

#6

Part Program: 710 RECEIVER  
Inspector: Administrator

Date/Time: 08/14/2000 11:08:43  
CMM: CMM1

CYLINDER FORMING DATUM-A OUTSIDE DIAMETER  
BARREL COUNTERBORE-DIA. & POSITION RELATIVE TO DATUM-A  
#2

TYPE: BORE  
NAME: BBL\_CBORE

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| X  | 0.0000  | 0.0000  | 0.0020 | 0.0020 | 0.0000  | -       |
| Z  | -0.0029 | 0.0000  | 0.0020 | 0.0020 | -0.0029 | -0.0009 |
| DI | 1.2269  | 1.2270  | 0.0050 | 0.0050 | -0.0001 | -       |
| PS |         |         | 0.0040 |        | 0.0057  | +++     |

RECEIVER ID AT FRONT OF PART  
WIDTH OF DATUM-C FIRE CONTROL SLOT  
DISTANCE MIDPOINT OF DATUM-C IS OFFSET FROM DATUM-A CENTERLINE (-0.004 TP)  
#5

|   | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|---|--------|---------|--------|--------|--------|---------|
| Z | 0.0002 | -0.0050 | 0.0020 | 0.0020 | 0.0052 | 0.0032  |

BOLT STOP HOLE ON LH SIDE OF RECEIVER

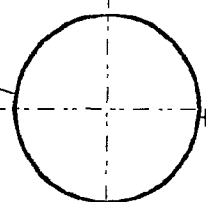
#6

TYPE: I.D.  
NAME: BOLT\_STOP\_HOLE

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| X  | 0.0078  | 0.0000  | 0.0100 | 0.0100 | 0.0078  | ++++    |
| Y  | -5.8027 | -5.8020 | 0.0100 | 0.0100 | -0.0007 | -       |
| DI | 0.2783  | 0.2790  | 0.0050 | 0.0050 | -0.0007 | -       |
| PS |         |         | 0.0100 |        | 0.0157  | 0.0013  |

0.0143

Y  
X



|    |         |
|----|---------|
| X  | 0.0078  |
| Y  | -5.8027 |
| DI | 0.0157  |

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

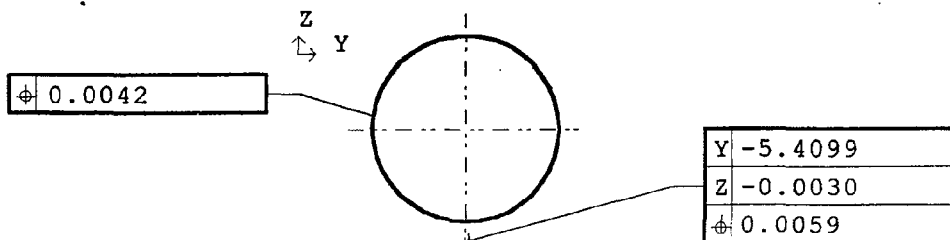
#12

TYPE: I.D.  
NAME: SCOPE\_SCREW\_1

|   | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|---|---------|---------|--------|--------|--------|---------|
| Y | -5.4099 | -5.4100 | 0.0040 | 0.0040 | 0.0001 | +       |

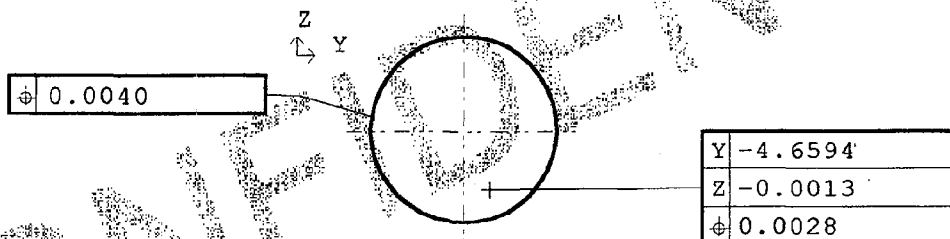
ET06109

|    |         |        |        |        |         |        |
|----|---------|--------|--------|--------|---------|--------|
| Z  | -0.0030 | 0.0000 | 0.0040 | 0.0040 | -0.0030 | ---    |
| DI | 0.1156  | 0.1164 | 0.0010 | 0.0010 | -0.0008 | ----   |
| PS |         |        | 0.0040 |        | 0.0059  | 0.0017 |



