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SILENCERCO

MUZZLE THREAD GUIDE

PART 1 OF 2: THIS DOCUMENT SERVES AS A GUIDE DETAILING RECOMMENDED MACHINING TOLERANCES AND THE COMPATIBILITY OF **CENTERFIRE RIFLE MUZZLE THREADS** WITH SILENCERCO ACCESSORIES. WHILE THESE SPECIFICATIONS AND TOLERANCES MAY ALIGN WITH SOME OTHER MANUFACTURERS' PRODUCTS AND EXHIBIT COMMONALITY WITH MOST OF SAAMI'S SPECIFICATIONS, THE RESPONSIBILITY FOR ANY DAMAGE, INJURY, OR INCOMPATIBILITY WITH OTHER MANUFACTURERS' PRODUCTS RESTS WITH THE END USER AND/OR THE MACHINIST. IF THE FACTORY BARREL CROWN IS REMOVED DURING THE MACHINING PROCESS, IT IS THE RESPONSIBILITY OF THE MACHINIST TO CUT A NEW CROWN. ALL NFA RULES APPLY WHEN SELECTING RIFLE BARREL LENGTHS.

 **SILENCERCO, LLC**
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WEST VALLEY, UT 84118

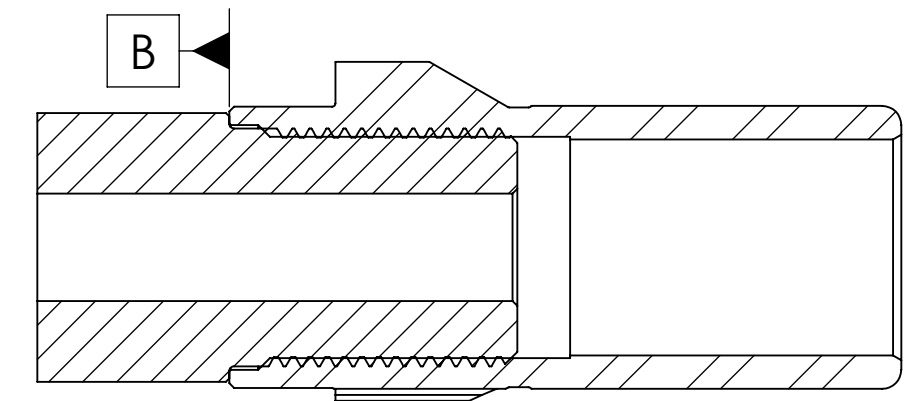
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ENGINEER	DATE	SHEET SIZE	DRAWING REVISION
Jared H.	3/4/2024	D	A1
		SCALE: 1:1	SHEET 1 OF 16

15 14 13 12 11 10 9 8 7 6 5 4 3 2 1

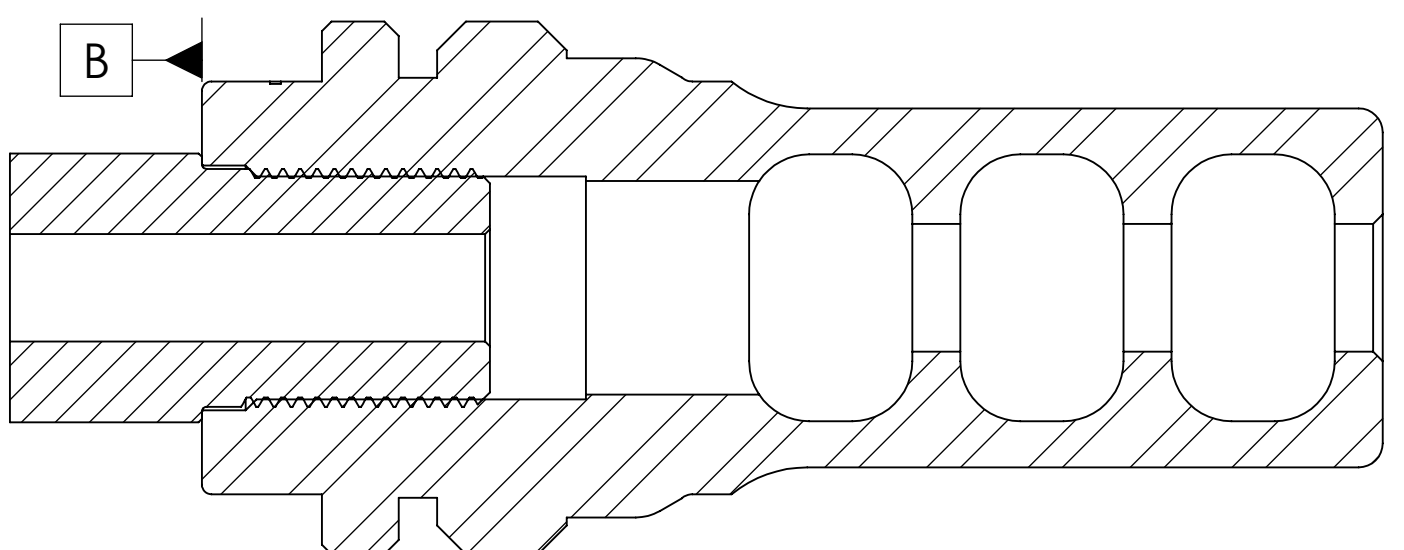
NOTE: 1/2 - 28 (.500-28) RIFLE BARREL THREAD IS MOST COMMONLY USED WITH 22 CALIBER, 9MM & 30 CALIBER. SILENCERCO OFFERS A MOUNTING OPTION FOR ALL OF OUR PRODUCTS WITH 1/2 - 28 THREADS.

ALL SILENCERCO 1/2 - 28 CENTERFIRE RIFLE ACCESSORIES SHOULD BE POSITIONED BEHIND THE THREADS, OR @ LOCATION [B].

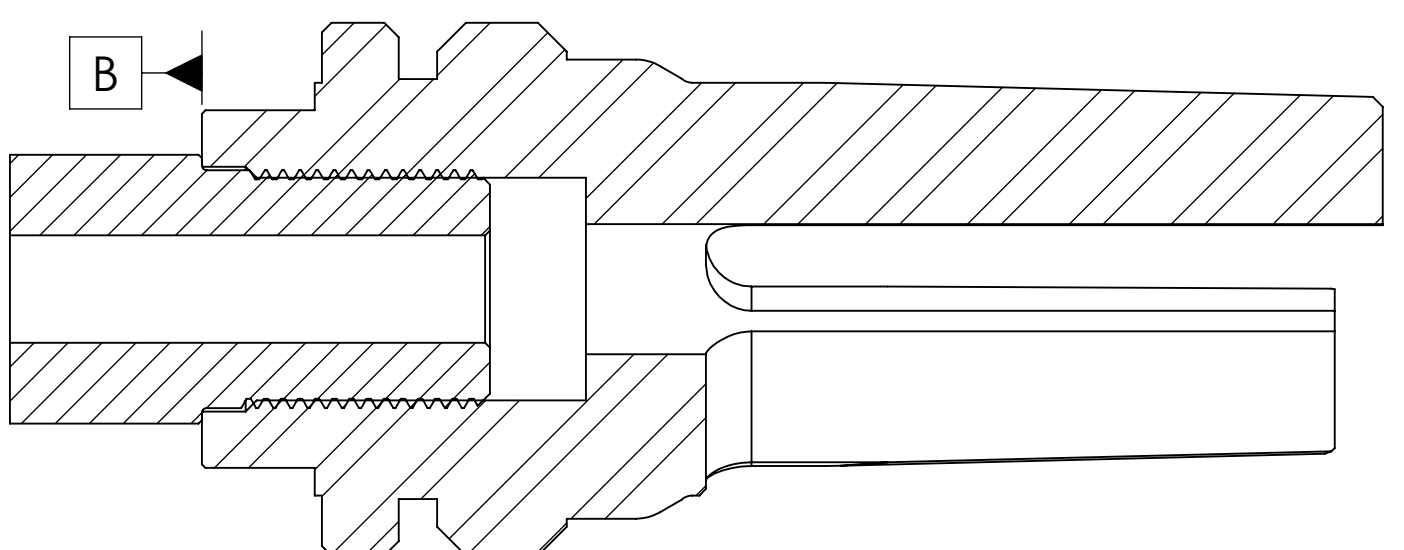
THREAD TYPE	.500-28 UNEF-3A	.500-28 UNS-2A
	TIGHTER TOLERANCE & FIT, WILL WORK WITH SILENCERCO ACCESSORIES	RECOMMENDED FOR UNIVERSAL FIT
PITCH ϕ	$\phi .4754 \pm .0014$	$\phi .4739 \pm .0019$
MAJOR ϕ	$\phi .4967 \pm .0032$	$\phi .4957 \pm .0033$



