

#72

Part Program: 710 RECEIVER  
Inspector: Administrator

Date/Time: 08/14/2000 13:10:01  
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

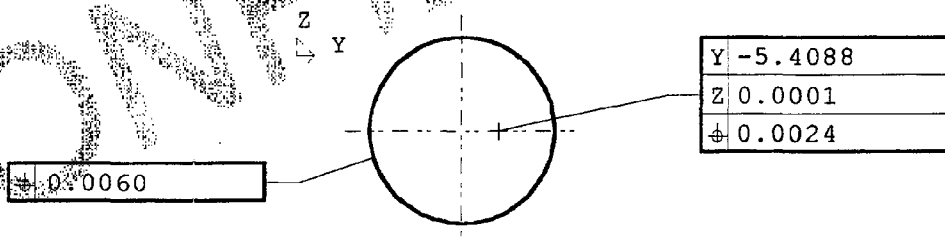
|   | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|---|---------|---------|--------|--------|--------|---------|
| Z | -0.0006 | -0.0050 | 0.0020 | 0.0020 | 0.0044 | 0.0024  |

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  | -5.4088 | -5.4100 | 0.0040 | 0.0040 | 0.0012 | ++      |
| Z  | 0.0001  | 0.0000  | 0.0040 | 0.0040 | 0.0001 | +       |
| DI | 0.1175  | 0.1164  | 0.0040 | 0.0010 | 0.0011 | 0.0001  |
| PS |         |         | 0.0040 |        | 0.0024 | ++      |



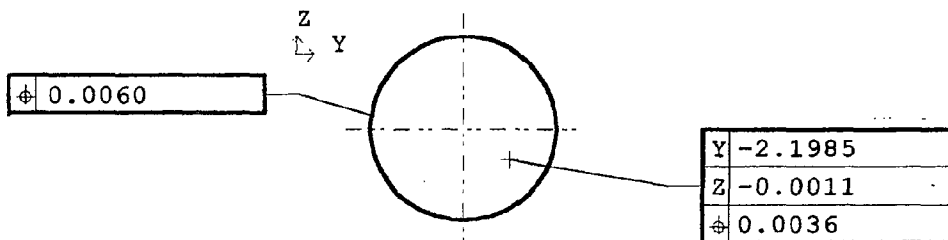
SCOPE SCREW HOLE .750 FORWARD OF REARMOST  
SCOPE SCREW HOLE AT 2.200 FROM DATUM-B  
#14

TYPE: I.D.

NAME: SCOPE\_SCREW\_3

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| Y  | -2.1985 | -2.2000 | 0.0040 | 0.0040 | 0.0015  | ++      |
| Z  | -0.0011 | 0.0000  | 0.0040 | 0.0040 | -0.0011 | --      |
| DI | 0.1174  | 0.1164  | 0.0010 | 0.0010 | 0.0010  | ++++    |
| PS |         |         | 0.0040 |        | 0.0036  | +++     |

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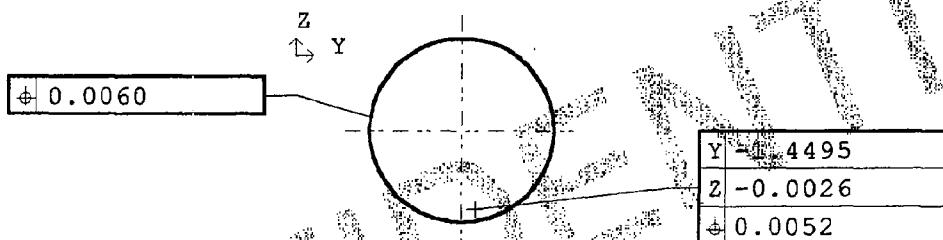
SCOPE SCREW .750 FORWARD OF SCOPE\_SCREW\_3

#15

TYPE: I.D.

NAME: SCOPE\_SCREW\_4

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| Y  | -1.4495 | -1.4500 | 0.0040 | 0.0040 | 0.0005  | +       |
| Z  | -0.0026 | 0.0000  | 0.0040 | 0.0040 | -0.0026 | ---     |
| DI | 0.1181  | 0.1164  | 0.0010 | 0.0010 | 0.0017  | 0.0007  |
| PS |         |         | 0.0040 |        | 0.0052  | 0.0012  |



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 | 0.1361 | 0.1250  | 0.0050 | 0.0050 | 0.0111 | 0.0061  |

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 | 0.1343 | 0.1250  | 0.0050 | 0.0050 | 0.0093 | 0.0043  |

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

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|    | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|----|--------|---------|--------|--------|--------|---------|
| DS | 4.9597 | 4.9500  | 0.0050 | 0.0050 | 0.0097 | 0.0047  |

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

#33

TYPE: POINT

NAME: LO BOLT REFIEF

|   | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|---|--------|---------|--------|--------|---------|---------|
| X | 0.2071 | 0.2130  | 0.0050 | 0.0050 | -0.0059 | -0.0009 |

#34

TYPE: POINT

NAME: BOLT STOP FLAT

|   | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|---|---------|---------|--------|--------|--------|---------|
| Z | -0.6647 | -0.6700 | 0.0050 | 0.0050 | 0.0053 | 0.0003  |

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