

#11

Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 11:48:23
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	0.0027	-0.0050	0.0020	0.0020	0.0077	0.0057

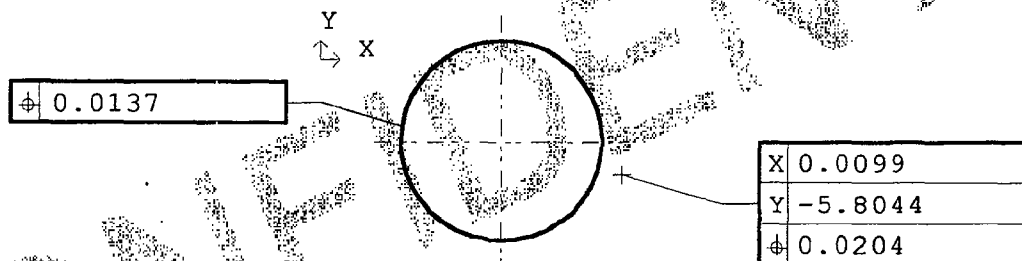
BOLT STOP HOLE ON LH SIDE OF RECEIVER

#6

TYPE: I.D.

NAME: BOLT_STOP_HOLE

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.0099	0.0000	0.0100	0.0100	0.0099	++++
Y	-5.8044	-5.8020	0.0100	0.0100	-0.0024	-
DI	0.2777	0.2790	0.0050	0.0050	-0.0013	--
PS			0.0100		0.0204	0.0067



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

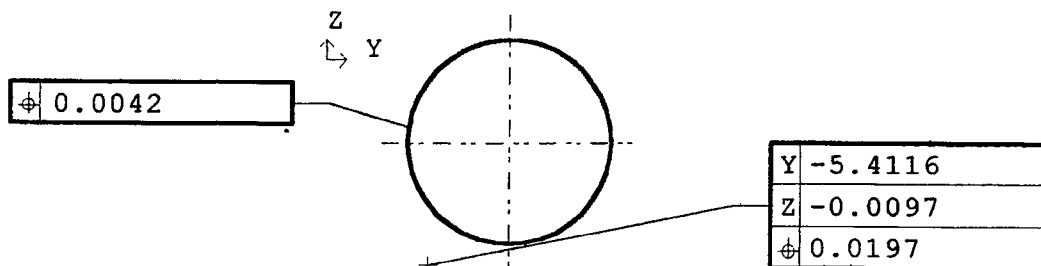
#12

TYPE: I.D.

NAME: SCOPE_SCREW_1

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-5.4116	-5.4100	0.0040	0.0040	-0.0016	--
Z	-0.0097	0.0000	0.0040	0.0040	-0.0097	-0.0057
DI	0.1156	0.1164	0.0010	0.0010	-0.0008	----
PS			0.0040		0.0197	0.0155

ET06130



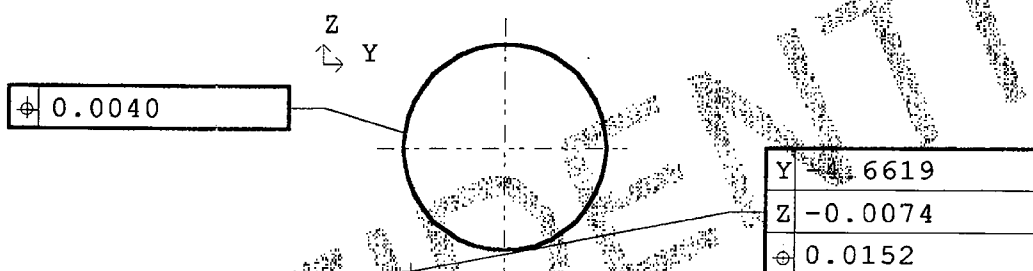
SCOPE SCREW HOLE .750 FORWARD OF REARMOST

#13

TYPE: I.D.

