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(54) METHOD AND APPARATUS FOR CARTRIDGE IDENTIFICATION IMPRINTING IN DIFFICULT CONTEXTS BY RECESS PROTECTED INDICIA

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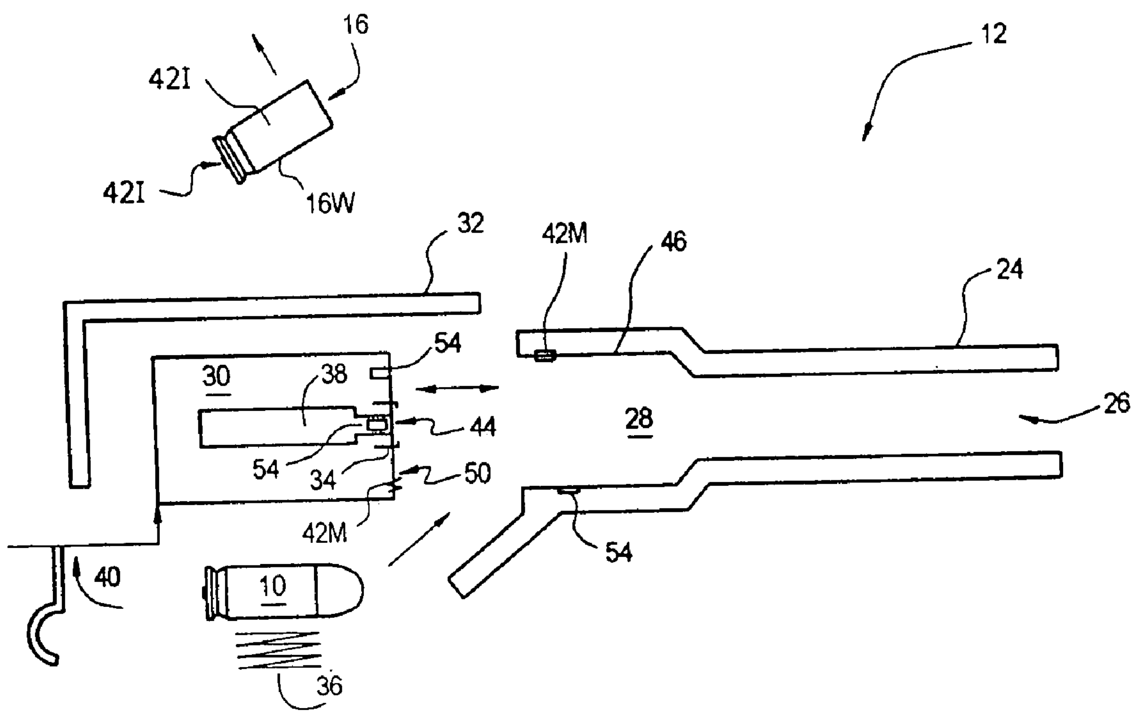
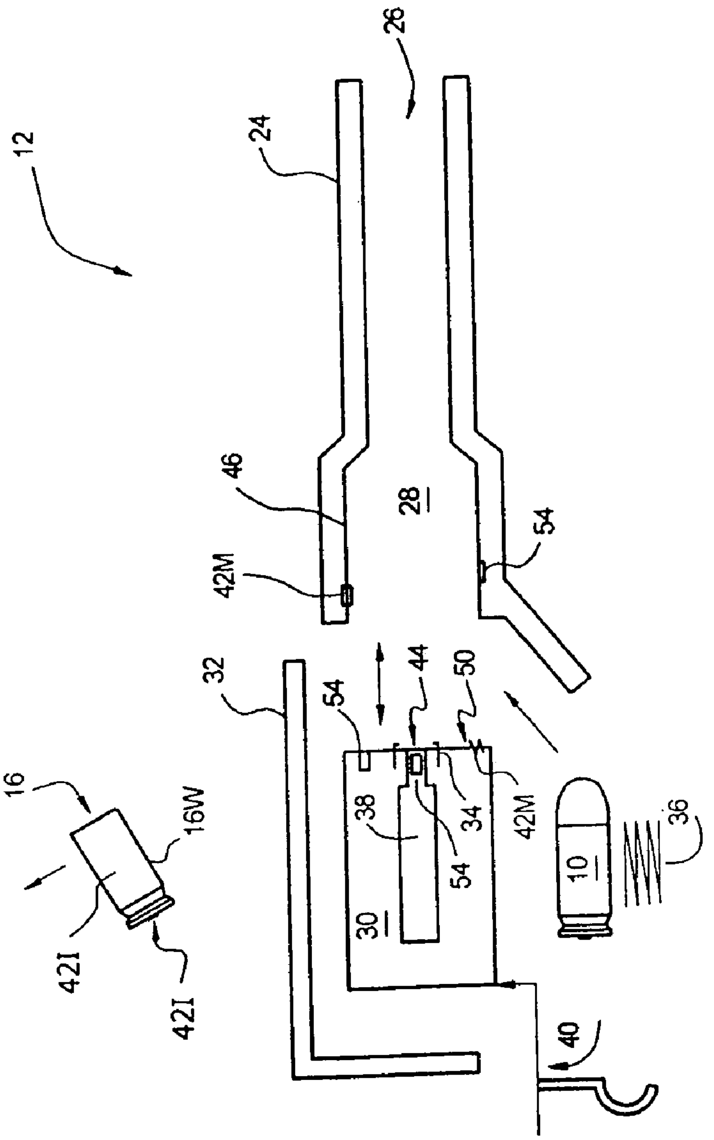
(57) **ABSTRACT**

Imprinting an identification indicia on a cartridge in a difficult context, such as on a coated cartridge or on a high power cartridge. A marking indicia is formed on a base surface located in the interior surface of a cartridge chamber containing the cartridge and includes marking lands raised with respect to the base surface and a maximum marking indicia elevation above the base surface that is coplanar with the interior surface. The marking indicia is thereby recessed with respect to the interior surface and the identification indicia is thereby recessed with respect to the imprint surface.




12
26
24
46
28
42M
54
32
44
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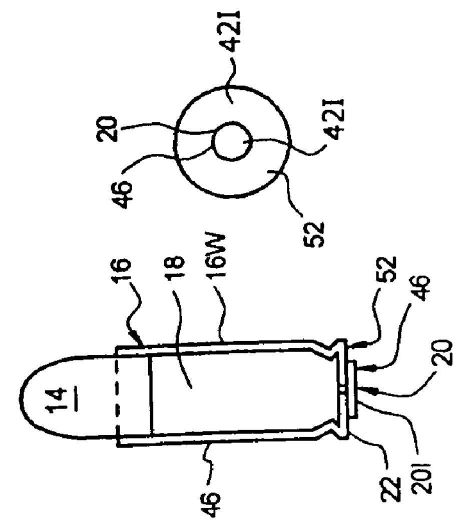
54
38
34
54
42M
30
10
36
40
16
16W
42I
42I

FIG. 2


42I
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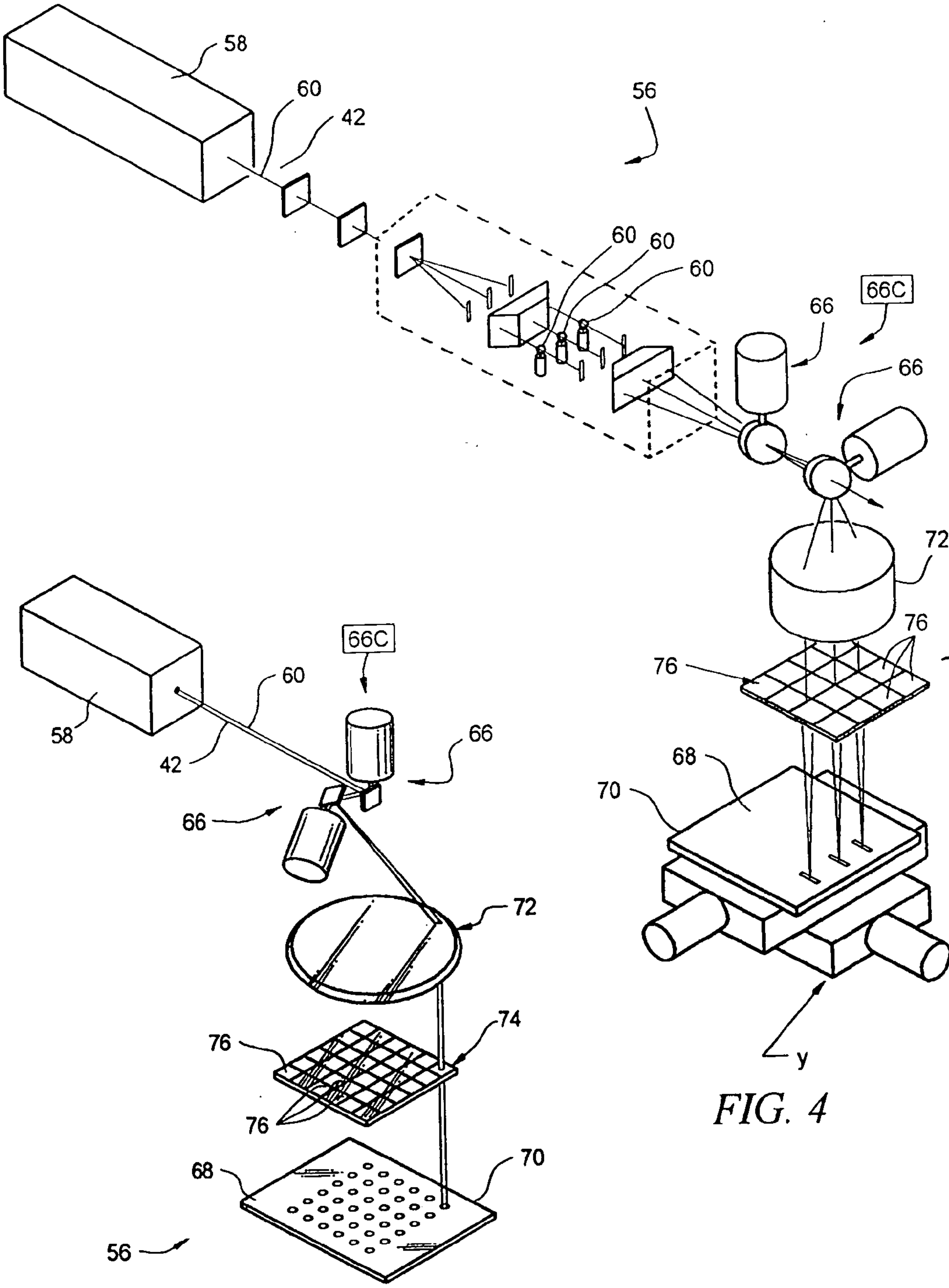
46
52
10
16
18
16W
52
46
20
14
46
22
20I

FIG. 1


58
60
42
56
60
60
60
66C
66
66
72
74
76
76
68
70
y
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66C
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42
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70
56

