

15

Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 12:09:58
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	-0.0025	-0.0050	0.0020	0.0020	0.0025	0.0005

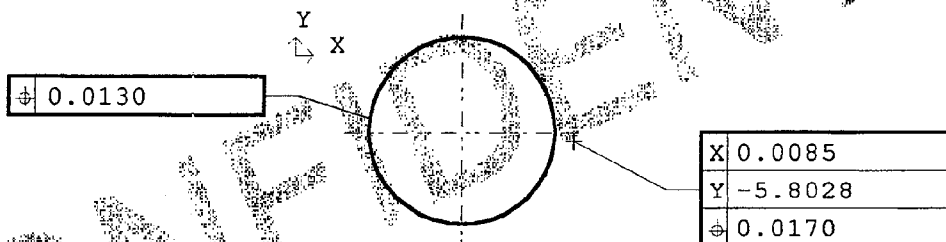
BOLT STOP HOLE ON LH SIDE OF RECEIVER

#6

TYPE: I.D.

NAME: BOLT_STOP_HOLE

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.0085	0.0000	0.0100	0.0100	0.0085	++++
Y	-5.8028	-5.8020	0.0100	0.0100	-0.0008	-
DI	0.2770	0.2790	0.0050	0.0050	-0.0020	--
PS			0.0100		0.0170	0.0040



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
REARMOIST SCOPE SCREW HOLE

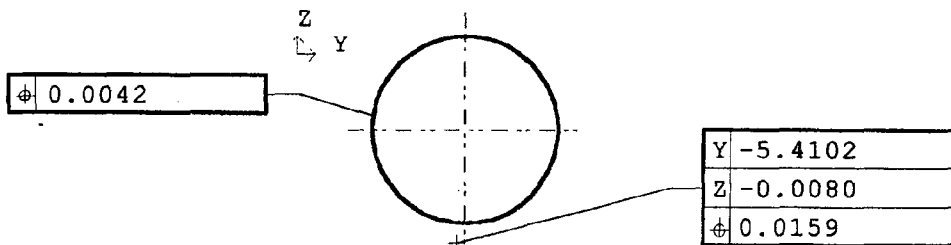
#12

TYPE: I.D.

NAME: SCOPE_SCREW_1

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-5.4102	-5.4100	0.0040	0.0040	-0.0002	-
Z	-0.0080	0.0000	0.0040	0.0040	-0.0080	-0.0040
DI	0.1156	0.1164	0.0010	0.0010	-0.0008	----
PS			0.0040		0.0159	0.0117

ET06143



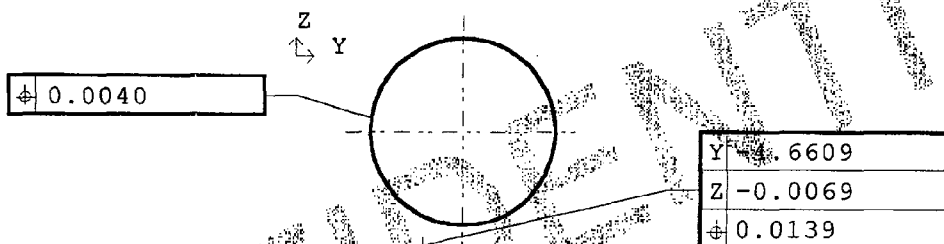
SCOPE SCREW HOLE .750 FORWARD OF REARMOST

#13

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	-0.0069	0.0000	0.0040	0.0040	-0.0069	-0.0029
DI	0.1150	0.1164	0.0010	0.0010	-0.0014	-0.0004
PS			0.0040		0.0139	0.0099



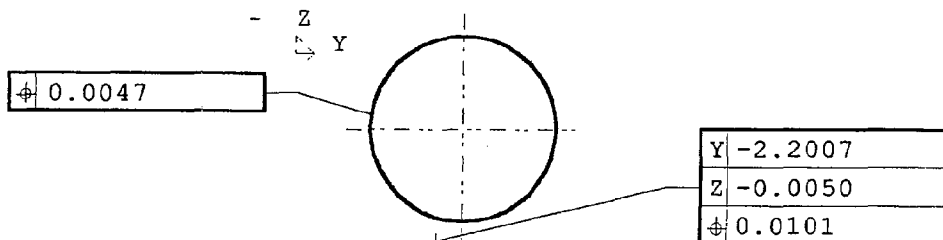
SCOPE SCREW HOLE AT 2.200 FROM DATUM-B

#14

TYPE: I.D.

NAME: SCOPE SCREW_3

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-2.2007	-2.2000	0.0040	0.0040	-0.0007	-
Z	-0.0050	0.0000	0.0040	0.0040	-0.0050	-0.0010
DI	0.1161	0.1164	0.0010	0.0010	-0.0003	--
PS			0.0040		0.0101	0.0053



SCOPE SCREW .750 FORWARD OF SCOPE_SCREW_3

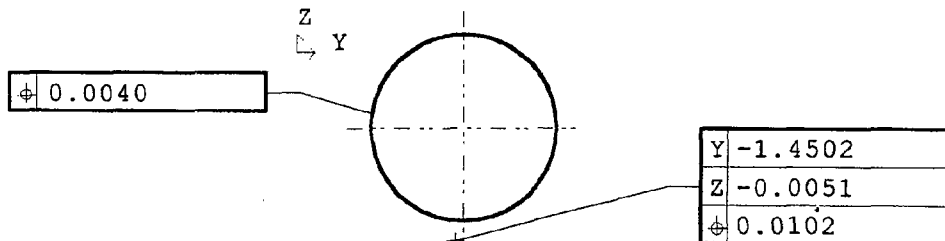
#15

TYPE: I.D.

ET06144

NAME: SCOPE SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4502	-1.4500	0.0040	0.0040	-0.0002	-
Z	-0.0051	0.0000	0.0040	0.0040	-0.0051	-0.0011
DI	0.1147	0.1164	0.0010	0.0010	-0.0017	-0.0007
PS			0.0040		0.0102	0.0062



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

#19

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
DS	3.7436	3.7500	0.0050	0.0050	-0.0064	-0.0014

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	0.1342	0.1250	0.0050	0.0050	0.0092	0.0042

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	0.1340	0.1250	0.0050	0.0050	0.0090	0.0040

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	4.9612	4.9500	0.0050	0.0050	0.0112	0.0062

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

ET06145