

#14

Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 12:04:47
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	-0.0040	0.0000	0.0020	0.0020	-0.0040	-0.0020
Z	-0.0011	0.0000	0.0020	0.0020	-0.0011	---
DI	1.2264	1.2270	0.0050	0.0050	-0.0006	-
PS			0.0040		0.0084	++++

RECEIVER ID AT FRONT OF PART

WIDTH OF DATUM-C FIRE CONTROL SLOT

DISTANCE MIDPOINT OF DATUM-C IS OFFSET FROM DATUM-A CENTERLINE (0.0041)

#5

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	-0.0023	-0.0050	0.0020	0.0020	0.0027	0.0007

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

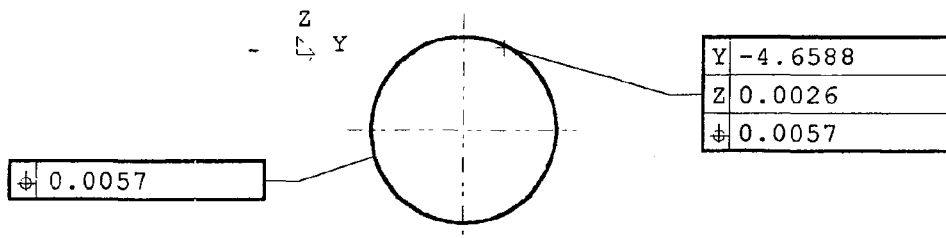
SCOPE SCREW HOLE .750 FORWARD OF REARMOST

#13

TYPE: I.D.

NAME: SCOPE SCREW_2

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-4.6588	-4.6600	0.0040	0.0040	0.0012	++
Z	0.0026	0.0000	0.0040	0.0040	0.0026	+++
DI	0.1171	0.1164	0.0010	0.0010	0.0007	+++
PS			0.0040		0.0057	++++



SCOPE SCREW HOLE AT 2.200 FROM DATUM-B

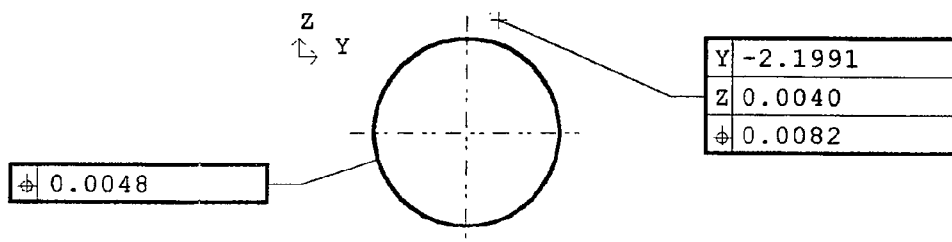
#14

TYPE: I.D.

NAME: SCOPE SCREW_3

ET06140

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-2.1991	-2.2000	0.0040	0.0040	0.0009	+
Z	0.0040	0.0000	0.0040	0.0040	0.0040	++++
DI	0.1162	0.1164	0.0010	0.0010	-0.0002	-
PS			0.0040		0.0082	0.0034



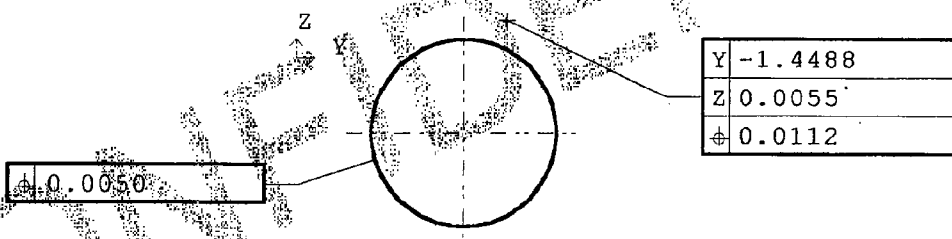
SCOPE SCREW .750 FORWARD OF SCOPE_SCREW_3

#15

TYPE: I.D.

NAME: SCOPE SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4488	-1.4500	0.0040	0.0040	0.0012	++
Z	0.0055	0.0000	0.0040	0.0040	0.0055	0.0015
DI	0.1164	0.1164	0.0010	0.0010	0.0000	+
PS			0.0040		0.0112	0.0062



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	0.1361	0.1250	0.0050	0.0050	0.0111	0.0061

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	0.1305	0.1250	0.0050	0.0050	0.0055	0.0005

ET06141

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	4.9598	4.9500	0.0050	0.0050	0.0098	0.0048

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