



1. Dimensions for reference.
2. * Dimensions are ensured by tool.
3. ** Dimensions not in projection.
4. Internal angle R = 0.4 mm.
5. Blunt edges R = 0.8 mm.
6. Non-perpendicularity of surface K relative to common axis of diameters J and L should not be more than 0.05 mm.
7. Misalignment of axis of surfaces K, J, O, Ф relative to axis of surface should not be more than 0.03 mm.
8. Difference in wall thickness of barrel channel should not be more than 0.5 mm.
9. Check straightness of barrel channel with plug-gauge (629.97 mm with length 300 mm).
10. Carry out inspection of dimensions specified from barrel axis with common axis of diameters T and H in zones N and M.
11. Cuts of right barrel channel with constant steepness No. Of cuts - 18. Pitch of cuts - 715.5 ± 20 mm.
12. Longitudinal (spiral on formation) scratches and steps by tool and similarly cross sectional and longitudinal not having sharp line forms and steps obtained during grinding is permissible. Nicks R = 0.2 * as per test specimen are permissible.
13. Passage of no-go gauge on base and cuts of channel to depth 30 mm from start of cut and on base up to 15 mm, and on cut up to 6 mm from muzzle groove is permissible.
14. Tolerance along contour N not above 0.05 mm, along contour B is 0.2 mm.
15. Increase in dimension H up to 4.5 mm and lowering of surface finish up to 0.25 on width of W of ring grooves is permissible.
16. Tolerance along contour P should not be above 0.1 mm. Tolerance towards decreasing section of component.
17. Coating: Barrel channel - Cr, hard 24 - 80. Decrease in chrome thickness in cuts up to Cr hard 18 is permissible. Dimensions are given after chrome plating. Bulging of chrome on face L is permissible. Sagging of chrome on hole C is permissible. Outer surface with Chsm. Phos. oil, sand blasting of surface K is not permissible.
18. Non flatness of face R is 0.03 mm. Check on paint. Fitting of gauge (ring) should not be less than 80% of surface.
19. Darkening and tempering of colour of chrome plating is permissible after releasing.
20. Make draft version by method of elec. chem. treatment.
21. Mark with letter size PO - 5 GOST 2930-82.
22. Mark no. of sleeve of trench piece, for which barrel is selected and article no. with letter size PO - 5 GOST 2930-82.
23. Stamp.
24. Dimensions A1 given with passage of plug with diameter 30 mm, set in barrel channel.
25. Substitute material - Steel OX103MkA-0-50 TU 53-45-98.

NOTE:

1. CHROME PLATED FINAL DIMENSIONS MUST BE CHECKED WITH FOLLOWING GAUGES ONLY :-
LK8321-4121, LK8321-4232, LK8321-4159, LK8321-4160, LK8321-4157, LK8321-4158,
LK8133-5055, LK8139-4837, LK8139-4839, 8139-4840, LK8734-4062, LK8139-5682
LK8321-5069, LK8130-5154, LK8449-4006, LK8344-4399, GWG-6724. O R LK 8130-6685
2. FINISH BARREL DRAWING NO. IS : AQ-18.01.018.

SCH.NO.:	PROJECTION 3RD ANGLE	COMPT.: BARREL AQ-18.01.018	STORE DRG.NO.: AK-630M
DRN.BY: [Signature]	INPUT SKETCH FOR CHROME PLATING		
TRD.BY:	M - 11250		
CKD.BY:			
APPD.BY: [Signature]			
DT & SG	DESCRIP	CONC. BY: GUN-B	M/C:
AMENDMENTS	DT: [Signature]	SG: [Signature]	G. & S.FY., COSSIPORE
			NO. OF SHTS : 1
			SHEET NO : 1

Reference No. []
 Date []
 Material []
 Drawing No. []
 Scale []
 Author []
 Checker []
 Approver []

