

QUALITY MONITORING INSTRUCTION FOR INSPECTION		Issue No : 01
		Rev No:
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TEND-2628 (BARREL AFTER HONING) For 30P 1001*3		OFT/MI/MGL/30P 1001
Rev.No	Amendment	Date

MATERIAL SPECIFICATION : IS: 5517-1993, GR. 42Cr4Mo2 (or)
BS: 970, Pt.1, 1983 Gr. 709 M40 (or) 708 M40 with 'T' Condition (or)
En 19 (or) En 19A with 'T' Condition.

CONDITION OF SUPPLY : Barrel After Honing (Blank)

END USE : 40mm MGL.

INSPECTION CHECK TO BE CARRIED OUT

Table 'A'

SL NO	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1.	Visual	The blank shall be free from defects such as rust, scale, burrs and any other harmful defects.	100%
2.	Dimension	100% Dimensional check as per store drawing.	
3.	Chemical Composition (%)	<p><u>IS: 5517-1993, Design 42Cr4 Mo2</u></p> <p>C = 0.38 – 0.45 Mn = 0.60 – 0.90 Si = 0.10 – 0.35 S = 0.010 (Max) Cr = 0.90 – 1.20 P = 0.016 (Max) Mo = 0.15 – 0.30 Ni = 0.25 (Max) Cu = 0.35 (Max) V = 0.05 (Max) B = 0.0003 (Max) Tin = 0.05 (Max) %Cu + 10times (%tin) = 0.60% (Max).</p> <p><u>BS : 970 PT-1, 1983 GR.709 M40</u></p> <p>C = 0.36-0.44 Mo = 0.25-0.35 Si = 0.10-0.35 S = 0.010 (Max) Mn = 0.70-1.00 P = 0.016 (Max) Cr = 0.90-1.20 Ni = 0.40(Max)</p> <p><u>BS: 970 PT-1, 1983 GR.708 M40</u></p> <p>C = 0.36-0.44 Mo = 0.15-0.25 Si = 0.10-0.35 S = 0.010 (Max) Mn = 0.70-1.00 P = 0.016 (Max) Cr = 0.90-1.20 Ni = 0.40(Max)</p> <p><u>EN-19</u></p> <p>C = 0.35-0.45 Mo = 0.20-0.40 Si = 0.10-0.35 V = 0.05 (Max) Mn = 0.50-0.80 S = 0.010 (Max) Cr = 0.90-1.50 P = 0.016 (Max) Ni = 0.40 (Max)</p> <p><u>EN-19A</u></p> <p>C = 0.35-0.45 Mo = 0.20-0.35 Si = 0.10-0.35 V = 0.05 (Max) Mn = 0.50-0.80 S = 0.010 (Max) Cr = 0.90-1.20 P = 0.016 (Max) Ni = 0.40 (Max)</p> <p>(Permissible variations in value as per specification)</p>	One Sample Per Heat