

#9

Part Program: 710 RECEIVER  
Inspector: Administrator

Date/Time: 08/14/2000 11:24:48  
CMM: CMM1

## CYLINDER FORMING DATUM-A OUTSIDE DIAMETER

#1

TYPE: BOSS

NAME: DATUM\_A

|    | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|--------|---------|--------|--------|---------|---------|
| DI | 1.3937 | 1.4000  | 0.0050 | 0.0050 | -0.0063 | -0.0013 |
| FM |        |         | 0.0050 |        | 0.0017  | ++      |

BARREL COUNTERBORE-DIA. & POSITION RELATIVE TO DATUM-A  
RECEIVER ID AT FRONT OF PART

#3

TYPE: I.D.

NAME: ID\_FRONT

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| Z  | 0.0006  | 0.0000  | 0.0050 | 0.0050 | 0.0006  | 0.0006  |
| X  | -0.0001 | 0.0000  | 0.0050 | 0.0050 | -0.0001 | -       |
| DI | 1.0430  | 1.0460  | 0.0030 | 0.0030 | -0.0030 | ----    |

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 | 0.0116 | -0.0050 | 0.0020 | 0.0020 | 0.0166 | 0.0146  |

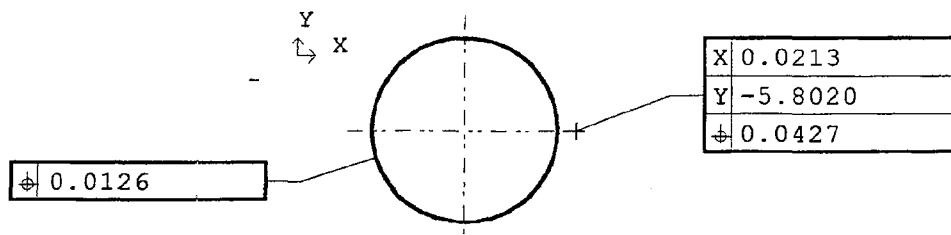
BOLT STOP HOLE ON LH SIDE OF RECEIVER

#6

TYPE: I.D.

NAME: BOLT\_STOP\_HOLE

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| X  | 0.0213  | 0.0000  | 0.0100 | 0.0100 | 0.0213  | 0.0113  |
| Y  | -5.8020 | -5.8020 | 0.0100 | 0.0100 | 0.0000  | +       |
| DI | 0.2766  | 0.2790  | 0.0050 | 0.0050 | -0.0024 | --      |
| PS |         |         | 0.0100 |        | 0.0427  | 0.0300  |



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

ET06122

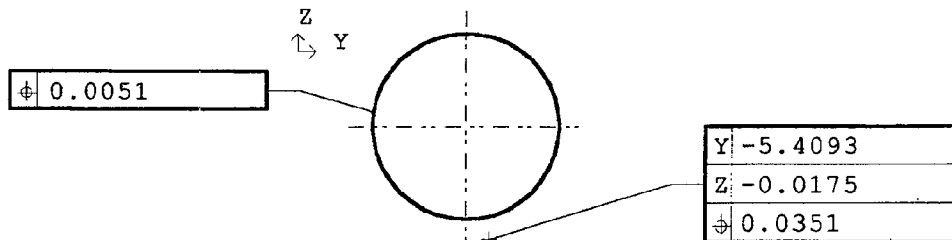
## REARMOST SCOPE SCREW HOLE

#12

TYPE: I.D.

NAME: SCOPE\_SCREW\_1

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| Y  | -5.4093 | -5.4100 | 0.0040 | 0.0040 | 0.0007  | +       |
| Z  | -0.0175 | 0.0000  | 0.0040 | 0.0040 | -0.0175 | -0.0135 |
| DI | 0.1165  | 0.1164  | 0.0010 | 0.0010 | 0.0001  | +       |
| PS |         |         | 0.0040 |        | 0.0351  | 0.0300  |



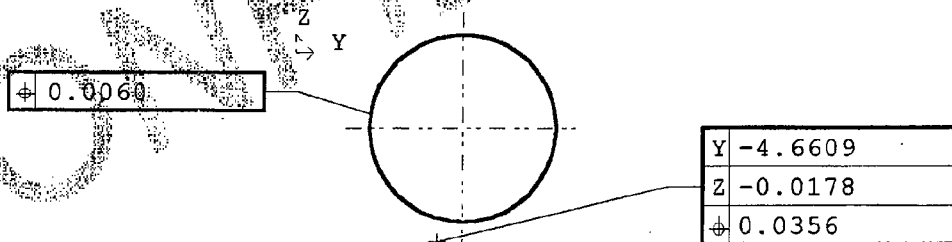
## SCOPE SCREW HOLE .750 FORWARD OF REARMOST

#13

TYPE: I.D.

