

#17

Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 12:20:50
CMM: CMM1

CYLINDER FORMING DATUM-A OUTSIDE DIAMETER

#1

TYPE: BOSS

NAME: DATUM A

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
DI	1.3945	1.4000	0.0050	0.0050	-0.0055	-0.0005
FM			0.0050		0.0014	++

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

#2

TYPE: BORE

NAME: BBL CBORE

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.0039	0.0000	0.0020	0.0020	0.0039	0.0019
Z	0.0009	0.0000	0.0020	0.0020	0.0009	++
DI	1.2260	1.2270	0.0050	0.0050	-0.0010	-
PS			0.0040		0.0080	++++

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

#7

TYPE: I.D.

NAME: ID_BACK

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	0.0016	0.0000	0.0050	0.0050	0.0016	++
X	0.0037	0.0000	0.0050	0.0050	0.0037	+++
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

REARMOST SCOPE SCREW HOLE

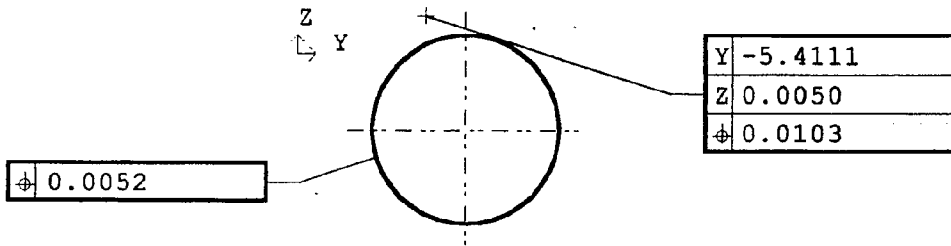
#12

TYPE: I.D.

NAME: SCOPE SCREW_1

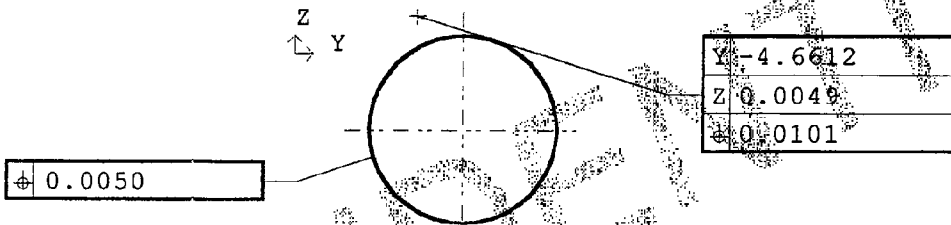
	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-5.4111	-5.4100	0.0040	0.0040	-0.0011	--
Z	0.0050	0.0000	0.0040	0.0040	0.0050	0.0010
DI	0.1166	0.1164	0.0010	0.0010	0.0002	+
PS			0.0040		0.0103	0.0051

ET06149



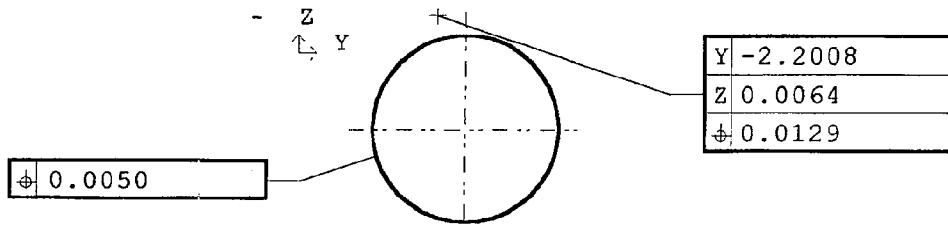
SCOPE SCREW HOLE .750 FORWARD OF REARMOST
#13
TYPE: I.D.
NAME: SCOPE SCREW_2

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-4.6612	-4.6600	0.0040	0.0040	-0.0012	--
Z	0.0049	0.0000	0.0040	0.0040	0.0049	0.0009
DI	0.1164	0.1164	0.0010	0.0010	0.0000	-
PS			0.0040		0.0101	0.0051



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	-2.2008	-2.2000	0.0040	0.0040	-0.0008	-
Z	0.0064	0.0000	0.0040	0.0040	0.0064	0.0024
DI	0.1164	0.1164	0.0010	0.0010	0.0000	-
PS			0.0040		0.0129	0.0079

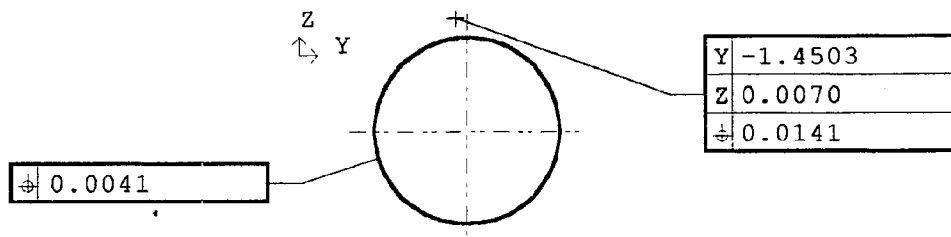


SCOPE SCREW .750 FORWARD OF SCOPE SCREW_3
#15
TYPE: I.D.

ET06150

NAME: SCOPE_SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4503	-1.4500	0.0040	0.0040	-0.0003	-
Z	0.0070	0.0000	0.0040	0.0040	0.0070	0.0030
DI	0.1155	0.1164	0.0010	0.0010	-0.0009	----
PS			0.0040		0.0141	0.0100



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	0.1346	0.1250	0.0050	0.0050	0.0096	0.0046

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	0.1321	0.1250	0.0050	0.0050	0.0071	0.0021

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	4.9618	4.9500	0.0050	0.0050	0.0118	0.0068

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

ET06151