FIG. 4

FIG. 3

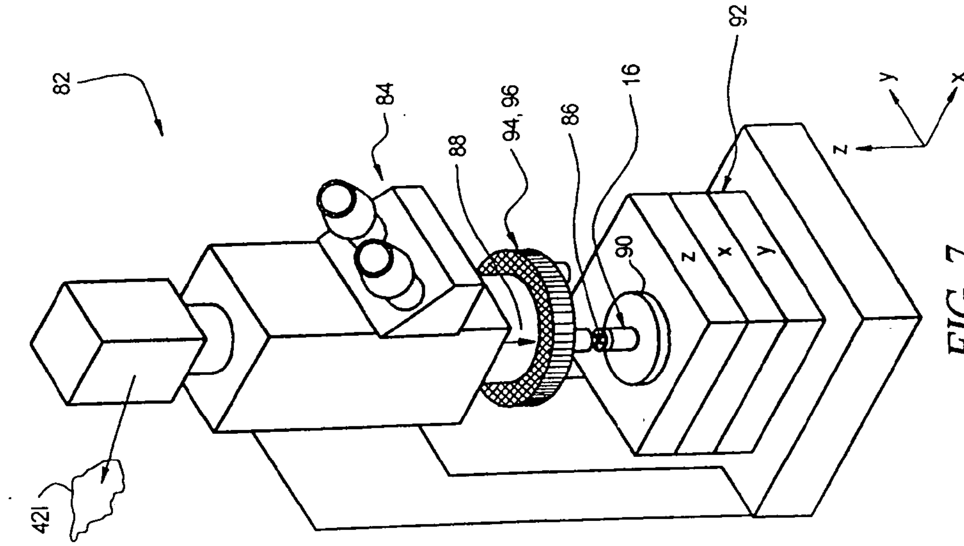


FIG. 7

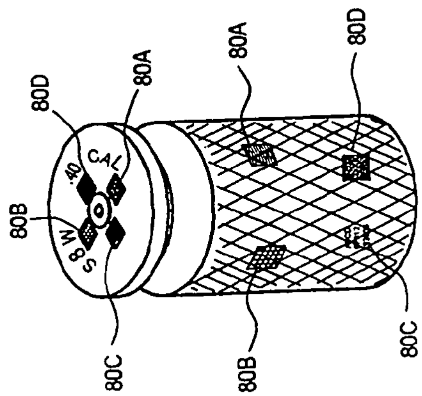


FIG. 6

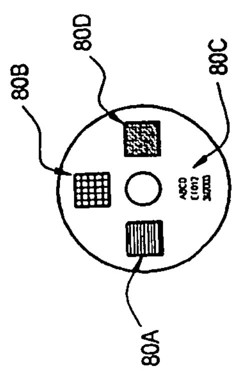


FIG. 5

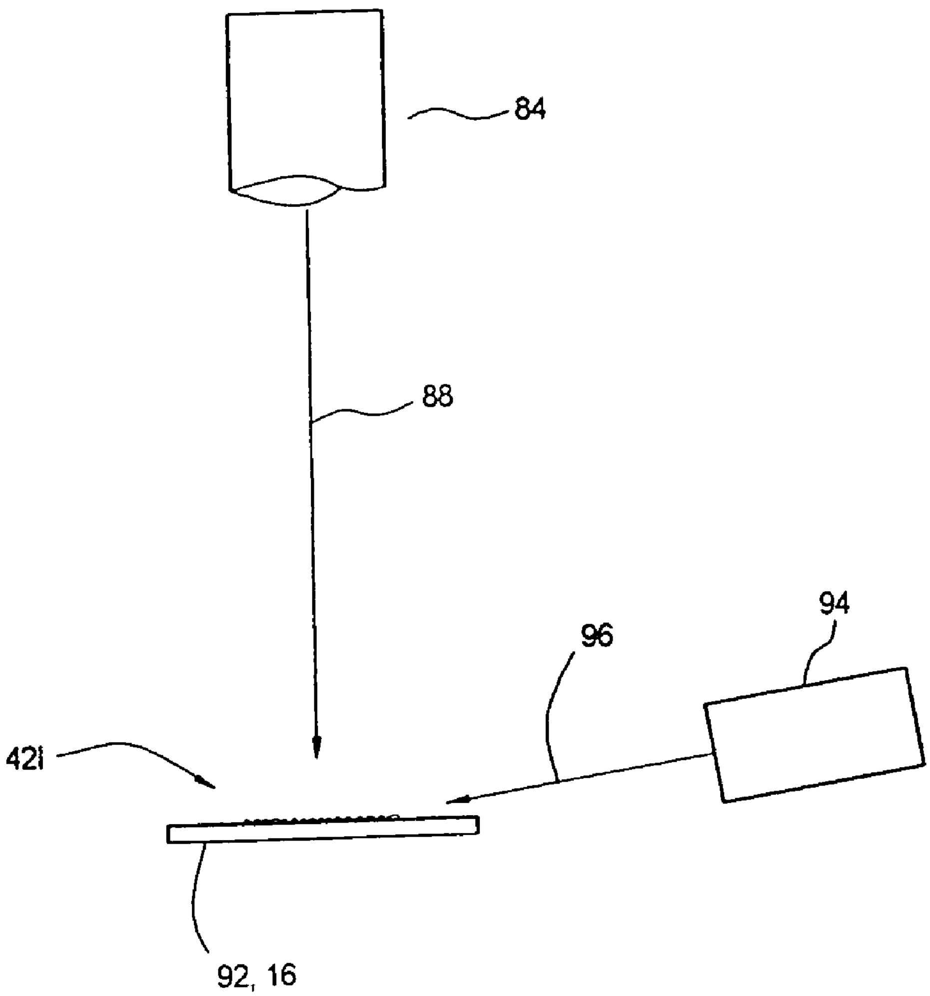


FIG. 8

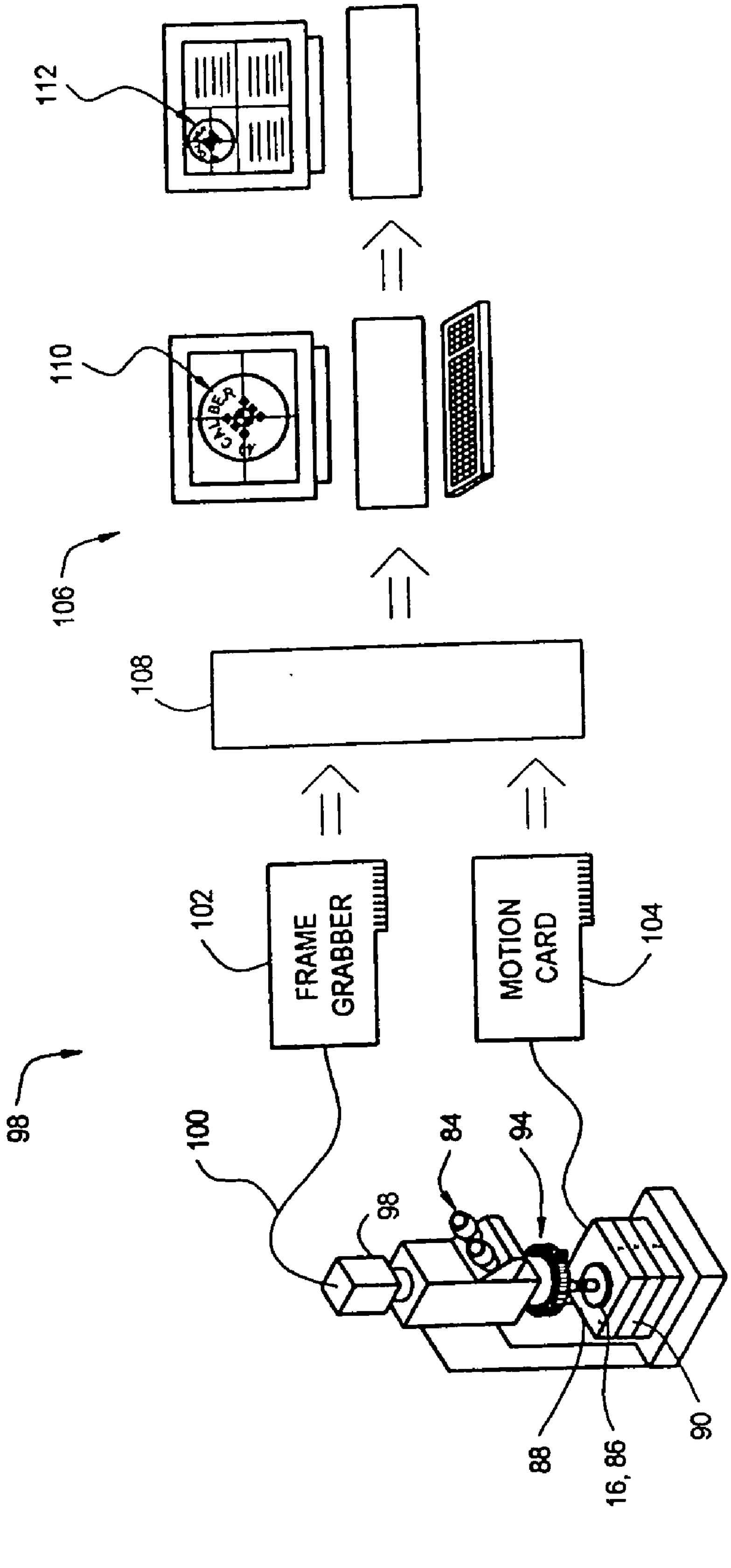

98
100
98
84
94
FRAME GRABBER
102
MOTION CARD
104
108
106
110
112
88
16, 86
90
82

FIG. 9

FIG. 10A

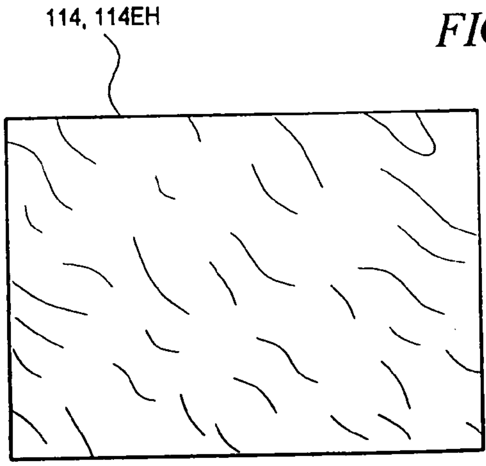


FIG. 10B

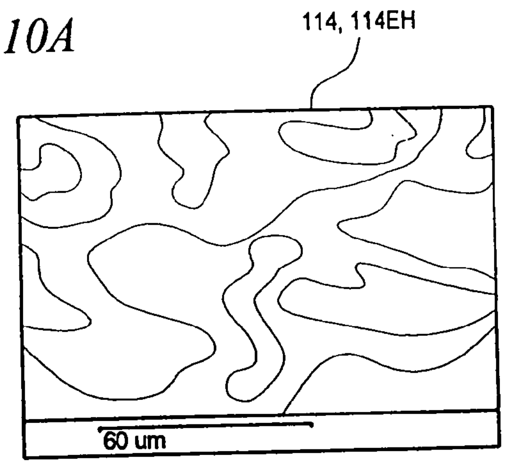


FIG. 10C

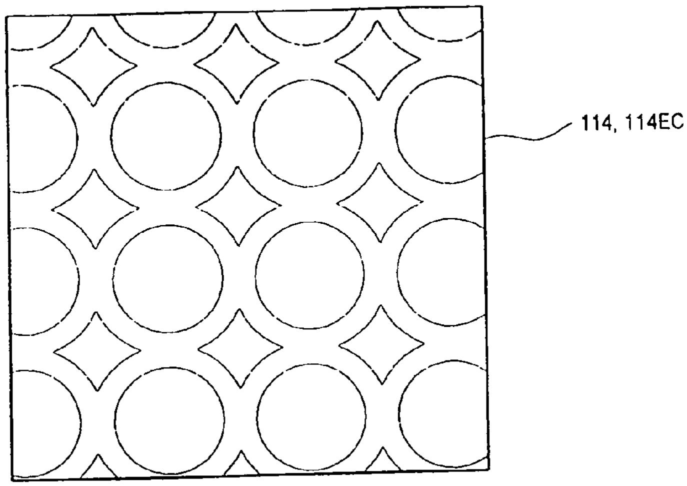


FIG. 11A

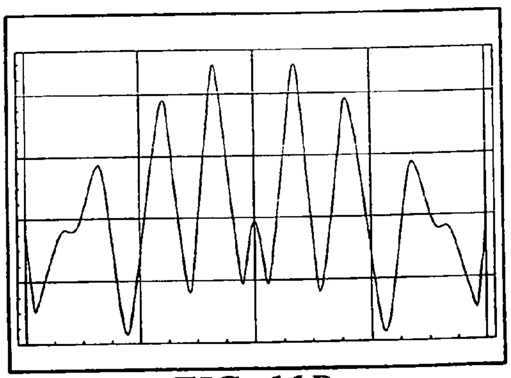


FIG. 11B

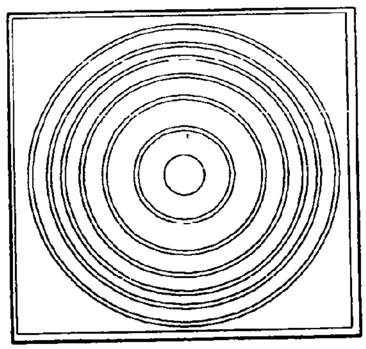
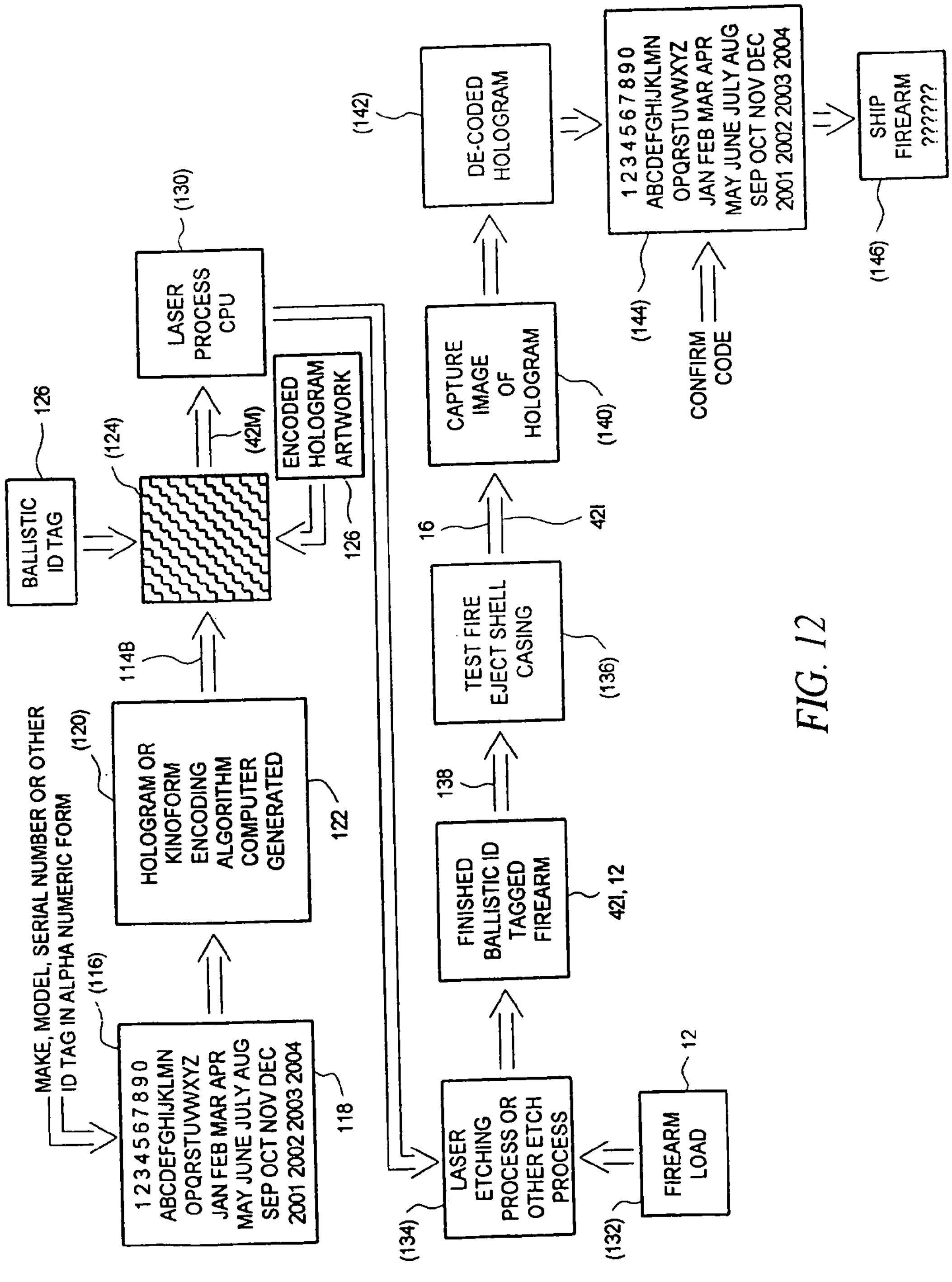


FIG. 11C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(116)
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118
(120)
HOLOGRAM OR KINOFORM ENCODING ALGORITHM COMPUTER GENERATED
122
114B
BALLISTIC ID TAG
126
(124)
(42M)
ENCODED HOLOGRAM ARTWORK
126
LASER PROCESS CPU
(130)
(134)
LASER ETCHING PROCESS OR OTHER ETCH PROCESS
FIREARM LOAD
(132)
12
FINISHED BALLISTIC ID TAGGED FIREARM
42I, 12
138
TEST FIRE EJECT SHELL CASING
(136)
16
42I
CAPTURE IMAGE OF HOLOGRAM
(140)
DE-CODED HOLOGRAM
(142)
1 2 3 4 5 6 7 8 9 0 ABCDEFGHIJKLMN OPQRSTUVWXYZ JAN FEB MAR APR MAY JUNE JULY AUG SEP OCT NOV DEC 2001 2002 2003 2004
(144)
CONFIRM CODE
SHIP FIREARM ??????
(146)

