

#9

Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 11:24:48
CMM: CMM1

CYLINDER FORMING DATUM-A OUTSIDE DIAMETER

#1

TYPE: BOSS

NAME: DATUM_A

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
DI	1.3937	1.4000	0.0050	0.0050	-0.0063	-0.0013
FM			0.0050		0.0017	++

BARREL COUNTERBORE-DIA. & POSITION RELATIVE TO DATUM-A
RECEIVER ID AT FRONT OF PART

#3

TYPE: I.D.

NAME: ID_FRONT

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	0.0006	0.0000	0.0050	0.0050	0.0006	-
X	-0.0001	0.0000	0.0050	0.0050	-0.0001	-
DI	1.0430	1.0460	0.0030	0.0030	-0.0030	----

WIDTH OF DATUM-C FIRE CONTROL SLOT

DISTANCE MIDPOINT OF DATUM-C IS OFFSET FROM DATUM-A CENTERLINE (.004 TP)

#5

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	0.0116	-0.0050	0.0020	0.0020	0.0166	0.0146

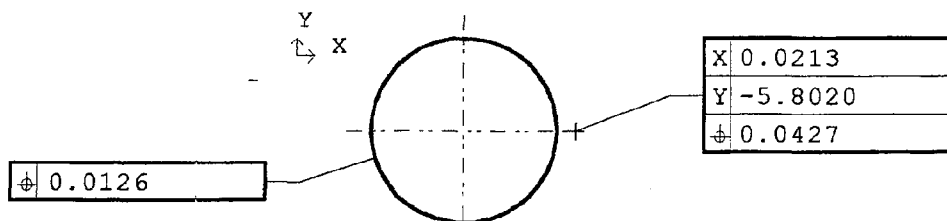
BOLT STOP HOLE ON LH SIDE OF RECEIVER

#6

TYPE: I.D.

NAME: BOLT_STOP_HOLE

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.0213	0.0000	0.0100	0.0100	0.0213	0.0113
Y	-5.8020	-5.8020	0.0100	0.0100	0.0000	+
DI	0.2766	0.2790	0.0050	0.0050	-0.0024	--
PS			0.0100		0.0427	0.0300



RECEIVER ID AT BACK OF PART
CENTERLINE OF ID OF RECEIVER
ANSI COAXIALITY: To DATUM_A
OVERALL LENGTH OF RECEIVER

LENGTH OF FRONT EDGE OF BOLT HANDLE CLEARANCE CUT TO DATUM-B

ET06122

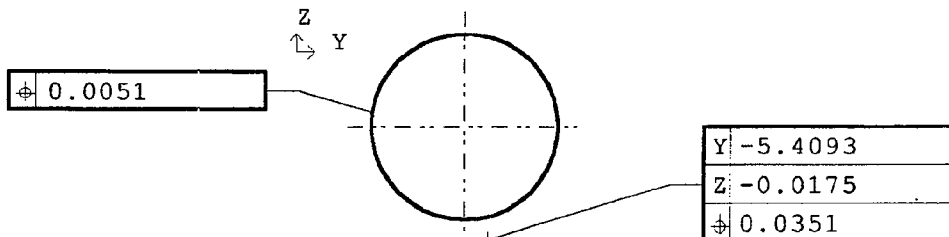
REARMOST SCOPE SCREW HOLE

#12

TYPE: I.D.

NAME: SCOPE_SCREW_1

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-5.4093	-5.4100	0.0040	0.0040	0.0007	+
Z	-0.0175	0.0000	0.0040	0.0040	-0.0175	-0.0135
DI	0.1165	0.1164	0.0010	0.0010	0.0001	+
PS			0.0040		0.0351	0.0300



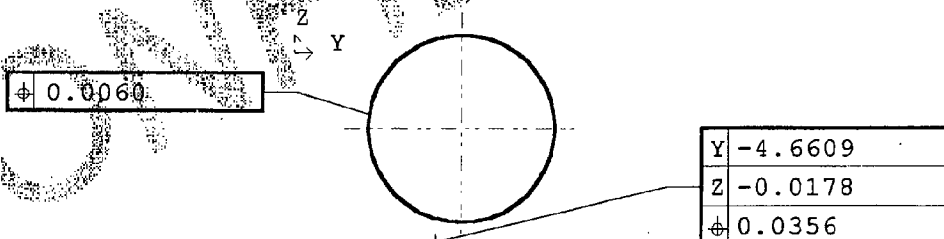
SCOPE SCREW HOLE .750 FORWARD OF REARMOST

#13

TYPE: I.D.

