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Regulations
2403

REGULATIONS FOR ARMY ORDNANCE SERVICES

PART II

PAMPHLET No. 19

1942

LIST OF TOOLS AND GAUGES FOR EXAMINATION OF ORDNANCE

By Command of the Army Council,

I. J. Grier

THE WAR OFFICE,
25th February, 1942.

LIST OF TOOLS AND GAUGES FOR EXAMINATION OF ORDNANCE.

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For notes and references, see end of Table.

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DESIGNATION		B.L. AND Q.F. GUNS		B.L. AND Q.F. HOWITZERS		MORTARS	
1		2		3		4	
Gauges, firing hole bush—		V.A.O.S. SECTION		B.L., 15-in. Mk. I			
No. 1	...	B.L., 14-in. Mk. VI					
No. 2	...	B.L., 9.2-in. Mk. IX and C, Mk. IX					
No. 3	...	B.L., 9.2-in. Mk. X, Xv and X*					
Gauges, head, machine, milling, rifling grooves—	...	B.L., 9.2-in. Mk. XIII, XIII* and XIIIa					
B.L. 9.2-in.	...	B.L., 6-in. Mk. VII and VIIv					
B.L. 6-in.	...	B.L., 6-in. Mk. XIX					
Gauges, main spring, Q.F. Hotchkiss 6-pr....	...	B.L., 6-in. Mk. XXI					
Gauges, measuring, bore—	...	B.L., 60-pr. Mk. I, I* and I**					
No. 1	...	B.L., 60-pr. Mk. II and II*					
No. 3	...	Q.F., 6-in. Mk. II					
No. 4	...	Q.F., 4.7-in. Mk. III to IV*					
No. 6	...	Q.F., 4.5-in. Mk. II					
No. 7	...	16					
No. 8	...	Q.F., 3.7-in. Mk. I, II and III					
No. 9	...	Q.F., 25-pr. Mk. I and II					
No. 10	...	Q.F., 3-in. 20-cwt. (All Marks)					
No. 11	...	Q.F., 18-pr. Mk. I to II*, IV, IVa and IVb					
No. 12	...	Q.F., 13-pr. Mk. I to III					
No. 13	...	Q.F., 12-pr. 12-cwt. Mk. I, I*, II and II*					
No. 16	...	Q.F., 6-pr. 10-cwt., Left and Right, Mk. I					
No. 17	...	Q.F., 6-pr. 8-cwt. Hotchkiss, Mk. I and II					
No. 19	...	Q.F., 6-pr. 6-cwt. Hotchkiss, Mk. II					
No. 23, Mk. I	...	Gun, sub-calibre, Q.F., 6-pr. Mk. I					
No. 27, Mk. II	...	Q.F., 6-pr. Nordenfelt, Mk. III					
No. 28	...	Q.F., 3-pr. 2-cwt. Mk. I and II					
No. 30	...	Gun, sub-calibre, Q.F., 3-pr. Mk. I, I*, III, V and VII					
No. 31	...	Gun, sub-calibre, Q.F., 3-pr. Mk. II, II* and IV					
	...	Q.F., 2-pr. Mk. VIII, IX and X					
	...	Q.F., 40-mm. Mk. I					
	...	B.L., 6-in. Mk. XXIV					
	...	B.L., 5.5-in. Mk. III					
	...	B.L., 4.5-in., Mk. I					
	...	B.L., 4.5-in., Mk. II					
	...	B.L., 18-in. howitzer, Mk. I					
	...	B.L., 12-in. howitzer, Mk. III					
	...	B.L., 12-in. howitzer, Mk. IV					
	...	B.L., 12-in. howitzer, Mk. V					
	...	B.L., 9.2-in. howitzer, Mk. I					
	...	B.L., 9.2-in. howitzer, Mk. II					
	...	B.L., 8-in. howitzer, Mk. VIII					
	...	B.L., 6-in. 26-cwt. howitzer, Mk. I					
	...	Q.F., 4.5-in. howitzer, Mk. I and II					
	...	Q.F., 3.7-in. howitzer, Mk. I					
	...	Q.F., 3-in. howitzer, Mk. I					
	...	B.L., 12-in. howitzer, Mk. IIIA, IVA, VA and VI					
	...	B.L., 9.2-in. howitzer, Mk. IIA					
	...	50					
	...	51					
	...	M.L., 3-in. mortar, Mk. I and II					
	...	Q.F., 3.7-in. mortar, Mk. I					
	...	M.L., 2-in. mortar, Mk. II					
	...	55					
	...	56					