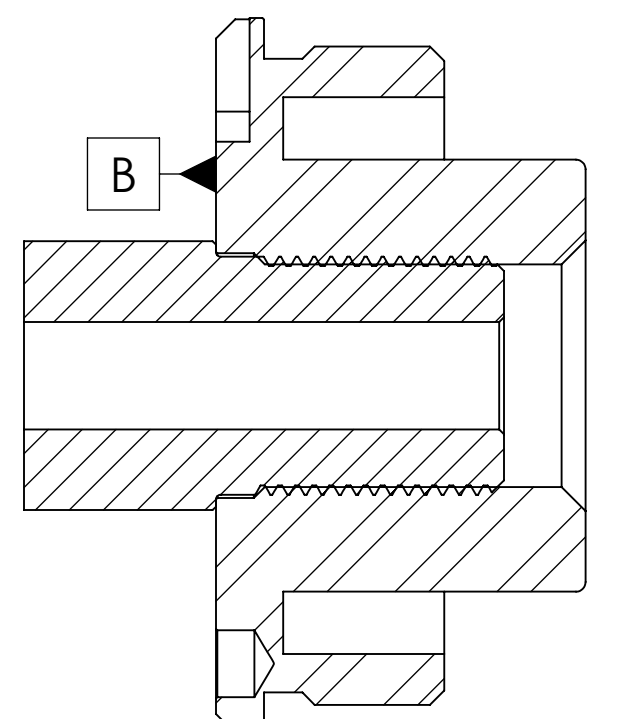
SECTION VIEW WITH 1/2 - 28 9MM 3 LUG MOUNT (AC2604) FOR PISTOL CALIBER & SUBSONIC RIFLE APPLICATIONS.



SECTION VIEW WITH 1/2 - 28 5.56/.223 ASR MUZZLE BRAKE (AC142). OTHER CALIBER MUZZLE BRAKES ARE AVAILABLE IN THE 1/2 - 28 THREAD PATTERN, SUCH AS: 6.5MM (AC4753), 30 CAL (AC1282), A SINGLE PORT 9MM (AC2628) & A THREAD OVER MUZZLE DEVICE (AC5232)

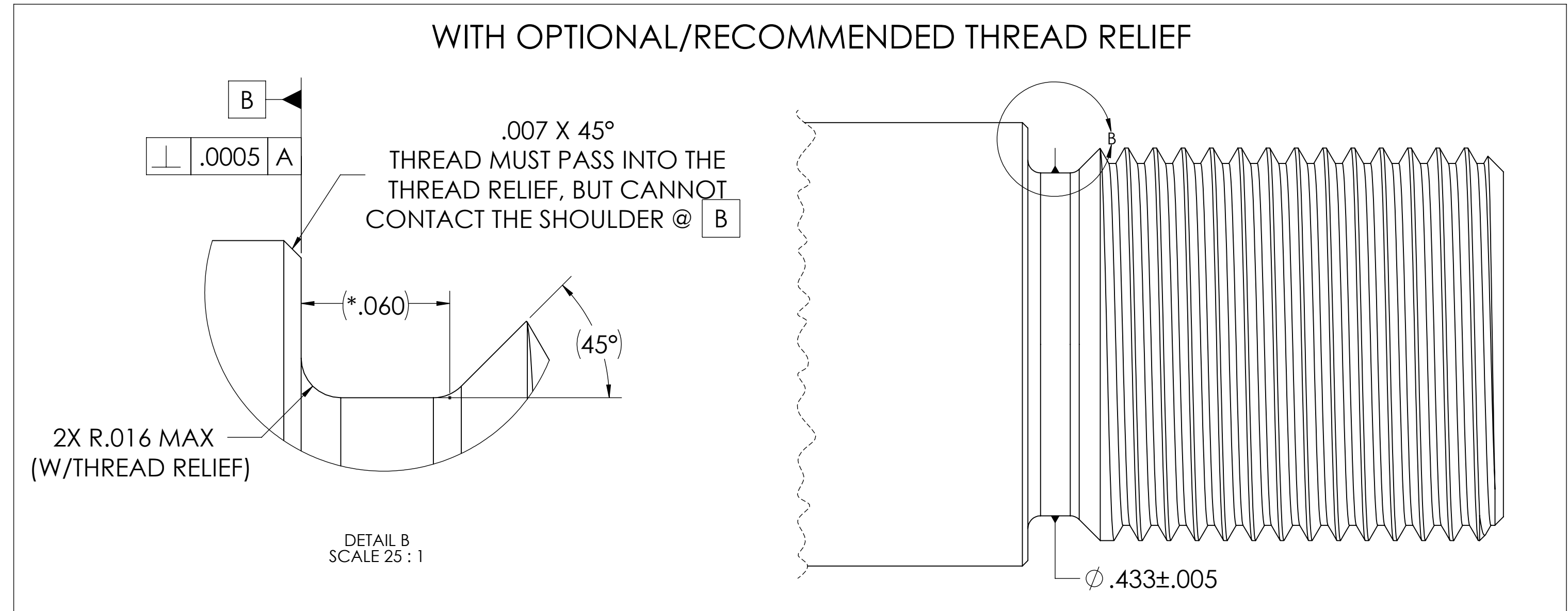
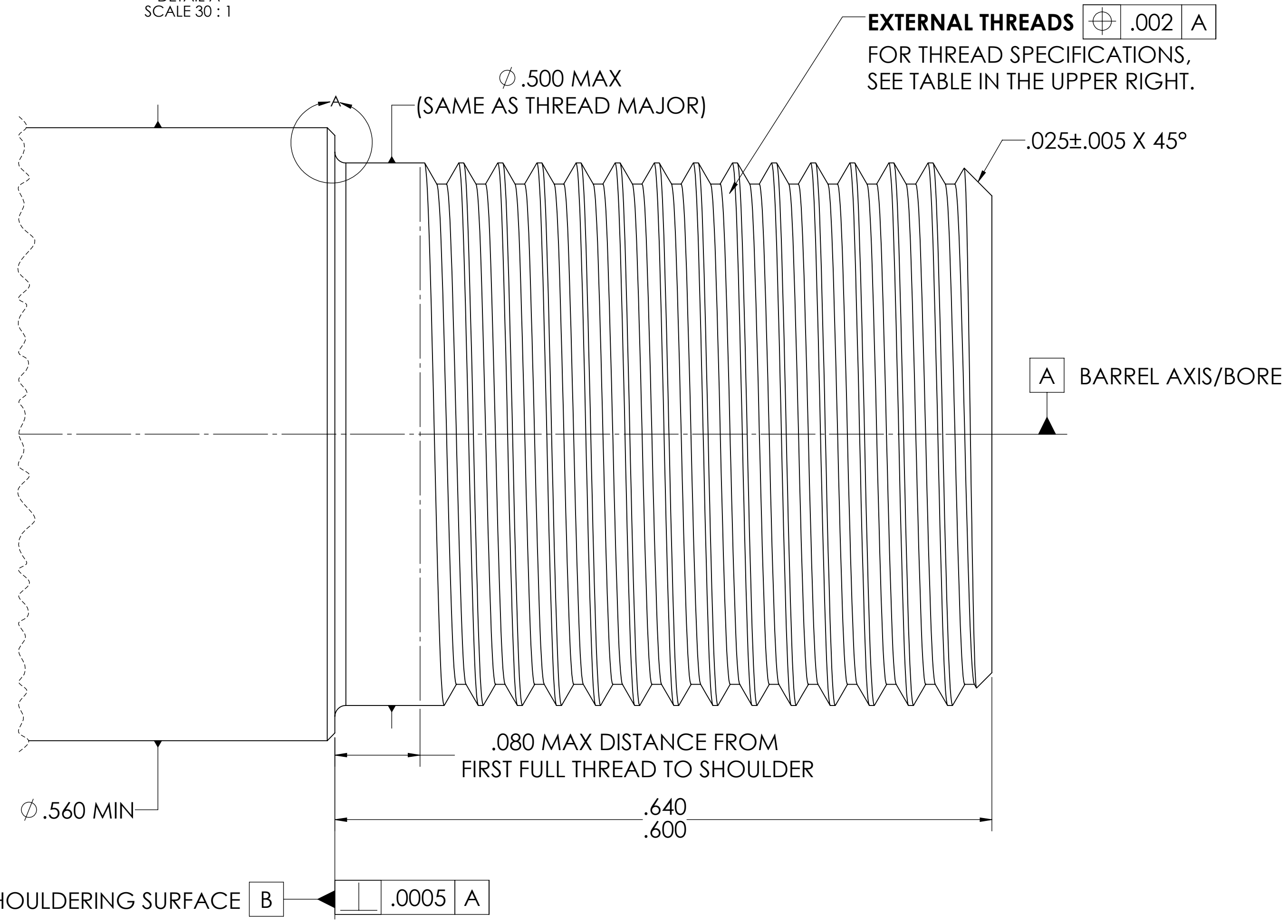
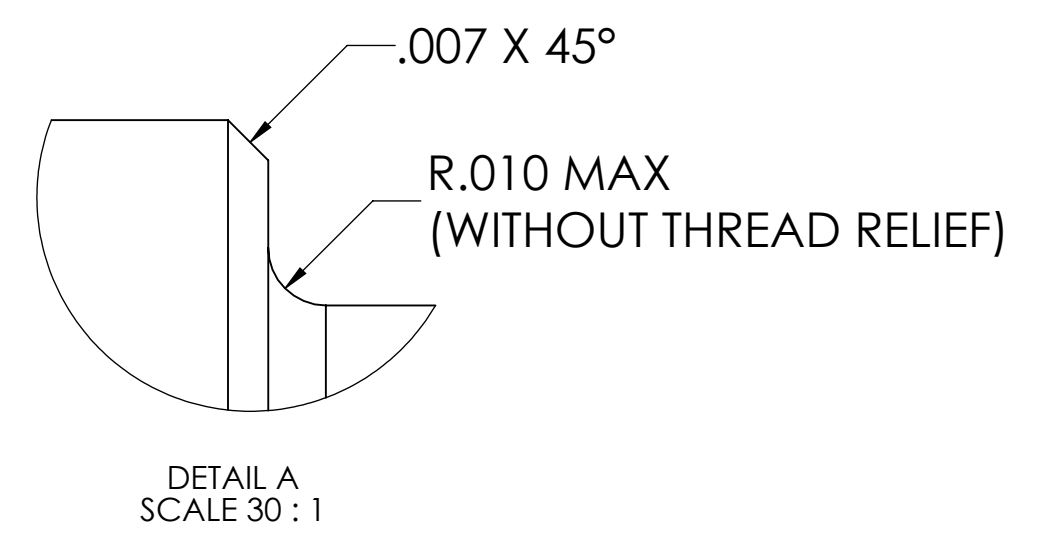