NAME: SCOPE_SCREW_2

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-4.6609	-4.6600	0.0040	0.0040	-0.0009	-
Z	-0.0178	0.0000	0.0040	0.0040	-0.0178	-0.0138
DI	0.1223	0.1164	0.0010	0.0010	0.0059	0.0049
PS			0.0040		0.0356	0.0296



SCOPE SCREW HOLE AT-2.200 FROM DATUM-B

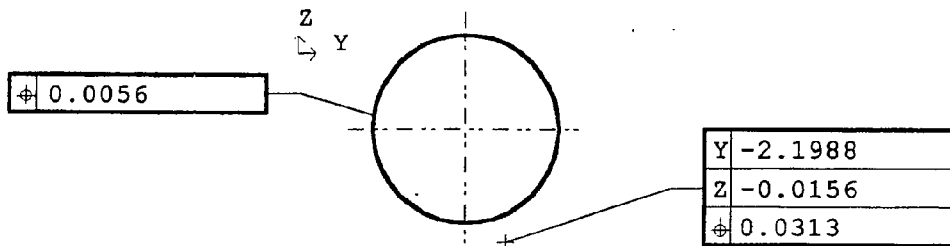
#14

TYPE: I.D.

NAME: SCOPE_SCREW_3

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-2.1988	-2.2000	0.0040	0.0040	0.0012	++
Z	-0.0156	0.0000	0.0040	0.0040	-0.0156	-0.0116
DI	0.1170	0.1164	0.0010	0.0010	0.0006	+++
PS			0.0040		0.0313	0.0257

ET06123



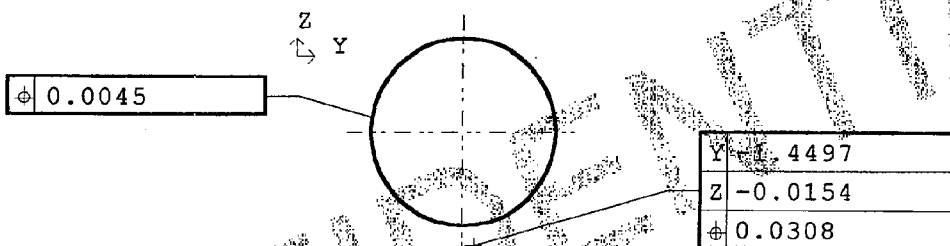
SCOPE SCREW .750 FORWARD OF SCOPE_SCREW_3

#15

TYPE: I.D.

NAME: SCOPE_SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4497	-1.4500	0.0040	0.0040	0.0003	+
Z	-0.0154	0.0000	0.0040	0.0040	-0.0154	-0.0114
DI	0.1159	0.1164	0.0010	0.0010	-0.0005	---
PS			0.0040		0.0308	0.0264



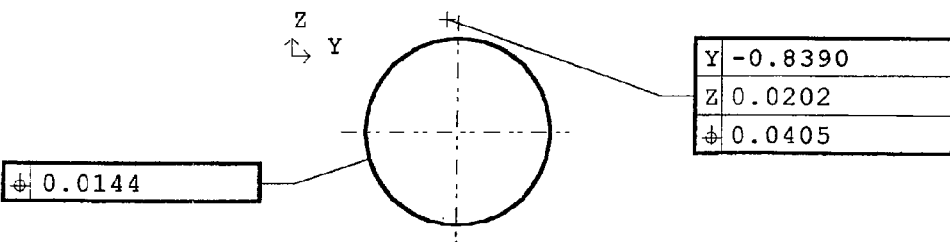
DEPTH OF BARREL COUNTERBORE
TAKEDOWN SCREW CLEARANCE HOLE

#17

TYPE: I.D.

NAME: TAKEDOWN

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-0.8390	-0.8380	0.0100	0.0100	-0.0010	-
Z	0.0202	0.0000	0.0100	0.0100	0.0202	0.0102
DI	0.2644	0.2650	0.0050	0.0050	-0.0006	-
PS			0.0100		0.0405	0.0261



MAGAZINE BOX POSITION FROM DATUM B
MAGAZINE BOX LENGTH

ET06124

DISTANCE OF RH SIDE OF MAGAZINE SLOT FROM CENTER @33 DEGREES
DISTANCE OF RH SIDE OF MAGAZINE SLOT FROM CENTER @33 DEGREES
#21

TYPE: PLANE

NAME: MAG_SLOT_LH

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.1500	0.1250	0.0050	0.0050	0.0250	0.0200

DISTANCE-FRONT OF FIRE CONTROL SLOT TO DATUM B
CENTER DISTANCE BETWEEN FIRECONTROL SLOT .125R UNDERCUTS
REAR EJECTION PORT RADIUS
REAR EJECTION PORT RADIUS POSITION FROM DATUM-B
#27

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
DS	4.9590	4.9500	0.0050	0.0050	0.0090	0.0040

EJECTION PORT WIDTH
POSITION OF TOP WALL OF EJECTION PORT TO DATUM-A CENTERLINE @ 60 DEGREES
#29

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.3107	0.2950	0.0050	0.0050	0.0157	0.0107

FRONT EJECTION PORT RADIUS
EJECTION PORT LENGTH FROM REAR RADIUS TO FRONT RADIUS
TOP SURFACE OF BOLT HANDLE RELIEF CUT
#32

TYPE: POINT

NAME: BOLT_RELIEF

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	-0.2779	-0.2620	0.0050	0.0050	-0.0159	-0.0109

BOTTOM SURFACE OF BOLT HANDLE RELIEF CUT
#33

TYPE: POINT

NAME: LO_BOLT_RELIEF

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.1970	0.2130	0.0050	0.0050	-0.0160	-0.0110

ET06125