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Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 10:57:28
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	-0.0034	0.0000	0.0020	0.0020	-0.0034	-0.0014
Z	-0.0009	0.0000	0.0020	0.0020	-0.0009	--
DI	1.2263	1.2270	0.0050	0.0050	-0.0007	-
PS			0.0040		0.0071	++++

RECEIVER ID AT FRONT OF PART

WIDTH OF DATUM-C FIRE CONTROL SLOT

DISTANCE MIDPOINT OF DATUM-C IS OFFSET FROM DATUM-A CENTERLINE (0.004 TP) 23

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

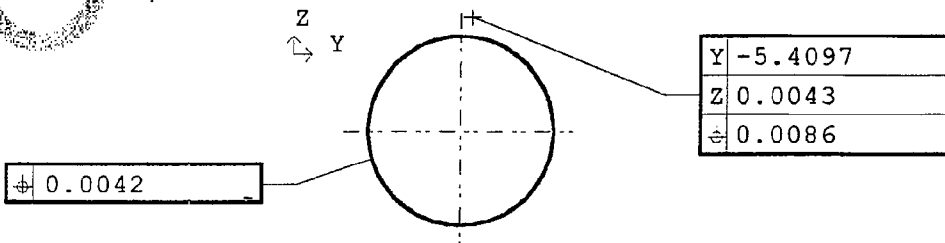
REARMOST SCOPE SCREW HOLE

#12

TYPE: I.D.

NAME: SCOPE SCREW_1

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-5.4097	-5.4100	0.0040	0.0040	0.0003	+
Z	0.0043	0.0000	0.0040	0.0040	0.0043	0.0003
DI	0.1156	0.1164	0.0010	0.0010	-0.0008	----
PS			0.0040		0.0086	0.0044



SCOPE SCREW HOLE .750 FORWARD OF REARMOST

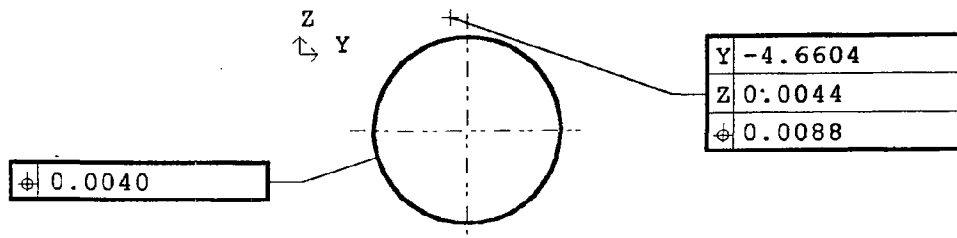
#13

TYPE: I.D.

NAME: SCOPE SCREW_2

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-4.6604	-4.6600	0.0040	0.0040	-0.0004	-
Z	0.0044	0.0000	0.0040	0.0040	0.0044	0.0004
DI	0.1151	0.1164	0.0010	0.0010	-0.0013	-0.0003
PS			0.0040		0.0088	0.0048

ET06103

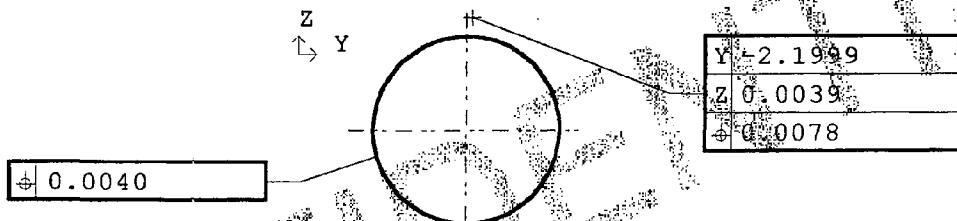


SCOPE SCREW HOLE AT 2.200 FROM DATUM-B
#14

TYPE: I.D.

NAME: SCOPE SCREW_3

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-2.1999	-2.2000	0.0040	0.0040	0.0001	+
Z	0.0039	0.0000	0.0040	0.0040	0.0039	++++
DI	0.1153	0.1164	0.0010	0.0010	-0.0011	-0.0001
PS			0.0040		0.0078	0.0038



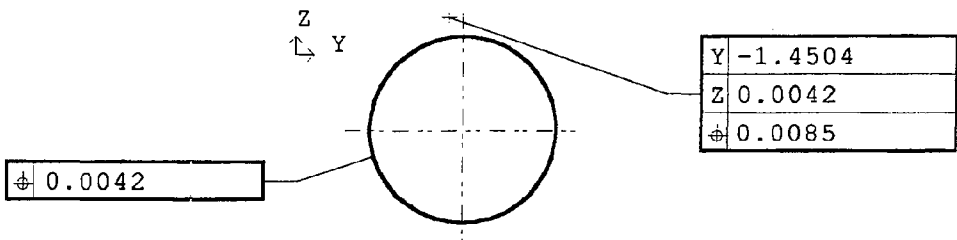
SCOPE SCREW .750 FORWARD OF SCOPE SCREW_3

#15

TYPE: I.D.

NAME: SCOPE SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4504	-1.4500	0.0040	0.0040	-0.0004	-
Z	0.0042	0.0000	0.0040	0.0040	0.0042	0.0002
DI	0.1156	0.1164	0.0010	0.0010	-0.0008	----
PS			0.0040		0.0085	0.0043



DEPTH OF BARREL COUNTERBORE
TAKEDOWN SCREW CLEARANCE HOLE

ET06104

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	0.1359	0.1250	0.0050	0.0050	0.0109	0.0059

DISTANCE OF RH SIDE OF MAGAZINE SLOT FROM CENTER @33 DEGREES

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	4.9603	4.9500	0.0050	0.0050	0.0103	0.0053

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

83

ET06105