SECTION VIEW WITH 1/2 - 28 5.56/.223 ASR FLASH HIDER (AC141). OTHER CALIBER FLASH HIDERS ARE AVAILABLE IN THE 1/2 - 28 THREAD PATTERN, SUCH AS: 9MM (AC1570) & 30 CAL (AC1283) ALSO, 5.56 CAL CLOSED-TINE (AC5326)



SECTION VIEW WITH 1/2 - 28 ALPHA DIRECT THREAD (AC633) CHARLIE 1/2 - 28 DT (AC4740) & BRAVO 1/2 - 28 DT (AC1415) HAVE A SIMILAR INTERIOR THREAD PROFILE.

- MACHINIST NOTES:
UNLESS OTHERWISE SPECIFIED,
1. REMOVE BURRS/BREAK ALL EDGES TO A MAX OF .005.
 2. GAGE ALL THREADS BETWEEN 1 TO 3 TURNS MAX OF NO-GO.
 3. DIMENSIONS WITH " * " ARE TO A THEORETICAL INTERSECTION.
 4. ALL NFA RULES APPLY TO RIFLE BARREL OVERALL LENGTH SELECTION.
- ASSEMBLY NOTES:
5. AVOID USING A CRUSH WASHER.
 6. UNLESS TIMING WITH SHIMS, ENSURE THERE'S NO VISIBLE GAP BETWEEN THE MUZZLE DEVICE AND LOCATION [B].
 7. UTILIZE ROCKSET OR ANOTHER HIGH-TEMPERATURE THREAD LOCKER.
 8. TORQUE MUZZLE DEVICES BETWEEN 20-30 FT LBS.
 9. FOR TIMING OF SILENCERCO MUZZLE BRAKES, USE THE SUPPLIED PRECISION SHIMS.

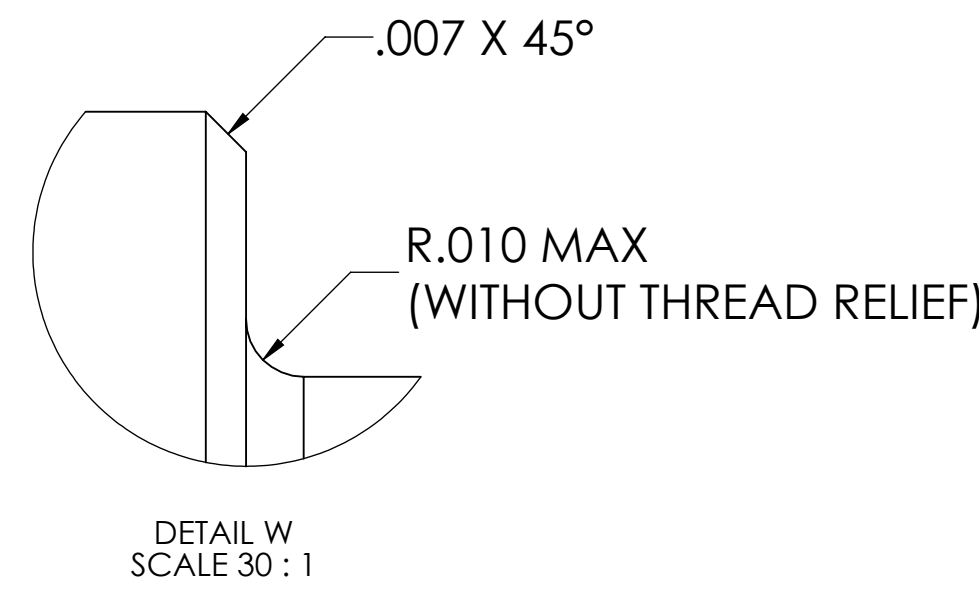


INTERPRET GEOMETRIC TOLERANCING PER ASME Y14.5-2018	PROPRIETARY AND CONFIDENTIAL	<p>SILENCERCO, LLC 5511 S 6055 W WEST VALLEY, UT 84118</p>								
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ANGULAR: SURFACE FINISH: OR BETTER PERPENDICULARITY: .001/INCH CIRCULARITY: .0005	<table border="1"> <tr> <td>ENGINEER</td> <td>DATE</td> <td>SHEET SIZE</td> <td>DRAWING REVISION</td> </tr> <tr> <td>Jared H.</td> <td>3/4/2024</td> <td>D</td> <td>A1</td> </tr> </table>	ENGINEER	DATE	SHEET SIZE	DRAWING REVISION	Jared H.	3/4/2024	D	A1	<p>.500-28 CENTERFIRE RIFLE MUZZLE THREADS</p> <p>SCALE: 10:1</p> <p>SHEET 2 OF 16</p>
ENGINEER	DATE	SHEET SIZE	DRAWING REVISION							
Jared H.	3/4/2024	D	A1							

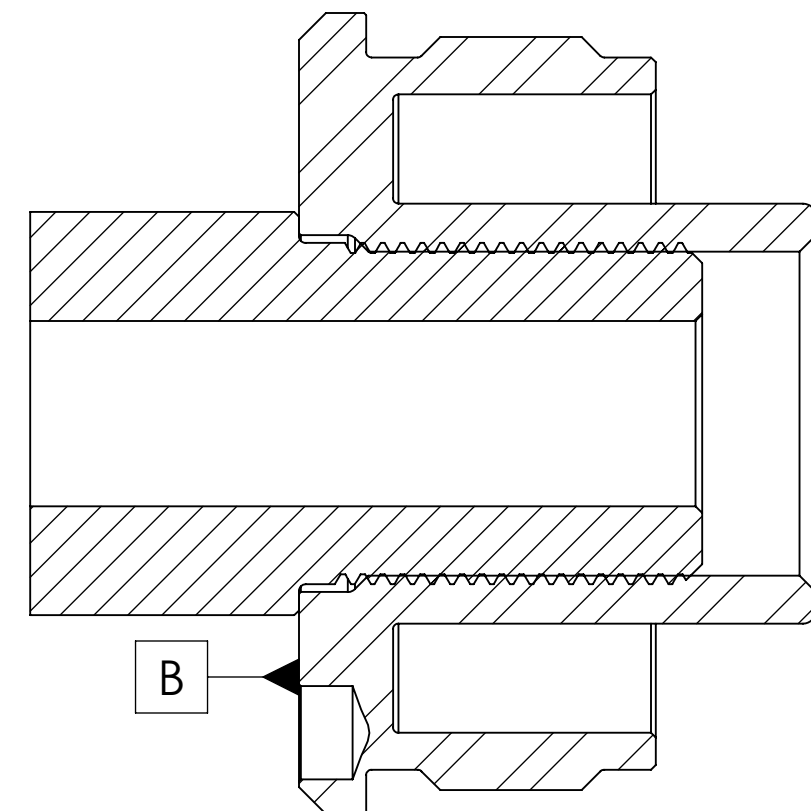
NOTE: M13X.75 RIFLE BARREL THREAD IS MOST COMMONLY USED WITH PENCIL & SPORTER BOLT ACTION RIFLES ORIGINALLY EQUIPPED WITH A COMPENSATOR, SUCH AS THE BROWNING® "X BOLT" SERIES ETC.

ALL SILENCERCO M13X.75 CENTERFIRE RIFLE ACCESSORIES SHOULD BE POSITIONED BEHIND THE THREADS, OR @ LOCATION **B**.

