

#5

Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 11:02:51
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

#4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
DS	0.3245	0.3200	0.0025	0.0025	0.0045	0.0020

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

#5

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	-0.0005	-0.0050	0.0020	0.0020	0.0045	0.0025

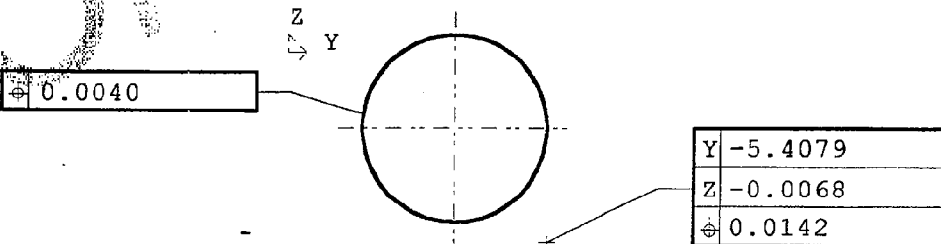
BOLT STOP HOLE ON LH SIDE OF RECEIVER
RECEIVER ID AT BACK OF PART
CENTERLINE OF ID OF RECEIVER
ANSI COAXIALITY: To DATUM_A
OVERALL LENGTH OF RECEIVER
LENGTH OF FRONT EDGE OF BOLT HANDLE CLEARANCE CUT TO DATUM-B
REARMOST SCOPE SCREW HOLE

#12

TYPE: I.D.

NAME: SCOPE_SCREW_1

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-5.4079	-5.4100	0.0040	0.0040	0.0021	+++
Z	-0.0068	0.0000	0.0040	0.0040	-0.0068	-0.0028
DI	0.1153	0.1164	0.0010	0.0010	-0.0011	-0.0001
PS			0.0040		0.0142	0.0102



SCOPE SCREW HOLE .750 FORWARD OF REARMOST

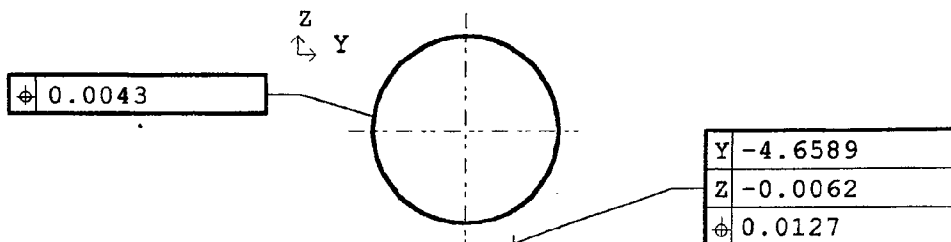
#13

TYPE: I.D.

NAME: SCOPE_SCREW_2

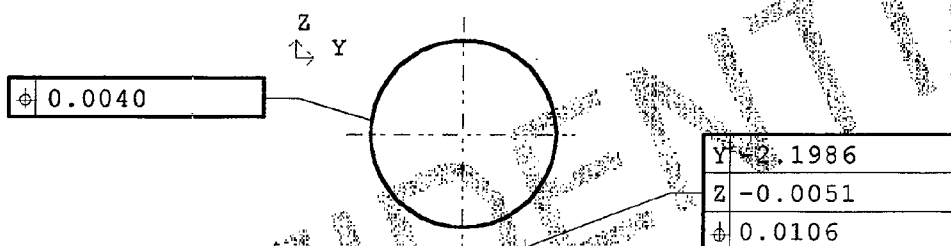
	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-4.6589	-4.6600	0.0040	0.0040	0.0011	++
Z	-0.0062	0.0000	0.0040	0.0040	-0.0062	-0.0022
DI	0.1157	0.1164	0.0010	0.0010	-0.0007	---
PS			0.0040		0.0127	0.0084

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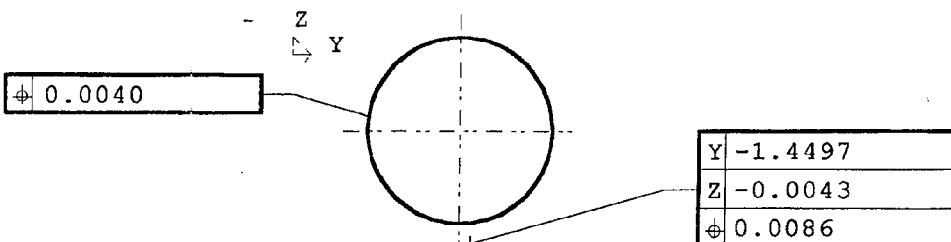
SCOPE SCREW HOLE AT 2.200 FROM DATUM-B
#14
TYPE: I.D.
NAME: SCOPE_SCREW_3

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-2.1986	-2.2000	0.0040	0.0040	0.0014	++
Z	-0.0051	0.0000	0.0040	0.0040	-0.0051	-0.0011
DI	0.1143	0.1164	0.0010	0.0010	-0.0021	-0.0011
PS			0.0040		0.0106	0.0066



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	-0.0043	0.0000	0.0040	0.0040	-0.0043	-0.0003
DI	0.1147	0.1164	0.0010	0.0010	-0.0017	-0.0007
PS			0.0040		0.0086	0.0046



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

ET06107

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	0.1354	0.1250	0.0050	0.0050	0.0104	0.0054

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	0.1336	0.1250	0.0050	0.0050	0.0086	0.0036

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	4.9579	4.9500	0.0050	0.0050	0.0079	0.0029

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

ET06108