FIG. 12

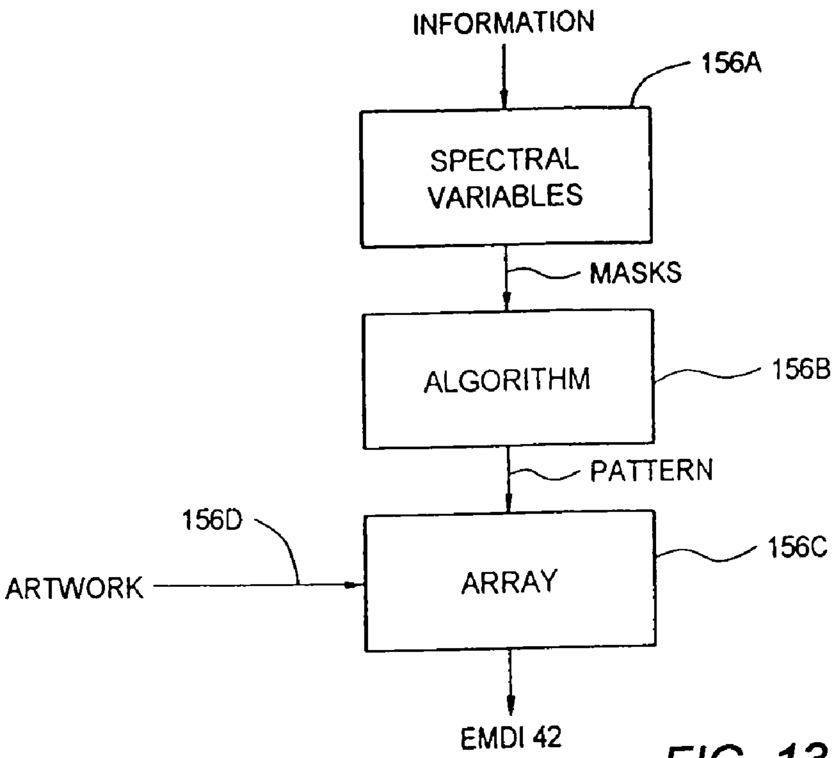

FIG. 13A

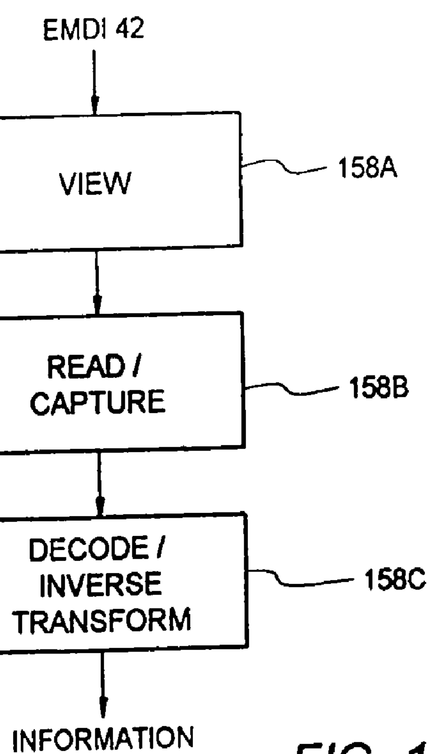

FIG. 13B

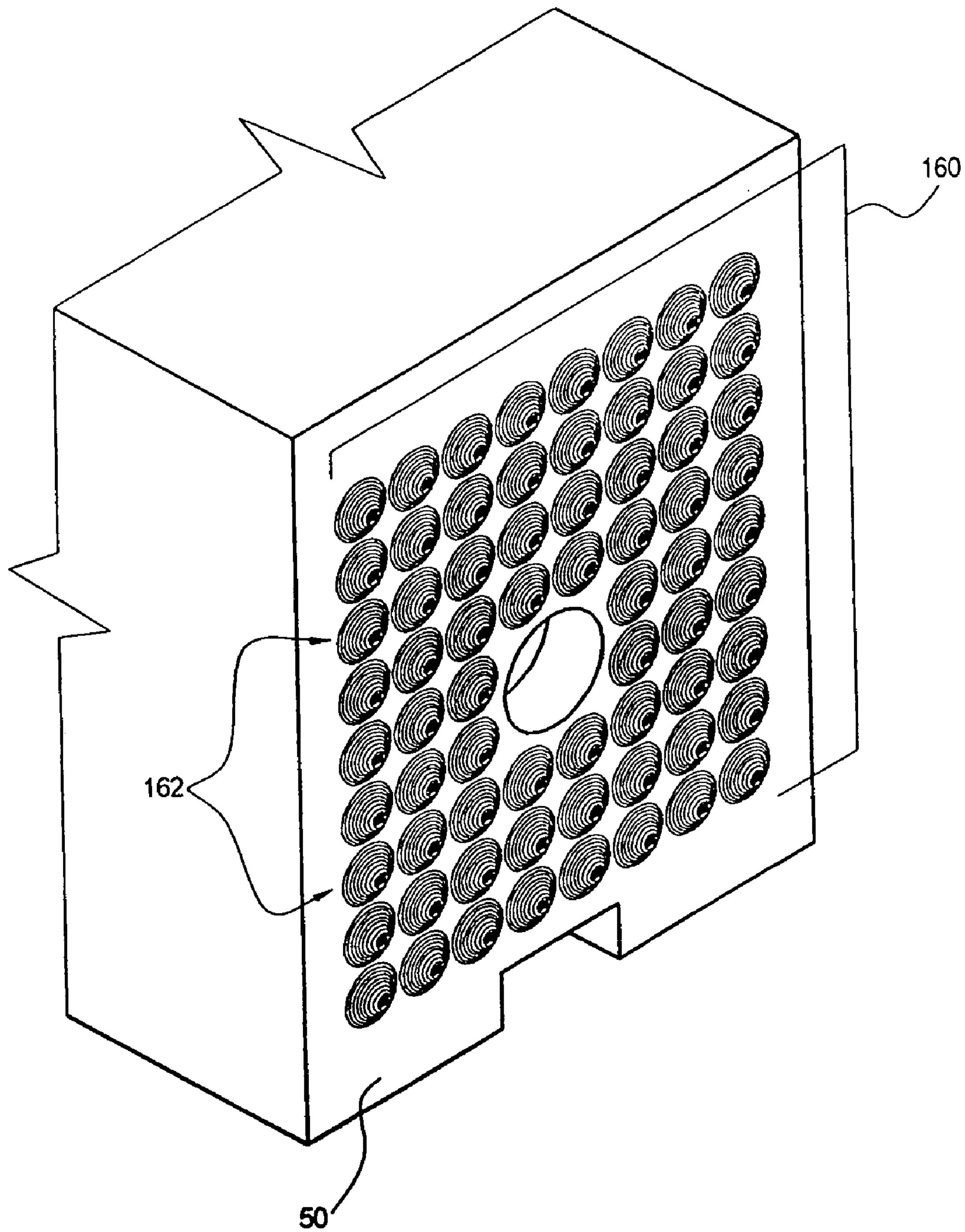

FIG. 14A

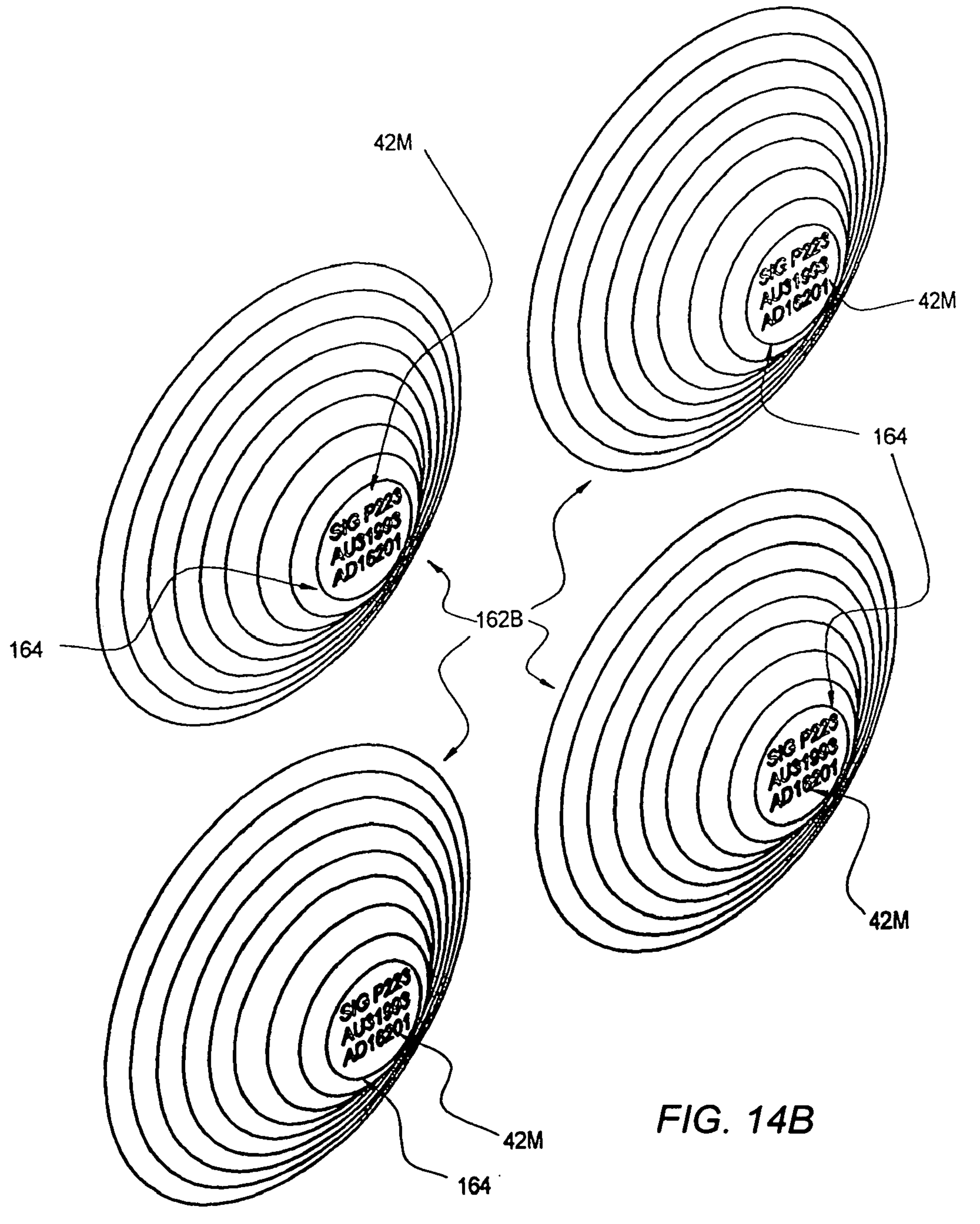

FIG. 14B

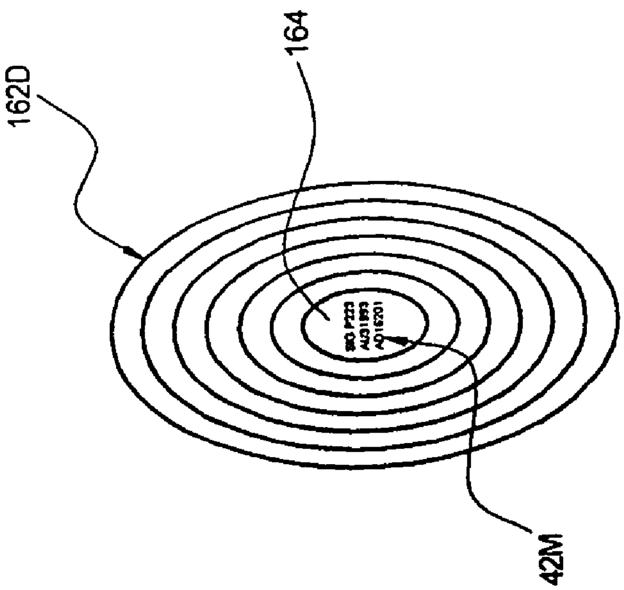

FIG. 14C

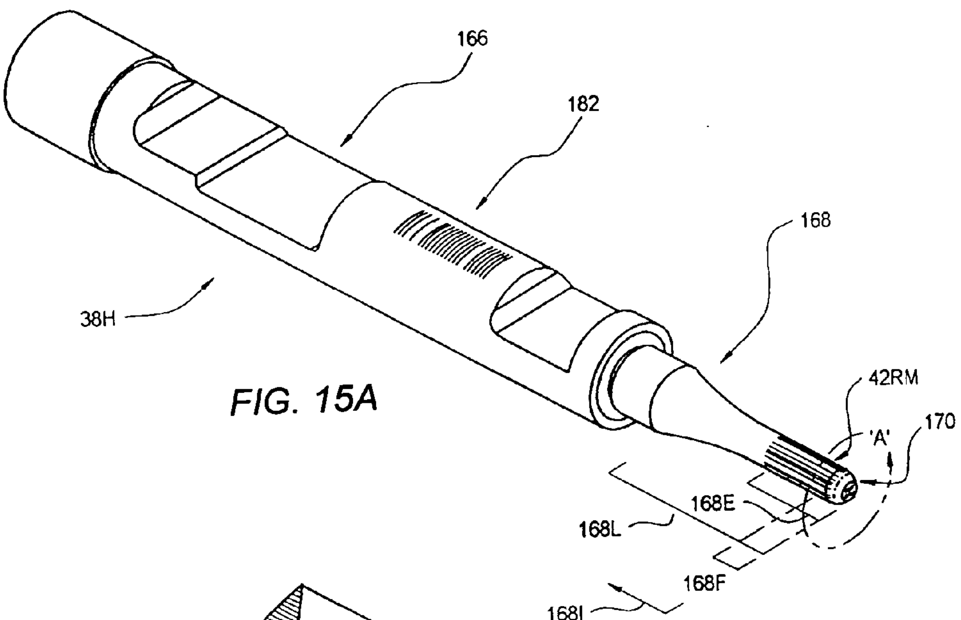

FIG. 15A

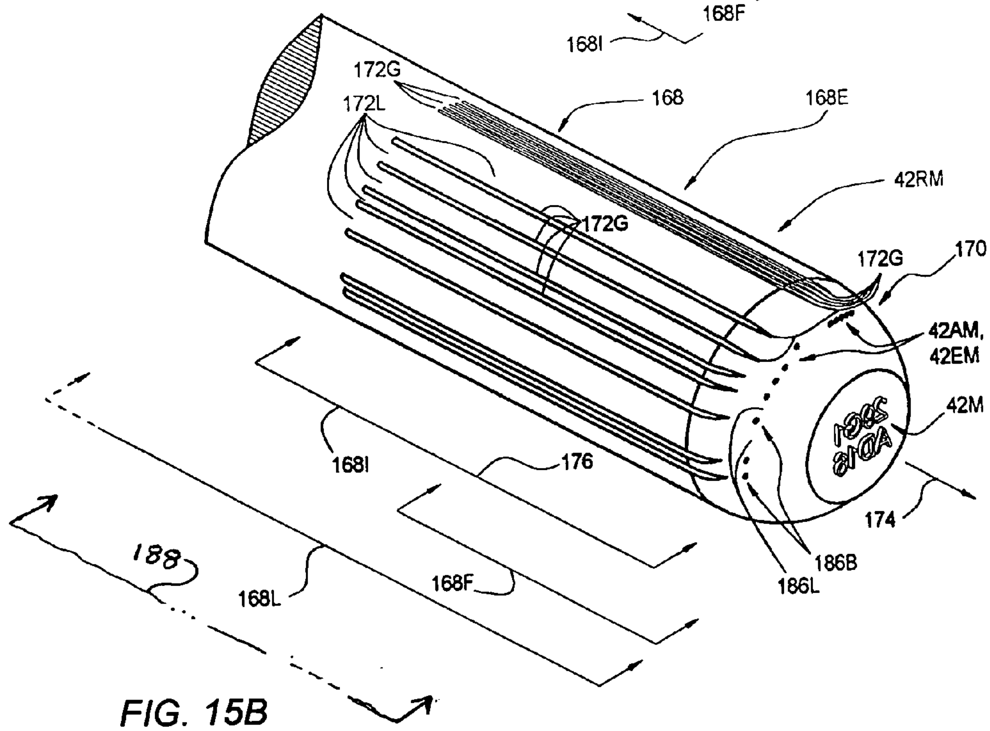

FIG. 15B

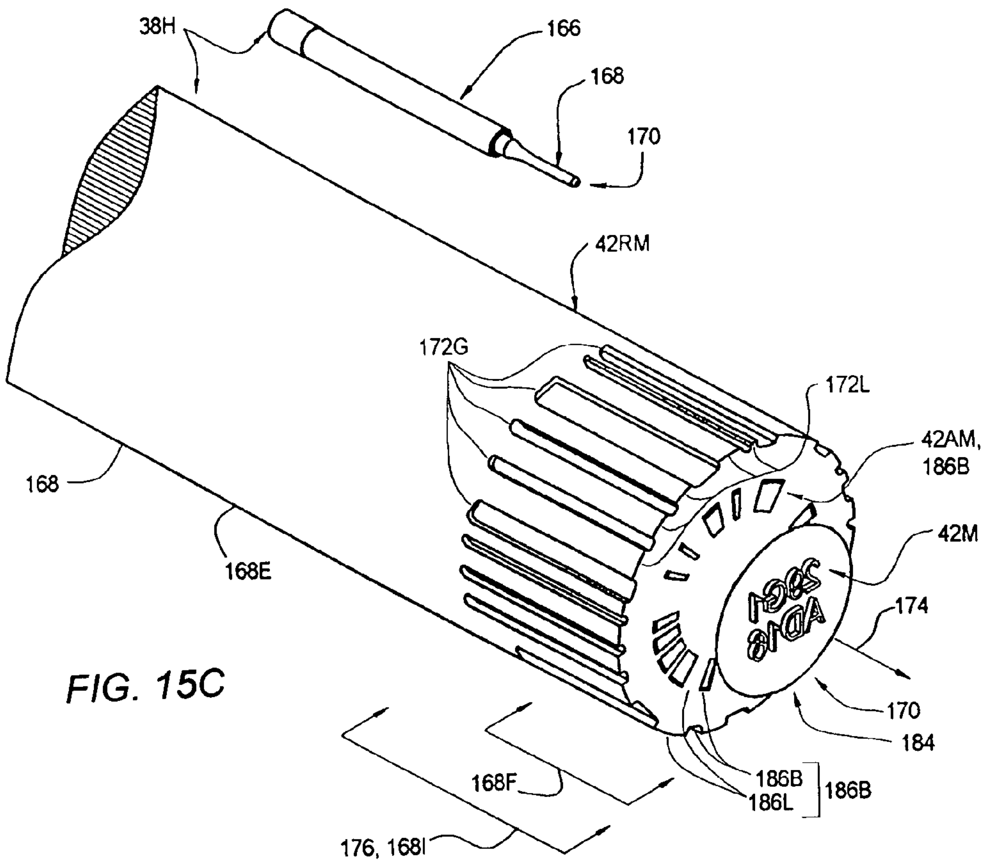

FIG. 15C

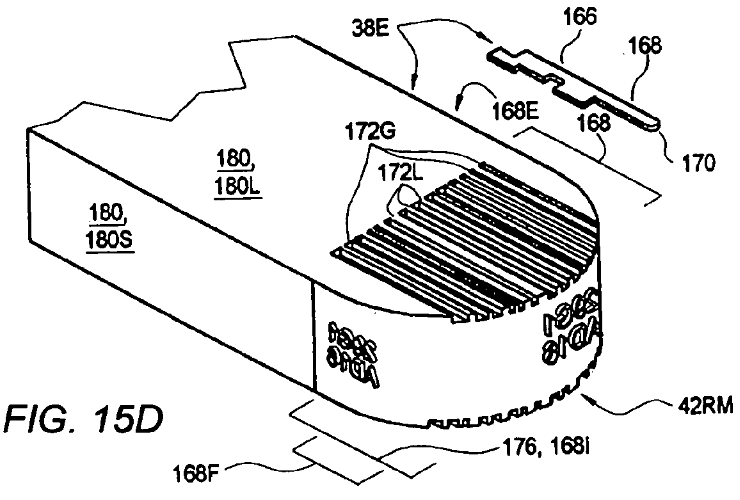

FIG. 15D

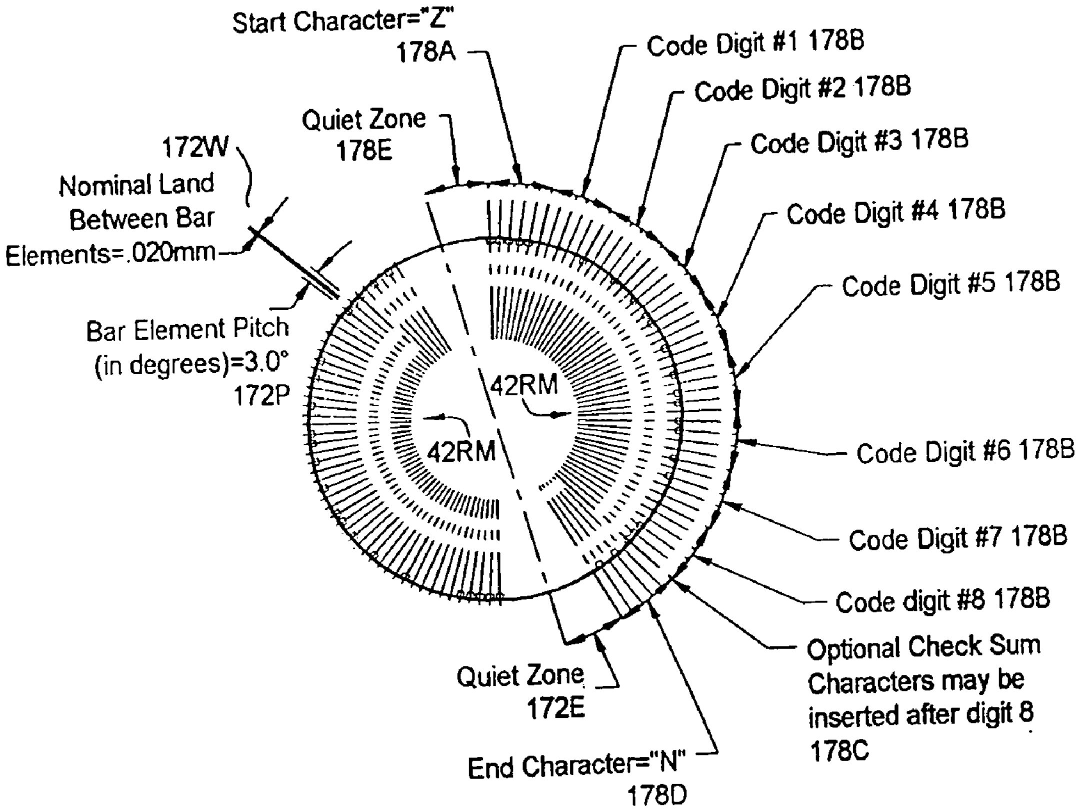

FIG. 16A

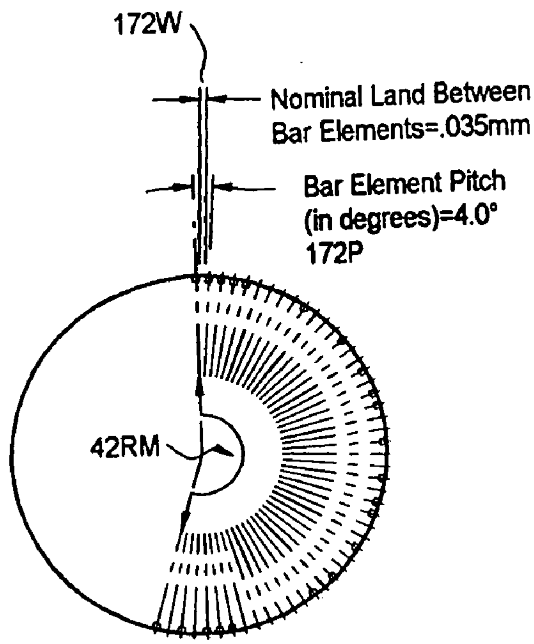

FIG. 16B

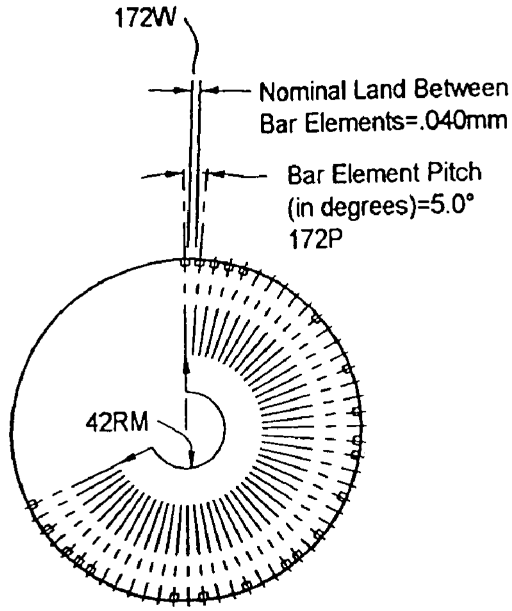

FIG. 16C

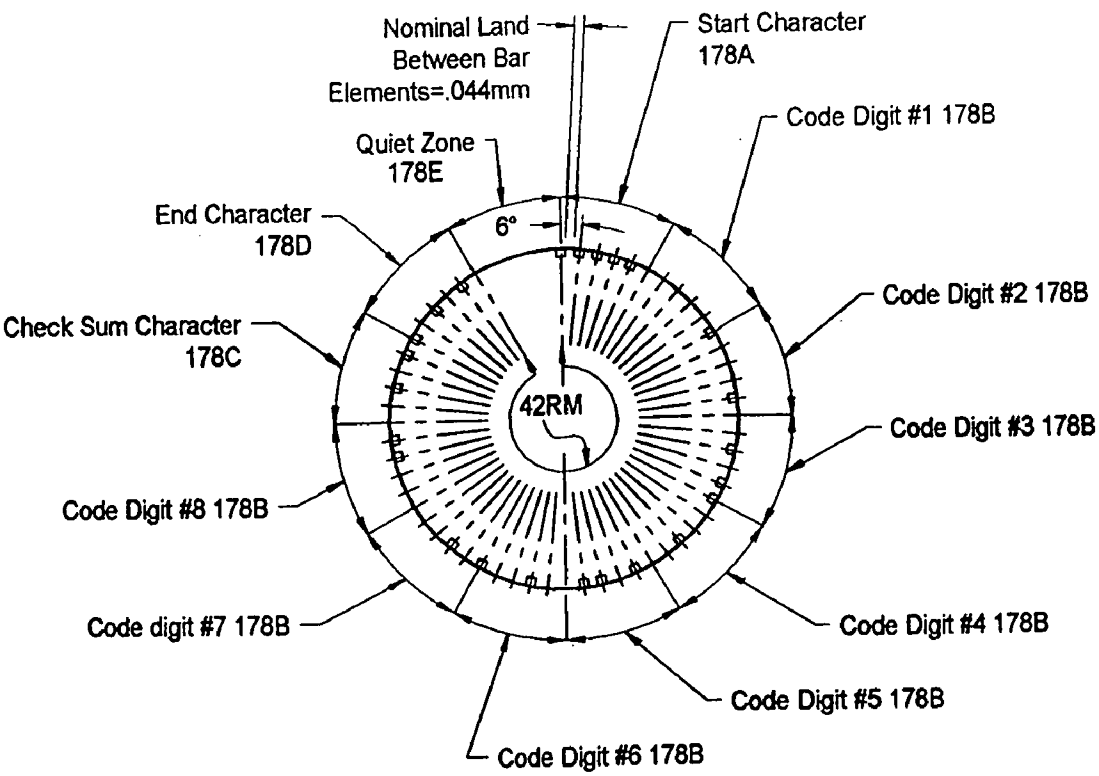

FIG. 16D

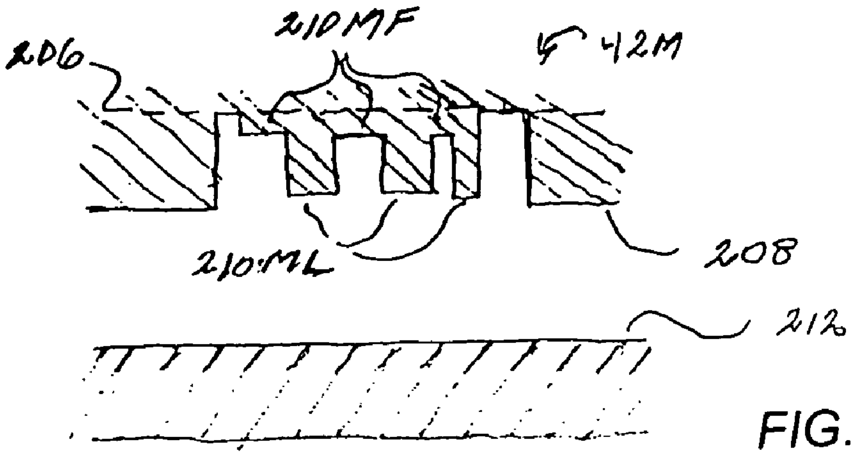

FIG. 17A

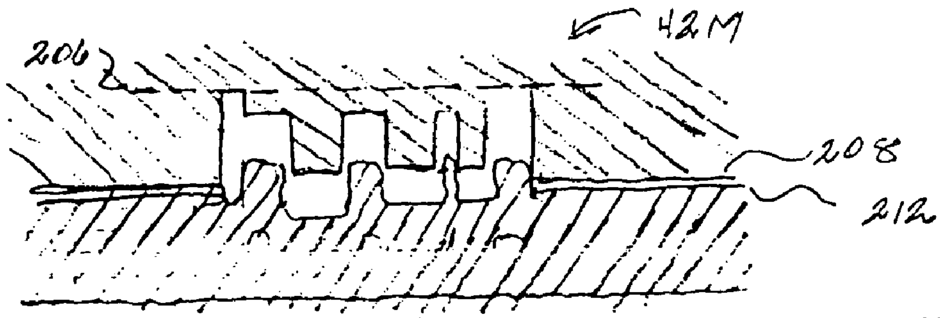

FIG. 17B

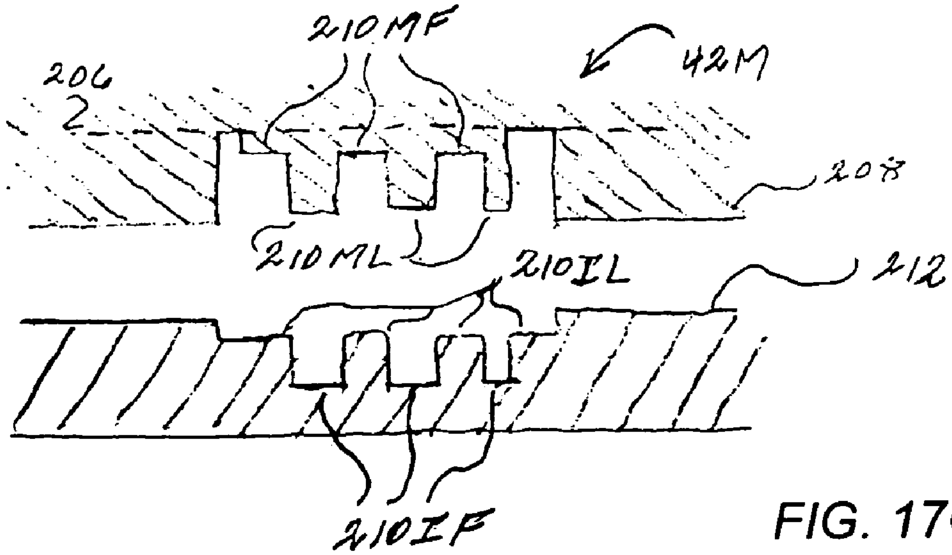

FIG. 17C

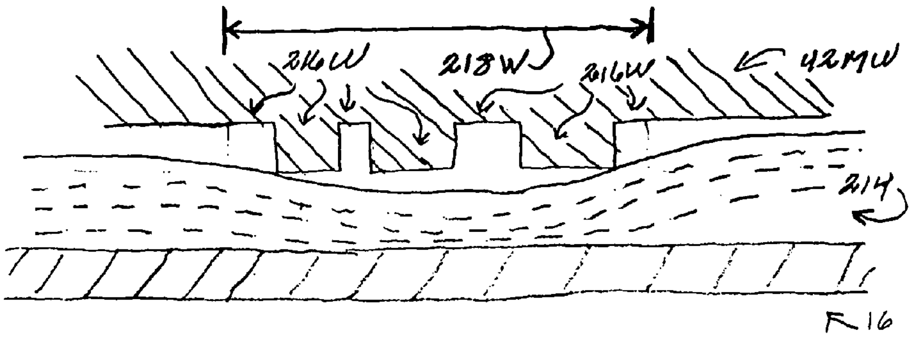

FIG. 18A

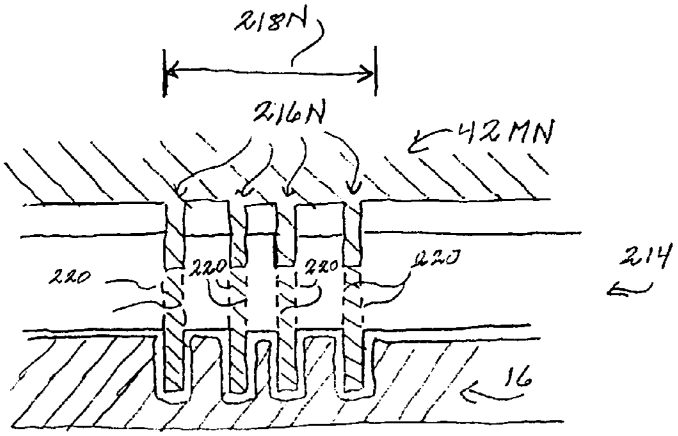

FIG. 18B

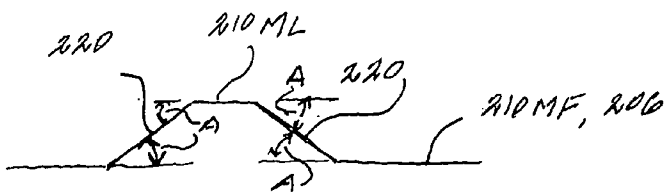

FIG. 18C

METHOD AND APPARATUS FOR CARTRIDGE IDENTIFICATION IMPRINTING IN DIFFICULT CONTEXTS BY RECESS PROTECTED INDICIA

[0001] This application is continuation in part of and claims benefit of U.S. patent application Ser. No. 10/622,236 filed Jul. 18, 2003, which is a continuation in part of and claims benefit of U.S. patent application Ser. No. 10/427,513 filed May 1, 2003, which in turn claims benefit of U.S. patent application Ser. No. 10/372,459 filed Feb. 21, 2003, which in turn claims benefit of U.S. patent application Ser. No. 10/232,766 filed Aug. 29, 2002, which in turn claims benefit of provisional Patent Application Ser. No. 60/315,851 filed Aug. 29, 2001, which is a continuation-in-part of and claims benefit of patent application Ser. No. 10/183,806 filed Jun. 26, 2002, which is a continuation-in-part of and claimed benefit of patent application Ser. No. 09/540,366 filed Mar. 31, 2000, now U.S. Pat. No. 6,420,675 B1, which is a continuation-in-part of and claimed benefit of patent application Ser. No. 09/514,084 filed Feb. 28, 2000, now U.S. Pat. No. 6,310,701 B1, which claimed benefit of provisional Ser. No. 60/158,478 filed Oct. 8, 1999.

FIELD OF THE INVENTION

[0002] The present invention relates to the identification of expended firearms cartridges and, in particular, to improved indicia for identifying a firearm that is the source of an expended cartridge and an improved apparatus for reading identifying indicia marked on a fired cartridge.

BACKGROUND OF THE INVENTION

[0003] Mechanical forensics and ballistics investigations are undertaken in crime investigations, accident reconstructions or other situations in which one or more weapons have been discharged and it is frequently essential to reliably establish an identification of a firearm that fired a given cartridge.

[0004] It is well known that bullets and cartridge cases that have been fired from a firearm will bear markings from contact between the bullets or cartridge cases and the surfaces of the firearm with which the bullets and cartridges come into contact. For example, the rifling of the barrel will emboss rifling and other marks on a bullet, and the firing pin, extractor, interior of the breach and face of the bolt will leave markings on the cartridge case. Certain such markings are general to a given type, manufacturer or model of firearm, and may this aid in identifying a firearm, while others are unique to each firearm and may thereby be used to identify a given firearm.

[0005] Firearms experts have frequently been able to compare the markings on cartridge cases and bullets, which are traditionally referred to as "scratches and dings" or "ballistic finger prints", with comparable markings made by a suspect firearm on a test bullet or cartridge casing, and have frequently been able to determine whether a specific firearm fired a given bullet or cartridge casing. In addition, there exist, for example, databases of "ballistic finger prints" or "scratch and ding" images of bullets and cartridges recovered from crime scenes, which may be subsequently used to match a firearm to a given crime scene by matching samples of fired cartridges and bullets with the archived "ballistic finger prints" or "scratch and ding" images.

[0006] Ballistic finger prints and scratch and ding markings, however, while traditionally the most useful and most used for identifying a given, specific firearm, are, however, pseudo-repeatable and largely random and non-specific in nature. That is, a cartridge case may be damaged in any of a number of ways before it is recovered for examination, and a bullet is often severely fragmented or deformed when it strikes an object, thereby obscuring the ballistic finger print or scratch and ding evidence on the bullet or cartridge case. In addition, the identification of a spent cartridge case or filed bullet to a specific firearm requires access to the firearm itself, either for direct examination or to fire test bullets and cartridge cases for comparison with the cartridge cases or bullets held in evidence. The firearm itself is also subject to influences between the time of firing a cartridge and bullet and the comparison of the markings on the cartridge or bullet to later fired test cartridges and bullets that may alter the markings made by it on cartridges and bullets. For example, the surfaces of a firearm that impose markings on a bullet or cartridge are subject to wear, corrosion, abrasion and intentional alterations, such as grinding , etching or filing of surfaces and the replacement of original parts with different parts.

[0007] In addition, investigators often have limited evidence to work with in order to determine the facts related to the situation at hand, such as when the suspect firearm is unavailable, missing, unrecoverable, damaged or intentionally altered or in instances in which numerous weapons were discharged. For example, it is very common for the perpetrator of a shooting to take a firearm away with him after committing a crime, and often the only evidence left behind is the discharged bullets themselves, if they can be found and are in adequate condition for examination, and spent cartridge cases, if the cartridge cases are available and in condition for examination. Therefore, while scratches, marks and/or other indicia on a spent bullet or cartridge case can assist an investigator with connecting the spent cartridge or bulletwith a given firearm, the identification usually requires possession of the firearm itself, for comparison purposes, is often difficult even when the firearm is available.

[0008] Currently, such forensic investigations are expensive and time consuming and require personal training and sophisticated equipment that not every law enforcement department has or can afford.

[0009] A concept referred to as "Ballistic Tagging", however, may be used to mark cartridges or bullets or both with specially encoded geometric shapes, holograms, alphanumeric codes, barcodes and other specific coding techniques which are not random and are which are completely repeatable and which are unique to each firearm. Such methods would be more reliable and less expensive and time consuming than traditional methods, and would not require the costly apparatus, imperfect imaging algorithms, image acquisition technical problems, non-standardized procedures and cross jurisdictional procedures and data bases used to store and share "ballistic finger prints" or "scratch and ding" images.

[0010] There are currently available a variety of systems for forming or micro-engraving images, shapes or symbols in or on an surface of a component of a firearm that contacts a bullet or cartridge case in such a manner as to permit the imposition of an identifying indicia on a bullet or cartridge case. Examples include such firearm surfaces as the face of a firing pin, the interior of the chamber or barrel of a firearm, or a surface of an extractor or loading mechanism. Any firearm surface coming into contact with a cartridge case with sufficient force or pressure, for example, can result an image, shape of symbol being embossed or otherwise marked on a surface of the cartridge by the normal operation of the firearm, such as the loading, firing or ejection of the cartridge. Such images, shapes or symbols, hereafter referred to generally as "images" or "indicia", may take many forms, including abstract symbols or brands, letters or numbers, and so on, and are typically formed of raised or indented areas of a surface, such as holes, vias, blind vias or some other form of surface indentation, raised areas formed by etching or machining away of surrounding surfaces, or any combination thereof.

[0011] As a result, fired bullets or cartridge cases or both may be left with markings uniquely identifying the firearm from which they were fired as a result of forced contact between the bullets or cartridge cases and metal parts in the firearm bearing such identifying images. Such parts of a firearm may include, for example, an interior face of the chamber, bolt or barrel or an engraved "marker" embedded in or mounted on such a surface, and may be unique to given firearm by the engraving of an image unique to the firearm during manufacture or as a result of a subsequent refitting or retro-fitting.

[0012] The advantages of such marking of bullets and cartridges can be realized, however, only if there exist suitable identifying indicia and methods, suitable apparatus for simply, inexpensively and reliably imprinting and reading the markings, and suitable apparatus for correlating the markings on a bullet or cartridge with a given firearm.

[0013] A number of problems in identifying cartridge cases, bullets and firearms still remain unresolved, however, even given means and methods for marking cartridge cases with identifying indicia and means for reading such indicia, such as evasion of the marking system and obtaining the maximum useful information from the marking system. Evasion of the system is, for example, a particular problem if the marking indicia is located in or on an accessible or removable and replaceable part of a firearm. In such instances, an individual or group wishing to evade the indicia marking mechanism may either attempt to eradicate, mutilate or otherwise obscure the indicia marker, or may replace the part bearing the marking indicia marker with a part having a different marking indicia or with a part not having an marking indicia. In the case of firing pins, for example, the marking indicia may be engraved or etched into the striking end or face of the firing pin that strikes the cartridge primer, and the marking system may be evaded by replacing the firing pin with a firing pin not having a marking indicia, or by filing or grinding off a portion of the end of the firing pin, thereby removing or obliterating the marking indicia. In other instances, such as when the marking indicia is located on the face of the bolt or on an inner wall of the chamber, the marking indicia may be removed or obliterated by grinding or etching that portion of the chamber wall.

