

#20

Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 12:59:14
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	-0.0009	0.0000	0.0020	0.0020	-0.0009	--
DI	1.2262	1.2270	0.0050	0.0050	-0.0008	-
PS			0.0040		0.0082	++++

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) 83

#5

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	-0.0090	-0.0050	0.0020	0.0020	-0.0040	-0.0020

BOLT STOP HOLE ON LH SIDE OF RECEIVER

RECEIVER ID AT BACK OF PART

#7

TYPE: I.D.

NAME: ID_BACK

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	-0.0017	0.0000	0.0050	0.0050	-0.0017	--
X	-0.0005	0.0000	0.0050	0.0050	-0.0005	-
DI	1.0498	1.0460	0.0030	0.0030	0.0038	0.0008

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

REARMOIST SCOPE SCREW HOLE

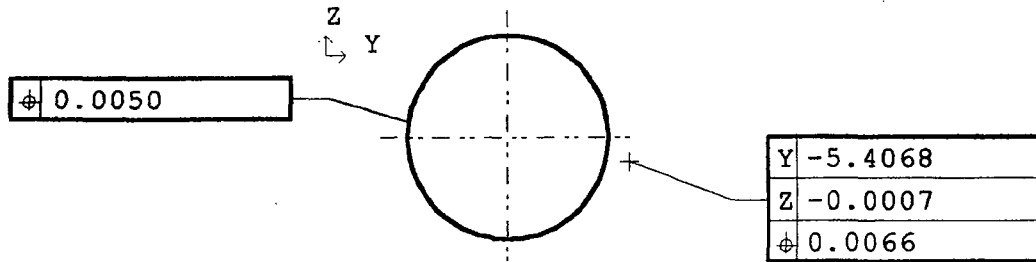
#12

TYPE: I.D.

NAME: SCOPE_SCREW_1

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-5.4068	-5.4100	0.0040	0.0040	0.0032	++++
Z	-0.0007	0.0000	0.0040	0.0040	-0.0007	-
DI	0.1164	0.1164	0.0010	0.0010	0.0000	+
PS			0.0040		0.0066	0.0016

ET06160



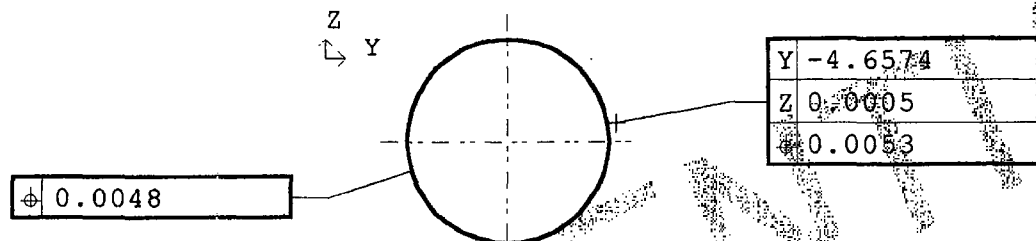
SCOPE SCREW HOLE .750 FORWARD OF REARMOST

#13

TYPE: I.D.

NAME: SCOPE_SCREW_2

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-4.6574	-4.6600	0.0040	0.0040	0.0026	+++
Z	0.0005	0.0000	0.0040	0.0040	0.0005	+
DI	0.1162	0.1164	0.0010	0.0010	-0.0002	-
PS			0.0040		0.0053	0.0005



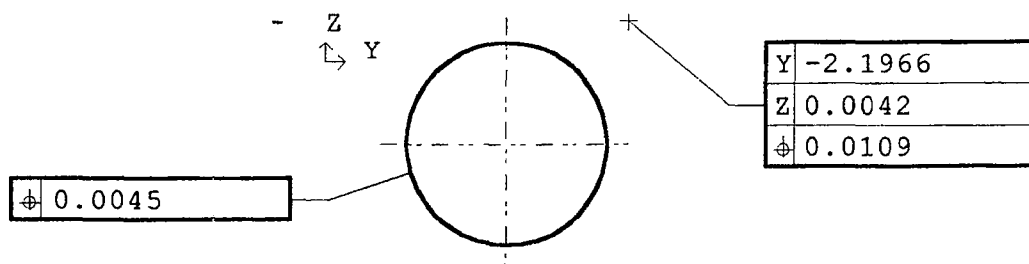
SCOPE SCREW HOLE AT 2.200 FROM DATUM-B

#14

TYPE: I.D.

NAME: SCOPE_SCREW_3

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-2.1966	-2.2000	0.0040	0.0040	0.0034	++++
Z	0.0042	0.0000	0.0040	0.0040	0.0042	0.0002
DI	0.1159	0.1164	0.0010	0.0010	-0.0005	--
PS			0.0040		0.0109	0.0063



SCOPE SCREW .750 FORWARD OF SCOPE_SCREW_3

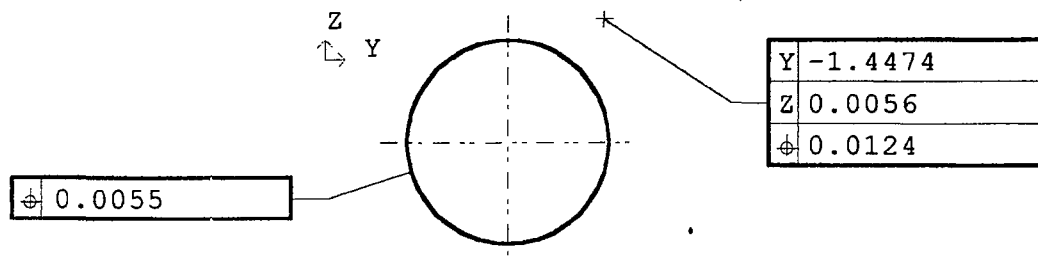
#15

TYPE: I.D.

ET06161

NAME: SCOPE SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4474	-1.4500	0.0040	0.0040	0.0026	+++
Z	0.0056	0.0000	0.0040	0.0040	0.0056	0.0016
DI	0.1169	0.1164	0.0010	0.0010	0.0005	+++
PS			0.0040		0.0124	0.0069



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	0.1440	0.1250	0.0050	0.0050	0.0190	0.0140

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

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	4.9596	4.9500	0.0050	0.0050	0.0096	0.0046

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

ET06162