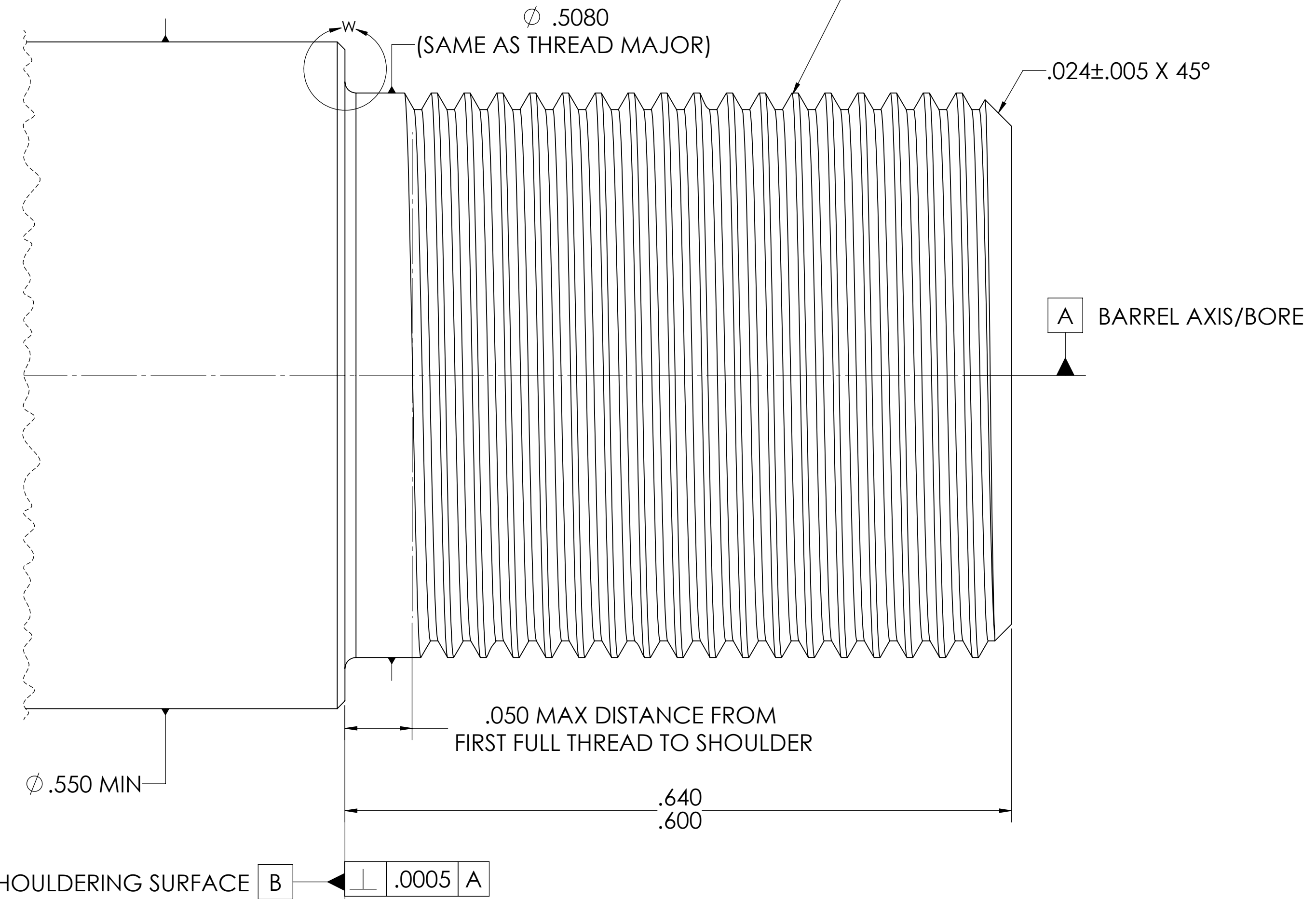
THREAD TYPE	M13X.75 4H6H	M13X.75 4G6G
	TIGHTER TOLERANCE & FIT, WILL WORK WITH SILENCERCO® ACCESSORIES	RECOMMENDED FOR UNIVERSAL FIT
PITCH ϕ	$\phi .4913 \pm .0013$	$\phi .4905 \pm .0013$
MAJOR ϕ	$\phi .5090 \pm .0028$	$\phi .5082 \pm .0028$



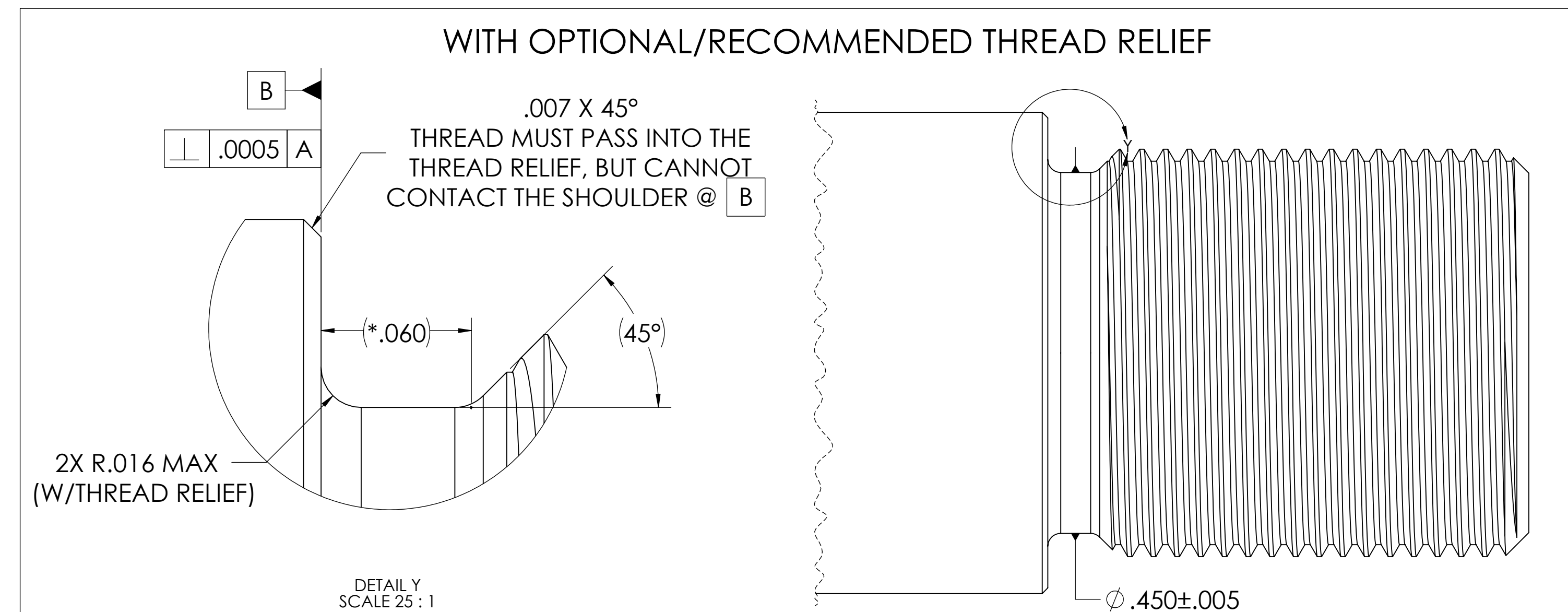
EXTERNAL THREADS $\oplus .002$ **A**
FOR THREAD SPECIFICATIONS, SEE TABLE IN THE UPPER RIGHT.



SECTION VIEW WITH M13X.75 ALPHA DIRECT THREAD (AC2629)
ALSO AVAILABLE IN BRAVO DIRECT THREAD (AC2630) & CHARLIE DIRECT THREAD (AC4745)



- MACHINIST NOTES:
UNLESS OTHERWISE SPECIFIED,
1. REMOVE BURRS/BREAK ALL EDGES TO A MAX OF .005.
 2. GAGE ALL THREADS BETWEEN 1 TO 3 TURNS MAX OF NO-GO.
 3. DIMENSIONS WITH " * " ARE TO A THEORETICAL INTERSECTION.
 4. ALL NFA RULES APPLY TO RIFLE BARREL OVERALL LENGTH SELECTION.
- ASSEMBLY NOTES:
5. AVOID USING A CRUSH WASHER.
 6. UNLESS TIMING WITH SHIMS, ENSURE THERE'S NO VISIBLE GAP BETWEEN THE MUZZLE DEVICE AND LOCATION **B**.
 7. UTILIZE ROCKSET OR ANOTHER HIGH-TEMPERATURE THREAD LOCKER.
 8. TORQUE MUZZLE DEVICES BETWEEN 20-30 FT LBS.
 9. FOR TIMING OF SILENCERCO MUZZLE BRAKES, USE THE SUPPLIED PRECISION SHIMS.



