

#10

Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 11:35:54
CMM: CMM1

CYLINDER FORMING DATUM-A OUTSIDE DIAMETER

#1

TYPE: BOSS

NAME: DATUM_A

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
DI	1.3943	1.4000	0.0050	0.0050	-0.0057	-0.0007
FM			0.0050		0.0014	++

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	0.0104	-0.0050	0.0020	0.0020	0.0154	0.0134

BOLT STOP HOLE ON LH SIDE OF RECEIVER

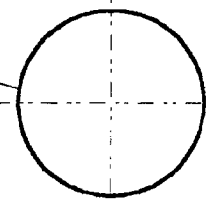
#6

TYPE: I.D.

NAME: BOLT_STOP_HOLE

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.0194	0.0000	0.0100	0.0100	0.0194	0.0094
Y	-5.8023	-5.8020	0.0100	0.0100	-0.0003	-
DI	0.2777	0.2790	0.0050	0.0050	-0.0013	--
PS			0.0100		0.0388	0.0251

0.0137

Y
X

X 0.0194

Y -5.8023

0.0388

RECEIVER ID AT BACK-OF PART

#7

TYPE: I.D.

NAME: ID_BACK

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	0.0012	0.0000	0.0050	0.0050	0.0012	+
X	0.0022	0.0000	0.0050	0.0050	0.0022	++
DI	1.0492	1.0460	0.0030	0.0030	0.0032	0.0002

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

ET06126

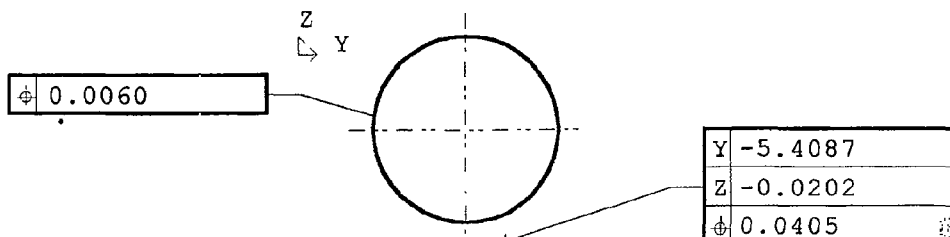
REARMOST SCOPE SCREW HOLE

#12

TYPE: I.D.

NAME: SCOPE_SCREW_1

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-5.4087	-5.4100	0.0040	0.0040	0.0013	++
Z	-0.0202	0.0000	0.0040	0.0040	-0.0202	-0.0162
DI	0.1221	0.1164	0.0010	0.0010	0.0057	0.0047
PS			0.0040		0.0405	0.0345



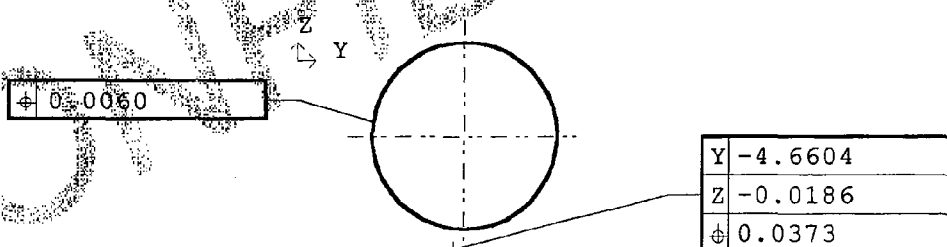
SCOPE SCREW HOLE .750 FORWARD OF REARMOST

#13

TYPE: I.D.

NAME: SCOPE_SCREW_2

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-4.6604	-4.6600	0.0040	0.0040	-0.0004	-
Z	-0.0186	0.0000	0.0040	0.0040	-0.0186	-0.0146
DI	0.1188	0.1164	0.0010	0.0010	0.0024	0.0014
PS			0.0040		0.0373	0.0313



SCOPE SCREW HOLE AT-2.200 FROM DATUM-B

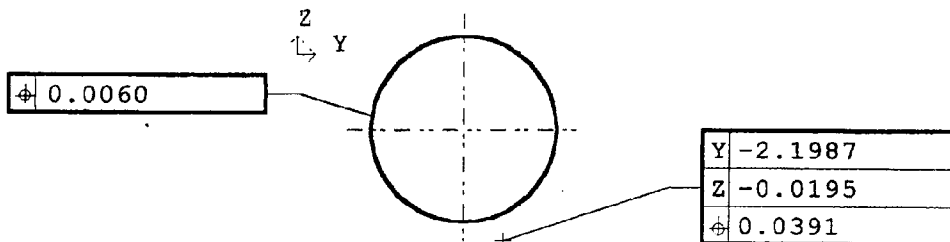
#14

TYPE: I.D.

