

#3

Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 10:45:53
CMM: CMM1

CYLINDER FORMING DATUM-A OUTSIDE DIAMETER
BARREL COUNTERBORE-DIA. & POSITION RELATIVE TO DATUM-A

#2

TYPE: BORE

NAME: BBL_CBORE

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.0051	0.0000	0.0020	0.0020	0.0051	0.0031
Z	0.0009	0.0000	0.0020	0.0020	0.0009	++
DI	1.2262	1.2270	0.0050	0.0050	-0.0008	-
PS			0.0040		0.0103	0.0021

RECEIVER ID AT FRONT OF PART

WIDTH OF DATUM-C FIRE CONTROL SLOT

DISTANCE MIDPOINT OF DATUM-C IS OFFSET FROM DATUM-A CENTERLINE (0.00411)

#5

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	0.0001	-0.0050	0.0020	0.0020	0.0051	0.0031

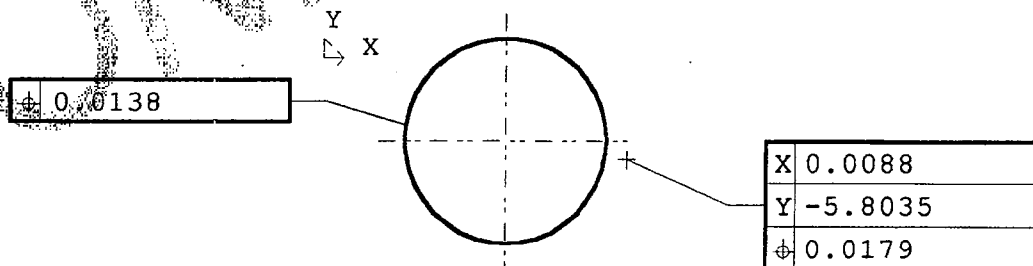
BOLT STOP HOLE ON LH SIDE OF RECEIVER

#6

TYPE: I.D.

NAME: BOLT_STOP_HOLE

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.0088	0.0000	0.0100	0.0100	0.0088	++++
Y	-5.8035	-5.8020	0.0100	0.0100	-0.0015	-
DI	0.2778	0.2790	0.0050	0.0050	-0.0012	-
PS			0.0100		0.0179	0.0040



RECEIVER ID AT BACK OF PART

#7

TYPE: I.D.

NAME: ID_BACK

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	0.0053	0.0000	0.0050	0.0050	0.0053	0.0003
X	0.0075	0.0000	0.0050	0.0050	0.0075	0.0025
DI	1.0513	1.0460	0.0030	0.0030	0.0053	0.0023

CENTERLINE OF ID OF RECEIVER
ANSI COAXIALITY: To DATUM_A

ET06099

#9	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
PS			0.0100		0.0184	0.0084

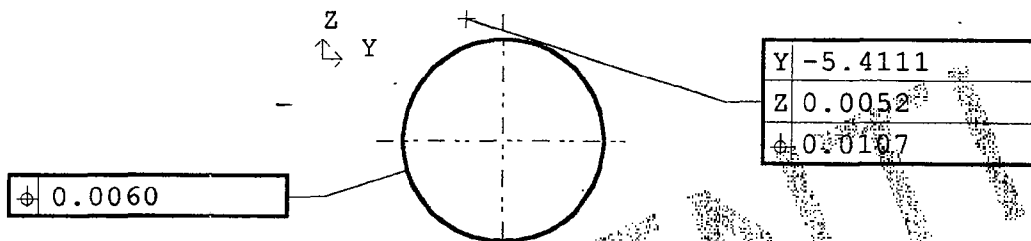
OVERALL LENGTH OF RECEIVER
 LENGTH OF FRONT EDGE OF BOLT HANDLE CLEARANCE CUT TO DATUM-B
 REARMOST SCOPE SCREW HOLE

#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	0.0052	0.0000	0.0040	0.0040	0.0052	0.0012
DI	0.1196	0.1164	0.0010	0.0010	0.0032	0.0022
PS			0.0040		0.0107	0.0047



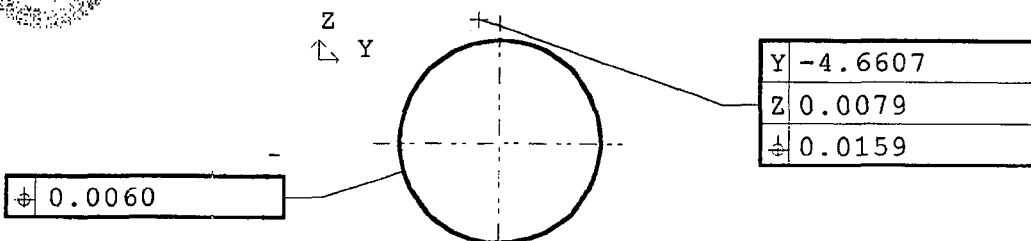
SCOPE SCREW HOLE .750 FORWARD OF REARMOST

#13

TYPE: I.D.