[0014] The question of obtaining the maximum useful information from the system addresses yet other issues. For example, the location at which a fired cartridge case is found at a shooting scene is frequently critical to an investigation, particularly in instances involving multiple firearms or multiple shots from a given firearm. The traditional procedures, however, require an investigation team to attach an identification to the case, for example, by placing the case in an evidence bag, and to determine the location of the case, usually by photographs or by physical measurement from a selected point, and to record the identification of the case and the location at which it was found. The case is then sent to a laboratory to identify and record any identifying "ballistic finger prints" or "scratch and ding" marks, which may then be matched up with a firearm, if available, by identifying the "ballistic fingerprints" of the firearm. It will be appreciated, therefore, that the present methods, with multiple, separate pieces of evidence and information and multiple handling and recording of the evidence by many persons over an extended period of time, often months or years, provides rich opportunities for error and loss of evidence.

[0015] It is, therefore, an object of the present invention to simplify and therefore to improve the process of fired cartridge and bullet imaging and analysis, to eliminate the need for complex image algorithms, to reduce the chances of human error, and to eliminate at least some of the need for mapping "scratches and dings" and "ballistic finger prints" of fired cartridges and bullets.

SUMMARY OF THE INVENTION

[0016] The present invention is directed to a method and apparatus for imprinting an identification indicia on an imprint surface of a cartridge when the cartridge is fired wherein the marking is performed in a difficult context, such as on a coated cartridge or on a high power cartridge.

[0017] According to the present invention, a marking indicia is located on an interior surface of a firearm chamber and is formed on a base surface located in the interior surface of a chamber containing the cartridge. The marking indicia includes a plurality of marking lands raised with respect to the base surface and with a maximum marking indicia elevation above the base surface that is coplanar with the interior surface, and a plurality of marking floors between and separating the marking lands.

[0018] According to the present invention, when the cartridge is fired the marking indicia and the imprint surface are forced into mutual contact to imprint a reverse image of the marking indicia in the imprint surface as the identification surface. The identification indicia then includes a plurality of indicia lands corresponding to the marking floors and a plurality of indicia floors corresponding to the marking lands, wherein the indicia lands are elevated with respect to the indicia floors with a maximum identification indicia elevation above the indicia floors that is coplanar with the imprint surface.

[0019] According to the present invention, therefore, the marking indicia is recessed with respect to the interior surface and the identification indicia is recessed with respect to the imprint surface.

[0020] In one implementation of the present invention, the interior surface is a striking surface of a firing pin and the marking indicia is brought into contact with the imprint surface by a striking action of the firing pin against the imprint surface and the imprint surface is located on a primer of the cartridge.

[0021] In another implementation of the present invention, the interior surface is an inner surface of the firearm chamber abutting a wall of the cartridge case and the marking indicia is brought into contact with the imprint surface by expansion of the cartridge case wall due to a propellant charge pressure in the cartridge case.

[0022] Further according to the present invention, the marking indicia is a holographic image.

[0023] Also according to the present invention, the maximum width of the marking indicia is less than 200 microns and a maximum width of a marking land is less than 35 microns. Also, the angle of each interior wall extending between a point on a marking land and an adjacent point of a marking floor is in the range of 6 to 22.5 degrees, and the ratio between the area of the marking lands of a marking indicia and the total area of the marking indicia is in the range of 6:1 to greater than 9:1.

BRIEF DESCRIPTION OF THE DRAWINGS

[0024] The invention will now be described, by way of example, with reference to the accompanying drawings in which:

[0025] **FIG. 1** is a diagrammatic representation of a round of ammunition;

[0026] **FIG. 2** is a diagrammatic representation of a firearm;

[0027] **FIGS. 3 and 4** are diagrammatic representations of laser systems for creating indicia;

[0028] **FIGS. 5 and 6** are illustrations of indicia on a cartridge case;

[0029] **FIGS. 7, 8** and **9** and diagrammatic representations of an indicia imaging device and an indicia imaging and recognition system;

[0030] **FIGS. 10A, 10B** and **10**C are representations of encoded hologram indicia;

[0031] **FIGS. 11A, 11B** and **11**C are representations of aspects of an encoded concentric circular barcode;

[0032] **FIG. 12** is a diagram of the marking of a firearm with an multi-dimensional encoded indicia;

[0033] **FIGS. 13A and 13B** are diagrams of the creation and reading of a multi-dimensional encoded indicia; and,

[0034] **FIGS. 14A, 14B** and **14**C are diagrammatic representations of marking arrays on a firearm surface for increasing the probability of imprinting of an identification indicia;

[0035] **FIGS. 15A, 15B**, **15**C and **15**D are diagrammatic representations of evasion resistant marking indicia as used on a firing pin;

[0036] **FIGS. 16A, 16B**, **16**C and **16**D are representations of coding for evasion resistant marking indicia;

[0037] **FIGS. 17A, 17B** and **17**C illustrate the imprinting of a recessed marking indicia as an identification indicia; and,

[0038] **FIGS. 18A, 18B** and **18**C illustrate the imprinting of wide and narrow marking indicia.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0039] A. Introduction

[0040] The following will first discuss the elements and operation of a typical firearm, cartridge and bullet, by way of a general introduction to parts and operations of a firearm in imposing identifying indicia on bullets or cartridge cases and to establish common definitions and points of reference. The following will then provide an introduction to the methods and apparatus for embossing or imprinting identifying indicia by a firearm on a cartridge case or bullet, following by a discussion and description of a laser system for generating or providing, on a part of a firearm, the "micro-engraving" or "micro-stamping" tool or image necessary to emboss or stamp an identifying indicia or a cartridge case or bullet.

[0041] Given foundation descriptions of the technology involved in and related to the present invention, the following will then describe the present invention and presently preferred embodiments of the invention, including presently preferred forms of identifying indicia and a method and apparatus for reading and identifying such indicia.

[0042] B. General Descriptions of Firearms and Cartridges and the Imprinting of Indicia by the Mechanisms of a Firearm

[0043] As discussed above and as will be described in the following, the present invention is directed to a method and apparatus for forming surface markings forming identifying indicia on an interior surface of a firearm, such as a breech, a firing pin, a cartridge extractor or a loading mechanism, to preferred types of indicia, and to a method and apparatus for reading and identifying such indicia when stamped or otherwise marked on a cartridge case, for example, by operation of the firearm. In particular, the present invention may be employed to form, read and identify a desired unique bar code, matrix, an alpha numeric code, or any desired identifying indicia on a surface of a firearm or on the surface of a cartridge case or bullet fired from the firearm and, in particular, a hologram indicia as described in the following.

[0044] First considering the general structures, mechanisms and operations of cartridges, bullets and firearms that facilitate the embossing or imprinting of an identifying indicia onto a cartridge case of bullet, the definitions established in the following discussions will be used throughout the following descriptions. Accordingly, and as illustrated in **FIG. 1**, a Round **10** of ammunition includes a Bullet **14** mounted in the end of a Cartridge Case **16** containing a Propellant Charge **18** and having a Primer **20** in the Base **22** of the Cartridge Case **16**. As is well known, a firearm firing pin strikes and ignites Primer **20**, which in turn ignites Propellant Charge **18**, and the combustion of Propellant Charge **18** generates hot gases at high pressures that propel the Bullet **14** out of the barrel of the firearm.

[0045] Referring to **FIG. 2**, a Firearm **12** generally includes a Barrel **24** having a Muzzle **26** from which the Bullet **14** is expelled and, at the opposite end, a Chamber **28** for receiving and holding a Round **10** before and during the firing of the Round **10**. The Round **10** is secured in Chamber

28 for firing by a Bolt 30 that moves forwards and backwards in Breach 32 to load successive Rounds 10 into the Chamber 28 and to extract and eject fired Cartridge Cases 16 from the Chamber 28 and Breach 32. Bolt 30 will typically include an Extractor 34 mechanism that engages the Cartridge Case 16 to extract and eject the Cartridge Case 16 and a Loading Mechanism 36 will typically be associated with the Breach 32 to feed successive Rounds 10 into the Breach 32 and to Bolt 30 to be loaded into Chamber 28 by Bolt 30. Bolt 30 will also include a Firing Pin 38, which is usually spring loaded and which is released at the appropriate point in the operations of Firearm 12 by Trigger Mechanism 40 to strike and ignite the Primer 20 of a Round 10 in Chamber 28. As described, the Primer 20 will in turn ignite Propellant Charge 18 to drive Bullet 14 down Barrel 24 and out Muzzle 26. Forces generated by the firing of Round 10, such as gas pressure in Barrel 24 or against the interior base of Cartridge Case 16 or recoil forces acting on Barrel 24, will cause the extraction and ejection of the spent Cartridge Case 16 and, possibly, the loading of a new Round 10 by Loading Mechanism 36.

[0046] It will be apparent from the above, and it is well known to those of ordinary skill in the relevant arts, that the operations of a Firearm 12 will result in pressures and forces on a Cartridge Case 16 or Bullet 14 by various components of the Firearm 12 to emboss or otherwise imprint identifying indicia on the Cartridge Case 16 or Bullet 14. For example, Firing Pin 38 will impact Primer 20 will sufficient force that an Marking Indicia 42M on Firing Pin Face 44 will imprint a corresponding inverse Identifying Indicia 42I on the Impact Face 20I of Primer 20. In addition, the pressures generated within a Cartridge Case 16 by the burning Propellant Charge 18 will cause Circumferential Wall 16W to expand against Inner Surface 46I of Chamber 28 with sufficient pressure that the corresponding inverse image of an Marking Indicia 42M on the Inner Surface 48 will be imprinted as an Identifying Indicia 42I on Circumferential Wall 16W. In a like manner, either or both of the force exerted by Bolt Face 50 on Base Face 52 of a Cartridge Case 16 in chambering a Round 10 and the pressure exerted by Base Face 52 on Bolt Face 50 by ignition of the Propellant Charge 18 will imprint a Marking Indicia 42M on Bolt Face 50 as an Identifying Indicia 42I on Base Face 52. It will also be recognized that Extractor 34 mechanisms in particular, and possibly Loading Mechanisms 36, may operate with sufficient force or pressures to imprint Identifying Indicia 42I on the surfaces of a Cartridge Case 16 with which they come into contact. It will also be noted, and is well known, that the interior surfaces of Barrel 24 will imprint various marks on the external surface of a Bullet 14.

[0047] While there are thereby a variety of surfaces in a Firearm 12 that may bear Marking Indicia 42M and imprint the corresponding inverse Identifying Indicia 42I, it will be understood that certain surfaces are preferable over others for these purposes. For example, the forces exerted by an Extractor 34 mechanism or a Loading Mechanism 36, and the areas of a Cartridge Case 16 that they operate upon, are generally insufficient for the desired Identifying Indicia 42I. In further example, and while a Firing Pin Face 44 is of sufficient dimensions and strikes with sufficient force to provide acceptable Identifying Indicia 42I, a Firing Pin 38 is readily removed and replaced, thereby breaking the correspondence between a Firearm 12 and the Identifying Indicia 42I.

[0048] According to the present invention, therefore, the preferred Firearm 12 surfaces for imprinting Identifying Indicia 42I on a Cartridge Case 16 include, for example, Inner Surface 46I of Chamber 28 and Bolt Face 50 of Bolt 30, as indicated in FIG. 2, but may include other surfaces. It will also be apparent that the material or structure comprising Marking Indicia 42M must have sufficient hardness and durability to physically stamp Marking Indicia 42M into or onto large numbers of Cartridge Cases 16 and into or onto a range of Cartridge Case 16 materials, such as brass, steel, other metals and yet other materials.

[0049] For these reasons, one or more Marking Indicia 42M may preferably formed directly in or on the materials of Inner Surface 46I of Chamber 28 or Bolt Face 50 as the materials of Chamber 28 and Bolt 30 normally possess the required hardness and durability. The Marking Indicia 42M may thereby be formed in, for example, an Inner Surface 46I of a Chamber 28, in a Bolt Fact 50 or in a Firing Pin Face 44, and may assume any desired form, such as a code, a bar code, a character set, a symbol, a design or any other identifying mark, and may be formed by a recessed indicia etched into the surface, a raised indicia formed by etching away the surrounding surface, or a combination thereof.

[0050] In other embodiments, or in addition to Marking Indicia 42M formed directly in the materials of Bolt 30 or Chamber 28, for example, Marking Indicia 42M may be implemented through Marking Inserts 54 which are attached to or preferably embedded in the material of, for example, Inner Surface 46I of Chamber 28, Bolt Face 50 or Firing Pin Face 44. Marking Inserts 54 may be comprised of any material suitable for the purpose, such as stainless steel, hardened steel, titanium, composites, ceramics, and so on, and will bear the Marking Indicia 42M on a Marking Face 54F that comes into contact with, for example, the Cartridge Case 16 or Primer 20. Again, the indicia may assume any desired form, such as a code, a bar code, a character set, a symbol, a design or any other identifying mark, and may be formed by a recessed indicia etched into the surface, a raised indicia formed by etching away the surrounding surface, or a combination thereof.

[0051] A Marking Insert 54 may be of any cross section shape suitable for mounting the Marking Insert 54 onto or into the selected Firearm 12 component or components, such as, the Inner Surface 46I of a Chamber 28, a Bolt Face 50 or a Firing Pin Face 44. A Marking Insert 54 may, for example, be cylindrical, hexagonal, pentagonal, square, triangular, round, elliptical or frusto-conical in cross section and may be mounted onto or preferably into the selected Firearm 12 surface by, for example, mechanical bonding, welding, soldering, or an interference fit, or may be threaded into the Firearm 12 component. The Marking Face 54F will generally be shaped to conform to the surface in which the Marking Insert 54 is embedded, such as a flat Bolt Face 50 or a cylindrical Inner Surface 46I of a Chamber 38 or a domed Firing Pin Face 44.

[0052] It will be recognized that a plurality of Marking Indicia 42M may be implemented in a given Firearm 12 and may be formed upon or embedded in any Firearm 12 surface that is brought into contact with any element or part of a Cartridge Case 16. In presently preferred embodiments, there are a plurality of Marking Indicia 42M located on or embedded in a plurality of components or surfaces of a

Firearm **12** to increase the probability that there will be at least one sufficiently clear Identification Indicia **42I** on any given fired Cartridge Case **16**.

[**0053**] In addition, the locations of the Marking Indicia **42I** are preferably selected so that they cannot be readily removed by a simple replacement of a part, such as a firing pin, cannot be easily removed or mutilated by other means, and, preferably, cannot be readily located. Also, in the preferred embodiments of Identification Indicia **42I**, the Identifying Indicia **42I** should uniquely identify each Firearm **12**, and if possible each major component of a Firearm **12**, such as a Barrel **24**, Bolt **30** or Chamber **30**, by including such information as a unique identifying number or code, the type, model, manufacturer, and date of manufacture of the firearm or component, and so on.

[**0054**] Briefly considering the generation of Marking Indicia **42M** on a surface of, for example, a Marking Insert **54**, or a surface of, for example, an Inner Surface **46I** of a Chamber **28**, a Bolt Face **50** or a Firing Pin Face **44**, it will be recognized by those of ordinary skill in the relevant arts that such Marking Indicia **42M** are readily and preferably formed by laser micro-machining processes.

[**0055**] C. Exemplary Laser Imaging System for Micro-Machining Marking Indicia

[**0056**] An exemplary and typical laser micro-machining system suitable for generating Marking Indicia **42M** is a selected surface is illustrated in **FIG. 3**. As shown therein, an Image Imprinting System **56** for ablating high-density array of vias or indentations in a surface of an object to form Marking Indicia **42M** therein or thereon includes a Laser **58** for generating and outputting a Laser Beam **60**. Laser Beam **60** may be, for example, an ultraviolet, a visible, an infrared, a coherent radiation beam or some other type of light radiation beam and is directed along a Laser Axis **62** toward one or more Expansion Lenses **64**, which expand the diameter of the generated ultraviolet, visible, infrared or other light radiation Laser Beam **60** to a desired diameter.

[**0057**] The expanded Laser Beam **60** continues along Laser Axis **62** and is directed through Steering Mirrors **66**, which are controlled by a Computer **66C** to control the direction and location of the beam with respect to Machining Surface **68** of a Workpiece **70**. Laser Beam **60** then passes through Collimating Lens **72** and to Holographic Imaging Lense **74**.

[**0058**] Holographic Imaging Lens **74** includes a plurality of Holographic Imaging Segments **76** which focus the laser beam at a desired location or locations along Machining Surface **68** of Workpiece **70** for the purpose of drilling, burning or otherwise forming desired blind vias, apertures, openings, indicia, indentations or other surface contours therein of desired size and depth by etching, or otherwise removing, the material of Machining Surface **68**. The size and shape of the area from which the material is removed is defined or determined by the design characteristics of a corresponding Holographic Imaging Segment **76**, while the volume or depth of material removed is controlled by the power levels or number of the laser beam pulses directed at a given area.

[**0059**] It will be understood by those of ordinary skill in the relevant arts that the number of Holographic Imaging Segments **76** used in a given machining operation may be variable and that, for example, a given Marking Indicia **52M** etched into a surface may be comprised of the combination or compilation, in parallel or in sequence, of multiple Holographic Imaging Segments **76**. The system or an equivalent system thereby allows very complex Marking Indicia **76** to be formed, and allows different elements of a Marking Indicia **42I** to be formed of different Holographic Imaging Segments **76**. For example, one Holographic Imaging Segment **76** may represent a firearm manufacturer, another the firearm type or model, and so on, and certain Holographic Imaging Segments **76** may be changed or varied from one Marking Indicia **42M** to the next, as when assigning unique serial numbers.

[**0060**] **FIG. 4** illustrates a further embodiment of a Image Imprinting System **56** wherein a Splitter **78** is employed to split Laser Beam **60** into multiple Laser Beams **60** and Image Imprinting System **56** includes multiple sets of Steering Mirrors **66** to direct the multiple Laser Beams **60** through a Holographic Imaging Lens **74** and to a Machining Surface **68** of Workpiece **70**, thereby permitting the concurrent generation of multiple Marking Indicia **42I**, or the concurrent etching of multiple elements of a Marking Indicia **42I**.

[**0061**] It will be understood by those of skill in the relevant arts that an Image Imprinting System **56** may employ any of a range of types of Lasers **58**, including ultraviolet, visible light and infra-red lasers. Suitable lasers may include, for example, slow flow CO2, CO2 TEA (transverse-electric-discharge), Impact CO2, and Nd:YAG, Nd:YLF, and Nd:YAP and Nd:YVO and Alexandrite lasers, gas discharge lasers, solid state flash lamp pumped lasers, solid state diode pumped lasers, ion gas lasers, and RF wave-guided lasers. The specific type of laser will depend upon the specific types of materials and specific types of laser machining operations to be performed. For example, in operations with longer wavelength lasers, such as CO_2 and Md:YAG infrared lasers, the interaction between the laser and the material is a thermal process which produces charring, or glassification in ceramics, and leaves a relatively poor surface quality with some materials. The processes at ultraviolet wavelengths as generated by, for example, excimer lasers, is however, and for many materials of interest, a "cold process" which uses energy to break chemical bonds in the material rather than to generate heat in the material. Thus, Identification Indicia **42I** having excellent accuracy and quality can be easily produced in a desired surface without substantially altering the characteristics of the material or creating chars and/or clumps of material.

[**0062**] Lastly in this regard, it must be noted that laser machining processes are particularly adaptable to the etching of Marking Indicia **42M** in confined spaces, such as on an Inner Surface **46I** of a Chamber **28**. In such instances, the optic path or paths of an Image Imprinting System **56** may be extended by an additional Steering Mirror **66** optical path inserted into the Chamber **28** of a Barrel **24** such that the laser beam or beams are directed axially into the Chamber **28** and redirected to a Machining Surface **68** located on the Inner Surface **46I**. The extended optical may be implemented using, for example, Micro-Electro-Mechanical (MEM) mirrors, which are significantly smaller than conventional galvanometer controlled mirrors.

[**0063**] Finally, and as will be described further in the following, it will be recognized that a Image imprinting

System **56** may be used to print, imprint, emboss, etch, ablate, engrave or otherwise form an image or images on a surface by etching or otherwise removing selected portions of the surface or by selective removal of a material on the surface, such as various forms of ink or deposited coatings. It will also be understood that the image or images may assume many forms, as determined by Holographic Imaging Segments **76** or similar means. Examples of such images may include a code, a bar code, a character set, a symbol, a design, an alphanumeric set or some other identifying mark or, as described in further detail in the following, an encoded hologram or a encoded concentric circular barcode. In this regard, and as will be discussed further in the following, the imprinting, etching or micro-machining of a holographic image such as an encoded hologram or a encoded concentric circular barcode variable may incorporate such encoding variables as the wavelength of light used in forming the image, and subsequently in reading the image, or the working distance of the holographic image, which is a factor in both forming and reading the image.

[0064] D. Methods for Reading of Identification Indicia

[0065] As described, the identification of the Firearm **12** which microstamped an Identification Indicia **42I** into or onto a Cartridge Case **16** is dependent upon the clarity with which the Identification Indicia **438** may be read. As also described, an Identification Indicia **42I** may include, for example, a code, a bar code, a character set, a symbol, a design, an alphanumeric set or some other identifying mark or, as described in further detail in the following, an encoded hologram. As also discussed, an Identifying Indicia **42I** may be formed by recessed or raised areas of the material the Identification Indicia **42I** is stamped into or onto, or of both raised and recessed areas together forming the Identification Indicia **42I**. Examples of Identification Indicia **42I** embossed or printed on various surface of a Cartridge Case **16** are illustrated in **FIGS. 5 and 6** and include a Raised Bar Code **80**A, a 2D (two dimensional) Bar Code **80**B, a Raised Alphanumeric Code **80**C and a raised Encoded Hologram Code **80**D. In this regard, is should be noted that an Encoded Hologram Code **80**D may be formed from, for example, alphanumeric data identifying, for example, a firearm maker, a firearm model and a unique identifier for the Firearm **12** or at least the Bolt **30**, Firing Pin **44** or Barrel **24**. This data may then be transformed or encoded into a hologram, and the reverse transform or image of the hologram etched, machined or otherwise formed in, for example, Bolt Face **50**. As is understood by those of ordinary skill in the relevant arts, any part or portion of a hologram essentially contains information describing or comprising the entire hologram, so that the entire hologram and the information encoded therein may be reconstructed from any part or portion of the hologram. For this reason, it is very difficult to destroy, eradicate or obscure Identification Indicia **42I** in the form of a Encoded Hologram Code **80**D.

[0066] It will also be recognized that certain parts of a firearm, and in particular those surfaces that are machined, will typically have a characteristic surface "pattern" that is unique to a given manufacturer or even a given model of firearm and that such a pattern will be embossed, stamped or otherwise formed on a surface of a Cartridge Case **16**. While normally considered as a form of "scratch and ding" or "ballistic finger print" identifier, such patterns, as will be discussed in the following, may be intentionally formed as Identification Indicia **42I**, either alone or in combination with other Identification Indicia **42I**.

