

#19

Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 12:53:58
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	-0.0026	0.0000	0.0020	0.0020	-0.0026	-0.0006
Z	0.0033	0.0000	0.0020	0.0020	0.0033	0.0013
DI	1.2264	1.2270	0.0050	0.0050	-0.0006	-
PS			0.0040		0.0083	++++

RECEIVER ID AT FRONT OF PART

WIDTH OF DATUM-C FIRE CONTROL SLOT

DISTANCE MIDPOINT OF DATUM-C IS OFFSET FROM DATUM-A CENTERLINE (0.004 TP)

#5

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	0.0009	-0.0050	0.0020	0.0020	0.0009	0.0039

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

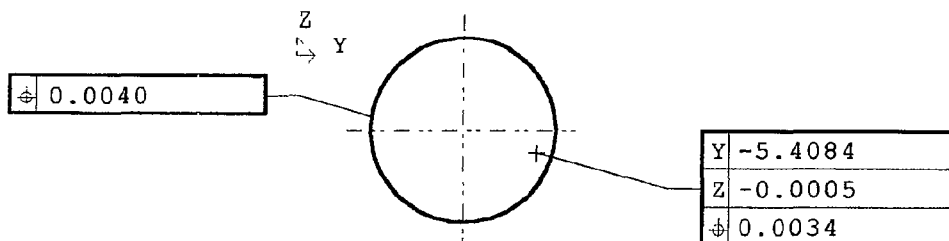
REARMOST SCOPE SCREW HOLE

#12

TYPE: I.D.

NAME: SCOPE SCREW_1

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-5.4084	-5.4100	0.0040	0.0040	0.0016	++
Z	-0.0005	0.0000	0.0040	0.0040	-0.0005	-
DI	0.1152	0.1164	0.0010	0.0010	-0.0012	-0.0002
PS			0.0040		0.0034	++++



SCOPE SCREW HOLE .750 FORWARD OF REARMOST

#13

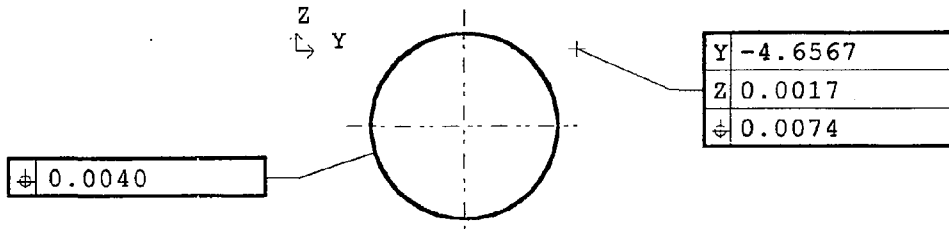
TYPE: I.D.

NAME: SCOPE SCREW_2

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
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Y	-4.6567	-4.6600	0.0040	0.0040	0.0033	++++
Z	0.0017	0.0000	0.0040	0.0040	0.0017	++
DI	0.1105	0.1164	0.0010	0.0010	-0.0059	-0.0049
PS			0.0040		0.0074	0.0034

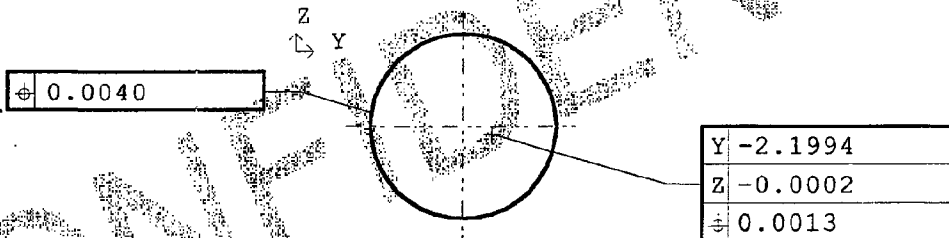


SCOPE SCREW HOLE AT 2.200 FROM DATUM-B
#14

TYPE: I.D.

NAME: SCOPE SCREW_3

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-2.1994	-2.2000	0.0040	0.0040	0.0006	+
Z	-0.0002	0.0000	0.0040	0.0040	-0.0002	-
DI	0.1138	0.1164	0.0010	0.0010	-0.0026	-0.0016
PS			0.0040		0.0013	++



SCOPE SCREW .750 FORWARD OF SCOPE SCREW_3

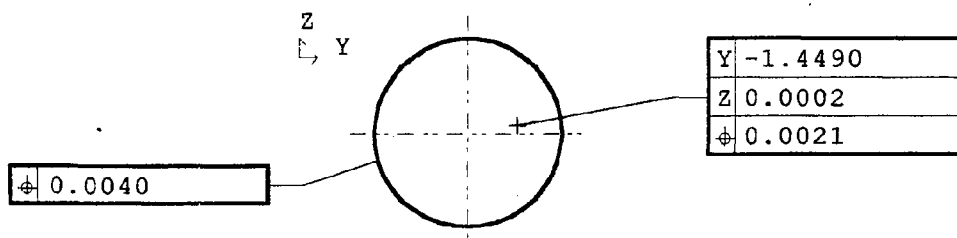
#15

TYPE: I.D.

NAME: SCOPE SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4490	--1.4500	0.0040	0.0040	0.0010	++
Z	0.0002	0.0000	0.0040	0.0040	0.0002	+
DI	0.1141	0.1164	0.0010	0.0010	-0.0023	-0.0013
PS			0.0040		0.0021	+++

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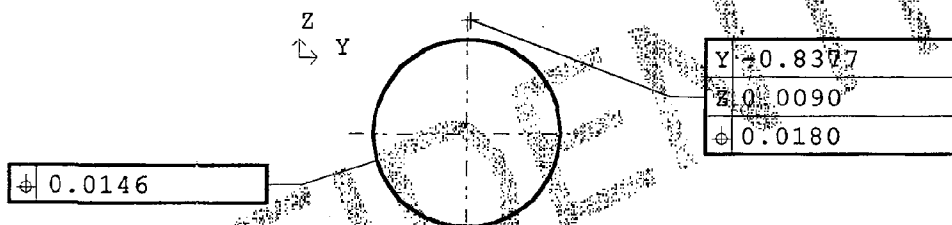
DEPTH OF BARREL COUNTERBORE
TAKEDOWN SCREW CLEARANCE HOLE

#17

TYPE: I.D.

NAME: TAKEDOWN

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-0.8377	-0.8380	0.0100	0.0100	0.0003	+
Z	0.0090	0.0000	0.0100	0.0100	0.0090	++++
DI	0.2646	0.2650	0.0050	0.0050	-0.0004	53
PS			0.0100		0.0180	0.0033



MAGAZINE BOX POSITION FROM DATUM B

MAGAZINE BOX LENGTH

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	0.1360	0.1250	0.0050	0.0050	0.0110	0.0060

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	4.9608	4.9500	0.0050	0.0050	0.0108	0.0058

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

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TOP SURFACE OF BOLT HANDLE RELIEF CUT
 BOTTOM SURFACE OF BOLT HANDLE RELIEF CUT
 #33

TYPE: POINT

NAME: LO_BOLT_REFIEF

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
X	0.2054	0.2130	0.0050	0.0050	-0.0076	-0.0026

#34

TYPE: POINT

NAME: BOLT_STOP_FLAT

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	-0.6642	-0.6700	0.0050	0.0050	0.0058	0.0008

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