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List of Tools and Gauges for Examination of Ordnance—*continued.*

DESIGNATION

B.L. AND Q.F. GUNS										B.L. AND Q.F. HOWITZERS										MORTARS									
2 V.A.O.S. SECTION																													
3 B.L., 15-in. Mk. I																													
4 B.L., 14-in. Mk. VI																													
5 B.L., 9-2-in. Mk. IX and C. Mk. IX																													
6 B.L., 9-2-in. Mk. X, Xv and X*																													
7 B.L., 9-2-in. Mk. XIII, XIII* and XIIIa																													
8 B.L., 6-in. Mk. VII and VIIv																													
9 B.L., 6-in. Mk. XIX																													
10 B.L., 6-in. Mk. XXI																													
11 B.L., 60-pr. Mk. I, I* and I**																													
12 B.L., 60-pr. Mk. II and II*																													
13 Q.F., 6-in. Mk. II																													
14 Q.F., 4-7-in. Mk. III to IV*																													
15 Q.F., 4-5-in. Mk. II																													
16																													
17 Q.F., 3-7-in. Mk. I, II and III																													
18 Q.F., 25-pr. Mk. I and II																													
19 Q.F., 3-in. 20-cwt. (All Marks)																													
20 Q.F., 18-pr. Mk. I to II*, IV, IVa and IVb																													
21 Q.F., 13-pr. Mk. I to III																													
22 Q.F., 12-pr. 12-cwt. Mk. I, I*, II and II*																													
23 Q.F., 6-pr. 10-cwt., Left and Right, Mk. I																													
24 Q.F., 6-pr. 8-cwt. Hotchkiss, Mk. I and II																													
25 Q.F., 6-pr. 6-cwt. Hotchkiss, Mk. II																													
26 Gun, sub-calibre, Q.F., 6-pr. Mk. I																													
27 Q.F., 6-pr. Nordenfolt, Mk. III																													
28 Q.F., 3-pr. 2-cwt. Mk. I and II																													
29 Gun, sub-calibre, Q.F., 3-pr. Mk. I, I*, III, V and VII																													
30 Gun, sub-calibre, Q.F., 3-pr. Mk. II, II* and IV																													
31 Q.F., 2-pr. Mk. VIII, IX and X																													
32 Q.F., 40-mm. Mk. I																													
33 B.L., 6-in. Mk. XXIV																													
34 B.L., 5-5-in. Mk. III																													
35 B.L., 4-5-in., Mk. I																													
36 B.L., 4-5-in., Mk. II																													
37 B.L., 18-in. howitzer, Mk. I																													
38 B.L., 12-in. howitzer, Mk. III																													
39 B.L., 12-in. howitzer, Mk. IV																													
40 B.L., 12-in. howitzer, Mk. V																													
41 B.L., 9-2-in. howitzer, Mk. I																													
42 B.L., 9-2-in. howitzer, Mk. II																													
43 B.L., 8-in. howitzer, Mk. VIII																													
44 B.L., 6-in. 26-cwt. howitzer, Mk. I																													
45 Q.F., 4-5-in. howitzer, Mk. I and II																													
46 Q.F., 3-7-in. howitzer, Mk. I																													
47 Q.F., 3-in. howitzer, Mk. I																													
48 B.L., 12-in. howitzer, Mk. IIIa, IVa, Va and VI																													
49 B.L., 9-2-in. howitzer, Mk. IIa																													
50																													
51																													
52 M.L., 3-in. mortar, Mk. I and II																													
53 Q.F., 3-7-in. mortar, Mk. I																													
54 M.L., 2-in. mortar, Mk. II																													
55																													
56																													

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List of Tools and Gauges for Examination of Ordnance—*continued*