[0067] It will be recognized, however, that an Identification Indicia **42I** is physically and visually small and may be imperfectly formed or may be obscured or deformed to at least some degree. For example, the degree of vertical relief in the Identification Indicia **42I**, that is, the degree to which the surface of the material forming the Cartridge Case **16** or a Impact Face **20I** of Primer **20** is raised or lowered with respect to the surrounding surface when the Identification Indicia **42I** is formed, and thus the contrast and clarity of the Identification Indicia **42I**, may vary widely. For example, the degree of relief and clarity of an Identification Indicia **42I** may be dependent upon such factors as the hardness or "stiffness" of the material and the force exerted in marking the material, which may in turn depend upon such factors as the striking force of the firing pin, the pressure exerted on the wall of a Cartridge Case **16** by the Propellant Charge **18**, or the pressure exerted by the Bolt Face **50**.

[0068] Other factors in forming and reading an Identification Indicia **42I** may include, for example, dirt, tarnish, corrosion or grease on the surface in which the Identification Indicia **42I** is formed, attempts to eradicate an Identification Indicia **42I**, wear of the firearm, or distortion in forming the Identification Indicia **42I**. Distortion in an Identification Indicia **42I**, for example, may arise from many causes, such as movement, "setback" or rupture of primer **410**, overexpansion or longitudinal movement of Cartridge Case **16** due, for example, to a worn or overlarge Chamber **28** or a mismatch between the Firearm **12** and Round **10** of ammunition, and so on. These and other factors may also operate to obscure or distort an Identification Indicia **42I** after it is formed into a Cartridge Case **16**, such as during a period after the Round **10** is fired and before the Cartridge Case **16** is found and taken as evidence. Such factors may include, for example, physical damage to the Cartridge Case **16** or tarnish or corrosion of the surface **452**.

[0069] The reliable and accurate "reading" of an Identification Indicia **42I** and thus the identification of a firearm that formed an Identification Indicia **42I** on a Cartridge Case **16** is thereby dependent upon an ability and capability to "read" and capture an Identification Indicia **42I** image from a surface of a Cartridge Case **16**, that is, the clarity with which the Identification Indicia **42I** can be read and identified.

[0070] **FIGS. 7A and 7B** illustrate an exemplary Indicia Imaging Apparatus **82** for capturing one or more Identification Indicia **42I** image from one or more surfaces of a Cartridge Case **16**, such as a base surface or wall surface of the Cartridge Case **16** or the face of the primer. The Indicia Imaging Apparatus **82** includes an Optical Magnifying Mechanism **84** for viewing an Indicia Surface **86** bearing an Identification Indicia **42I** along a Viewing Axis **88** that is generally perpendicular to the Cartridge Case Surface **86** bearing the Identification Indicia **42I**. In this regard, it will be recognized that the method and apparatus of the present invention is equally usable for identifying an Identification Indicia **42I** stamped or otherwise formed in other elements of a Round **10**, such as the Bullet **14**.

[0071] Indicia Imaging Apparatus **82** further includes a Specimen Mounting Device **90** for holding an item to be viewed, such as a Cartridge Case **16** or a Bullet **14**, with the Indicia Surface **86** bearing the Identification Indicia **42I** or a region of an Indicia Surface **86** suspected of bearing an Identification Indicia **42I**, such that the Indicia Surface **86** is parallel to a plane perpendicular to the Viewing Axis **88**, wherein the Viewing Axis **88** extends along the perpendicular or z-axis and the plane of the Indicia Surface **86** extends along the plane defined by the horizontal x- and y- axes. The Indicia Imaging Apparatus **82** may further include a Positioning Mechanism **92** whereby the Specimen Mounting Device **90** may be positioned along the z-axis, that is, the Viewing Axis **88**, for focusing purposes. Focusing may also or alternatively be accomplished in the Optical Magnifying Mechanism **84**, or by a combination thereof. Positioning Mechanism **92** will typically include mechanisms for positioning the Specimen Mounting Device **90** in the x- and y- planes so that an Identification Indicia **42I** or region of a Indicia Surface **86** suspected of bearing an Identification Indicia **42I** may be generally centered along the Viewing Axis **88**, and so that the Indicia Surface **86** may be moved or scanned in the x- and y- planes with respect to the Viewing Axis **88**.

[**0072**] A Specimen Mounting Device **90** is illustrated in **FIG. 7** as supporting and holding a Cartridge Case **16** in a position so that an Indicia Surface **86**, such as the wall or base of a cartridge case may be viewed by Optical Magnifying Mechanism **84**. It will be recognized and understood, however, that a Specimen Mounting Device **90** may be readily designed and adapted to hold a cylindrical item, such as a Cartridge Case **16** or Bullet **14**, in the vertical or horizontal positions so that the wall or base surfaces of a cartridge may be viewed by Optical Magnifying Mechanism **84**. In this regard, it will be further recognized and understood that a Specimen Mounting Device **90** may be designed and constructed to allow rotation of the Cartridge Case **16**, Bullet **14** or other item about any or all of the x-, y- and z- axes, thereby allowing all exterior surfaces of the item to be viewed and allowing the item to be oriented around any selected axis. The design of Specimen Mounting Devices **90** capable of lateral motion in any plane or along any axis and capable of rotation about any axis are well known to those of skill in the arts, and therefore will not be discussed in further detail herein.

[**0073**] As indicated in **FIG. 7**, an Indicia Imaging Apparatus **82** of the present invention also includes an Illuminator **94** directing illumination onto the Indicia Surface **86** being viewed by Optical Magnifying Mechanism **84**. According to the present invention, Illuminator **94** directs illumination onto the Indicia Surface **86** being viewed along an Illumination Plane **96**, or axis, that is aligned substantially normal to the Viewing Axis **88**, thereby approximately parallel to the x/y plane. The Illumination Plane **96** is thereby approximately parallel to and is incident upon the Indicia Surface **86** being viewed along Viewing Axis **88**, at least in a region wherein the Identification Indicia **42I** being examined is located or where an Identification Indicia **42I** is suspected of being present. As will be described below, the angle of Illumination Plane **96** is variable and adjustable with respect to the surface being examined, as is the intensity of Illuminator **94**, so that Illuminator **94** can provide the optimum level and angle of lighting to the surface being viewed. Illuminator **94** thereby illuminates the Identification Indicia **42I**, or region suspected of containing an Identification Indicia **42I** in a manner to maximize the contrast and resolution of the highlighted and shadowed areas of the Identification Indicia **42I** or region suspected of containing an Identification Indicia **42I**, that is, the higher and lower areas of the region, to thereby provide the maximum image contrast and clarity.

[**0074**] In a presently preferred embodiment of an Indicia Imaging Apparatus **82**, Illuminator **94** and Optical Magnification Mechanism **84** include or are comprised of an optimized holographic imaging system integrated into a mono-chromatic and multi-chromatic illuminator to provide illumination from various angles onto the working areas of the Optical Magnifying Mechanism **84** and Indicia Surface **86** and to provide a non-shadowing intensity variable light.

[**0075**] An Illuminator **94** may further include facilities for providing colored or polarized light, while the Optical Magnifying Mechanism **84** may include appropriate filters, and various lenses, masks and so on to shape Illumination Plane **96** as desired or necessary. Also, it will be understood that imaging systems of the present invention may utilize illumination other than visible light, such as ultraviolet or infrared radiation, and may incorporate the appropriate filters, lenses and imaging apparatus as necessary and may incorporate a wide range of illumination sources, such as a laser diode array and/or light emitting diode array. The illumination mechanism may also include various positioning and rotational mechanisms to control the angle of incidence of Illumination Plane **96** with the surface being viewed and, in at least some embodiments, the angle of rotation of the Illumination Plane **96** axis around Viewing Axis **88**.

[**0076**] As illustrated in **FIG. 8**, an Indicia Imaging Apparatus **82** will typically further include an Image Capture Device **98**, such as a CCD(Charge Coupled Device) camera, for capturing and providing digital Surface Images **100** of a selected area of a Indicia Surface **86**, including any Identification Indicia **42I** appearing therein. In this regard, it will be recognized and understood that Optical Magnifying Mechanism **84** will be capable of providing optical images at a range of selectable magnifications, resolutions and image areas. Image Capture Device **98** captures digitally encoded images from the optical images provided by Optical Magnifying Mechanism **84**, and can thereby capture digitally encoded images of a range of selectable magnifications, resolutions and image areas.

[**0077**] Lastly in this regard, the Indicia Imaging Apparatus **82** will typically include a Frame Grabber **102** or equivalent for capturing Surface Images **100**, and a Motion Card **104**, controlled by a user or by other elements of the apparatus, for controlling viewing Specimen Mounting Device **90**. Motion Card **104** may, for example, include an automatic focusing mechanism whereby a present Surface Image **100** is analyzed to determine the sharpens and focus of the image, and the analysis results employed, through Motion Card **104**, to control the focus of the optical elements of Optical Magnifying Mechanism **84**. Such autofocus methods and mechanisms are, however, well known in the art and need not be discussed further herein.

[**0078**] As shown, the Surface Images **100** may be communicated to an Image Processing System **106** through a Data Link **108** comprised, for example, of a network, computer, database or server, or other system. Then Image Processing System **106** may be comprised, for example, of an Image Processing and Analysis System **110** for performing such operations as image enhancement, image analysis and recognition, and so on, and an Image Data Storage System **112** for storing the Surface Images **100**, including any Identification Indicia **42I** found thereon. Image Data Storage System **112** may also store, for example, information translating and identifying various assigned Identification Indicia **42I**, and may include mechanisms for identifying firearms from the imaged Identification Indicia **42I**.

[0079] For example, the Image Processing System **106** may include a specialized computer algorithm for generating one or more of a reconstruction, a decipherment or an optical recognition at least one of a make, a model, a serial number, a unique ballistic identifier or a ballistic identifier tag of a specific firearm used to fire the cartridge or bullet being analyzed by viewing one or more indicia on a surface of the cartridge or bullet, wherein the indicia may be comprised of an encrypted code, an encoded hologram, encoded alphanumeric code, a barcode or any other form of indicia on a surface of the cartridge or a bullet, and to analyze the captured image.

[0080] In summary, therefore, the present invention provides an apparatus and method for identifying firearms that includes the steps of:

[0081] (A) illuminating a base of the fired cartridge from a firearm found at a crime scene using axially homogenized light from various illumination angles using a holographic imaging system integrated into either a mono-chromatic or multi-chromatic light;

[0082] (B) obtaining, through an imaging microscope, an image of the encoded hologram or encoded alphanumeric code or barcodes or indicia that form the breech face impressions on a primer of the cartridge or bullet; and,

[0083] (C) utilizing specialized analysis software to read the encoded codes and provide the serial number or tracking number unique to the firearm that fired the bullet or cartridge.

[0084] The method of the present invention thereby does not require a comparison of cartridges, but simply takes an image of the code embossed on the cartridge or bullet that is formed upon the firing of the firearm and the subsequent ejection of the cartridge or bullet from that specific firearm.

[0085] E. Creation and Reading of Encoded Multi-Dimensional Indicia

[0086] It has been described herein above that a wide range of types and forms of Identification Indicia **42I** and corresponding Marking Indicia **42M** may be used for the purpose of identifying a firearm that has fired a round by embossing or imprinting an Identification Indicia **42I** unique to the firearm on the cartridge case, or bullet, of the round. It is preferable that the Identification Indicia **42I** be physically small, and that the indicia convey a large amount of information, such as a unique firearm identifier, a manufacturer, a model or type identifier, and so on.

[0087] One of the presently most commonly proposed and useful forms of Identification Indicia **42I** is the barcode, which, until the present invention, offered the capability of representing a significant amount of information in a relatively small space. The most common form of barcode is a bar, that is, a series or sequence, of optically or magnetically readable parallel stripes of different widths etched, printed or imprinted on an object wherein the widths and locations of the stripes convey the information contained therein. Two dimensional barcodes have also be developed, wherein the information is represented by an array or dots or rectangles that are read by scanning in two dimensions, or directions.

[0088] Two dimensional barcodes contain significantly more information than do one dimensions barcodes, but are more difficult to form and print and are more susceptible to reading errors and information loss due to damage.

[0089] Barcodes suffer from a number of limitations and problems which limit their suitability as Identification Indicia **42I**, however. For example, most barcodes are normally monochromatic, which limits information representation to the physical dimensions of the bars, dots and rectangles and the uses of barcodes to applications suitable for simple laser, magnetic or optical scanning methods. The limitation to simple scanning methods also restricts the security of the information represented therein. That is, barcodes are readily readable by simple, commonly available scanning devices and the possible encoding of the information stored in a barcode is limited by the relatively small amount of data that can be stored in a barcode.

[0090] Recent developments in conventional barcodes have attempted to overcome information storage and security limitations by various additional encoding factors. For example, some methods overprint a one dimensional barcode with a second barcode of a different color, use transparent ink containing infrared absorbers to introduce an additional variable, print different types of barcodes over one another, and use materials having various infrared or ultraviolet properties with colored barcodes to introduce additional variables. While such methods increase the amount of information that can be represented in a barcode by adding additional variables to the barcode representation, in a manner analogous to adding bits to a binary number representation, issues regarding security of data, reading errors and data loss through damage remain a serious problem. For example, it is significantly more difficult to read a multi-color barcode or a barcode using infrared or ultraviolet properties or multiple coding patterns than a monochrome barcode, and such barcodes are much more susceptible to damage, such as wear and fading, than are monochrome barcodes.

[0091] According to the present invention, however, the above problems are addressed by Identification Indicia **42I** in the form of Encoded Hologram Multi-Dimensional Barcodes (EHMDBs), which, according to the present invention, add additional dimensions to the information representation capacity of an Identification Indicia **42I** and, in particular, will introduce a spectral dimension to Identification Indicia **42I** and **42M**. As will be discussed below, Encoded Hologram Multi-Dimensional Barcodes (EHMDBs) may be implemented as either or both of Encoded Holograms (EHs) or Encoded concentric Circular Barcodes (ECCBs).

[0092] According to the present invention, the designs of Encoded Hologram Multi-Dimensional Barcodes (EHMDBs), whether embodied as Encoded Holograms (EHs) or as Encoded concentric Circular Barcodes (ECCBs), are based on several variables which affect the geometric construction, or pattern of markings, of the Encoded Hologram Multi-Dimensional Barcodes (EHMDBs). One variable is the wavelength of light or radiation used as the encoding variable, and another is the working distance of the Encoded Hologram Multi-Dimensional Barcodes (EHMDBs). The added spectral component is thereby obtained through spectral factors that effect the geometries of the Encoded Hologram Multi-Dimensional Barcodes (EHMDBs), that is, the EHs or ECCBs, themselves. In particular, and according to the present invention, sets of wavelengths are used for specific encoding applications wherein each wavelength or set of wavelengths has a particular unique effect on the final outcome of the geometric dimensions of the Encoded Hologram Multi-Dimensional Barcodes (EHMDBs), that is, the EHs and ECCBs, and their security levels. One consequence of this method for generating Encoded Hologram Multi-Dimensional Barcodes (EHMDBs) in the form of EHs and ECCBs is that numerous distinct encoded Encoded Hologram Multi-Dimensional Barcodes (EHMDBs) may be created as EHs or ECCBs, thus providing more extensive multi-dimensional encoding than previously possible.

[**0093**] Referring to **FIGS. 10A through 10C** and **11**A through **11**C, therein are respectively illustrated diagrammatic representations of Encoded Multi-Dimensional Indicia (EMDI) **114** according to the present invention, wherein **FIGS. 10A through 10C** illustrate Encoded Holograms (EHs) **114**EH and **FIGS. 11A through 11C** illustrate various aspects of Encoded Concentric Circular Barcodes (ECCBs) **114**EC.

[**0094**] In this regard, **FIG. 10A** illustrates an Encoded Hologram (EH) **114**EH wherein the hologram image is comprised of square pixels and **FIGS. 10B and 10C** illustrate Encoded Holograms (EHs) **114**EH in the form of etched encoded holograms.

[**0095**] **FIG. 11A**, in turn, illustrates an etched encoded concentric circular barcode array and it may be seen that the encoding of information in a concentric circular barcode results in a simpler design than does the hologram encoded design illustrated in **FIGS. 10A-10C**, and uses a circular based intensity encoding method wherein each concentric ring pattern corresponds to one or more specific alphanumeric digits or letters. The array of such concentric ring patterns illustrated in **FIG. 11A** is, for example, a series of alphanumeric codes arranged to allow an very large amount of data to be stored in the array, and to allow the data to be decoded with a reader or decoder specifically adapted to this encoding method. It should be noted that in the example illustrated in **FIG. 11A** each concentric ring pattern of the array of concentric ring patterns represents a corresponding alphanumeric character or digit. In other embodiments, however, and depending upon the complexity of the concentric ring patterns, including the number of rings in each pattern, a plurality of alphanumeric characters or digits or combinations thereof may be encoded in each ring pattern of the array. This encoding is further illustrated in **FIGS. 11B and 11B**, which respectively illustrates the depth profile encoding method across a portion of a concentric circular barcode and a top view surface analysis of such a barcode.

[**0096**] EHMDBs **114** may be encoded by a variety of methods, examples of which may include but not be limited to binary phase Fourier DOE, CGH, Lohmann, Lee, Fourier, Fraunhofer, Fresnel or kinoform types of hologram encoding algorithms, including multi-phase levels fro level **2** and greater phase levels. The encoding algorithms may include error checking functions to reduce reading errors, which may occur when the Identification Indicia **42I** or other marks have faded or become worn or damaged and no longer imprint or emboss a clear, high quality Identification Indicia **42I**. It will also be recognized that the encoded holograms and Encoded concentric Circular Barcodes may use any standard encoding algorithm as used, forexample, forencoding diffractive and holographic images.

[**0097**] As described, and according to the present invention, Encoded Multi-Dimensional Indicia (EMDI) **114**, such as Encoded Holograms **114**EH or Encoded concentric Circular Barcodes (ECCBs) **114**EC, may be employed as Marking Indicia **42M** to imprint, emboss or otherwise form corresponding inverted Identification Indicia **42I** on such surfaces as cartridge cases or bullets. Multi-Dimensional Barcodes (EHMDBs) **114** maybeformed, forexample, directly into the material of a firearm, such as the inner surface of a chamber, the face of the bolt or firing pin, the extractor mechanism, or a surface of a barrel ramp, that is, a portion of the barrel and breach formed to guide a round from a clip and into the breach. Multi-Dimensional Barcodes (EHMDBs) **114** may also be formed into the face of a Marking Insert **54**, which may in turn be embedded in such surfaces of a firearm.

[**0098**] It must also be recognized, however, that the Marking Indicia **42M** and Identification Indicia **42I** of the present invention, that is, Encoded Holograms (Ehs) **114** and Encoded concentric Circular Barcodes (ECCBs) **114**, may be used in many other applications requiring Identification Indicia **42I**, and may be formed on variety of surfaces by a wide range of methods. For example, and as described, Encoded Multi-Dimensional Indicia (EMDI) **114** such as Encoded Holograms **114**EH or Encoded concentric Circular Barcodes (ECCBs) **114**EC may be directly etched, imprinted, micro-machined into a surface by, for example, an Image Imprinting System **56**, or similarly formed in a surface that is in turn used to print, imprint or emboss the image in yet another surface by, for example, impact or pressure, or by printing by a transferrable media such as ink or other forms of transferrable media or coatings.

[**0099**] Methods for forming Encoded Multi-Dimensional Indicia (EMDI) **114** may thereby include, for example, laser imaging, etching and engraving methods, dry etch and erosion processes such as chemical milling, ion milling and electro-discharge machining. Other methods may include, for example, ink-jet printing or letterpress, gravure, lithographic or screen printing techniques.

[**0100**] In other embodiments, Encoded Multi-Dimensional Indicia (EMDI) **114** may also be formed by removal of areas of a coating from a surface, such as an ink, paint or deposited or plated coating, by etching, ablating, micromachining of the surface. Other methods involve coating or plating a surface layer of a first material onto the surface, such as an ink having a first property or color, and printing or otherwise placing an image or a reversed, negative image of the Encoded Multi-Dimensional Indicia (EMDI) **114** onto or over that initial surface in a second material having one or more properties that may be distinguished from those of the first material.

[**0101**] In further embodiments, Encoded Multi-Dimensional Indicia (EMDI) **114** may be formed of or in, for example, infrared, ultraviolet or visible inks or in materials having photosensitive or magneto-optic qualities, or analogous properties, so thatthe Encoded Multi-Dimensional Indicia (EMDI) **114** is readable only when effected, for example, by suitable radiation or illumination or under the effect of a magnetic field. In other embodiments, and for example, the pattern of magnetic ink may be read directly by a magnetic sensing scanner, while ultraviolet and infrared inks may be similarly read by suitable direct sensing scanners. Other methods for forming Encoded Multi-Dimensional Indicia (EMDI) **114** may include various chemical or mechanical treatments of a surface to provide a surface that may then be suitably modified in representation of the Encoded Multi-Dimensional Indicia (EMDI) **114**.

[**0102**] Lastly with respect to the encoding and creation of Encoded Multi-Dimensional Indicia (EMDI) **114**, the above methods for creation of a Encoded Multi-Dimensional Indicia (EMDI) **114**, whether as Encoded Holograms **114**EH or as Encoded Concentric Circular Barcodes (ECCBs) **114**EC, may be combined in such a manner as to introduce a "third dimension" into the encoding. That is, Encoded Multi-Dimensional Indicia (EMDI) **114** may be created as superimposed layers of distinguishable elements, that is, one on top of another, and subsequently read by selective viewing or illumination of the layers, so long as the materials or methods by which the successive Encoded Multi-Dimensional Indicia (EMDI) **114** are distinguishable. Examples of such distinguishable layers may include, for example, successive overlaid Encoded Multi-Dimensional Indicia (EMDI) **114** comprised of differently colored transparent inks and various illumination sensitive inks, such as infrared or ultraviolet sensitive inks, and so on. In other instances, a first Encoded Multi-Dimensional Indicia (EMDI) **114** may be physically embossed or imprinted in the base material, and overlaid with other Encoded Multi-Dimensional Indicia (EMDI) **114** comprised of various coatings that can be distinguished from one another and through which the embossed or imprinted Encoded Multi-Dimensional Indicia (EMDI) **114** can be read. It will be recognized that, as a consequence, the user of multiple, superimposed Encoded Multi-Dimensional Indicia (EMDI) **114** will result in multiple, separately distinguishable and readable Encoded Multi-Dimensional Indicia (EMDI) **114** or in a single Encoded Multi-Dimensional Indicia (EMDI) **114** having additional "dimensions" for the representation of information, thereby significantly increasing the information capacity of the Encoded Multi-Dimensional Indicia (EMDI) **114**.

[**0103**] It will be apparent, therefore, that the Encoded Multi-Dimensional Indicia (EMDI) **114** of the present invention, such as Encoded Holograms **114**EH or Encoded Concentric Circular Barcodes (ECCBS) **114**EC, may be embodied or implemented for a range of applications, and that the specific form of implementation will depend upon the specific application in which the Encoded Multi-Dimensional Indicia (EMDI) **114** are used. For example, the Encoded Multi-Dimensional Indicia (EMDI) **114** such as Encoded Holograms **114**EH or Encoded concentric Circular Barcodes (ECCBs) **114**EC may be implemented as Marking Indicia **42**M to be imprinted or embossed onto cartridge cases or bullets as Identification Indicia **42**I for the purpose of identifying firearms that had discharged a cartridge case or bullet.

[**0104**] In other applications, such as product identifiers, anti-counterfeit markings, security badges or codes, and so on, the methods and materials used to create the Encoded Multi-Dimensional Indicia (EMDI) **114**, and the methods for reading such Encoded Multi-Dimensional Indicia (EMDI) **114** will depend upon the application and materials involved. It must be noted, however, that certain methods may be combined. For example, a cartridge case may be coated with a durable, non-visible ink or other coating and a product identifier etched into the coating. The discharge of the cartridge would then result in the imprinting or embossing of a firearm identification Encoded Multi-Dimensional Indicia (EMDI) **114** into the material of the cartridge case or into the coating by removing further areas of the coating.

