

#72

Part Program: 710 RECEIVER
Inspector: Administrator

Date/Time: 08/14/2000 13:10:01
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	-0.0006	-0.0050	0.0020	0.0020	0.0044	0.0024

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

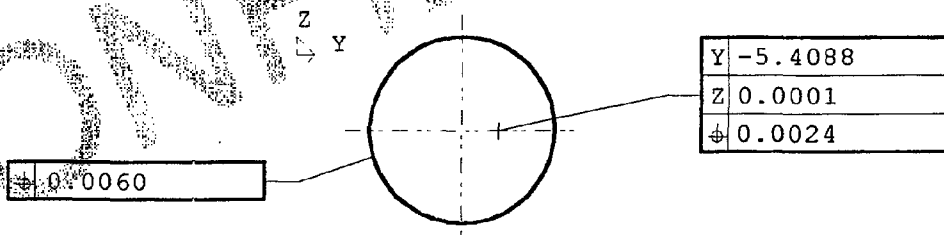
REARMOST SCOPE SCREW HOLE

#12

TYPE: I.D.

NAME: SCOPE_SCREW_1

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-5.4088	-5.4100	0.0040	0.0040	0.0012	++
Z	0.0001	0.0000	0.0040	0.0040	0.0001	+
DI	0.1175	0.1164	0.0010	0.0010	0.0011	0.0001
PS			0.0040		0.0024	++



SCOPE SCREW HOLE .750 FORWARD OF REARMOST

SCOPE SCREW HOLE AT 2.200 FROM DATUM-B

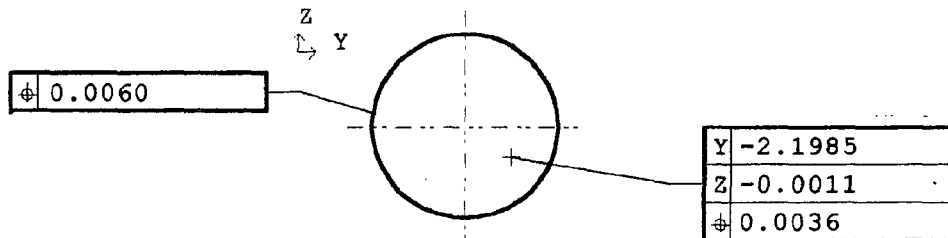
#14

TYPE: I.D.

NAME: SCOPE_SCREW_3

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-2.1985	-2.2000	0.0040	0.0040	0.0015	++
Z	-0.0011	0.0000	0.0040	0.0040	-0.0011	--
DI	0.1174	0.1164	0.0010	0.0010	0.0010	++++
PS			0.0040		0.0036	+++

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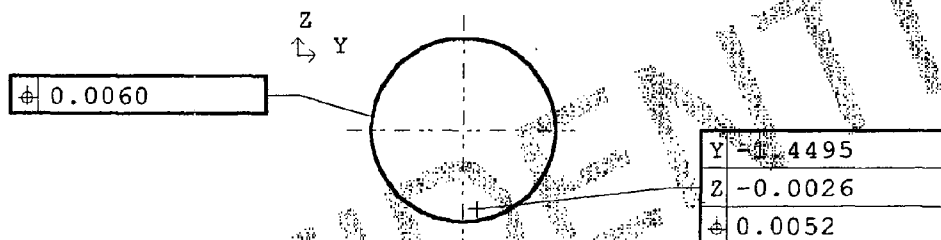
SCOPE SCREW .750 FORWARD OF SCOPE_SCREW_3

#15

TYPE: I.D.

NAME: SCOPE_SCREW_4

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Y	-1.4495	-1.4500	0.0040	0.0040	0.0005	+
Z	-0.0026	0.0000	0.0040	0.0040	-0.0026	---
DI	0.1181	0.1164	0.0010	0.0010	0.0017	0.0007
PS			0.0040		0.0052	85++



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	0.1343	0.1250	0.0050	0.0050	0.0093	0.0043

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

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	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
DS	4.9597	4.9500	0.0050	0.0050	0.0097	0.0047

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	0.2071	0.2130	0.0050	0.0050	-0.0059	-0.0009

#34

TYPE: POINT

NAME: BOLT_STOP_FLAT

	ACTUAL	NOMINAL	+ TOL	- TOL	DEV	OUT-TOL
Z	-0.6647	-0.6700	0.0050	0.0050	0.0053	0.0003

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