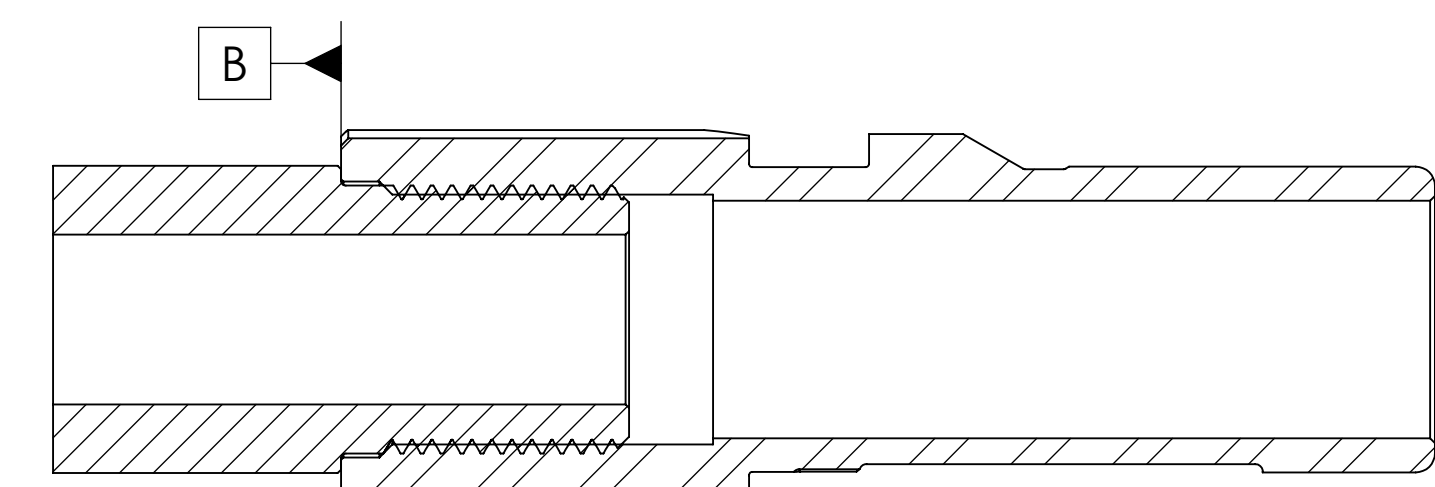
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INTERPRET GEOMETRIC TOLERANCING PER ASME Y14.5-2018	PROPRIETARY AND CONFIDENTIAL	<p>M13X.75 CENTERFIRE RIFLE MUZZLE THREADS</p> <p>ENGINEER: Jared H. DATE: 3/4/2024</p> <p>SHEET SIZE: D DRAWING REVISION: A1</p> <p>SCALE: 10:1 SHEET 3 OF 16</p>	
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ANGULAR: SURFACE FINISH: OR BETTER PERPENDICULARITY \perp : .001/INCH CIRCULARITY \bigcirc : .0005			

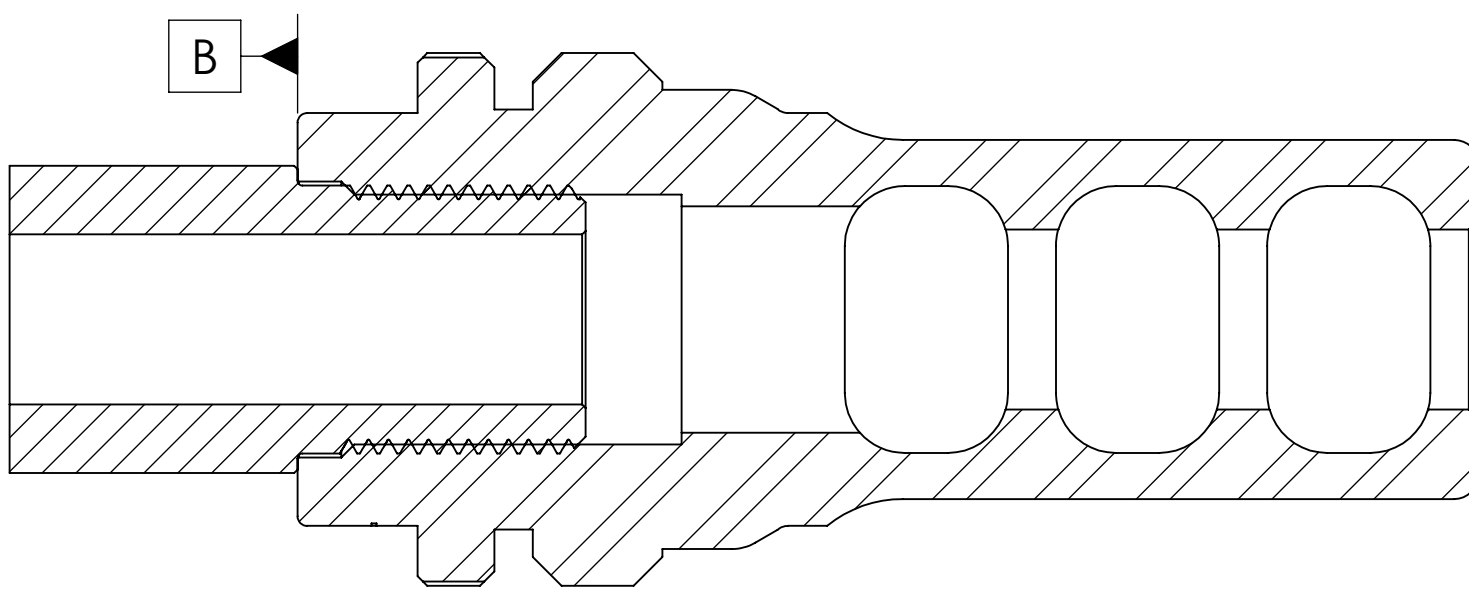
NOTE: 9/16-24 (.5625-24) RIFLE BARREL THREAD IS MOST COMMONLY USED WITH 5.56 THROUGH .40 CALIBER/10MM.

ALL SILENCERCO 9/16-24 CENTERFIRE RIFLE ACCESSORIES SHOULD BE POSITIONED BEHIND THE THREADS, OR @ LOCATION **B**.

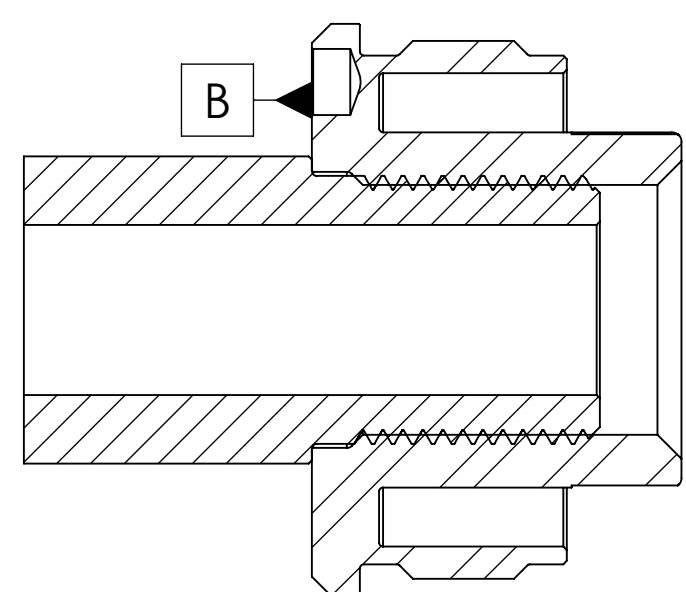
THREAD TYPE	.5625-24 UNEF-3A	.5625-24 UNEF-2A
	TIGHTER TOLERANCE & FIT, WILL WORK WITH SILENCERCO ACCESSORIES	RECOMMENDED FOR UNIVERSAL FIT
PITCH ϕ	$\phi .5339 \pm .0015$	$\phi .5322 \pm .0020$
MAJOR ϕ	$\phi .5589 \pm .0036$	$\phi .5577 \pm .0036$
MINOR ϕ	$\phi .5170 \text{ MAX}$	$\phi .5162 \text{ MAX}$