[**0105**] Next considering the reading of Encoded Multi-Dimensional Indicia (EMDI) **114** such as Encoded Holograms **114**EH or Encoded concentric Circular Barcodes (ECCBs) **114**EC, an example of an Indicia Imaging Apparatus **82** suitable for reading Encoded Multi-Dimensional Indicia (EMDI) **114** has been described herein above with respect to **FIGS. 7, 8** and **9** and, as such, need be discussed in further detail. It will be noted, however, that the described Indicia Imaging Apparatus **82** may be further adapted for the specific characteristics of Encoded Multi-Dimensional Indicia (EMDI) **114**. For example, Optical Magnifying Mechanism **84** may incorporate one or more filters suitable spectral domains of observation and the specific radiation used to illuminate the Encoded Multi-Dimensional Indicia (EMDI) **114**, such as color filters, polarizing filters or holographic filters. Illuminator **94**, in turn, may be constructed as a ring light source, that is, a light source radiating from the circumference of a ring surrounding the image area, and may employ, for example, mono-chromatic light sources or diode lasers. Illuminator **94** may also be implemented to provide radiation adapted and matched to the Encoded Multi-Dimensional Indicia (EMDI) **114**, such as infrared, ultraviolet, colored visible frequencies, polarized radiation, and other specific wavelengths of light, or combinations thereof, or may include elements for generating, for example, magnetic fields for magneto-sensitive or activated materials. The light sources implemented in an Illuminator **94** may therefore include, for example, lamps or laser or LED sources, with or without filters of various types, which emit radiation in a frequency range and of a type suitable to make the Encoded Multi-Dimensional Indicia (EMDI) **114** visible to a viewer, scanner or camera.

[**0106**] Referring now to **FIG. 12**, therein is illustrated the process for imprinting an Encoded Multi-Dimensional Indicia (EMDI) **114** on or in a surface, such as a chambre, ramp or bolt face of a firearm, the impact face a firing pin or a bearing surface of an extractor. As shown therein, in Step **116** Product Information **118** is compiled and, in Step **120**, encoded by means of, for example, a hologram or kinoform Encoding Algorithm **122** to generate a Base Encoded Multi-Dimensional Indicia (EMDI) **114**B. In Step **124**, the Base Encoded Multi-Dimensional Indicia (EMDI) **114**B is compiled together with a Ballistic Identifier Tag **126**, that is, a unique Firearm **12** identification code, and Encoded Hologram Artwork **126** to generate a Marking Indicia **42**M filed comprised of the Encoded Multi-Dimensional Indicia (EMDI) **114**. The Marking Indicia **42**M file is sent to a Laser Process System **130**, such as an Image Imprinting System **56**, and in Step **132** the Firearm **12**, a component of a Firearm **12**, such as a Bolt **50**, or a Marking Insert **54** is loaded to the Laser Process System **130**, which performs the Laser Etch Process **134** to imprint the Marking Indicia **42**M on the Firearm **12**, the component thereof, or the Marking

Insert **54**. In Step **136** the Finished Firearm **138** may be test fired to obtain an expended and ejected Cartridge Case **16** marked with the Identifying Indicia **42I** and, in Step**2140**, **142** and **144** the Encoded Multi-Dimensional Indicia (EMDI) **114** captured, decoded and confirmed, whereupon in Step **146** the Firearm **12** may be released for shipment.

[**0107**] Lastly referring to **FIG. 13A and 13B**, therein are illustrated a hand-held, portable EHMDB Reading Device **148**, which is essentially comprised of the elements, components and functions described herein above with regard to Indicia Imaging Apparatus **82** and Image Processing System **106** as illustrated in **FIGS. 7, 8** and **9**, and a diagrammatic cross section side view of the EHMDB Reading Device **148**.

[**0108**] As shown in **FIG. 13A**, the Indicia Imaging Apparatus **82** and Image Processing System **106** are essentially packaged into the casing of EHMDB Reading Device **148**, which further includes a Control Panel **150** for controlling the functions and operations of the EHMDB Reading Device **148**, a Display **152** for displaying either or both of any Identifying Indicia **42I** located on either a cartridge casing wall or a cartridge casing base orthe primer in the cartridge case base and the decoded and translated information encoded in the Encoded Multi-Dimensional Indicia (EMDI) **114**. As also shown, the EHMDB Reading Device **148** includes a Specimen Port **154** for receiving and holding a Cartridge Case **16** to be inspected, with illumination sources, optical imaging elements and image capture elements arranged therein to scan and capture Encoded Multi-Dimensional Indicia (EMDI) **114** images from the surfaces of the Cartridge Case **16**. The Specimen Port **154** of the EHMDB Reading Device **148** will preferably include a Specimen Mounting Device **90** capable of receiving, for example, a Cartridge Case **16** base end first and of holding and positioning the Cartridge Case **16**, either manually or automatically, so that all surfaces of interest of the Cartridge Case **16** may be scanned by one or more imaging systems and elements therein.

[**0109**] **FIG. 13B** illustrates an exemplary arrangement of the interior components of a EHMDB Reading Device **148**. As shown, an EHMDB Reading Device **148** typically includes a Processing System **10**, Display **152** and Control Panel **150**, which occupy the main section of the body or casing of the EHMDB Reading Device **148**, with the optical elements occupying the spaces interior to the Specimen Port **154**.

[**0110**] As shown, a Cartridge Case **16** may be inserted into Specimen Port **154**, typically base first, and is retained and manipulated by a Support Device **90** which is preferably adaptable to different sizes of Cartridge Case **16** by means of adaptable or adjustable restraining members (not shown). Base **22** and Sidewall **16**W of the Cartridge Case **16** are viewed through separate optical paths wherein Base **22**, which will be in a relatively fixed position when the Cartridge Case **16** is held in Support Mechanism **90**, is view through Axial Optical Elements **85**A. As indicated, a ring Illuminator **94**A surrounding the optical path from Axial Optical Elements **85**A and Base **22** may be located along the axial optical viewing path for optimum controllable illumination of Base **22** and the Axial Optical Elements **85**A and Illuminator **94**A may also include various forms of filters. Illuminator **94**A may also be adjustable with regard to the illuminating radiation and perhaps the angle of incidence of the illumination on Base **22**.

[**0111**] A radial optical path for viewing of Sidewall **16W** is illustrated as including a Prism Element **85**B, which turns the radial viewing path through two right angles so that an image of Sidewall **16**W is routed to an Optical Element **85**C, which combines axial viewing path through Axial Optical Elements **85**A and Prism Element **85**B to form a single viewing path through an Optical Magnifying Mechanism **84** and to an Image Capture Device **98**,which has been previously discussed. A second Illuminator **94**B similar to Illuminator **94**A is associated with Prism Element **85**B to provide the appropriate illumination on Sidewall **16**W, and various forms of filters may be interposed in the optical path through Prism Element **85**B.

[**0112**] F. Summary of the Creation and Reading of Encoded Multi-Dimensional Indicia

[**0113**] In summary, therefore, an Encoded Multi-Dimensional Indicia **42** may be marked upon any suitable object, whether a firearm, a discharged cartridge case, a product of some form, a security badge or tag, for the purpose of representing selected information. An Encoded Multi-Dimensional Indicia **42** of the present invention is comprised of a multi-dimensional array of encoded marks, which include encoded marks determined by spectral encoding variables representing the selected information wherein each spectral variable being spectrally distinguishable from others of the spectral variables representing variables, and an encoded pattern of the encoded marks determined by an algorithmic transformation of the selected information.

[**0114**] In typical embodiments, an Encoded Multi-Dimensional Indicia **42** may be embodied as a multi-dimensional encoded hologram or as an encoded concentric circular barcode wherein, in particular, a concentric circular barcode comprises an array of concentric ring patterns wherein each ring pattern is a circular based intensity encoding of a corresponding information item. Examples of spectral encoding variables, each of which is selected as having a unique effect in determining the encoded pattern of marks, could include a wavelength of radiation used in encoding the hologram and a working distance of the hologram, and the selected information may be encoded by any of binary phase Fourier, DOE, CGH, Lohmann, Lee, Fourier, Fraunhofer, Fresnel and kinoform type of hologram encoding algorithms. Encoded Multi-Dimensional Indicia **42** may also be comprised of a plurality of spectrally distinguishable layers superimposed on a surface of an object, and a first layer of the indicia may be formed in a surface material of the object by one of removal of selected areas of the surface material and by physical impact of a marking indicia that is an inverse image of the indicia.

[**0115**] As illustrated in **FIG. 14A**, Encoded Multi-Dimensional Indicia **42** are created by (Step **156**A) generating a multi-dimensional array of encoded marks forming an encoded pattern as determined by (Step **156**B) an algorithmic transformation of the selected information wherein each encoded mark is (Step **156**C) determined by spectral encoding variables representing the selected information, and wherein each spectral variable is spectrally distinguishable from the other spectral variables. The process may also include (Step **156**D) the conjoining of an algorithm related artwork with the encoded pattern.

[**0116**] The reading of Encoded Multi-Dimensional Indicia **42**, as illustrated in **FIG. 14B**, is essentially a reverse transform of the creation process, and includes (Step **158**A) viewing the encoded multi-dimensional indicia according to at least one spectral encoding variable, wherein each spectral encoding variable corresponds to a spectral encoding variable employed in creating the encoded multi-dimensional indicia, Step (**158**B) reading an encoded pattern representing a multi-dimensional array of encoded marks represented the selected information, and (Step **158**C) decoding the encoded pattern of encoded marks with an inverse algorithmic transform of an algorithmic transformation employed in generating the encoded pattern from the selected information.

[**0117**] G. Multiple Indicia Marking

[**0118**] It has been described herein above that ballistic finger prints and scratch and ding markings, while traditionally the most useful and most used for identifying a given, specific firearm, are, however, pseudo-repeatable and largely random and non-specific in nature. These characteristics of ballistic finger prints and scratch and ding markings arise because the "scratches and dings" are largely formed by random irregularities in the surfaces of a firearm and by largely random impacts or pressure points between the surfaces of the cartridges and the firearms.

[**0119**] For this reason, the present invention addresses the methods and mechanisms forforming and reading Indicia **42** to provide consistent, unique, and repeatable identification markings; that is, and in many respects, to replicate "scratch and ding" markings, but in a more reliable, repeatable and unique form. As described, the methods and mechanisms of the present invention include various forms of Indicia **52**, including Encoded Multi-Dimensional Indicia **42**, and various systems and methods for etching or otherwise forming Indicia **42** on a surface of a firearm and subsequently reading such Indicia **42**.

[**0120**] It must be noted, however, that under certain circumstances the Identification Indicia **42I** of the present invention may not be properly formed. For example, many Identification Indicia **42I** are formed by the striking or pressing of a single Marking Indicia **42M** on a surface of a cartridge and distortion or deformation of the cartridge case may cause the Marking Indicia **42M** to "miss" the cartridge surface. In other instances, the imprint may be blurred, incompletely formed or distorted by, for example, dirt, grease, scratches or abrasions on the cartridge surface, or the possessor of the firearm may have sought to locate and remove or mutilate the Marking Indicia **42M**.

[**0121**] The present invention provides various forms of the Marking Indicia **42M** and Identification Indicia **42I** and various methods of forming the Identification Indicia **42I** that address these problems. For example, the Encoded Multi-Dimensional Indicia **42** of the present invention are advantageous in dealing with distorted, deformed, blurred, or incompletely formed Identification Indicia **42I**, and with at least some attempts to destroy the Marking Indicia **42M**.

[**0122**] According to a present aspect of the present invention, however, such issues may be advantageously addressed by adapting or adopting certain aspects of replicate "scratch and ding" markings, but in a more reliable, repeatable and unique form. For example, "scratch and ding" markings may occur anywhere on a given surface of a firearm and in certain instances may cover or effectively cover an entire surface or a large proportion of a surface, such as machining markings left on a Bolt Face **50**. This, in turn, significantly increases the probability that at least some identifiable corresponding "scratch and ding" markings will be formed on a surface of a cartridge case. As discussed, however, reliance on random "scratch and ding" markings is unsatisfactory because the resulting "identification marks", or"ballistic fingerprints", are pseudo-repeatable and largely random and non-specific. In contrast, the Indicia **42** of the present invention provide consistent, unique, and repeatable identification markings. An object of the following embodiment of the present invention is to increase the probability that one or more useable Identification Indicia **42I** will be marked on a Cartridge Case **16** by operation of the firearm firing the Cartridge Case **16**, despite such random factors such as the cartridge feeding, seating or ejecting at an unexpected angle, irregularities in the surface of the cartridge, or other random or deliberate factors, such as dirt, grease or attempts to mutilate or obscure the Marking Indicia **42M**.

[**0123**] Referring to **FIGS. 14A, 14B** and **14**C, therein are illustrated an embodiment of the present invention to enhance the probability that a usable Identification Indicia **42I** will be marked on a surface of a Cartridge Case **16**, such as the Base **22**. The exemplary Firearm **12** surface shown in **FIGS. 14A and 14B** is a Bolt Face **50**, but may be virtually any other surface capable of bearing Marking Indicia **42M** and of imprinting the Marking Indicia **42M** on a surface as an Identification Indicia **42I**.

[**0124**] As shown in **FIG. 14A**, Bolt Face **50** is provided with a Marking Array **160** of Marking Elements **162** wherein, as illustrated in **FIG. 15B**, a Marking Element **162** may be a Marking Boss **162**B wherein each Marking Boss **162**B is a generally conical or hemispherical convex protrusion from Bolt Face **50** and bears a Marking Indicia **42M** of any of the types discussed herein above on an outer, central Striking Face **164**. In alternate embodiments, as illustrated in **FIG. 14C**, Marking Elements **162** may be comprised of Marking Dimples **162**D, each of which is a concave depression of a generally conical or hemispherical shape having a centrally located Striking Face **164** bearing a Marking Indicia **42M**.

[**0125**] As will be readily seen, the contact of a Bolt Face **50** having a Marking Array **160** with the Base **22** of a Cartridge Case **16** will result in the Marking Indicia **42M** of at least one and usually a plurality of either of Marking Bosses **162**B or Marking Dimples **16**D imprinting corresponding Identification Indicia **42I** on the Base **22** surface. It will also be apparent that, due to the number and distribution of Marking Bosses **162**B or Marking Dimples **162**D on the Bolt Face **50**, there will be a corresponding high probability that at least one Identification Indicia **42I** will be imprinted on the surface of the Cartridge Case **16**. It will be further apparent that a Marking Array **160** may be formed on any surface of a Firearm **12** that is capable of bearing a plurality of Marking Bosses **162**B or Marking Dimples **162**D, and that one or more Identification Indicia **42I** will be imprinted despite a wide range of angles or placements of the striking surface with respect to the cartridge case surface and despite a wide range of conditions of either or both of the striking surface or the cartridge case surface.

[**0126**] H. Evasion Resistant Marking Indicia

[**0127**] As discussed previously, evasion of the above described identification indicia marking systems is a particular problem if the Marking Indicia **42**M is located, for example, in or on an accessible or removable and replaceable part of a firearm. An individual or group wishing to evade the Marking Indicia **42**M may either attempt to eradicate, mutilate or otherwise obscure the Marking Indicia **42**M or may replace the part bearing the marking indicia marker with a part having a different Marking Indicia **42**M or with a part not having a Marking Indicia **42**M. In the case of firing pins, for example, the Marking Indicia **42**M is typically engraved or etched into the striking end or face of the firing pin and the marking of an Identification Indicia **42**I on the primer may be evaded by replacing the firing pin with a firing pin not having a Marking Indicia **42**M or by filing or grinding off a portion of the end of the firing pin, thereby removing or obliterating the Marking Indicia **42**M. In other instances, such as when the Marking Indicia **42**M is located on the bolt face or on an inner wall of the chamber, the Marking Indicia **42**M may be removed or obliterated by grinding or etching that portion of the bolt face or chamber wall. In other instances, a person or group may attempt to "conceal" or obliterate a Marking Indicia **42**M by filling in or covering over the Marking Indicia **42**M with another substance, such as a plated metal or a plastic material.

[**0128**] It will be apparent, however, that certain methods of evading the Marking Indicia **42**M/Identification Indicia **42**I system may be readily foiled, at least to a significant degree. For example, the replacement of parts bearing Marking Indicia **42**M by parts not having Marking Indicia **42**M may be at least hampered by requiring that all of at least certain types of parts, such as firing pins, bolts and barrels/chambers, be manufactured with unique, individual Marking Indicia **42**M as described herein above. Marking Indicia **42**M can uniquely identify a given part in the same manner and with the same facility as an Identification Indisuch part to be identified and tracked. The replacement of one such part by another will thereby only result in a change in the specific identification code implanted in or on the part. Another advantage of implanting Marking Indicia **42**I on all of certain types of parts, such as firing pins, bolts and barrels with barrel chambers, is that the replacement of a marked part with an unmarked part would require that any person or group doing so either manufacture of the necessary parts or acquire a source of such unmarked parts, which merely transfers the manufacturing problem. In this regard, it should be noted that not only is the custom manufacture of parts expensive, but that many such parts will be unique to specific firearms or firearms manufacturers, thereby again increasing the cost and difficulty of obtaining unmarked parts.

[**0129**] Any attempt to cover over or fill in a Marking Indicia **42**M is similarly likely to meet with little success. For example, there will typically be significant differences between the hardness and ductility of the part material, which is typically steel, and the "filler" material, and there would probably be difficulties in bonding the "filler" to the part material. As a result, the "filler" material would most probably chip or wear away in a relatively short time, possibly even with a single shot, or the Marking Indicia **42**M may simply stamp the Identification Indicia **42**I through the filler material, as it would through oil, grease, dirt or corrosion.

[**0130**] It is therefore apparent that the most probable method used to evade the Marking Indicia **42**M/Identification Indicia **42**I system is to physically remove material from the part in an area including the Marking Indicia **42**M, such as by grinding or etching, thereby obliterating or removing the Marking Indicia **42**M or otherwise rendering the Marking Indicia **42**M physically incapable of performing its function. According to the present invention, however, such attempts to remove or obliterate Marking Indicia **42**M may be thwarted or at least seriously hampered by encoding the Marking Indicia **42**M on a surface of a part, such as a firing pin, such that the removal of material from the part in the area of the Marking Indicia **42**M in sufficient quantity to render the Marking Indicia **42**M non-functional will also render the part itself non-functional. In this regard, it must be noted that the term used in the present invention with respect to both the part and the Marking Indicia **42**M is "rendered non-functional", which does not necessarily mean "destroyed".

[**0131**] To illustrate, and as will be described in further detail in the following, according to the present invention the Marking Indicia **42**M may be encoded around the outer circumference of a firing pin in the area adjacent to and possibly extending onto the face of the firing pin that strikes the cartridge primer. As such, the impact of the firing pin will imprint the Marking Indicia **42**M as a circular array of code bits or marks on the face of the primer. In accordance with the present invention, the encoded Marking Indicia **42**M will extend along the circumference of the firing pin shaft from the edge of the striking face of the firing pin and for a distance along the body of the firing pin such that an attempt to obliterate the Marking Indicia **42**M by filing off the end of the firing pin will require removal of sufficient length of the firing pin that the firing pin is too short to perform its function.

[**0132**] An embodiment of this aspect of the present invention is illustrated in **FIGS. 15A and 15B** for a typical "hemispherical" Firing Pin **38**H. As represented therein, a hemispherical Firing Pin **38**H is generally comprised of a generally cylindrica Pin Body **166** having a diameter in, for example, the range of 2 mm to 10 mm, with a Striking Member **168** extending axially therefrom and having a typical diameter in the range of, for example, 1 mm to 5 mm and a typical length in the range, for example, of 75 mm. Pin Body **166** is shaped and dimensioned to mechanically interact with other parts of the firearm, such as the bolt and firing mechanism, while Striking Member **168** is shaped and dimensioned to perform the actual function of striking the face of a Primer **20** of a Cartridge Case **16** in a Chamber **28**. As illustrated in the present example, Firing Pin Tip **170**, that is, the end portion of Striking Member **168** that actually strikes the Primer **20**, has a generally hemispherical shape, hence the common name of this general type of Firing Pin **38**, and at least an End Section **168**E of Striking Member **168** adjacent to and extending from Firing Pin Tip **170** has a circular cross section extending for some distance from Firing Pin Tip **170**. In typical Firing Pins **38** Firing Pin Type **170** may have a length in the range of, for example, **50**mm to **100**mm, and a diameter in the range of, for example, 2 mm to 10 mm.

[**0133**] As indicated, and for purposes of the following discussions, Striking Member **168**, which includes End Section **168**E and Firing Pin Tip **170**, has an overall Striking Member Length **168**L, typically in the range of 50 mm to 75 mm, of which a Firing Length **168**F, which is measured back from the tip of Firing Pin Tip **170** and which typically includes at least the length of Firing Pin Tip **170**, is involved in and required for the firing of a Primer **20**. That is, and stated another way, a Firing Pin **38** is typically somewhat longer than the minimum length required to fire a Primer **20** under ideal conditions, the additional length allowing for such factors as wear of the firing pin tip, tolerances in machining and assembly, tolerances in Primers **20**, and so on. The tip of the firing pin thereby actually drives into the Primer **20** by a distance greater than actually required to fire the Primer **20**. For purposes of the following discussions, this additional length is referred to as Firing Length **168**F and is of significance in the following descriptions as being the greatest amount by which the length of Stroking Member **168** may be shortened while still allowing the Firing Pin **38** to fire a Primer **20**. In typical examples, Firing Length **186**F may be in the range of 0.5 mm to 2 mm.

[**0134**] As illustrated in **FIGS. 15A and 15B**, End Section **168**E, which may have a typical and exemplary length in the range of 3 mm to 6 mm, includes a Radial Bar Code Marking Indicia **42**RM, which will be discussed further in the following. In one implementation of the present invention, illustrated in **FIG. 16B**, the Radial Bar Code Marking Indicia **42**RM occupies the circumference of Striking Member **168** in an Indicia Area **168I** that in one direction extends from the end of End Section **168**E, that is, from the intersection of End Section **168**E with the circumference of Firing Pin Tip **170**, and along End Section **168**E in the direction away from Firing Pin Tip **170** for a distance that, in typical and examplary Firing Pins **38**, may be in the range of 1 mm to 6 mm. Indicia Area **168I** may also extend onto the hemispherical face of Firing Pin Tip **170**. In an alternate embodiment, illustrated in **FIG. 16C**, the Indicia Area **168I** extends only from the intersection of End Section **168**E with the circumference of Firing Pin Tip **170** and along End Section **168**E in the direction away from Firing Pin Tip **170**. The Indicia Area **168I** ends, however, at the intersection of End Section **168**E with the circumference of Firing Pin Tip **170** and does not extend onto the face of Firing Pin Tip **170** except insofar as the grooves or trenches forming the Indicia **42** code "cut into" the circumferential edge of Firing Pin Tip **170**.

