

#6

Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 11:08:43
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	0.0000	0.0000	0.0020	0.0020	0.0000	-
Z	-0.0029	0.0000	0.0020	0.0020	-0.0029	-0.0009
DI	1.2269	1.2270	0.0050	0.0050	-0.0001	-
PS			0.0040		0.0057	+++

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) 83
#5

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	0.0002	-0.0050	0.0020	0.0020	0.0002	0.0032

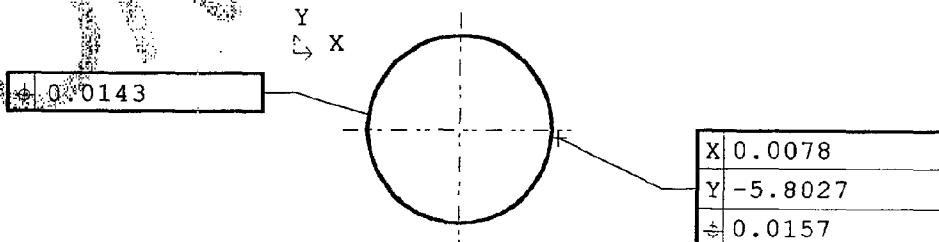
BOLT STOP HOLE ON LH SIDE OF RECEIVER

#6

TYPE: I.D.

NAME: BOLT_STOP_HOLE

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.0078	0.0000	0.0100	0.0100	0.0078	++++
Y	-5.8027	-5.8020	0.0100	0.0100	-0.0007	-
DI	0.2783	0.2790	0.0050	0.0050	-0.0007	-
PS			0.0100		0.0157	0.0013



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

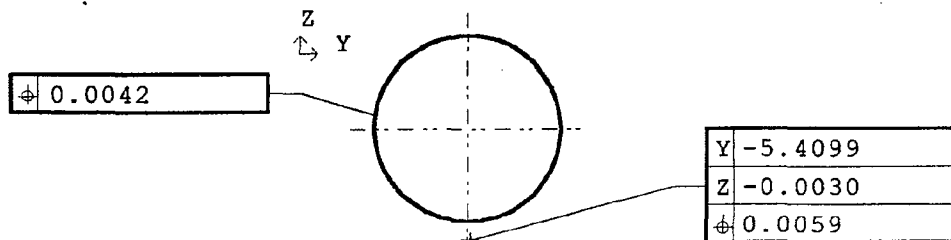
TYPE: I.D.

NAME: SCOPE_SCREW_1

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-5.4099	-5.4100	0.0040	0.0040	0.0001	+

ET06109

Z	-0.0030	0.0000	0.0040	0.0040	-0.0030	---
DI	0.1156	0.1164	0.0010	0.0010	-0.0008	----
PS			0.0040		0.0059	0.0017

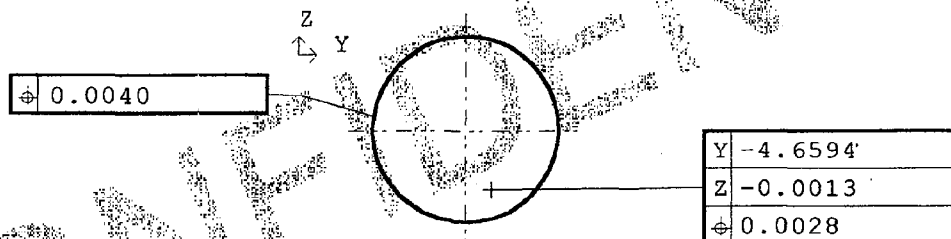


SCOPE SCREW HOLE .750 FORWARD OF REARMOST
#13

TYPE: I.D.

NAME: SCOPE_SCREW_2

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-4.6594	-4.6600	0.0040	0.0040	0.0006	---
Z	-0.0013	0.0000	0.0040	0.0040	-0.0013	--
DI	0.1136	0.1164	0.0010	0.0010	-0.0028	-0.0018
PS			0.0040		0.0028	+++



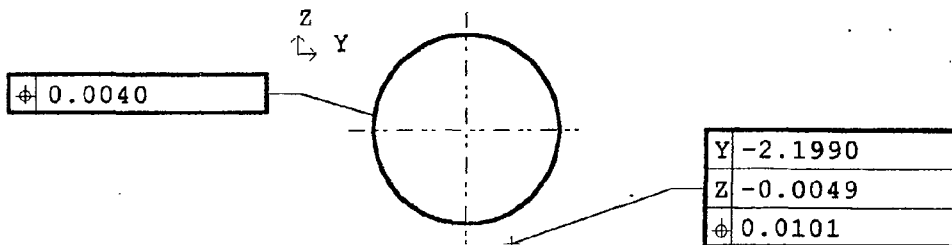
SCOPE SCREW HOLE AT 2.200 FROM DATUM-B
#14

TYPE: I.D.

NAME: SCOPE_SCREW_3

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-2.1990	-2.2000	0.0040	0.0040	0.0010	+
Z	-0.0049	0.0000	0.0040	0.0040	-0.0049	-0.0009
DI	0.1151	0.1164	0.0010	0.0010	-0.0013	-0.0003
PS			0.0040		0.0101	0.0061

ET06110



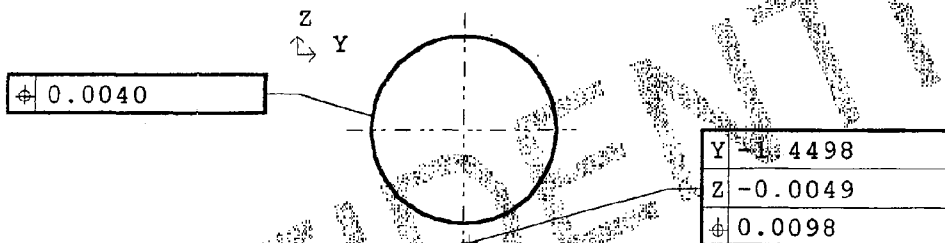
SCOPE SCREW .750 FORWARD OF SCOPE_SCREW_3

#15

TYPE: I.D.

NAME: SCOPE_SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4498	-1.4500	0.0040	0.0040	0.0002	+
Z	-0.0049	0.0000	0.0040	0.0040	-0.0049	-0.0009
DI	0.1152	0.1164	0.0010	0.0010	-0.0012	-0.0002
PS			0.0040		0.0098	0.0058



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	0.1354	0.1250	0.0050	0.0050	0.0104	0.0054

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	0.1331	0.1250	0.0050	0.0050	0.0081	0.0031

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

ET06111

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
DS	4.9602	4.9500	0.0050	0.0050	0.0102	0.0052

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

CONFIDENTIAL

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ET06112