

8

Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 11:19:24
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	0.0016	-0.0050	0.0020	0.0020	0.0066	0.0046

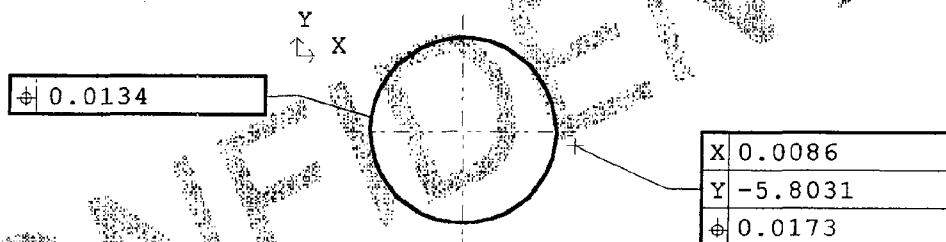
BOLT STOP HOLE ON LH SIDE OF RECEIVER

#6

TYPE: I.D.

NAME: BOLT_STOP_HOLE

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.0086	0.0000	0.0100	0.0100	0.0086	++++
Y	-5.8031	-5.8020	0.0100	0.0100	-0.0011	-
DI	0.2774	0.2790	0.0050	0.0050	-0.0016	--
PS			0.0100		0.0173	0.0039



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

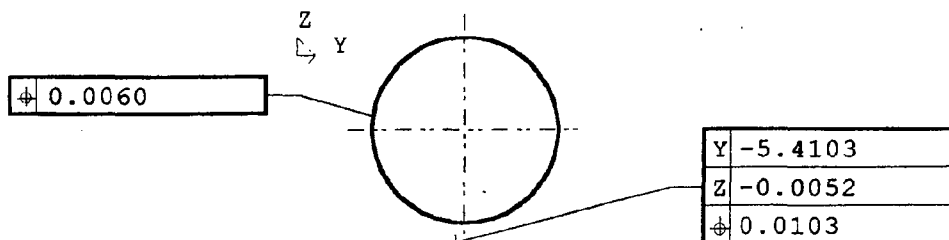
#12

TYPE: I.D.

NAME: SCOPE SCREW_1

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-5.4103	-5.4100	0.0040	0.0040	-0.0003	-
Z	-0.0052	0.0000	0.0040	0.0040	-0.0052	-0.0012
DI	0.1175	0.1164	0.0010	0.0010	0.0011	0.0001
PS			0.0040		0.0103	0.0043

ET06118

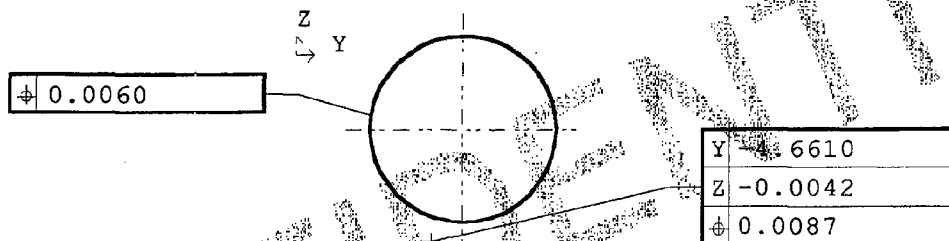


SCOPE SCREW HOLE .750 FORWARD OF REARMOST
#13

TYPE: I.D.

NAME: SCOPE_SCREW_2

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-4.6610	-4.6600	0.0040	0.0040	-0.0010	--
Z	-0.0042	0.0000	0.0040	0.0040	-0.0042	-0.0002
DI	0.1180	0.1164	0.0010	0.0010	0.0016	0.0006
PS			0.0040		0.0087	0.0027



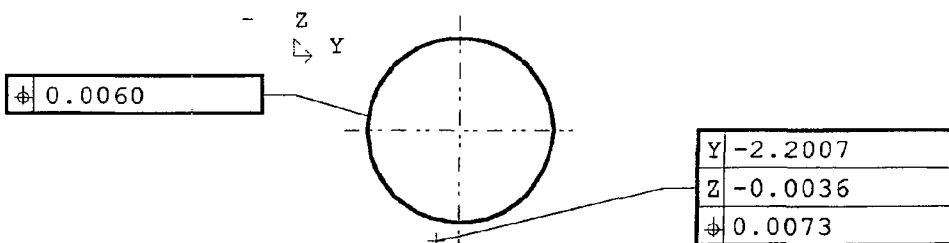
SCOPE SCREW HOLE AT 2.200 FROM DATUM-B

#14

TYPE: I.D.

NAME: SCOPE_SCREW_3

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-2.2007	-2.2000	0.0040	0.0040	-0.0007	-
Z	-0.0036	0.0000	0.0040	0.0040	-0.0036	----
DI	0.1179	0.1164	0.0010	0.0010	0.0015	0.0005
PS			0.0040		0.0073	0.0013



SCOPE SCREW .750 FORWARD OF SCOPE_SCREW_3

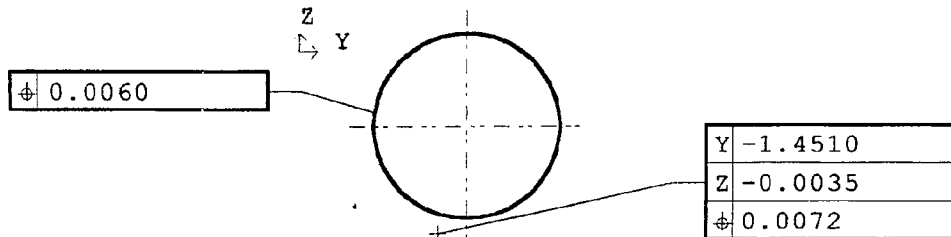
#15

TYPE: I.D.

ET06119

NAME: SCOPE_SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4510	-1.4500	0.0040	0.0040	-0.0010	-
Z	-0.0035	0.0000	0.0040	0.0040	-0.0035	----
DI	0.1175	0.1164	0.0010	0.0010	0.0011	0.0001
PS			0.0040		0.0072	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	0.1341	0.1250	0.0050	0.0050	0.0091	0.0041

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	0.1391	0.1250	0.0050	0.0050	0.0141	0.0091

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	4.9621	4.9500	0.0050	0.0050	0.0121	0.0071

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_RELIEF

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
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ET06120

X 0.2065 0.2130 0.0050 0.0050 -0.0065 -0.0015.

CONFIDENTIAL 83

ET06121