

#1

Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 10:22:36
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)
#5

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	0.0062	-0.0050	0.0020	0.0020	0.0112	0.0092

BOLT STOP HOLE ON LH SIDE OF RECEIVER
RECEIVER ID AT BACK OF PART
#7

TYPE: I.D.

NAME: ID_BACK

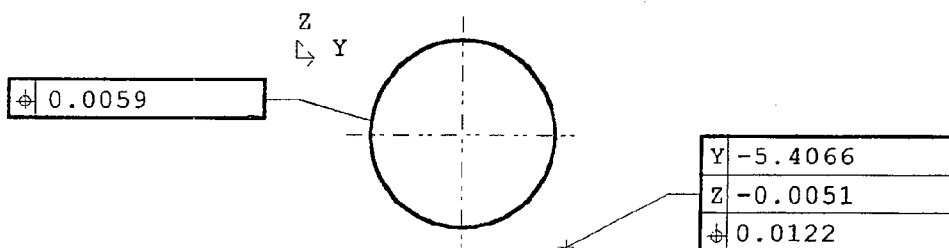
	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	0.0035	0.0000	0.0050	0.0050	0.0035	+++
X	-0.0005	0.0000	0.0050	0.0050	-0.0005	-
DI	1.0510	1.0460	0.0030	0.0030	0.0050	0.0020

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	-5.4066	-5.4100	0.0040	0.0040	0.0034	++++
Z	-0.0051	0.0000	0.0040	0.0040	-0.0051	-0.0011
DI	0.1173	0.1164	0.0010	0.0010	0.0009	++++
PS			0.0040		0.0122	0.0063



SCOPE SCREW HOLE .750 FORWARD OF REARMOST

#13

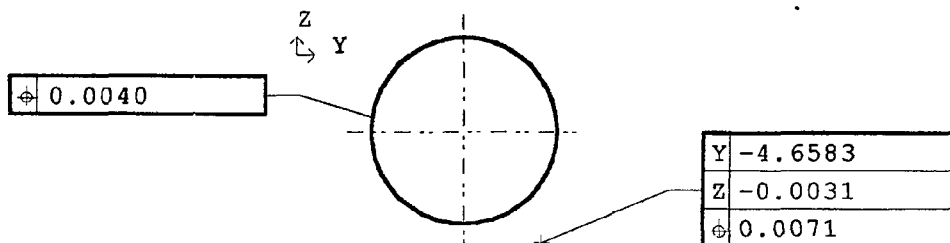
TYPE: I.D.

NAME: SCOPE SCREW 2

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-4.6583	-4.6600	0.0040	0.0040	0.0017	++

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Z	-0.0031	0.0000	0.0040	0.0040	-0.0031	----
DI	0.1137	0.1164	0.0010	0.0010	-0.0027	-0.0017
PS			0.0040		0.0071	0.0031



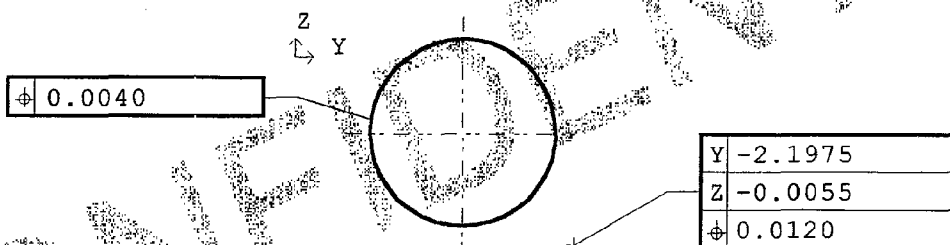
SCOPE SCREW HOLE AT 2.200 FROM DATUM-B

#14

TYPE: I.D.

NAME: SCOPE_SCREW_3

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-2.1975	-2.2000	0.0040	0.0040	0.0025	---
Z	-0.0055	0.0000	0.0040	0.0040	-0.0055	-0.0015
DI	0.1148	0.1164	0.0010	0.0010	-0.0016	-0.0006
PS			0.0040		0.0120	0.0080



SCOPE SCREW .750 FORWARD OF SCOPE_SCREW_3

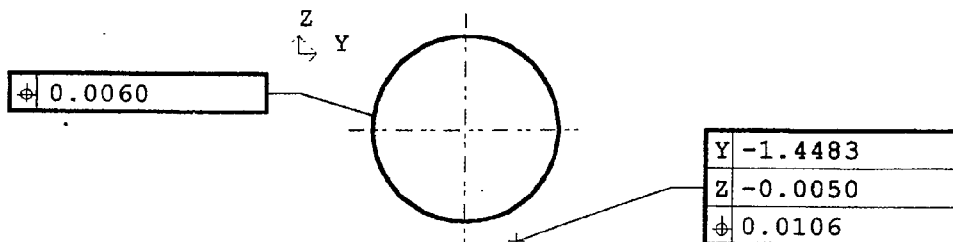
#15

TYPE: I.D.

NAME: SCOPE_SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4483	-1.4500	0.0040	0.0040	0.0017	++
Z	-0.0050	0.0000	0.0040	0.0040	-0.0050	-0.0010
DI	0.1215	0.1164	0.0010	0.0010	0.0051	0.0041
PS			0.0040		0.0106	0.0046

ET06093

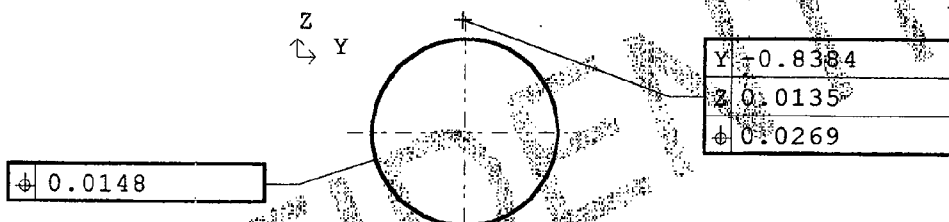


DEPTH OF BARREL COUNTERBORE
TAKEDOWN SCREW CLEARANCE HOLE
#17

TYPE: I.D.

NAME: TAKEDOWN

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-0.8384	-0.8380	0.0100	0.0100	-0.0004	-
Z	0.0135	0.0000	0.0100	0.0100	0.0135	0.0035
DI	0.2648	0.2650	0.0050	0.0050	-0.0002	83
PS			0.0100		0.0269	0.0121



MAGAZINE BOX POSITION FROM DATUM B

MAGAZINE BOX LENGTH

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	0.1397	0.1250	0.0050	0.0050	0.0147	0.0097

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	4.9599	4.9500	0.0050	0.0050	0.0099	0.0049

EJECTION PORT WIDTH

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

#29

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
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X 0.3050 0.2950 0.0050 0.0050 0.0100 0.0050

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	-0.2730	-0.2620	0.0050	0.0050	-0.0110	-0.0060

BOTTOM SURFACE OF BOLT HANDLE RELIEF CUT

#33

TYPE: POINT

NAME: LO_BOLT_RELIEF

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.1988	0.2130	0.0050	0.0050	-0.0142	-0.0092

#34

TYPE: POINT

NAME: BOLT_STOP_FLAT

Z	-0.6638	-0.6700	0.0050	0.0050	0.0062	0.0012
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