CLAIMS:

1. A medical syringe barrel comprising a tubular barrel section for accommodating an internal-use solution in the interior thereof, an injection nozzle section formed at one end of the barrel section, and a flange section formed at an opening section on the other end of the barrel section to project radially outward, wherein

the barrel section includes an intermediate body part, a large outer diameter barrel section having an outer diameter formed between the flange section and the intermediate body part and larger than an outer diameter of the intermediate body part, an internal-use solution filled section which is set to be filled with the internal-use solution and an internal-use solution unfilled section which is set not to be filled with the internal-use solution when the internal-use solution is poured into the syringe barrel from the opening section;

the surface of the flange section has a recess portion; and

a weld line which is potentially formed by injection molding is not formed in the internal-use solution filled section.

2. A medical syringe barrel according to Claim 1, the height of a gate rest by injection molding is smaller than the depth of the recess portion in the flange section, and the gate rest fits in the interior of the recess portion.

3. A manufacturing method for producing a medical syringe barrel, which comprises a tubular barrel section for accommodating an internal-use solution in the interior thereof, an injection nozzle section formed at one end of the barrel section, and a flange section formed at an opening section of the other end of the barrel section to project radially outward, the barrel section including an intermediate body part, a large outer diameter barrel section having an outer diameter formed between the flange section and the intermediate body part and larger than an outer diameter of the intermediate body part, wherein

preparing a mold so that the surface of the flange section has a recess portion; and

conducting injection molding of a thermoplastic resin material by installing a gate at the position where the recess portion is to be formed.