



MGL BARREL BLANK UP TO HONING STAGE

0.05 A
+0.05
Ø40.79
HONING FINISH A

MATERIAL: IS5517 -1993, GR:42Cr4Mo2 (OR)
BS:970, PT:1, 1983, GR.709M40 (OR)
Z08M40, WITH 'T' CONDITION.

ALT. MATERIAL: En19 (OR) En19A WITH 'T' CONDITION
HARDNESS: 269 - 331 BHN.

SURFACE FINISH: 0.2-0.4 MICRONS AFTER HONING

RESTRICTION OF S & P
S = 0.010 %
P = 0.016 %

DIMENSIONS ARE IN mm.
UNTOLERATED DIMNS. AS PER IS : 2102 (MED)
SHARP CORNERS SHOULD BE BLUNT TO R 0.5

Handwritten: 58/01/2020
HOS/PS-2

AMENDMENTS	SIG. & DATE	PART NO.		DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS	
		PART NO.		SIGNATURE & DATE		Tiruchirappalli-620014			
		TRACED						SCALE 1:2	
		DRAWN						STORE DRG.NO. 30P 1001	
		CHECKED						OPERATION NO.	
		HOS/D&DO							
		NDAL OFFICER							
		OFFICER/D&DO							
APPROVED ON: 06/01/2020		SUB: BARREL AFTER HONING		DES. REF. NO.		DRG. No.: TEND-2628		SHEETS: 1	
		FOR: BARREL				ORDNANCE FACTORY TIRUCHIRAPPALLI-16.		SHAFT No. 4	
		OF: 40mm MGL							

CERTIFIED CORRECT COPY
OF APPROVED DRAWINGS
AT THIS DATE 03/10/2020
Handwritten: J. Venkatesh 03/10/20
Design & Drawing Office
Ordnance Factory,
Tiruchirappalli-620014

CONTROLLED COPY