NAME: SCOPE\_SCREW\_2

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| Y  | -4.6609 | -4.6600 | 0.0040 | 0.0040 | -0.0009 | -       |
| Z  | -0.0178 | 0.0000  | 0.0040 | 0.0040 | -0.0178 | -0.0138 |
| DI | 0.1223  | 0.1164  | 0.0010 | 0.0010 | 0.0059  | 0.0049  |
| PS |         |         | 0.0040 |        | 0.0356  | 0.0296  |



## SCOPE SCREW HOLE AT-2.200 FROM DATUM-B

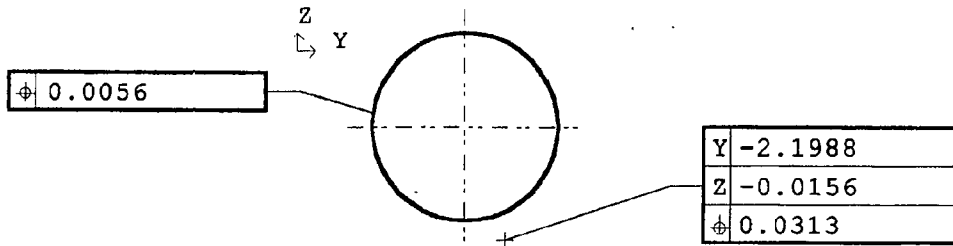
#14

TYPE: I.D.

NAME: SCOPE\_SCREW\_3

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| Y  | -2.1988 | -2.2000 | 0.0040 | 0.0040 | 0.0012  | ++      |
| Z  | -0.0156 | 0.0000  | 0.0040 | 0.0040 | -0.0156 | -0.0116 |
| DI | 0.1170  | 0.1164  | 0.0010 | 0.0010 | 0.0006  | +++     |
| PS |         |         | 0.0040 |        | 0.0313  | 0.0257  |

ET06123



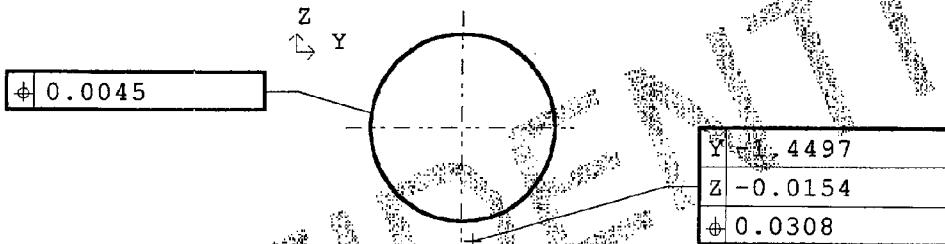
SCOPE SCREW .750 FORWARD OF SCOPE\_SCREW\_3

#15

TYPE: I.D.

NAME: SCOPE\_SCREW\_4

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| Y  | -1.4497 | -1.4500 | 0.0040 | 0.0040 | 0.0003  | +       |
| Z  | -0.0154 | 0.0000  | 0.0040 | 0.0040 | -0.0154 | -0.0114 |
| DI | 0.1159  | 0.1164  | 0.0010 | 0.0010 | -0.0005 | ---     |
| PS |         |         | 0.0040 |        | 0.0308  | 0.0264  |



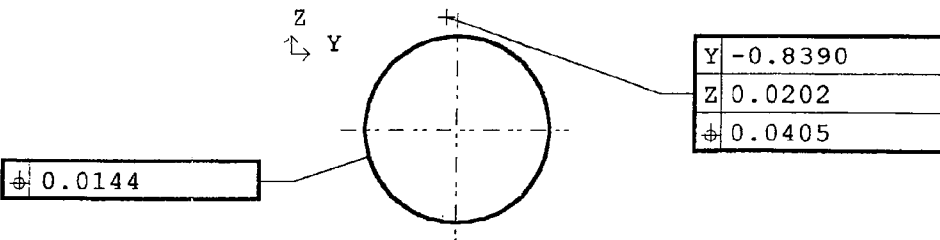
DEPTH OF BARREL COUNTERBORE  
TAKEDOWN SCREW CLEARANCE HOLE

#17

TYPE: I.D.

NAME: TAKEDOWN

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| Y  | -0.8390 | -0.8380 | 0.0100 | 0.0100 | -0.0010 | -       |
| Z  | 0.0202  | 0.0000  | 0.0100 | 0.0100 | 0.0202  | 0.0102  |
| DI | 0.2644  | 0.2650  | 0.0050 | 0.0050 | -0.0006 | -       |
| PS |         |         | 0.0100 |        | 0.0405  | 0.0261  |



MAGAZINE BOX POSITION FROM DATUM B  
MAGAZINE BOX LENGTH

ET06124

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

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 | 0.1500 | 0.1250  | 0.0050 | 0.0050 | 0.0250 | 0.0200  |

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 | 4.9590 | 4.9500  | 0.0050 | 0.0050 | 0.0090 | 0.0040  |

EJECTION PORT WIDTH

POSITION OF TOP WALL OF EJECTION PORT TO DATUM-A CENTERLINE @ 60 DEGREES

#29

|   | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|---|--------|---------|--------|--------|--------|---------|
| X | 0.3107 | 0.2950  | 0.0050 | 0.0050 | 0.0157 | 0.0107  |

FRONT EJECTION PORT RADIUS

EJECTION PORT LENGTH FROM REAR RADIUS TO FRONT RADIUS

TOP SURFACE OF BOLT HANDLE RELIEF CUT

#32

TYPE: POINT

NAME: BOLT\_RELIEF

|   | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|---|---------|---------|--------|--------|---------|---------|
| X | -0.2779 | -0.2620 | 0.0050 | 0.0050 | -0.0159 | -0.0109 |

BOTTOM SURFACE OF BOLT HANDLE RELIEF CUT

#33

TYPE: POINT

NAME: LO\_BOLT\_RELIEF

|   | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|---|--------|---------|--------|--------|---------|---------|
| X | 0.1970 | 0.2130  | 0.0050 | 0.0050 | -0.0160 | -0.0110 |

ET06125