NAME: SCOPE_SCREW_2

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-4.6619	-4.6600	0.0040	0.0040	-0.0019	--
Z	-0.0074	0.0000	0.0040	0.0040	-0.0074	-0.0034
DI	0.1152	0.1164	0.0010	0.0010	-0.0012	-0.0002
PS			0.0040		0.0152	0.0112



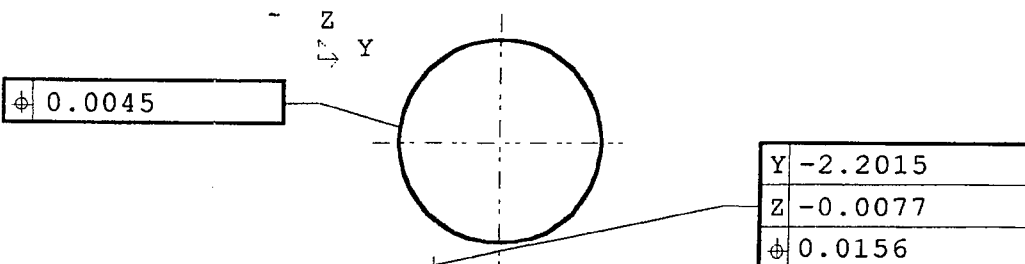
SCOPE SCREW HOLE AT 2.200 FROM DATUM-B

#14

TYPE: I.D.

NAME: SCOPE_SCREW_3

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-2.2015	-2.2000	0.0040	0.0040	-0.0015	--
Z	-0.0077	0.0000	0.0040	0.0040	-0.0077	-0.0037
DI	0.1159	0.1164	0.0010	0.0010	-0.0005	---
PS			0.0040		0.0156	0.0112



SCOPE SCREW .750 FORWARD OF SCOPE_SCREW_3

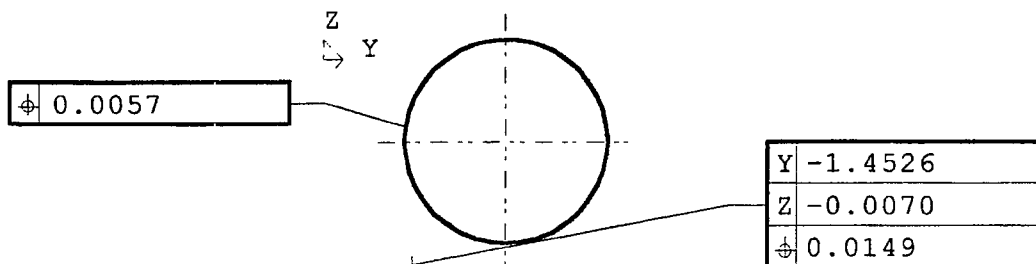
#15

TYPE: I.D.

ET06131

NAME: SCOPE_SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4526	-1.4500	0.0040	0.0040	-0.0026	---
Z	-0.0070	0.0000	0.0040	0.0040	-0.0070	-0.0030
DI	0.1171	0.1164	0.0010	0.0010	0.0007	+++
PS			0.0040		0.0149	0.0093

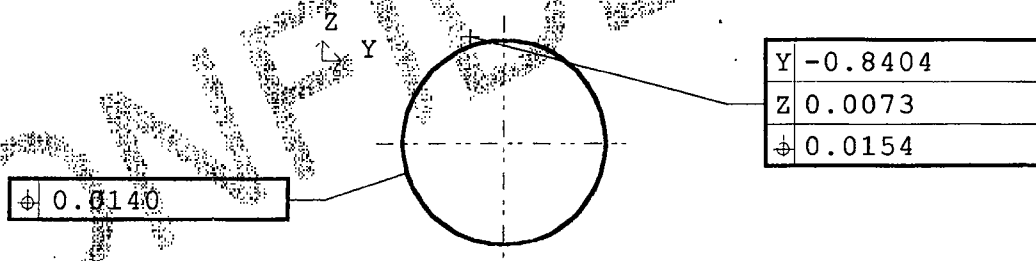


DEPTH OF BARREL COUNTERBORE
TAKEDOWN SCREW CLEARANCE HOLE
#17

TYPE: I.D.

NAME: TAKEDOWN

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-0.8404	-0.8380	0.0100	0.0100	-0.0024	-
Z	0.0073	0.0000	0.0100	0.0100	0.0073	+++
DI	0.2640	0.2650	0.0050	0.0050	-0.0010	-
PS			0.0100		0.0154	0.0014



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	0.1316	0.1250	0.0050	0.0050	0.0066	0.0016

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	0.1373	0.1250	0.0050	0.0050	0.0123	0.0073

ET06132

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	4.9631	4.9500	0.0050	0.0050	0.0131	0.0081

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	0.3056	.0.2950	0.0050	0.0050	0.0106	0.0056

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	-0.2731	-0.2620	0.0050	0.0050	-0.0111	-0.0061

BOTTOM SURFACE OF BOLT HANDLE RELIEF CUT
 #33

TYPE: POINT

NAME: LO_BOLT_RELIEF

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.2013	0.2130	0.0050	0.0050	-0.0117	-0.0067

ET06133