

2

Part Program: 710 RECEIVER
Inspector: Administrator

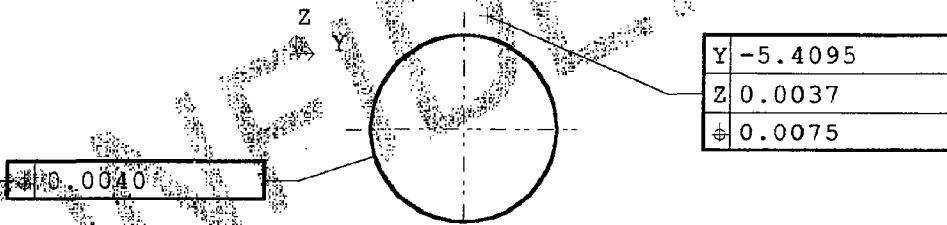
Date/Time: 08/14/2000 10:39:54
CMM: CMM1

CYLINDER FORMING DATUM-A OUTSIDE DIAMETER
BARREL COUNTERBORE-DIA. & POSITION RELATIVE TO DATUM-A
RECEIVER ID AT FRONT OF PART
WIDTH OF DATUM-C FIRE CONTROL SLOT
DISTANCE MIDPOINT OF DATUM-C IS OFFSET FROM DATUM-A CENTERLINE (.004 TP)
BOLT STOP HOLE ON LH SIDE OF RECEIVER
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
REARMOST SCOPE SCREW HOLE
#12

TYPE: I.D.

NAME: SCOPE_SCREW_1

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-5.4095	-5.4100	0.0040	0.0040	0.0005	+
Z	0.0037	0.0000	0.0040	0.0040	0.0037	++++
DI	0.1151	0.1164	0.0010	0.0010	-0.0013	-0.0003
PS			0.0040		0.0075	0.0035



SCOPE SCREW HOLE .750 FORWARD OF REARMOST

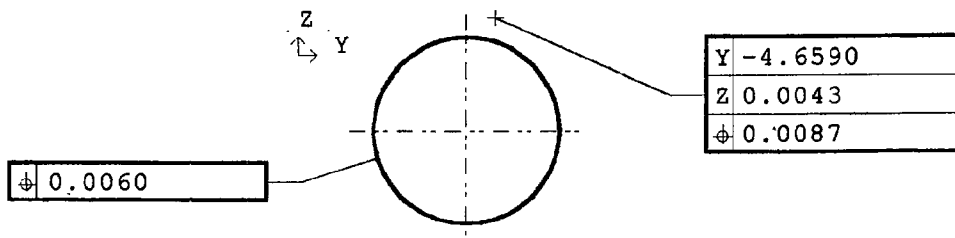
#13

TYPE: I.D.

NAME: SCOPE_SCREW_2

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-4.6590	-4.6600	0.0040	0.0040	0.0010	+
Z	0.0043	0.0000	0.0040	0.0040	0.0043	0.0003
DI	0.1228	0.1164	0.0010	0.0010	0.0064	0.0054
PS			0.0040		0.0087	0.0027

ET06096



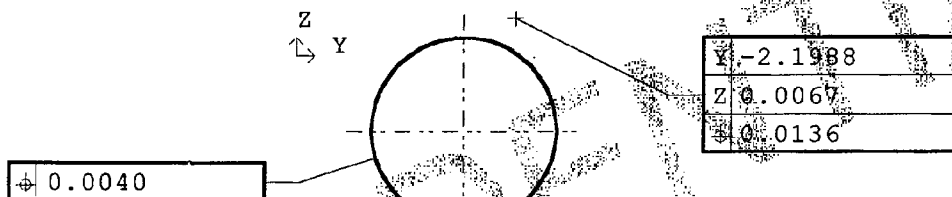
SCOPE SCREW HOLE AT 2.200 FROM DATUM-B

#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	0.0067	0.0000	0.0040	0.0040	0.0067	0.0027
DI	0.1154	0.1164	0.0010	0.0010	-0.0010	----
PS			0.0040		0.0136	0.0096



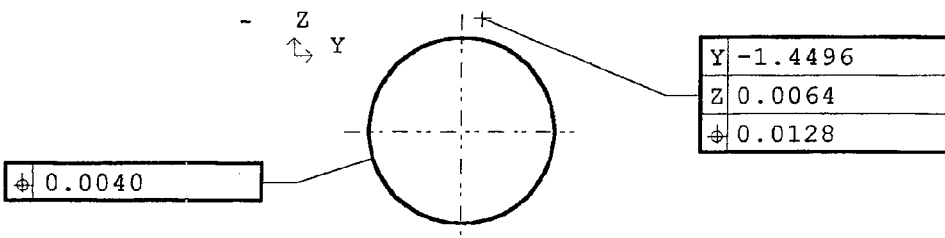
SCOPE SCREW .750 FORWARD OF SCOPE_SCREW_3

#15

TYPE: I.D.

NAME: SCOPE_SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4496	-1.4500	0.0040	0.0040	0.0004	+
Z	0.0064	0.0000	0.0040	0.0040	0.0064	0.0024
DI	0.1154	0.1164	0.0010	0.0010	-0.0010	----
PS			0.0040		0.0128	0.0088



DEPTH OF BARREL COUNTERBORE
 TAKEDOWN SCREW CLEARANCE HOLE
 MAGAZINE BOX POSITION FROM DATUM B

ET06097

MAGAZINE BOX LENGTH

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

#20

TYPE: PLANE

NAME: MAG_SLOT_RH

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.1341	0.1250	0.0050	0.0050	0.0091	0.0041

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	0.1312	0.1250	0.0050	0.0050	0.0062	0.0012

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	4.9602	4.9500	0.0050	0.0050	0.0102	0.0052

EJECTION PORT WIDTH

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

FRONT EJECTION PORT RADIUS

EJECTION PORT LENGTH FROM REAR RADIUS TO FRONT RADIUS

TOP SURFACE OF BOLT HANDLE RELIEF CUT

BOTTOM SURFACE OF BOLT HANDLE RELIEF CUT

#34

TYPE: POINT

NAME: BOLT_STOP_FLAT

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	0.6634	0.6700	0.0050	0.0050	0.0066	0.0016

ET06098