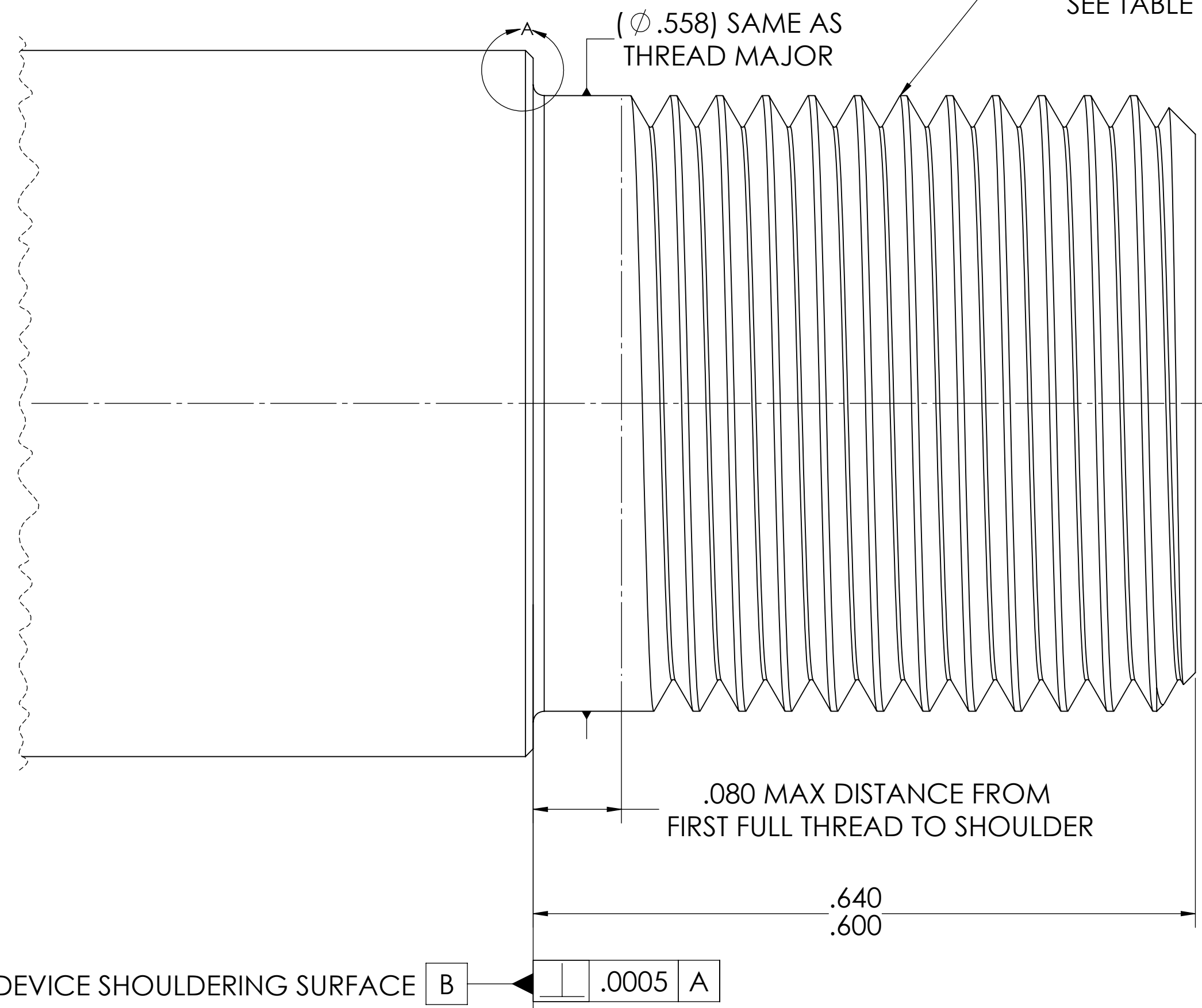
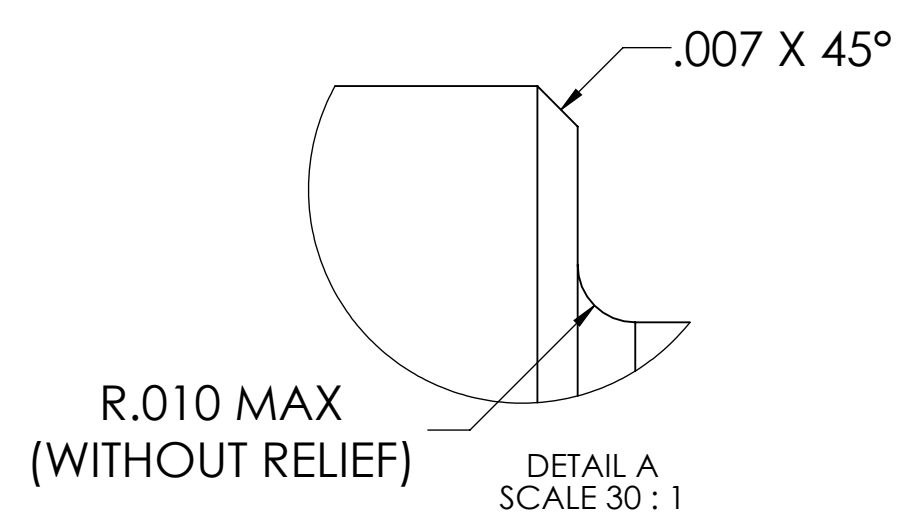
SECTION VIEW WITH 9/16 - 24 45 CAL 3 LUG MOUNT (AC2606). FOR PISTOL CALIBER & SUBSONIC RIFLE APPLICATIONS.



SECTION VIEW WITH 9/16 - 24 7.62/30 CAL ASR MUZZLE BRAKE (AC1276). A 9/16 - 24 9MM ASR MUZZLE BRAKE (AC4766) IS ALSO AVAILABLE.

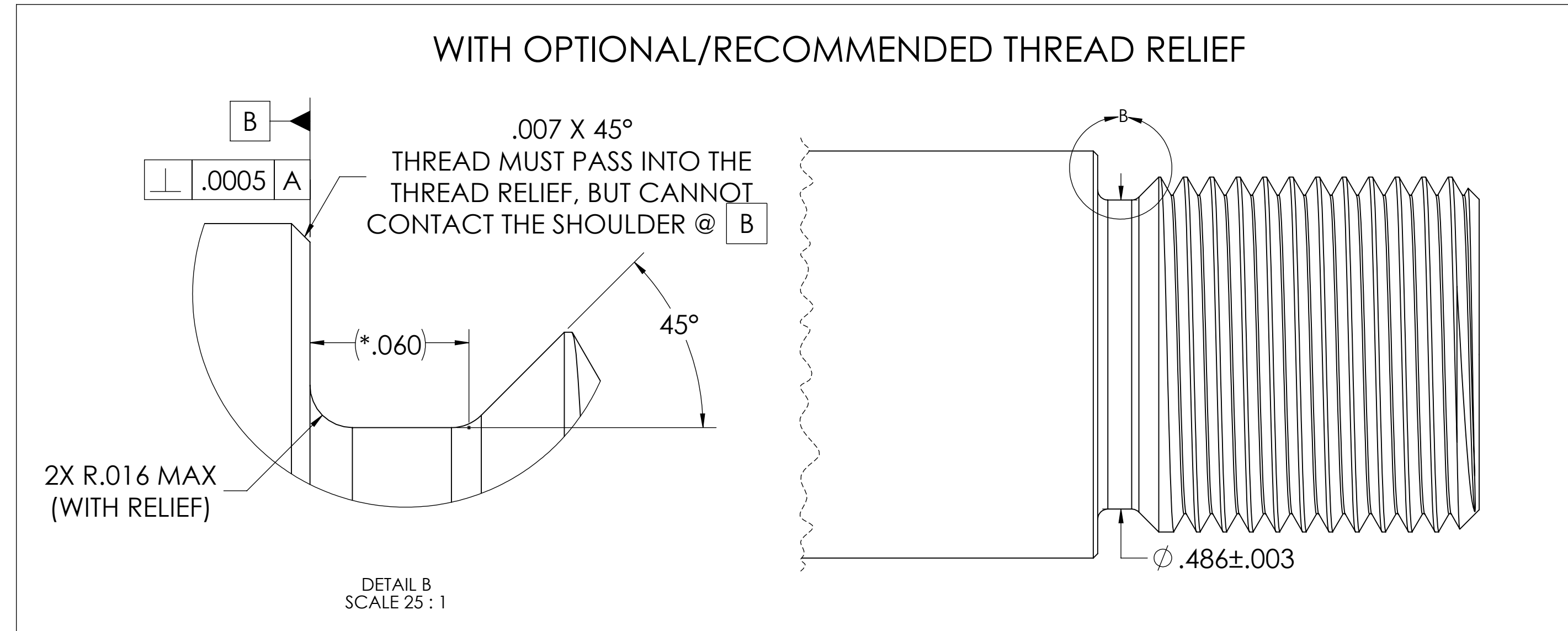


SECTION VIEW WITH 9/16-24 ALPHA DIRECT THREAD (AC822) CHARLIE 9/16-24 DT(AC4744) & BRAVO 9/16-24 DT (AC2435) HAVE A SIMILAR INTERIOR THREAD PROFILE.



EXTERNAL THREADS $\oplus .002$ **A**
FOR THREAD SPECIFICATIONS, SEE TABLE IN THE UPPER RIGHT.

- MACHINIST NOTES:**
UNLESS OTHERWISE SPECIFIED,
1. REMOVE BURRS/BREAK ALL EDGES TO A MAX OF .005.
 2. GAGE ALL THREADS BETWEEN 1 TO 3 TURNS MAX OF NO-GO.
 3. DIMENSIONS WITH "*" ARE TO A THEORETICAL INTERSECTION.
 4. ALL NFA RULES APPLY TO RIFLE BARREL OVERALL LENGTH SELECTION.
- ASSEMBLY NOTES:**
5. AVOID USING A CRUSH WASHER.
 6. UNLESS TIMING WITH SHIMS, ENSURE THERE'S NO VISIBLE GAP BETWEEN THE MUZZLE DEVICE AND LOCATION **B**.
 7. UTILIZE ROCKSET OR ANOTHER HIGH-TEMPERATURE THREAD LOCKER.
 8. TORQUE MUZZLE DEVICES BETWEEN 20-30 FT LBS.
 9. FOR TIMING OF SILENCERCO MUZZLE BRAKES, USE THE SUPPLIED PRECISION SHIMS.



