

#18

Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 12:47:12
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
#4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
DS	0.3165	0.3200	0.0025	0.0025	-0.0035	-0.0010

DISTANCE MIDPOINT OF DATUM-C IS OFFSET FROM DATUM-A CENTERLINE (.004 TP)
BOLT STOP HOLE CN 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
#12

TYPE: I.D.

NAME: SCOPE_SCREW_1

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-5.4102	-5.4100	0.0040	0.0040	-0.0002	-
Z	0.0074	0.0000	0.0040	0.0040	0.0074	0.0034
DI	0.1143	0.1154	0.0010	0.0010	-0.0021	-0.0011
PS			0.0040		0.0147	0.0107

0.0040

Z
Y

Y	-5.4102
Z	0.0074
⊕	0.0147

SCOPE SCREW HOLE .750 FORWARD OF REARMOST

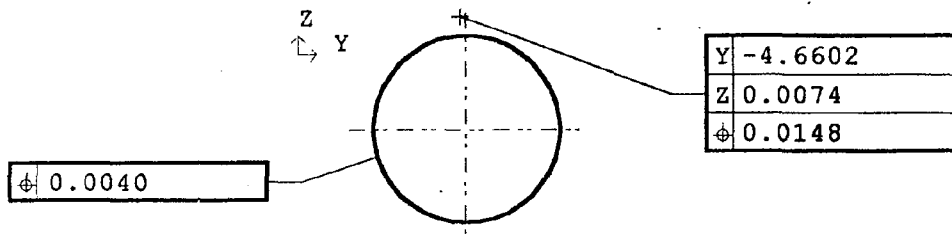
#13

TYPE: I.D.

NAME: SCOPE_SCREW_2

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-4.6602	-4.6600	0.0040	0.0040	-0.0002	-
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		0.0148	0.0108

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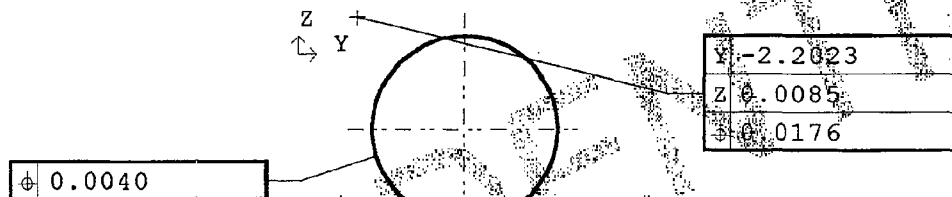
SCOPE SCREW HOLE AT 2.200 FROM DATUM-B

#14

TYPE: I.D.

NAME: SCOPE_SCREW_3

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-2.2023	-2.2000	0.0040	0.0040	-0.0023	---
Z	0.0085	0.0000	0.0040	0.0040	0.0085	0.0045
DI	0.1150	0.1164	0.0010	0.0010	-0.0014	-0.0004
PS			0.0040		0.0176	0.0136



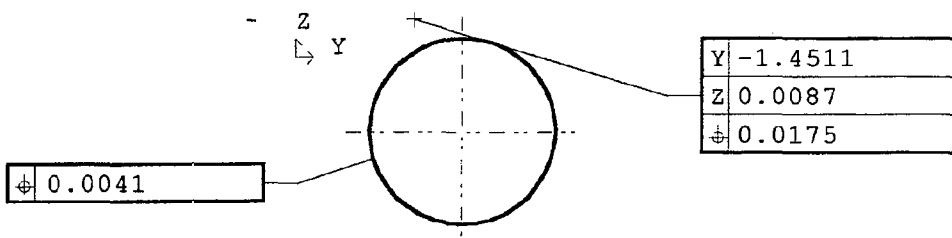
SCOPE SCREW .750 FORWARD OF SCOPE_SCREW_3

#15

TYPE: I.D.

NAME: SCOPE_SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4511	-1.4500	0.0040	0.0040	-0.0011	--
Z	0.0087	0.0000	0.0040	0.0040	0.0087	0.0047
DI	0.1155	0.1164	0.0010	0.0010	-0.0009	----
PS			0.0040		0.0175	0.0133



DEPTH OF BARREL COUNTERBORE
 TAKEDOWN SCREW CLEARANCE HOLE
 MAGAZINE BOX POSITION FROM DATUM B

ET06153

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	0.1373	0.1250	0.0050	0.0050	0.0123	0.0073

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	0.1309	0.1250	0.0050	0.0050	0.0059	0.0009

DISTANCE-FRONT OF FIRE CONTROL SLOT TO DATUM B

#22

TYPE: POINT

NAME: LEFTWIDTH1

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-5.3051	-5.3000	0.0050	0.0050	-0.0051	-0.0001

#24

TYPE: I.D.

NAME: RAD_2

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
RD	0.1327	0.1250	0.0050	0.0050	0.0077	0.0027
FM			0.0003		0.0000	+

CENTER DISTANCE BETWEEN FIRECONTROL SLOT .125R UNDERCUTS

#25

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
DS	0.2360	0.2500	0.0050	0.0050	-0.0140	-0.0090

REAR EJECTION PORT RADIUS

REAR EJECTION PORT RADIUS POSITION FROM DATUM-B

#27

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
DS	4.9636	4.9500	0.0050	0.0050	0.0136	0.0086

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
X	0.2067	0.2130	0.0050	0.0050	-0.0063	-0.0013

#34

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TYPE: POINT

NAME: BOLT_STOP_FLAT

Z	-0.6616	-0.6700	0.0050	0.0050	0.0084	0.0034
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CONFIDENTIAL

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