SCOPE SCREW HOLE .750 FORWARD OF REARMOST  
#13  
TYPE: I.D.  
NAME: SCOPE\_SCREW\_2

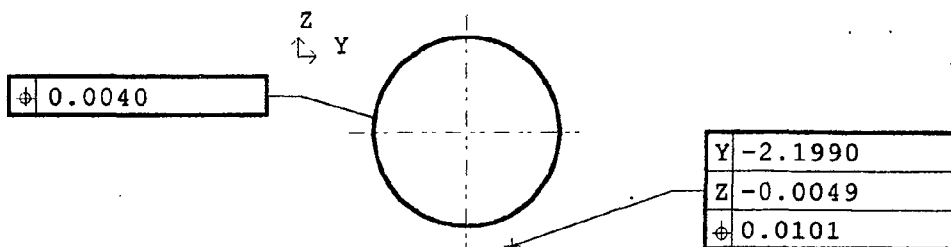
|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| Y  | -4.6594 | -4.6600 | 0.0040 | 0.0040 | 0.0006  | ---     |
| Z  | -0.0013 | 0.0000  | 0.0040 | 0.0040 | -0.0013 | --      |
| DI | 0.1136  | 0.1164  | 0.0010 | 0.0010 | -0.0028 | -0.0018 |
| PS |         |         | 0.0040 |        | 0.0028  | +++     |



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  | -2.1990 | -2.2000 | 0.0040 | 0.0040 | 0.0010  | +       |
| Z  | -0.0049 | 0.0000  | 0.0040 | 0.0040 | -0.0049 | -0.0009 |
| DI | 0.1151  | 0.1164  | 0.0010 | 0.0010 | -0.0013 | -0.0003 |
| PS |         |         | 0.0040 |        | 0.0101  | 0.0061  |

ET06110



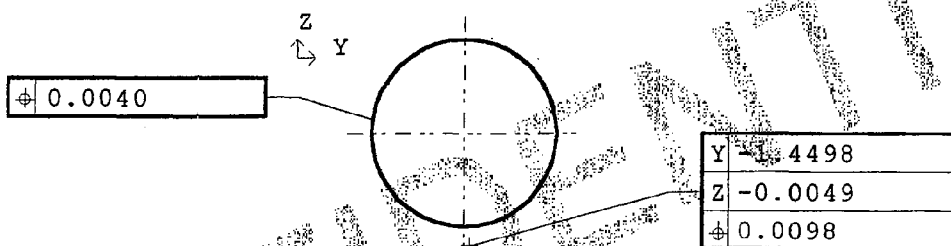
SCOPE SCREW .750 FORWARD OF SCOPE\_SCREW\_3

#15

TYPE: I.D.

NAME: SCOPE\_SCREW\_4

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| Y  | -1.4498 | -1.4500 | 0.0040 | 0.0040 | 0.0002  | +       |
| Z  | -0.0049 | 0.0000  | 0.0040 | 0.0040 | -0.0049 | -0.0009 |
| DI | 0.1152  | 0.1164  | 0.0010 | 0.0010 | -0.0012 | -0.0002 |
| PS |         |         | 0.0040 |        | 0.0098  | 0.0058  |



DEPTH OF BARREL COUNTERBORE

TAKEDOWN SCREW CLEARANCE HOLE

MAGAZINE BOX POSITION FROM DATUM B

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 | 0.1331 | 0.1250  | 0.0050 | 0.0050 | 0.0081 | 0.0031  |

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

ET06111

|    | 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

CONFIDENTIAL

ET06112