INTERPRET GEOMETRIC TOLERANCING PER ASME Y14.5-2018	PROPRIETARY AND CONFIDENTIAL								
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ANGULAR: SURFACE FINISH: OR BETTER PERPENDICULARITY: CIRCULARITY:	<table border="1"> <tr> <td>ENGINEER</td> <td>DATE</td> <td>SHEET SIZE</td> <td>DRAWING REVISION</td> </tr> <tr> <td>Jared H.</td> <td>3/4/2024</td> <td>D</td> <td>A1</td> </tr> </table>	ENGINEER	DATE	SHEET SIZE	DRAWING REVISION	Jared H.	3/4/2024	D	A1
ENGINEER	DATE	SHEET SIZE	DRAWING REVISION						
Jared H.	3/4/2024	D	A1						

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WEST VALLEY, UT 84118

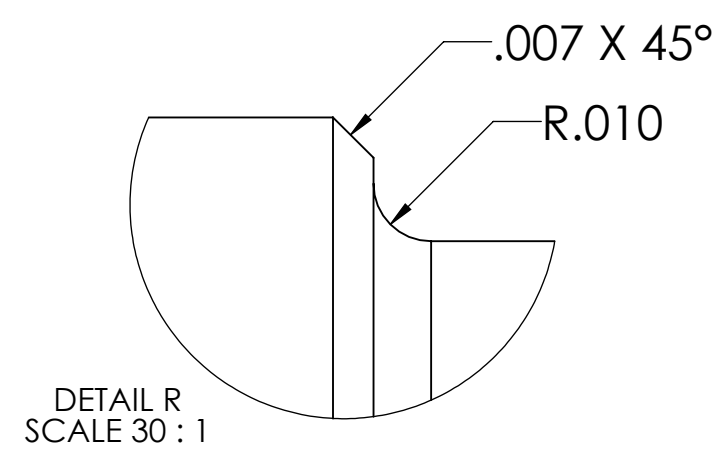
.5625-24 CENTERFIRE RIFLE MUZZLE THREADS

SCALE: 10:1
SHEET 4 OF 16

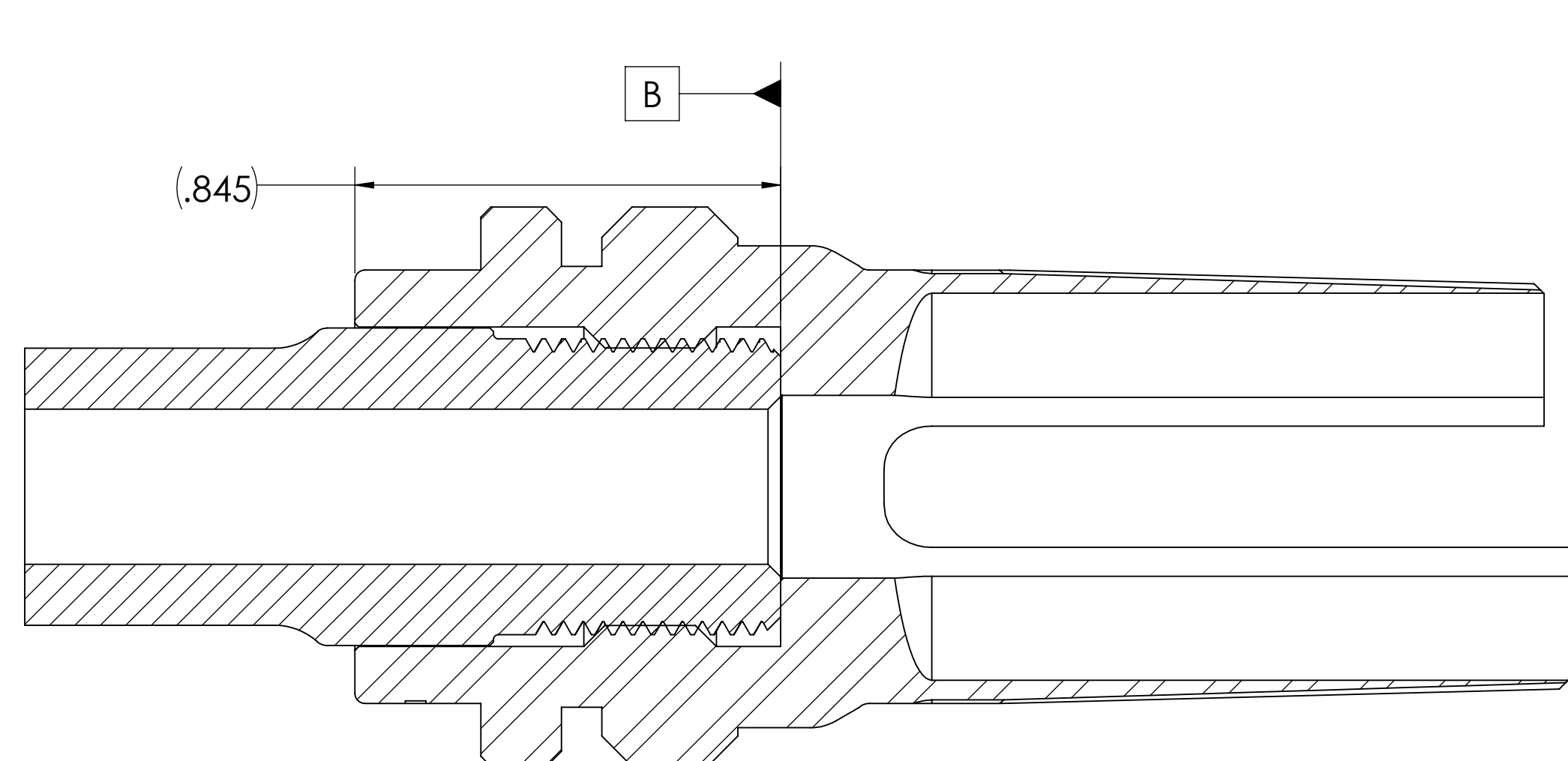
NOTE: M15X1 RIFLE BARREL THREADS ARE MOST COMMONLY USED WITH 5.56 & .308 CALIBER RIFLES SUCH AS THE HK® MODELS 33, 91, 93 & G3. THIS IS NOT A POPULAR THREAD OUTSIDE OF THOSE PLATFORMS.

ALL SILENCERCO M15X1 CENTERFIRE RIFLE ACCESSORIES SHOULDER ON THE NOSE, OR @ LOCATION **B**.

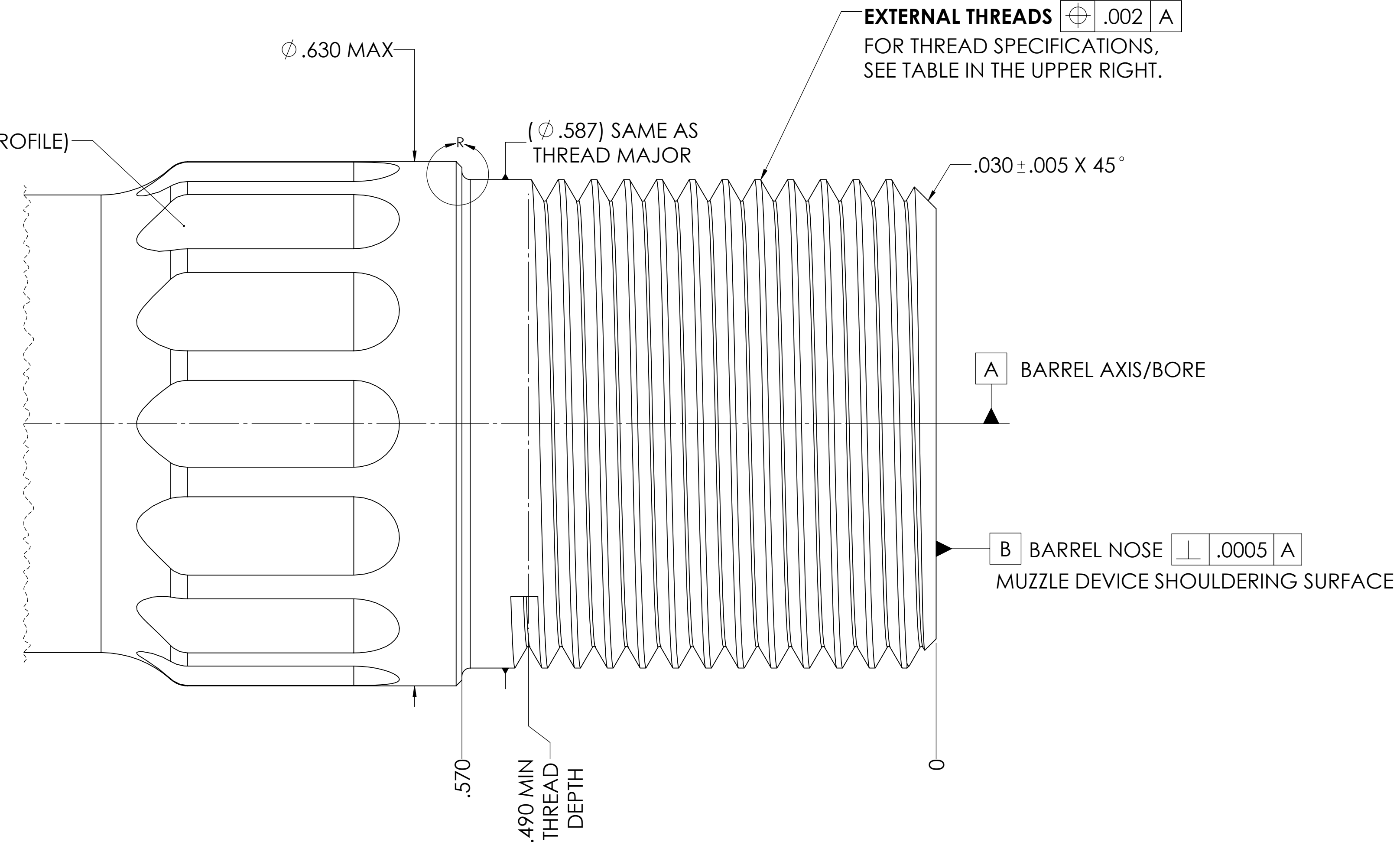
THREAD TYPE	M15 X 1-4H6H	M15 X 1-4G6G
	TIGHTER TOLERANCE & FIT, WILL WORK WITH SILENCERCO® ACCESSORIES	RECOMMENDED FOR UNIVERSAL FIT
PITCH ϕ	$\phi .5635 \pm .0015$	$\phi .5624 \pm .0015$
MAJOR ϕ	$\phi .5870 \pm .0035$	$\phi .5860 \pm .0035$
MINOR ϕ	$\phi .5479 \text{ MAX}$	$\phi .5469 \text{ MAX}$