DESIGNATION		B.L. AND Q.F. GUNS		B.L. AND Q.F. HOWITZERS		MORTARS	
2	V.A.O.S. SECTION						
3	B.L., 15-in. Mk. I						
4	B.L., 14-in. Mk. VI						
5	B.L., 9·2-in. Mk. IX and C, Mk. IX						
6	B.L., 9·2-in. Mk. X, Xv and X*						
7	B.L., 9·2-in. Mk. XIII, XIII* and XIIIa						
8	B.L., 6-in. Mk. VII and VIIv						
9	B.L., 6-in. Mk. XIX						
10	B.L., 6-in. Mk. XXI						
11	B.L., 60-pr. Mk. I, I* and I**						
12	B.L., 60-pr. Mk. II and II*						
13	Q.F., 6-in. Mk. II						
14	Q.F., 4·7-in. Mk. III to IV*						
15	Q.F., 4·5-in. Mk. II						
16							
17	Q.F., 3·7-in. Mk. I, II and III						
18	Q.F., 25-pr. Mk. I and II						
19	Q.F., 3-in. 20-cwt. (All Marks)						
20	Q.F., 18-pr. Mk. I to II*, IV, IVa and IVb						
21	Q.F., 13-pr. Mk. I to III						
22	Q.F., 12-pr. 12-cwt. Mk. I, I*, II and II*						
23	Q.F., 6-pr. 10-cwt., Left and Right, Mk. I						
24	Q.F., 6-pr. 8-cwt. Hotchkiss, Mk. I and II						
25	Q.F., 6-pr. 6-cwt. Hotchkiss, Mk. II						
26	Gun, sub-calibre, Q.F., 6-pr. Mk. I						
27	Q.F., 6-pr. Nordenfelt, Mk. III						
28	Q.F., 3-pr. 2-cwt. Mk. I and II						
29	Gun, sub-calibre, Q.F., 3-pr. Mk. I, I*, III, V and VII						
30	Gun, sub-calibre, Q.F., 3-pr. Mk. II, II* and IV						
31	Q.F., 2-pr. Mk. VIII, IX and X						
32	Q.F., 40-mm. Mk. I						
33	B.L., 6-in. Mk. XXIV						
34	B.L., 5·5-in. Mk. III						
35	B.L., 4·5-in., Mk. I						
36	B.L., 4·5-in., Mk. II						
37	B.L., 18-in. howitzer, Mk. I						
38	B.L., 12-in. howitzer, Mk. III						
39	B.L., 12-in. howitzer, Mk. IV						
40	B.L., 12-in. howitzer, Mk. V						
41	B.L., 9·2-in. howitzer, Mk. I						
42	B.L., 9·2-in. howitzer, Mk. II						
43	B.L., 8-in. howitzer, Mk. VIII						
44	B.L., 6-in. 26-cwt. howitzer, Mk. I						
45	Q.F., 4·5-in. howitzer, Mk. I and II						
46	Q.F., 3·7-in. howitzer, Mk. I						
47	Q.F., 3-in. howitzer, Mk. I						
48	B.L., 12-in. howitzer, Mk. IIIA, IVA, VA and VI						
49	B.L., 9·2-in. howitzer, Mk. IIA						
50							
51							
52	M.L., 3-in. mortar, Mk. I and II						
53	Q.F., 3·7-in. mortar, Mk. I						
54	M.L., 2-in. mortar, Mk. II						
55							
56							

For notes and references, see end of Table

NOTES.

a Indicates nature of ordnance with which employed.

1 Except guns with P.J. locks.

2 For guns using P.J. locks.

3 Will be replaced by "Frames, measuring, chamber, No. 11" when existing stocks become exhausted.

4 For "A" guns.

5 For Mk. I vents only.

6 For "B" guns only.

7 These gauges are also suitable for measuring buffer and recuperator cylinder.

8 For use with ordnance firing low diameter projectiles.

9 For guns not liable to steel choke.

10 For guns liable to steel choke.

11 For ordnance with P.K. locks.

12 For Mk. I to I***, IA and IB guns only.

13 For Mk. III, III* and IIIA guns only.

14 For ordnance with P.H. locks.

15 For Mk. IA barrels only.

16 For ordnance using T tubes.

17 Also for chamber.

18 In two lengths of 50 in. each.

19 Will be used if "Straightedge, 7-ft. by 2½-in. by ½-in." is not available.

20 Will be replaced by "Frames, measuring chamber, No. 12" when existing stocks become exhausted.

21 Mk. I frames are not suitable for Mk. VIII guns.

22 Not for 2-pr. Mk. IX and X guns.

23 For buffer cylinder.

24 For piston rod and grooves.

25 Will be replaced by "Frames, measuring, chamber, No. 4, Mk. II" when existing stocks become exhausted.