baffle at a forward end of the expansion chamber, the expansion chamber being further formed by a longitudinal portion of the structure extending between the first and second slanted baffles; and

a partial baffle in the expansion chamber, the partial baffle extending inboard from the longitudinal portion of the structure and slanting rearwardly.

28. The suppressor of claim 27, wherein the structure is formed as a single piece of material.

29. The suppressor of claim 27, further comprising a housing in which the structure is receivable, the housing bounding the expansion chamber when the structure is received in the housing.

30. The suppressor of claim 27, wherein the expansion chamber includes a recess between the partial baffle and said longitudinal portion, the partial baffle having a free end spaced from said longitudinal portion across the recess in a direction perpendicular to the projectile passage.

31. The suppressor of claim 30, wherein the partial baffle slants rearwardly such that the free end of the partial baffle points directly at the first slanted baffle.

32. The suppressor of claim 31, wherein the first slanted baffle includes an opening defining part of the projectile passage, the partial baffle slanting rearwardly such that the free end of the partial baffle points directly at the opening.

33. The suppressor of claim 30, wherein the first slanted baffle slants away from the longitudinal portion and toward the forward end.

34. The suppressor of claim 33, wherein the second slanted baffle slants away from the longitudinal portion and toward the rear end.

35. The suppressor of claim 34, wherein the longitudinal portion is a first longitudinal portion and the structure further comprises a second longitudinal portion across the projectile passage from the first longitudinal portion, wherein the expansion chamber is a first expansion chamber

and the partial baffle is a first partial baffle, the suppressor further comprising a third slanted baffle located forward from the second slanted baffle and bounding a second expansion chamber, the third slanted baffle slanting away from the first longitudinal portion and toward the forward end, the suppressor further comprising a second partial baffle in the second expansion chamber, the second partial baffle extending inboard from the second longitudinal portion and slanting rearwardly.

36. The suppressor of claim 35, wherein the second slanted baffle bounds the second expansion chamber.

37. The suppressor of claim 36, wherein the first slanted baffle extends from the first longitudinal portion to the second longitudinal portion, the second slanted baffle extends from the first longitudinal portion to the second longitudinal portion, and the third slanted baffle extends from the first longitudinal portion to the second longitudinal portion.

38. The suppressor of claim 35, further comprising a fourth slanted baffle located forward from the third slanted baffle and bounding a third expansion chamber, the fourth slanted baffle slanting away from the first longitudinal portion and toward the rear end, the suppressor further comprising a third partial baffle in the third expansion chamber, the third partial baffle extending inboard from the first longitudinal portion and slanting rearwardly.

39. The suppressor of claim 38, wherein the second slanted baffle bounds the second expansion chamber, and the third slanted baffle bounds the third expansion chamber.

40. The suppressor of claim 27, wherein the longitudinal portion is a first longitudinal portion and the structure further comprises a second longitudinal portion across the projectile passage from the first longitudinal portion, wherein the expansion chamber is a first expansion chamber and the partial baffle is a first partial baffle, the suppressor further comprising a third slanted baffle located forward from the second slanted baffle and bounding a second expansion chamber, the suppressor further comprising a second partial baffle in the second expansion chamber, the second partial baffle extending toward the projectile passage.

41. The suppressor of claim 40, further comprising a fourth slanted baffle located forward from the third slanted baffle and bounding a third expansion chamber, the suppressor further comprising a third partial baffle in the third expansion chamber, the third partial baffle extending toward the projectile passage.

42. The suppressor of claim 41, wherein the second slanted baffle bounds the second expansion chamber, and the third slanted baffle bounds the third expansion chamber.

43. The suppressor of claim 41, wherein the first slanted baffle extends from the first longitudinal portion to the second longitudinal portion, the second slanted baffle extends from the first longitudinal portion to the second longitudinal portion, and the third slanted baffle extends from the first longitudinal portion to the second longitudinal portion, and wherein the second and third partial baffles slant rearwardly.

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