

#13

Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 11:59:31
CMM: CMM1

CYLINDER FORMING DATUM-A OUTSIDE DIAMETER

#1

TYPE: BOSS

NAME: DATUM A

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
DI	1.3942	1.4000	0.0050	0.0050	-0.0058	-0.0008
FM			0.0050		0.0017	++

BARREL COUNTERBORE-DIA. & POSITION RELATIVE TO DATUM-A

#2

TYPE: BORE

NAME: BBL CBORE

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.0028	0.0000	0.0020	0.0020	0.0028	0.0008
Z	-0.0019	0.0000	0.0020	0.0020	-0.0019	---
DI	1.2258	1.2270	0.0050	0.0050	-0.0012	-
PS			0.0040		0.0068	++++

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)

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

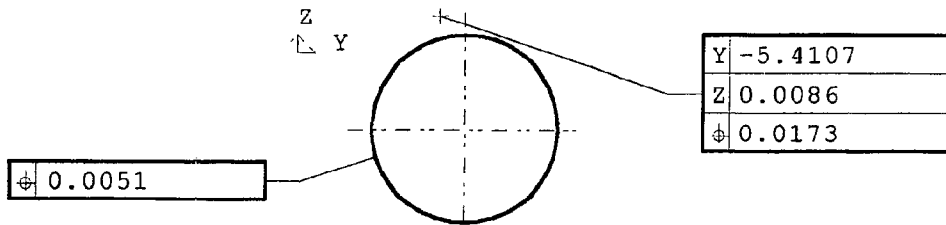
REARMOST SCOPE SCREW HOLE

#12

TYPE: I.D.

NAME: SCOPE SCREW_1

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-5.4107	-5.4100	0.0040	0.0040	-0.0007	-
Z	0.0086	0.0000	0.0040	0.0040	0.0086	0.0046
DI	0.1165	0.1164	0.0010	0.0010	0.0001	+
PS			0.0040		0.0173	0.0122



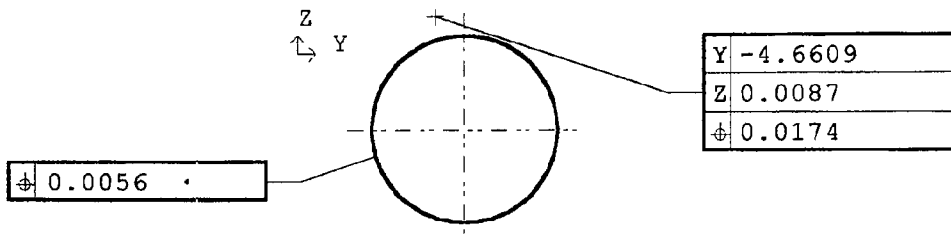
SCOPE SCREW HOLE .750 FORWARD OF REARMOST

#13

ET06137

TYPE: I.D.
NAME: SCOPE_SCREW_2

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-4.6609	-4.6600	0.0040	0.0040	-0.0009	-
Z	0.0087	0.0000	0.0040	0.0040	0.0087	0.0047
DI	0.1170	0.1164	0.0010	0.0010	0.0006	+++
PS			0.0040		0.0174	0.0118



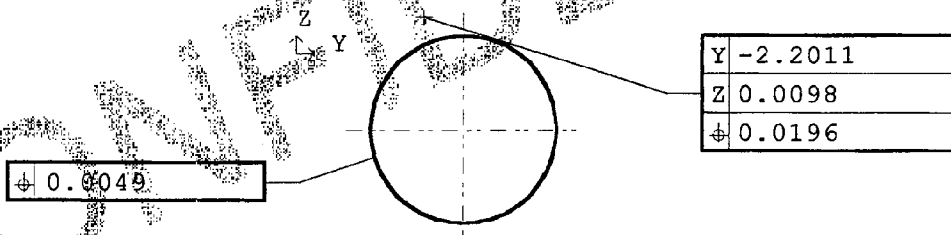
SCOPE SCREW HOLE AT 2.200 FROM DATUM-B

#14

TYPE: I.D.

NAME: SCOPE SCREW 3

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-2.2011	-2.2000	0.0040	0.0040	-0.0011	--
Z	0.0098	0.0000	0.0040	0.0040	0.0098	0.0058
DI	0.1163	0.1164	0.0010	0.0010	-0.0001	-
PS			0.0040		0.0196	0.0147



SCOPE SCREW .750 FORWARD OF SCOPE_SCREW_3

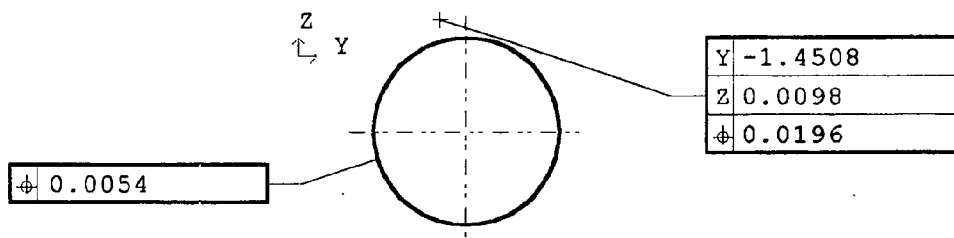
#15

TYPE: I.D.

NAME: SCOPE_SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4508	-1.4500	0.0040	0.0040	-0.0008	-
Z	0.0098	0.0000	0.0040	0.0040	0.0098	0.0058
DI	0.1168	0.1164	0.0010	0.0010	0.0004	++
PS			0.0040		0.0196	0.0142

ET06138



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	0.1397	0.1250	0.0050	0.0050	0.0147	0.0097

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	0.1304	0.1250	0.0050	0.0050	0.0054	0.0004

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
US	4.9606	4.9500	0.0050	0.0050	0.0106	0.0056

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

#34
 TYPE: POINT
 NAME: BOLT_STOP_FLAT

Z	-0.6641	-0.6700	0.0050	0.0050	0.0059	0.0009

ET06139