

Rich Kosko, The Hanson Group
Receiver Insert Inspection Recommendations (Dwg. 1E & 2E-300327)

Rich,

Please find enclosed three drawings total, two 1E-300327 and one 2E-300327. Of the two 1E-300327 drawings, one is your official copy of the revision level #1, depicting the tolerance changes as described in the fax of 3/8/99. The highlighted drawings of 1E-300327 and 2E-300327 are in response to your request for inspection recommendations. The highlighted dimensions indicate the geometry that I would recommend to be inspected throughout the production processing of receiver inserts. First article inspection will require verification of all dimensions per our phone conversation of 3/2/99. Assuming first article acceptance and production release of the tool by Remington, the inspection procedure should include, at a minimum, the highlighted information discussed below.

Highlighted 1E-300327:

Right End View -
1.043 +.000/-.003
A- Datum

I would recommend ring receiving gages of approx. 5" in length. The receiver - insert would be required to fully slide into the max. receiving gage, and not slide into the min. receiving gage. In production, the receiver insert will be assembled in this manner to the receiver, which is a hollow cylinder.

.701 +/- .002 Dia.

I would recommend go/no go plug gages of approx. 6" in length. The "go" plug gage must drop through the receiver insert without binding. This will provide diametral inspection as well as straightness over the length.

.380 +/- .003 Typ
(Lobes/Lug geometry)

Again, go/no go plug gages of approx. 3" in length. The go plug gage should drop through the receiver insert.

Detail D

1.046 +/- .001

Should not fit inside of the 1.043 dia. go gage mentioned above, measure with micrometers for the max. dimension.

Section B-B and E-E

.175 +.003/-.001

Inspect with height gage.

Highlighted 2E-300327:

Front View

(4) .1220 +/- .0015 dia. holes

Plug gage hole diameters, optically measure locations.

Partial Back View (right edge)

(2) .097 +/- .0015 dia. holes

Plug gage hole diameters, optically measure locations.

Michael D. Keeney
Staff Engineer

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