NAME: SCOPE SCREW 2

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-4.6607	-4.6600	0.0040	0.0040	-0.0007	-
Z	0.0079	0.0000	0.0040	0.0040	0.0079	0.0039
DI	0.1183	0.1164	0.0010	0.0010	0.0019	0.0009
PS			0.0040		0.0159	0.0099



SCOPE SCREW HOLE AT 2.200 FROM DATUM-B

#14

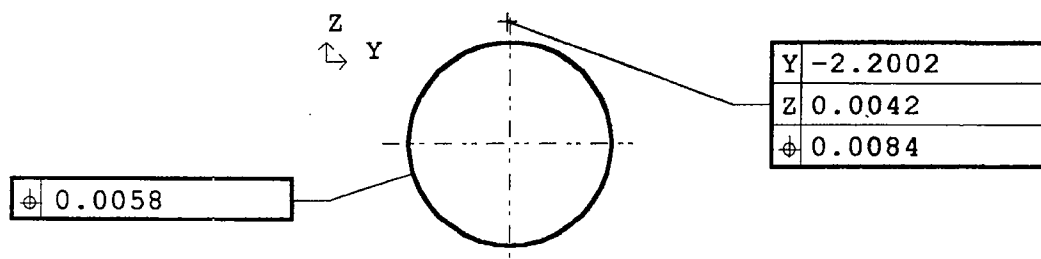
TYPE: I.D.

NAME: SCOPE SCREW 3

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-2.2002	-2.2000	0.0040	0.0040	-0.0002	-
Z	0.0042	0.0000	0.0040	0.0040	0.0042	0.0002

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DI	0.1172	0.1164	0.0010	0.0010	0.0008	++++
PS			0.0040		0.0084	0.0026



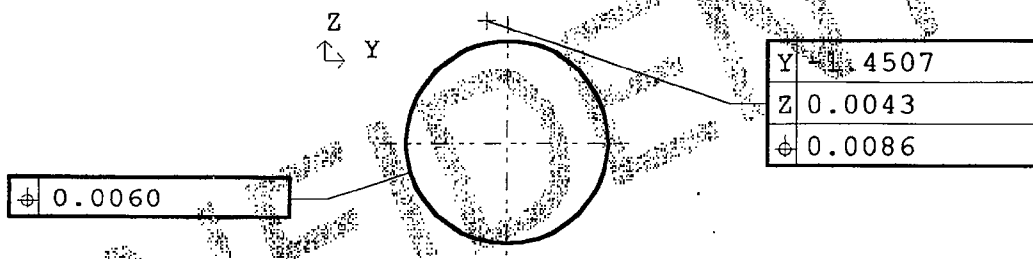
SCOPE SCREW .75C FORWARD OF SCOPE_SCREW_3

#15

TYPE: I.D.

NAME: SCOPE_SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4507	-1.4500	0.0040	0.0040	-0.0007	0.0003
Z	0.0043	0.0000	0.0040	0.0040	0.0043	0.0003
DI	0.1193	0.1164	0.0010	0.0010	0.0029	0.0019
PS			0.0040		0.0086	0.0026



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	0.1345	0.1250	0.0050	0.0050	0.0095	0.0045

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	0.1345	0.1250	0.0050	0.0050	0.0095	0.0045

DISTANCE-FRONT OF FIRE CONTROL SLOT TO DATUM B

#23

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TYPE: I.D.

NAME: RAD_1

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
RD	0.1197	0.1250	0.0050	0.0050	-0.0053	-0.0003
FM			0.0003		0.0000	+

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	4.9605	4.9500	0.0050	0.0050	0.0105	0.0055

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	-0.6589	-0.6700	0.0050	0.0050	0.0111	0.0061
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CONFIDENTIAL

ET06102