[**0135**] As illustrated in **FIGS. 15A, 15B** and **15**C, a Radial Bar Code Marking Indicia **42**RM is comprised of a plurality of Encoding Bars **172**G extending axially along the Indicia Area **168I** parallel with Firing Pin Axis **174**, with the Encoding Bars **172**B being separated and delineated by Encoding Lands **172**L. As shown, each Encoding Bar **172**B is formed an area that is depressed with respect to Encoding Lands **172**L, such as a groove, trench or elongated depression formed in or on the surface of the Firing Pin **38**, while Encoding Lands **172**L are comprised of areas between the Encoding Bars **172**B that are raised with respect to the Encoding Bars **172**B. Encoding Lands **172**L may, for example, be formed by the original surface of the Firing Pin **38**, with Encoding Bars **172**B being cut or etched into the Firing Pin **38** material, or may be formed by areas that have been raised with respect to the original surface, such as by deposition or plating of a layer of material that is then etched by any of several processes to form Encoding Bars **172**B.

[**0136**] As indicated in **FIGS. 15B and 15C**, the cross sectional shape of Encoding Bars **172**B may be of any shape that can be unambiguous and reliably distinguished from Encoding Lands **172**L and that can be unambiguous and reliably read by a corresponding scanning or reading device, unless too severely damaged. Examples of such cross sectional shapes are illustrated in **FIG. 15B**, wherein the Encoding Bars **172**B are indicated as having groove or v-shape cross sections, and in **FIG. 15C** wherein Encoding Bars **172**B are indicated as having rectangular or square cross sections. In general, the cross sectional shapes of Encoding Grooves **172**G, and often of Encoding Lands **172**L, will be determined or at least strongly influenced by the process or processes used to form the Radial Bar Code Marking Indicia **42**RM in the Firing Pin **38**. In addition, and as described further below, the widths of Encoding Bars **172**B and Encoding Lands **172**L are selected so that the circumference of End Section **168**E and Firing Pin Tip **170** can accommodate at least one copy of the Radial Bar Code Marking Indicia **42**RM.

[**0137**] According to the present invention, the axial length of Indicia Area **168I** along Firing Pin **38** is an Encoded Distance **176** that begins at the start of Encoding Bars **172**B and Encoding Lands **172**L at or on Firing Pin Tip **170** and extends along Firing Pin **38** for the length of Encoding Bars **172**B and Encoding Lands **172**L. According to the present invention, and as stated above, Encoded Length **176** is selected so that the removal of the tip or end of Firing Pin **38**, that is, the removal part of or all of Firing Pin Tip **170** or Firing Pin Tip **170** and End Section **168**E, for a distance that is sufficient to render the Radial Bar Code Marking Indicia **42**RM non-functional for marking Primer **20** will also render Firing Pin **38** incapable of firing Primer **20**. Stated another way, Encoded Length **176**, as measured from the tip of Firing Pin **38**, is greater than Firing Length **168**F and the removal of Encoded Length **176** from the Firing Pin **38** will thereby result in the removal of Firing Length **168**F from the Firing Pin **38**.

[**0138**] Referring now to **FIGS. 16A, 16B**, **16**C and **16**D, therein are illustrated corresponding embodiments of Radial Bar Code Marking Indicia **42**RM embodied in modulo **11** encoding, while may encode various alphanumeric codes, start and stop delineation codes, checksum codes and so on comprising a Radial Bar Code Marking Indicia **42**RM. As represented therein, each Radial Bar Code Marking Indicia **42**RM is comprised of and includes a Start Code **178**A, eight Digit Codes **178**B, an optional Checksum Code **178**C and an End Code **178**D. The Start Code **178**A and Stop Code **178**D delineate the Radial Bar Code Marking Indicia **42**RM by indicating the beginning and end of the Radial Bar Code Marking Indicia **42**RM, each Digit Code **178**B represents an alphanumeric character or number value of the Indicia **42**, and the Checksum Code **178**C, if used, is a modulo **11** error detection and correction value. As also indicated, each of Codes **178**A, **178**B, **178**C and **178**D is expressed as a five bit binary code when physically encoded as Encoding Bars **172**B and Encoding Lands **172**L.

[**0139**] Each of **FIGS. 16A, 16B**, **16**C and **16**D illustrates an embodiment of a Radial Bar Code Marking Indicia **42**RM at a cross section of an End Section **168**E and Firing Pin Tip **170** wherein the cross section is located at approximately the intersection of the End Section **168**E with the circumference of the Firing Pin Tip **170**. **FIG. 16A** illustrates an embodiment wherein the Indicia Area **168I** contains two complete Radial Bar Code Marking Indicia **42**RM, separated by two Quiet Zones **178**E. As shown, each Radial Bar Code Marking Indicia **42**RM includes, in order around the circumference of Firing Pin **38**, a Start Code **178**A, eight Digit Codes **178**B, a Checksum Code **178**C and a Stop Code **178**D. Encoding Bars **172**B are laser scribed and are 0.025 mm wide and 0.025 mm deep and are spaced apart around the circumference of Indicia Area **168**I at an on-center Groove Pitch **172**P of 3° between Encoding Bars **172**B and Encoding Lands **172**L have a nominal Land Width **172**W of 0.020 mm. In this regard, it will be understood by those of ordinary skill in the arts that that Groove Pitch **172**P and Land Width **172**W may vary according to a number of factors, including tolerances in the processes by which Encoding Bars **172**B are formed into the material of Firing Pin **38**.

[**0140**] **FIG. 16B** illustrates a second implementation of Radial Bar Code Marking Indicia **42**RM wherein the Indicia Area **168**I around the circumference of Firing Pin **38** contains a single copy of the Radial Bar Code Marking Indicia **42**RM. In this example, Encoding Bars **172**B are 0.025 mm wide and 0.025 mm deep with an on-center Groove Pitch **172**P of 4° and a nominal Land Width **172**W of 0.035 mm.

[**0141**] **FIG. 16C** illustrates a third implementation of Radial Bar Code Marking Indicia **42**RM wherein the Indicia Area **168**I around the circumference of Firing Pin **38** contains a single copy of the Radial Bar Code Marking Indicia **42**RM. In this example, Encoding Bars **172**B are 0.035 mm wide and 0.035 mm deep with an on-center Groove Pitch **172**P of 5° and a nominal Land Width **172**W of 0.040 mm.

[**0142**] **FIG. 16D** illustrates still another implementation of Radial Bar Code Marking Indicia **42**RM wherein the Indicia Area **168**I around the circumference of Firing Pin **38** contains a single copy of the Radial Bar Code Marking Indicia **42**RM. In this example, Encoding Bars **172**B are 0.045 mm wide and 0.045 mm deep with an on-center Groove Pitch **172**P of 6° and a nominal Land Width **172**W of 0.044 mm.

[**0143**] Those of ordinary skill in the relevant arts will understand that the Radial Bar Code Marking Indicia **42**RM of the present invention may be adapted to Firing Pins **38** other than the "hemispherical" Firing Pins **38**H discussed above, and will how such adaptations may be performed. Such alternative Firing Pins **38** may include, for example, Firing Pins **38** having generally a cylindrical Striking Member **168**, or at least a generally cylindrical End Section **168**E, but wherein Firing Pin Tip **170** is non-hemispherical and is instead, for example, conical or flat or any other shape so long as End Section **168**E has a generally circular axial cross section, or at least a cross section generally forming a closed continuous curve, such as an ellipse, providing a circumference into which a Radial Bar Code Marking Indicia **42**RM may be encoded.

[**0144**] Referring to **FIG. 15D**, therein is illustrated a yet further implementation of the present invention for the instance of a non-hemispherical, or non-cylindrica, "Elliptical " Firing Pin **38**E, such as found in certain firearms. As illustrated in **FIG. 15D**, an Elliptical Firing Pin **38**G is generally formed of a flat piece of suitable material, such as steel, shaped and dimensioned to mechanically interact with other parts of the firearm, such as the bolt and firing mechanism. Pin Body **166**, Striking Member **168** and Firing Pin Tip **170** thereby have generally square or rectangular axial cross sections and the axial profile of Firing Pin Tip **170** is a generally elliptical or rounded form when viewed from a direction generally orthogonal to either of two opposing "flat" sides of the Firing Pin **38**E. It may be readily seen, therefore, that the perimeter of Firing Pin Tip **170**, as formed by the intersection of the perimeter of Firing Pin Tip **170** with the perimeter of End Section **168**E of Striking Member **168**, is not a circle, ellipse or other form of continuous closed curve. The axial cross section perimeter of Firing Pin Tip **170** is instead a polygram formed by a plurality of straight Pin Side Faces **180** defining the intersections between End Section **168**E and Firing Pin Tip **170**. The axial cross section perimeter of Firing Pin Tip **170** and End Section **168**E will typically be a rectangular or square formed by four Pin Side Faces **180**, as illustrated in **FIG. 15D**, and in the case of a rectangular cross section, there will be two opposing Long Pin Side Faces **180**L and two opposing Short Pin Side Faces **180**S. In exemplary embodiments of Elliptical Firing Pins **38**G, the width of the Elliptical Firing Pin **38**G is typically in the range of 3 mm to 8 mm and the thickness of the firing pin is typically in the range of 1 mm to 4 mm and the length of the elliptical Firing Pin Tip **170** is typically in the range of 50 mm to 100 mm.

[**0145**] In the instance of Elliptical Firing Pins **38**E, therefore, by which is meant firing pins having a rectangular or square cross section, a Radial Bar Code Marking Indicia **42**RM of the present invention is encoded along one or more Pin Side Faces **180** by Encoding Bars **172**G and Encoding Lands **172**L which extend axially along the Indicia Area **168**. In the exemplary embodiment illustrated in **FIG. 15D**, for example, Indicia Area **168**I is located along the two Long Pin Side Faces **180**L, and may include two copies of a Bar Code Marking Indicia **42**M, one on each Long Pin Side Face **180**L, or one copy of a Bar Code Marking Indicia **42**M distributed across the two Long Pin Side Faces **180**L. It will be recognized and understood, however, that one of more Bar Code Marking Indicia **42**M may be distributed across all four Pin Side Faces **180**, and that a Bar Code Marking Indicia **42**M may be a linear version of the Radial Bar Code Marking Indicia **42**RM described above. The length of Indicia Area **168**I along the axis of the Elliptical Firing Pin **38**E is typically in the range of 0.5 mm to 10 mm, measured from the tip of the firing pin.

[**0146**] Again, Encoding Bars **172**B may have groove or v-shape cross sections or rectangular or square cross sections and the cross sectional shapes of Encoding Grooves **172**G, and often of Encoding Lands **172**L, will be determined or at least strongly influenced by the process or processes used to form the Radial Bar Code Marking Indicia **42**RM in the Firing Pin **38**.

[**0147**] In the exemplary embodiment illustrated in **FIG. 15D** the Indicia Area **168**I and thus Encoding Grooves **172**G and Encoding Lands **172**L are shown as extending to the Impact Face **180**I of Firing Pin Tip **170**, that is, to the face of Firing Pin Tip **180**I that impacts Primer **20**, so that Encoding Groves **172**G and Encoding Lands **172**L do not extend onto Impact Face **180**I except insofar as the grooves or trenches forming the Radial Bar Code Marking Indicia **42**RM "cut into" the edge of Impact Face **180**I. In this regard, and as illustrated in the exemplary embodiment of **FIG. 15D**, it must be noted that Impact Face **180**I is a curved surface having an elliptical profile, so that the forward ends of Encoding Grooves **172**G and Encoding Lands **172**L lie along the curved line formed by the edge of Impact Face **180**I and so that Encoded Length **176** will vary for across

Impact Face **180I**. For the purposes of the present invention, however, Encoded Length **176** is measured back from the tip of Firing Pin Tip **170** and is greater than Firing Length **168**F, which is also measured from the tip of Firing Pin Tip **170**.

[**0148**] Again according to the present invention, Indicia Area **168I**, that is, Encoding Grooves **172**G and Encoding Lands **172**L, extend along Firing Pin **38** for an Encoded Distance **176** that is selected so that the removal of the tip or end of Firing Pin **38** for a distance sufficient to render the Radial Bar Code Marking Indicia **42**RM non-functional for marking Primer **20** will also render Firing Pin **38** incapable of firing Primer **20**. Stated another way, Encoded Length **176**, as measured from the tip of Firing Pin **38**, is again greater than Firing Length **168**F and the removal of Encoded Length **176** from the Firing Pin **38** will thereby result in the removal of Firing Length **168**F from the Firing Pin **38** and an inoperative firing Pin **38**.

[**0149**] Referring to **FIGS. 15B, 15C** and 15D, it is illustrated therein that a Firing Pin **38** of the present invention may include further Marking Indicia **42**M, which may, for example, range from simple manufacturer's codes and symbols to Marking Indicia **42**M of any of the types described herein above. A Firing Pin **38** of the present invention may also include such markings as manufacturer's or assembly Tracking Codes **182** located at any place on the Firing Pin **38**.

[**0150**] Referring again to **FIGS. 15B and 15C**, therein are illustrated examples of Anti-Tamper Marking Indicia **42**AM, which are employed to provide an additional check and hamperment to persons or organizations attempting to circumvent or evade Radial Bar Code Marking Indicia **42**RM by attempting to remove or obscure a Radial Bar Code Marking Indicia **42**RM. As discussed with respect to Marking Indicia **42**M in general, attempts to remove or obscure a Radial Bar Code Marking Indicia **42**RM may include, for example, attempts to fill the Encoding Grooves **172**G with metal or some other substance to "clog" the stamping of the indicia on a Primer **20** and attempts to mutilate or remove the Radial Bar Code Marking Indicia **42**RM, such as by grinding or etching away the circumference of the end of Firing Pin **38** or simply marring the circumferential surface of the end of the firing pin to the point the Radial Bar Code Marking Indicia **42**RM is too damaged to fulfil its purpose.

[**0151**] **FIG. 15C** illustrates an Anti-Tamper Marking Indicia **42**AM disposed in a circular pattern on the End Face **184** of a Firing Pin Tip **170** wherein the circular pattern is centered about Firing Pin Axis **174**. An Anti-Tamper Marking Indicia **42**AM may be formed in the same general manner as a Radial Bar Code Marking Indicia **42**RM discussed above, or, forexample, as an encoded multi-dimensional indicia, an encoded hologram indicia, encoded concentric circular barcode, or in any other form discussed herein, and may be encoded using any desired encoding scheme, such as that employed in the Radial Bar Code Marking Indicia **42**RM discussed above. In the embodiment shown in **FIG. 15C**, for example, the encoding of the Anti-Tamper Marking Indicia **42**AM is the same as and follows the encoding of the Radial Bar Code Marking Indicia **42**RM disposed about the circumference of End Section **168**E of Striking Member **168**. In this instance, however, the Anti-Tamper Marking Indicia **42**AM is physically encoded as a sequence of Encoded Bits **186**B recessed into the surface of End Face **184** and separated by Encoded Lands **186**L, which would typically be comprised of the original surface of End Face **184**, wherein Encoded Bits **186**B and Encoded Lands **186**L are functionally similar and analogous to Encoded Grooves **172**G and Encoded Lands **172**L. It will be understood by those of ordinary skill in the arts that Encoded Bits **186**B may take any desired or advantageous form, such as square or round depressions or short grooves, and that Encoded Bits **186**B may be raised with respect to Encoded Lands **186**L, rather than depressed, and may take the form, for example, of raised bosses or mesas or of any other desired form.

[**0152**] It will also be recognized by those of ordinary skill in the art that an Anti-Tamper Marking Indicia **42**AM as described with respect to the Hemispherical Firing Pin **38**H of **FIG. 15C** may be employed with other forms of Firing Pins **38**, such as the Elliptical Firing Pin **38**E of **FIG. 15D** by suitably adapting the Anti-Tamper Marking Indicia **42**AM to the specific shape of the End Face **184** of the Firing Pin **38**. For example, in the instance of an Elliptical Firing Pin **38**E, the Anti-Tamper Marking Indicia **42**AM may be adapted to the Impact Face **180I** as a linear or rectangular bar code rather than as a circularly disposed bar code array.

[**0153**] As described above, the present invention is directed to Marking Indicia **42** and methods of encoding Marking Indicia **42**, including the locations of Marking Indicia **42**, such that attempts to remove or obliterate the Marking Indicia **42**M by the removal or distortion of the material of a marked part in the area of the Marking Indicia **42**M to renderthe Marking Indicia **42**M non-functional will also render the part itself non-functional. An Anti-Tamper Marking Indicia **42**AM such as described just above will thereby operate in cooperation with other Marking Indicia **42**, such as a Radial Bar Code Marking Indicia **42**RM, to make the evasion of the Radial Bar Code Marking Indicia **42**RM more difficult.

[**0154**] That is, an attempt to remove a Radial Bar Code Marking Indicia **42**RM by grinding or etching the circumference of circumference of the end of the Firing Pin **38** may well leave an Anti-Tamper Marking Indicia **42**AM undisturbed, or at least only partially damaged. In the reverse, an attempt to remove an Anti-Tamper Marking Indicia **42**AM by filing or etching away the end of the Firing Pin **38** may, as described herein above, leave a Radial Bar Code Marking Indicia **42**RM in place and in a functional condition. Attempts to remove both a Radial Bar Code Marking Indicia **42**RM and an Anti-Tamper Marking Indicia **42**AM would require etching, filing or grinding of both the end and the circumference of the Firing Pin **38** and is likely to result in an unusable Firing Pin **38**.

[**0155**] A further embodiment of an Anti-Tamper Marking Indicia **42**AM is as an Embedded Anti-Tamper Marking Indicia **42**EM is illustrated in **FIG. 16B**. As illustrated therein, the Embedded Anti-Tamper Marking Indicia **42**EM is again disposed in a circular pattern on the End Face **184** of a Firing Pin Tip **170** and wherein the circular pattern is centered about Firing Pin Axis **174**. In this embodiment, as may be seen from **FIG. 15B**, the Embedded Anti-Tamper Marking Indicia **42**EM is physically encoded as a sequence of Encoded Bits **186**B recessed into the surface of End Face **184** and separated by Encoded Lands **186**L, which would typically be comprised of the original surface of End Face

184, so that Encoded Bits **186**B and Encoded Lands **186**L are functionally similar and analogous to Encoded Grooves **172**G and Encoded Lands **172**L.

[0156] In the present embodiment, the Embedded Anti-Tamper Marking Indicia **42**EM is preferably encoded in the same general manner and using the same code as the Radial Bar Code Marking Indicia **42**RM discussed above, but may be encoded by other methods, such as discussed with regard to an encoded multi-dimensional indicia or encoded concentric circular barcode, so long as the Embedded Anti-Tamper Marking Indicia **42**EM is encoded in Encoded Bits **186**B and Encoded Lands **186**L.

[0157] In the present embodiment of an Embedded Anti-Tamper Marking Indicia **42**EM, Encoded Bits **186**B are formed of relatively narrow but deep holes extending axially into the body of the Firing Pin **38** from End Face **184** and for an Encoded Depth **188** similar to and analogous to Encoded Length **176**, being a greater in depth than Firing Length **168**F. For example, Encoded Bits **186**B may be up to several millimeters deep and as large as the area between the outer cylinder and the **42**M area will allow, and may be formed, for example, by laser etch; mechanical drilling; electro discharge machining; or any other known drilling process.

[0158] In accordance with the present invention, any attempt to shorten the Firing Pin **38** by a length sufficient to remove the Embedded Anti-Tamper Marking Indicia **42**EM, and perhaps a Radial Bar Code Marking Indicia **42**RM, will again result in the Firing Pin **38** being rendered inoperative. In this regard, it must be noted that because an Embedded Anti-Tamper Marking Indicia **42**EM is "embedded" in the body of the tip of a firing pin, the removal of a Radial Bar Code Marking Indicia **42**RM by grinding or etching of the circumference of the firing pin will not remove or otherwise effect the Embedded Anti-Tamper Marking Indicia **42**EM. In fact, an Embedded Anti-Tamper Marking Indicia **42**EM can effectively be removed only by removing the entire tip of the firing pin for a distance that will leave the firing pin inoperative.

[0159] Lastly in this regard, it will be noted and understood by those of ordinary skill in the relevant arts that an Embedded Anti-Tamper Marking Indicia **42**EM may be implemented in a number of variant forms. For example, the holes forming Encoded Bits **186**B may be filed with metal or other material having a different hardness, or ductility, than the material forming the main body of the firing pin, so that the difference in hardness or ductility between Encoded Bits **186**B and the firing pin result in differential imprinting of the Anti-Tamper Marking Indicia **42**EM in the material of a Primer **20**. The material may be deposited or formed in the holes of Encoded Bits **186**B by a number of methods, including, for example, vapor deposition and electro-plating.

[0160] In other embodiments, Encoded Bits **186**B and Encoded Lands **186**L may be comprised of wires, bars or rods of material having different hardnesses and ductilities from each other and from the material comprising the body of the firing pin, the differences in hardness and ductility again causing differential imprinting into a Primer **20** and thus a readable imprinting of the indicia. These rods, bars or rods may then be assembled around a cylinder of suitable material, or in groove or slots in the outer face of the cylinder, and the assembly inserted into an axial opening in the firing pin tip, which would then be formed into a desired shape.

[0161] J. Microstamping in Difficult Contexts

[0162] As described herein above, there are a number of factors that can effect the forming of an Identification Indicia **42**I on a cartridge case or a primer, such as dirt, tarnish, corrosion or grease on the surface in which the Identification Indicia **42**I is formed. Such deposits tend to cushion and dissipate the force pressing the Marking Indicia **42**M into the surface, and in many instances "blur" the imprint by, in effect, "clogging" the contours of the Marking Indicia **42**M.

[0163] Yet other problems arise from linear or rotational sheer forces between the cartridge case or primer surface and, for example, a firing pin or the interior of the chamber during firing or extraction or between the surface and a Marking Indicia **42**M during the imprinting of an Identification Indicia **42**I. For example, linear or rotational sheer forces between the primer surface and a Marking Indicia **42**M on a firing pin may occur due to "setback" or rupture of primer **410** or backward movement of the cartridge case during firing or in the initial stages of extraction, which may be due, for example, to wear in the chamber or to normal operation of the extraction mechanisms. Similar effects may occur when the Marking Indicia **42**M is located on an interior surface of the chamber, and for much the same reasons, that is, linear or rotational movement of the cartridge case during firing or extraction, either as part of the normal operation of the gun mechanisms or because of, for example, wear in the chamber. It should also be noted that motion of a cartridge case, meaning apparent motion of a point or area on the surface of the cartridge case relative to a corresponding point or area on a surface the cartridge case surface bears against, such as the interior chamber wall, can also result form linear or circumferential expansion and contraction of the cartridge case when fired.

[0164] Experiments have shown that the above problems are of particular significance in two contexts in particular.

[0165] One such problem context is the case of high pressure cartridges, which are typically designed to provide high muzzle velocities, generate correspondingly high pressures and forces between all surfaces of the cartridge and the firing chamber, both during firing and during at least the initial phases of the extraction process. The increased pressures not only increase the chances of unwanted linear or rotational movement of the cartridge case during firing or extraction, and in particular during the stamping of the indicia, but increase the detrimental effects of such unwanted motion. As a result, the Marking Indicia **42**M may be "wiped" across the surface during the imprinting of the indicia, thereby blurring or wiping out the indicia. In addition, the Identification Indicia **42**I itself may be wiped out or blurred by the increased pressures and sheer forces between the imprinted surface of the cartridge and a chamber or bolt surface as the cartridge moves during firing or extraction.

[0166] This problem is particularly severe when any part of the Marking Indicia **42**M or the imprinted Identification Indicia **42**I extends above the plane of the surface in which it resides. For example, any part of the Marking Indicia **42**M that protrudes above the inner surface of the chamber or bolt will rub and drag against the corresponding part of the surface of the cartridge case. Motion of the cartridge case will thereby drag the Marking Indicia **42**M across the surface of the cartridge case, resulting in excess wear to the Marking Indicia **42**M and possible defacement or obliteration of the Identification Indicia **42**I. The inverse, but with the same results, will happen if any part of the Identification Indicia **42**I protrudes above the surface of the cartridge case.