NAME: SCOPE_SCREW_3

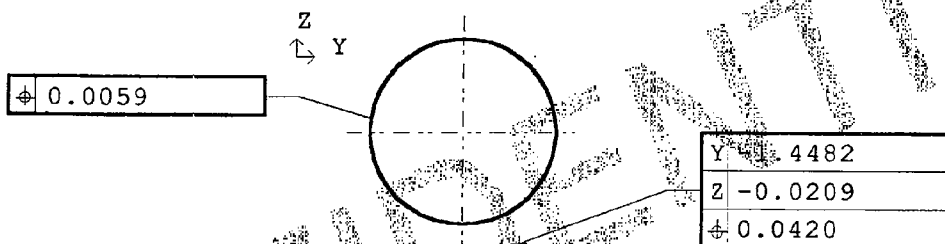
	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-2.1987	-2.2000	0.0040	0.0040	0.0013	++
Z	-0.0195	0.0000	0.0040	0.0040	-0.0195	-0.0155
DI	0.1189	0.1164	0.0010	0.0010	0.0025	0.0015
PS			0.0040		0.0391	0.0331

ET06127



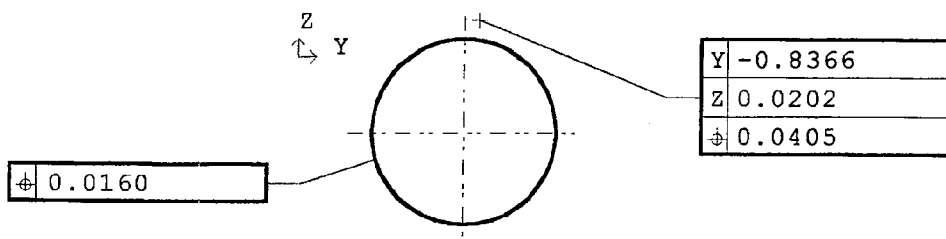
SCOPE SCREW .750 FORWARD OF SCOPE_SCREW_3
 #15
 TYPE: I.D.
 NAME: SCOPE_SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4482	-1.4500	0.0040	0.0040	0.0018	++
Z	-0.0209	0.0000	0.0040	0.0040	-0.0209	-0.0169
DI	0.1173	0.1164	0.0010	0.0010	0.0009	++++
PS			0.0040		0.0420	0.0361



DEPTH OF BARREL COUNTERBORE
 TAKEDOWN SCREW CLEARANCE HOLE
 #17
 TYPE: I.D.
 NAME: TAKEDOWN

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-0.8366	-0.8380	0.0100	0.0100	0.0014	+
Z	0.0202	0.0000	0.0100	0.0100	0.0202	0.0102
DI	0.2660	0.2650	0.0050	0.0050	0.0010	+
PS			0.0100		0.0405	0.0245



MAGAZINE BOX POSITION FROM DATUM B
 MAGAZINE BOX LENGTH

ET06128

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	0.1512	0.1250	0.0050	0.0050	0.0262	0.0212

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	4.9591	4.9500	0.0050	0.0050	0.0091	0.0041

EJECTION PORT WIDTH
POSITION OF TOP WALL OF EJECTION PORT TO DATUM-A CENTERLINE @ 60 DEGREES
#29

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.3113	0.2950	0.0050	0.0050	0.0163	0.0113

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	-0.2776	-0.2620	0.0050	0.0050	-0.0156	-0.0106

BOTTOM SURFACE OF BOLT HANDLE RELIEF CUT
#33

TYPE: POINT

NAME: LO_BOLT_RELIEF

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.1996	0.2130	0.0050	0.0050	-0.0134	-0.0084

ET06129