[**0167**] The problem has also been found to be particularly severe with Marking Indicia **42**M and corresponding Identification Indicia **42**I comprised of bar codes and other symbols or characters having predominately linear elements.

[**0168**] The other problem context is cartridges, such as military cartridges, that are coated with a varnish or other protective coat, usually for waterproofing. As described above, such coatings will often cushion and dissipate the force exerted by the Marking Indicia **42**M against the surface, and will often effectively "clog" the markings of the Identification Indicia **42**I. The result is then typically a very lightly impressed indicia, or an actually non-impressed indicia, or a blurred indicia, either of which may be difficult or impossible to read effectively.

[**0169**] Two aspects of the present invention, however, offer solutions to these and related problems of the prior art.

[**0170**] First considering the problem of high pressure cartridges, it has been described herein above and in parent patent applications Lizotte '**766** and Lizotte '**459**, cited in the Cross References to Related applications, that in a presently preferred embodiment of a Marking Indicia **42**M, and thus of an Identification Indicia **42**I, no part of either of the Marking Indicia **42**M or the Identification Indicia **42**I protrudes above the surfaces in which they reside.

[**0171**] According to a presently preferred embodiment of the present invention as discussed herein above and as illustrated in **FIG. 17A**, a Marking Indicia **42**M is formed on a Base Surface **200** located on an Interior Surface **208** of the Chamber **28**. As illustrated, the Marking Indicia **42**M is typically comprised of one or more raised Marking Lands **204**ML and one or more Marking Floors **204**MF that together form the characters, symbols, images, including hologram images, or other forms of the Identification Indicia **42**I. As shown, Marking Lands **204**ML are raised with respect to Base Surface **200** but do not protrude above Interior Surface **208** and at the maximum elevation are at most coplanar with Interior Surface **208**. Marking Floors **204**MF, in turn, are depressed or recessed with respect to Marking Lands **204**ML and, in the typical case, are coplanar with the Base Surface **200** but may be raised with respect to Base Surface **200**. As such, the symbol, character or form of the Marking Indicia **42**M is thereby recessed into a depression in the Interior Surface **202** in which it is located so that the highest portions of the symbol, character or form do not protrude above the Interior Surface **202** in which it is formed, but are at most coplanar with the Interior Surface **202**. Further in this regard, it must be recognized that the specific nature and details of Marking Lands **204**ML and Marking Floors **204**MF and their counterparts of the Identification Indicia **42**I will depend upon the nature of the Marking Indicia **42**M symbols, characters or images, several of which have been described in detail herein above. The variations in the details of the structures of Marking Indicia **42**M will, however, be apparent to those of ordinary skill in the arts after a review of the different possible specific forms of Marking Indicia **42**M described herein above.

[**0172**] Referring to **FIGS. 17B and 17C**, therein is illustrated the impressing of an Identification Indicia **42**I onto an Imprint Surface **212** and the resulting Identification Indicia **42**I wherein Imprint Surface **212** may be, for example, the surface of a Cartridge Case **16** or a Primer **20**. As shown therein, when Marking Indicia **42**M is driven into Imprint Surface **212** the Identification Indicia **42**I that is formed therein is the mirror image of the Marking Indicia **42**M and is comprised of one or more raised Indicia Lands **204**IL and one or more depressed or recessed Indicia Floors **2041**F. The Indicia Lands **204**IL and Indicia Floors **2041**F together form the character, symbol or image forming the Identification Indicia **42**I wherein Indicia Lands **204**IL correspond to and are the mirror impressions of Marking Floors **204**MF and Indicia Floors **2041**F correspond to and are the mirror impressions of Marking Lands **204**ML.

[**0173**] As illustrated, therefore, the Indicia Lands **204**IL are raised with respect to the Indicia Floors **2041**F Base but do not protrude above Imprint Surface **212** and at the maximum elevation are at most coplanar with Imprint Surface **212** while Indicia Floors **2041**F, in turn, are depressed or recessed with respect to Indicia Lands **204**IL. As such, the symbol, character or form of the Identification Indicia **42**I is thereby recessed into a depression in the Imprint Surface **212** in which it is located so that the highest portions of the symbol, character or form do not protrude above the Imprint Surface **212** in which it is formed, but are at most coplanar with the Imprint Surface **212**.

[**0174**] Consideration of **FIGS. 17A-17C** will show that except for the very brief moment in which a Marking Indicia **42**M in an Interior Surface **202** is in the act of being imprinted into an Imprint Surface **212** as an Identification Indicia **42**I, neither the Marking Indicia **42**M nor the identification Indicia **42**I can or will have any physical contact with any opposing surface that will exert any form of sheer force against either the Marking Indicia **42**M or the Identification Indicia **42**I. That is, Marking Lands **204**ML and Indicia Lands **204**IL, the highest points of the Marking Indicia **42**M and the Identification Indicia **42**I, are each recessed or at most coplanar with Interior Surface **202** and Imprint Surface **206** and are thereby protected from obliterating or blurring sheer forces by Interior Surface **202** and Imprint Surface **206**.

[**0175**] It should be noted with respect to the above that there are distinctions between a Marking Indicia **42**M residing in a Striking Surface **436** of a Firing Pin **412** and a Marking Indicia **42**M residing in an Inner Surface **46**I of a Chamber **28** as regards the imprinting process and the possibility and nature of sheer forces acting on the imprint process or on the imprinted Identification Indicia **42**I.

[**0176**] For example, when the Identification Indicia **42**I is imprinted into a Primer **20** or, in some instances into the base of a Cartridge Case **16**, by a Firing Pin **412** the imprinting force exerted by the Firing Pin **412** is typically perpendicular to the Imprint Surface **206**. In addition, the primary sources of pressure in the region of Marking Indicia **42**M or Identification Indicia **42**I would typically arise from setback of the Primer **20** or axial backward movement of the Cartridge Case **16** in Chamber **28**, and would likewise be generally perpendicular to the surfaces between Marking Indicia **42**M and Identification Indicia **42**I. In addition, it must be noted that the pressures generated by the Propellant Charge **18** on the walls of the Cartridge Case **16** and the Primer **20** typically do not occur until after the Striking Surface **436** bearing the Marking Indicia **42M** has been withdrawn from the Imprint Surface **206** or, at the earliest, is in the state of being withdrawn from contact with the Imprint Surface **206**.

[0177] For these reasons, the obliterating or blurring effects of pressures generated by high power cartridges will be alleviated to at least a certain extent when the Identification Indicia **42I** is imprinted by the firing pin on the base of a cartridge or on the primer. In addition, however, the recessing of the Identification Indicia **42I** into the surface of the cartridge base or the surface of the primer will protect the Identification Indicia **42I** from the blurring or obliterating forces of high power cartridges. That is, the excess pressures due to high power cartridges will be born by either or both of the Interior Surface **202** and the Imprint Surface **206** rather than by the Identification Indicia **42I** or the Marking Indicia **42M**.

[0178] Next considering those implementation wherein the Marking Indicia **42M** is embedded in an Interior Surface **202** of the Chamber **28**, rather than in the Striking Surface **436** of the Firing Pin **412**, it will be noted that in the instance of a firing pin imprint it is the Marking Indicia **42M** that is driven into the Imprint Surface **206** to imprint the Identification Indicia **42I** into the Imprint Surface **206**.

[0179] When the Marking Indicia **42M** is located in a wall of the Chamber **28**, however, the imprinting pressure arises from expansion of the Circumferential Wall **16W** of the Cartridge Case **16** against the Interior Surface **202** of the Chamber **28** due to the pressure of the burning Propellant Charge **18**. Stated another way, in this instance the Imprint Surface **206** is driven against the Marking Indicia **42M** to imprint the Identification Indicia **42I** into the Imprint Surface **206**, and in fact protrudes beyond Imprint Surface **206** and into the Marking Indicia **42I** during the imprinting.

[0180] It can also be seen that in this instance the forces acting on the cartridge wall in the area receiving the Identification Indicia **42I** imprint will include perpendicular forces acting outward against the chamber wall and that will force the area of the cartridge case opposite the Marking Indicia **42M** into contact with the Marking Indicia **42M**, thereby imprinting the Identification Indicia **42I** into that area of the cartridge case wall.

[0181] Other forces acting on the cartridge case wall in the region of Marking Indicia **42M** will include forces parallel to the chamber wall due to circumferential and perhaps axial stretching of the cartridge case wall. These forces, however, will be generally symmetric at each point on the cartridge case circumference and, as such, will be largely radial and symmetric with respect to the Marking Indicia **42M**, wherever the Marking Indicia **342M** is located. As such, circumferential and axial expansion of the cartridge case wall should result in no more than a slight and negligible variation in the dimensions of the imprinted Identification Indicia **42I**.

[0182] Lastly, there will be sheer forces along and parallel to the wall of the cartridge case due to movement of the cartridge case. These sheer forces will be predominately and typically almost entirely axial with respect to the cartridge case and will predominately occur during extraction of the cartridge case. There may, however, also be some axial movement of the cartridge case due, for example, to wear and tolerances in the chamber or in the bolt or bolt mechanism.

[0183] It will be apparent that the first two types of forces discussed above and resulting from combustion of the propellant charge will be at a maximum during the period in which the Marking Indicia **42M** imprints the Identification Indicia **42I** into the wall of the cartridge case, thereby maximizing the possibility for blurring or wiping out of the Identification Indicia **42I**. It will also be apparent, however, that in the case of the first force discussed, that is, for perpendicular to the cartridge case wall due to expansion of the case, the force is in fact the force imprinting the Identification Indicia **42I** and typically will not, in itself, result in blurring or obliteration of the identification Indicia **42I**. The second force, resulting from localized circumferential and axial expansion of the cartridge case wall, should result in no more than a slight and negligible variation in the dimensions of the imprinted Identification Indicia **42I** and would typically not be a significant problem, particularly in consideration of the aspects of the invention as discussed hereafter with regard to coated cartridges.

[0184] The third force discussed above, however, that is, sheer forces along the surface of the cartridge case due to movement of the cartridge case during extraction or perhaps during firing, is typically the primary factor in blurring or obliteration of an imprinted Identification Indicia **42I**. In this regard, and while the majority of the extraction process takes place after the chamber pressures have dropped from their maximum, it must be noted that in certain firearms, and in particular automatic or semi-automatic firearms, the extraction process may actually begin while the chamber pressures are at or near maximum. Also, and even if the chamber pressures have dropped from their maximum during most or all of the extraction process, the residual pressures in the chamber during cartridge case extraction will typically be notably higher for high power cartridges than for more conventional or lower power rounds. It must also be recognized that the extraction forces acting on the cartridge case, such as the initial pulling force or tug exerted by the extractor, will be greater for higher power firearms and can result in increased axial or rotational sheer pressures on the case wall and even in distortion of the cartridge case.

[0185] In summary, therefore, the pressures in the cartridge case during extraction or even a lingering expansion or a distortion of the cartridge case during extraction or the forces exerted on the cartridge case by the extraction mechanisms will often result in the area of the cartridge case imprinted with the Identification Indicia **42I** being pressed outwards to wipe against the inner wall of the chamber. Any of these effects can result in blurring or obliteration of the Identification Indicia **42I** and, while these effects are typically present in most firearms, they are significantly increased in the case of high power firearms and cartridges. It must also be recognized that these effects will obviously be further increased when either or both of the Identification Indicia **42I** or the Marking Indicia **42M** protrude above the level the inner surface of the chamber or the outer surface of the cartridge case, even with lower power firearms and cartridges.

[0186] Also, and as discussed, these problems have been found to be particularly significant when the Marking Indicia **42M** and corresponding Identification Indicia **42I** are predominately comprised of linear elements, such as bar codes, and for Marking Indicia **42M** and Identification Indicia **42I** comprised of larger symbol or character elements.

[0187] The problems are addressed and resolved in the mechanism and method of the present invention, however, wherein both the Marking Indicia **42M** and the Identification Indicia **42I** are recessed below the Interior Surface **202** of the Chamber **28** and below the Imprint Surface **206**, that is, the Cartridge Case Circumferential Wall **16W**.

[0188] As a consequence, the highest part of the Marking Indicia **42M** is always recessed or depressed below the surface of the Chamber **28** and the only period during which the area of Imprint Surface **206** that is imprinted with the Identification Indicia **42I** extends above Imprint Surface **206**, and is thus exposed to sheer forces, is during the actual imprinting of the Identification Indicia **42I**. At all other times the area of Imprint Surface **206** that is being imprinted with or that has been imprinted with the Identification Indicia **42I** is recessed below the plane of Imprint Surface **206** and is thereby not exposed to sheer forces. The recessing of the Marking Indicia **42M** and of the Identification Indicia **42I** into their respective surfaces will thereby protect the Identification Indicia **42I** from the blurring or obliterating forces of high power cartridges.

[0189] It should also be noted, in this regard, that it has often been found advantageous to locate the Marking Indicia **42M** in the Inner Surface **46I** of the Chamber **28** at a location near or adjacent to a point where the contour of the inner surface of the chamber changes direction. That is, whereby the Marking Indicia **42M** is located at or near, for example, the region in the front of the chamber where the chamber typically cones down to the barrel diameter or the region at the back of the chamber where the face of the bolt forms the rear wall of the chamber. It is believed that the nearby change in the contour of the inner surface of the chamber engages the cartridge case to assist in supporting the cartridge case against dimensional or positional changes in the manner of a brace or reinforcing element

[0190] Also, and as will be discussed below with regard to coated cartridges, it has been found advantageous that the Marking Indicia **42M**, and the corresponding Identification Indicia **42I**, be of relatively small dimensions and that the Marking Indicia **42M** and corresponding Identification Indicia **42I** be comprised of relatively small elements. Typical presently preferred dimensions for the Marking Indicia **42M** and corresponding Identification Indicia **42I** may be, for example, on the order of 25 to 150 microns, and the Marking Indicia **42M** and corresponding Identification Indicia **42I** may be preferably comprised, for example, of holographic patterns or alphanumeric codes.

[0191] Next considering the problems arising with coated cartridges, it has been described herein above that coatings and other deposits on cartridge cases appear to cushion and dissipate the force pressing the Marking Indicia **42M** into the surface, and in many instances, to effectively blur the imprint, sometimes to the point of being unreadable, by apparently "clogging" the contours of the Marking Indicia **42M**.

[0192] Experimentation has shown, however, that the problem is largely alleviated when the Marking Indicia **42M** and the corresponding Identification Indicia **42I** are of relatively small dimensions and the Marking Indicia **42M** and corresponding Identification Indicia **42I** are comprised of relatively small elements. Typical presently preferred dimensions for the Marking Indicia **42M** and corresponding Identification Indicia **42I** may be, for example, on the order of 25 to 150 microns, and the Marking Indicia **42M** and corresponding Identification Indicia **42I** may be preferably comprised, for example, of holographic patterns or alphanumeric codes.

[0193] While the information and experimental results presently available do not offer a definitive explanation of the observed results, the following discussion addresses what is presently believed to be the cause of the observed results.

[0194] One explanation of the cause of the observed results is presently believed to be a function of force per unit area exerted by the Marking Indicia **42M** and the sheer, compression and deformation or bending strengths of a Coating **208** on a Cartridge Case **16** and is illustrated in **FIGS. 18A and 18B**. **FIG. 18A** addresses the case of a coated cartridge with a relatively Wide Marking Indicia **42MW** with relative wide Indicia Elements **216W** and **FIG. 18B** addresses the case of a coated cartridge with a Narrow Marking Indicia **42MN** comprised of Narrow Indicia Elements **216N**.

[0195] Referring to **FIG. 18A**, it is believed that when a Wide Marking Indicia **42MW** is driven against the Coating **208** and underlying Cartridge Case Wall **16W**, the force is distributed over a relatively Wide Imprint Area **212W**. It is believed that the force per unit area exerted by Wide Marking Indicia **42MW** over Wide Imprint Area **212W** exceeds the compression and deformation or bending strengths of Coating **208**, but does not exceed the sheer strength of Coating **208**. As a result, and as illustrated in **FIG. 18A**, Coating **208** compresses and deforms or bends in and around the Wide Imprint Area **212W**, distributing or dissipating the force exerted by Wide Marking Indicia **42MW** over a sufficiently wide area, with part being absorbed by the Coating **208**, that the force is insufficient to adequately imprint the Wide Marking Indicia **42MW** into the underlying Cartridge Case Wall **16W**.

[0196] Referring to **FIG. 18B**, it is believed that when a Narrow Marking Indicia **42MN** is driven against the Coating **208** and underlying Cartridge Case Wall **16W**, the force is distributed over a relatively Narrow Imprint Area **212N**, and is particularly concentrated under the areas impacted by the individual Narrow Indicia Elements **216N**. It is believed that the force per unit area exerted by Wide Marking Indicia **42MW** over Wide Imprint Area **212W** exceeds the sheer strength of Coating **208**, so that Coating **208** sheers along Sheer Boundaries **214**. The locations of Sheer Boundaries **214** are defined by the areas occupied by Narrow Indicia Elements **216N**, so that the portions of Coating **208** within Sheer Boundaries **214** are compressed and displaced downwards against the surface of Cartridge Case Wall **16W**. As may be seen from **FIG. 18B**, the downwardly displaced portions of Coating **208** take the form of Narrow Indicia Elements **216N**. It is also believed that the compressed strength of the displaced portions of Coating **208** are sufficiently strong to transmit sufficient force from Narrow Indicia Elements **216N** through the Coating **208** and to the underlying Cartridge Case Wall **16**W to imprint the corresponding Identification Indicia **42**I into Cartridge Case Wall **16**W.

[**0197**] It must be recognized, however, that the above is a presently accepted explanation of the operation of the present invention with coated cartridge cases and a Narrow Marking Indicia **42**MN comprised of Narrow Indicia Elements **210**N, and that this explanation may be displaced by another explanation or explanations as more information about the observed phenomena becomes available.

[**0198**] In summary, and to illustrate the above finding and conclusions as embodied in the present invention, it has been found that, as described above, the presently preferred dimensions for the Marking Indicia **42**M and corresponding Identification Indicia **42**I may be, for example, on the order of 25 to 150 microns, and the Marking Indicia **42**M and corresponding Identification Indicia **42**I may be preferably comprised, for example, of holographic patterns or alphanumeric codes.

[**0199**] In addition, and as illustrated in **FIG. 18C** and in the instances of both coated cartridges and high power cartridges, it has been found that the optimum angle A of the interior Walls **220** of a Marking Indicia **42**M ,that is, the angle A of each Wall **220** extending between a point on a Marking Land **220**ML and an adjacent point on a Marking Floor **210**MF or Base Surface **206**, is in the range of 6 to 22.5 degrees per side. It has also been found that the optimum ratio between the area of the Marking Lands **210**M and the total area of a Marking Indicia **42**M, that is, and in particular the total area of the Marking Floors **210**MF and Base Surface **206**, of the Marking Indicia **42**M is in the range of 6:1 to greater than 9:1 with a ratio of approximately 9:1 presently appearing to be the optimum.

[**0200**] Since certain changes may be made in the above described method and system, without departing from the spirit and scope of the invention herein involved, it is intended that all of the subject matter of the above description or shown in the accompanying drawings shall be interpreted merely as examples illustrating the inventive concept herein and shall not be construed as limiting the invention.

Wherefore, I/we claim:

1. A marking indicia located on an interior surface of a firearm chamber to imprint an identification indicia on an imprint surface of a cartridge when the cartridge is fired, comprising:

a base surface located in the interior surface of a chamber containing the cartridge,

a plurality of marking lands raised with respect to the base surface and with a maximum marking indicia elevation above the base surface that is coplanar with the interior surface, and

a plurality of marking floors between and separating the marking lands, wherein

when the cartridge is fired the marking indicia and the imprint surface are forced into mutual contact to imprint a reverse image of the marking indicia in the imprint surface as the identification surface, and wherein

the identification indicia includes

a plurality of indicia lands corresponding to the marking floors, and

a plurality of indicia floors corresponding to the marking lands, wherein

the indicia lands are elevated with respect to the indicia floors with a maximum identification indicia elevation above the indicia floors that is coplanar with the imprint surface, so that

the marking indicia is recessed with respect to the interior surface, and

the identification indicia is recessed with respect to the imprint surface.

2. The marking indicia of claim 1 wherein:

the interior surface is a striking surface of a firing pin and the marking indicia is brought into contact with the imprint surface by a striking action of the firing pin against the imprint surface, and

the imprint surface is located on a primer of the cartridge.

3. The marking indicia of claim 1 wherein:

the interior surface is an inner surface of the firearm chamber abutting a wall of the cartridge case, and

the marking indicia is brought into contact with the imprint surface by expansion of the cartridge case wall due to a propellant charge pressure in the cartridge case.

4. The marking indicia of claim 1 wherein:

a maximum width of the marking indicia is less than 200 microns, and

a maximum width of a marking land is less than 35 microns.

5. The marking indicia of claim 1 wherein:

the marking indicia is a holographic image.

6. The marking indicia of claim 1, wherein:

an angle of each interior wall extending between a point on a marking land and an adjacent point of a marking floor is in the range of 6 to 22.5 degrees.

7. The marking indicia of claim 1, wherein:

a ratio between an area of the marking lands of a marking indicia and the total area of the marking indicia is in the range of 6:1 to greater than 9:1.

8. A method for imprinting an identification indicia on an imprint surface of a cartridge when the cartridge is fired, comprising:

forming a marking indicia on a base surface located in the interior surface of a chamber containing the cartridge,

the marking indicia including

a plurality of marking lands raised with respect to the base surface and with a maximum marking indicia elevation above the base surface that is coplanar with the interior surface, and

a plurality of marking floors between and separating the marking lands, and

when the cartridge is fired, forcing the marking indicia and the imprint surface into mutual contact to imprint a reverse image of the marking indicia in the imprint surface as the identification surface, wherein

the identification indicia includes

a plurality of indicia lands corresponding to the marking floors, and

a plurality of indicia floors corresponding to the marking lands, wherein

the indicia lands are elevated with respect to the indicia floors with a maximum identification indicia elevation above the indicia floors that is coplanar with the imprint surface, so that

the marking indicia is recessed with respect to the interior surface, and

the identification indicia is recessed with respect to the imprint surface.

9. The method of claim 8 for imprinting an identification indicia on an imprint surface of a cartridge when the cartridge is fired, wherein:

the interior surface is a striking surface of a firing pin and the marking indicia is brought into contact with the imprint surface by a striking action of the firing pin against the imprint surface, and

the imprint surface is located on a primer of the cartridge.

10. The method of claim 8 for imprinting an identification indicia on an imprint surface of a cartridge when the cartridge is fired, wherein:

the interior surface is an inner surface of the firearm chamber abutting a wall of the cartridge case, and

the marking indicia is brought into contact with the imprint surface by expansion of the cartridge case wall due to a propellant charge pressure in the cartridge case.

11. The method of claim 8 for imprinting an identification indicia on an imprint surface of a cartridge when the cartridge is fired, wherein:

a maximum width of the marking indicia is less than 200 microns, and

a maximum width of a marking land is less than 35 microns.

12. The method of claim 8 for imprinting an identification indicia on an imprint surface of a cartridge when the cartridge is fired, wherein:

the marking indicia is a holographic image.

13. The method of claim 8 for imprinting an identification indicia on an imprint surface of a cartridge when the cartridge is fired, wherein:

an angle of each interior wall extending between a point on a marking land and an adjacent point of a marking floor is in the range of 6 to 22.5 degrees.

14. The method of claim 8 for imprinting an identification indicia on an imprint surface of a cartridge when the cartridge is fired, wherein:

a ratio between an area of the marking lands of a marking indicia and the total area of the marking indicia is in the range of 6:1 to greater than 9:1.

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