(COSMETIC REPRESENTATION OF COMMON M15X1 BARREL PROFILE)



SECTION VIEW WITH M15X1 .30 CAL ASR FLASH HIDER (AC233).

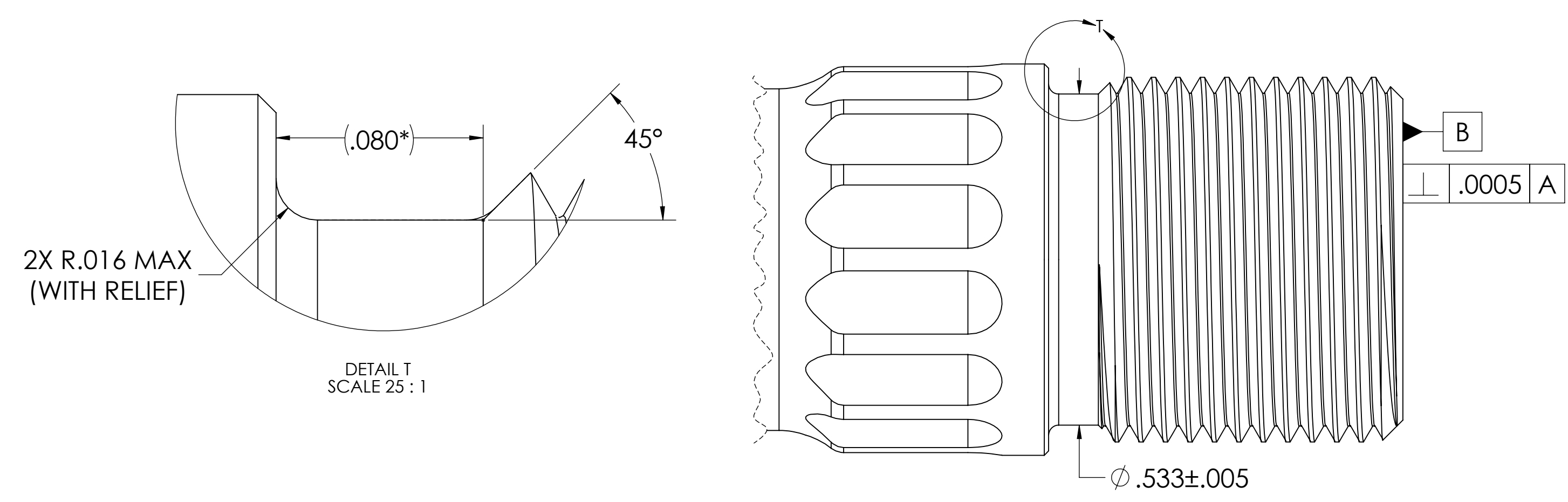


EXTERNAL THREADS $\oplus .002 \text{ A}$
FOR THREAD SPECIFICATIONS, SEE TABLE IN THE UPPER RIGHT.

A BARREL AXIS/BORE

B BARREL NOSE $\perp .0005 \text{ A}$
MUZZLE DEVICE SHOULDERING SURFACE

WITH OPTIONAL/RECOMMENDED THREAD RELIEF



DETAIL T SCALE 25:1

- MACHINIST NOTES:
UNLESS OTHERWISE SPECIFIED,
1. REMOVE BURRS/BREAK ALL EDGES TO A MAX OF .005.
2. GAGE ALL THREADS BETWEEN 1 TO 3 TURNS MAX OF NO-GO.
3. DIMENSIONS WITH " * " ARE TO A THEORETICAL INTERSECTION.
4. ALL NFA RULES APPLY TO RIFLE BARREL OVERALL LENGTH SELECTION.
ASSEMBLY NOTES:
5. AVOID USING A CRUSH WASHER.
6. UTILIZE ROCKSET OR ANOTHER HIGH-TEMPERATURE THREAD LOCKER.
7. TORQUE MUZZLE DEVICES BETWEEN 20-30 FT LBS.
8. FOR TIMING OF SILENCERCO MUZZLE BRAKES, USE THE SUPPLIED PRECISION SHIMS.

INTERPRET GEOMETRIC TOLERANCING PER ASME Y14.5-2018	PROPRIETARY AND CONFIDENTIAL
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ANGULAR: SURFACE FINISH: OR BETTER PERPENDICULARITY \perp : .001/INCH CIRCULARITY \circ : .0005	ENGINEER: Jared H. DATE: 3/4/2024

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WEST VALLEY, UT 84118

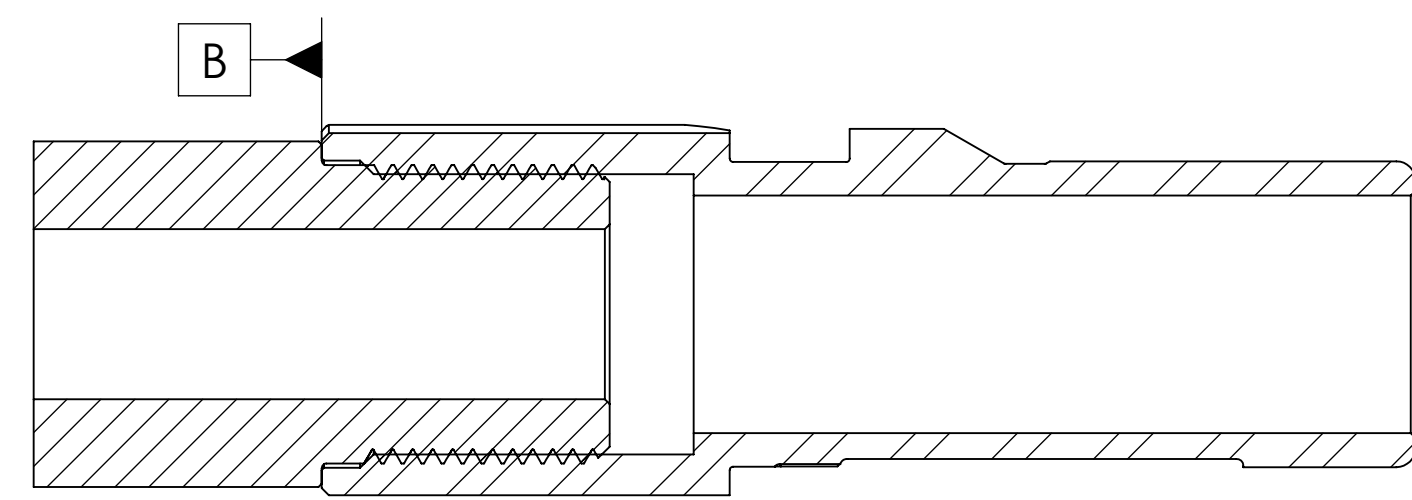
M15X1 CENTERFIRE RIFLE MUZZLE THREADS

SHEET SIZE **D** DRAWING REVISION **A1**
SCALE: 10:1 SHEET 5 OF 16

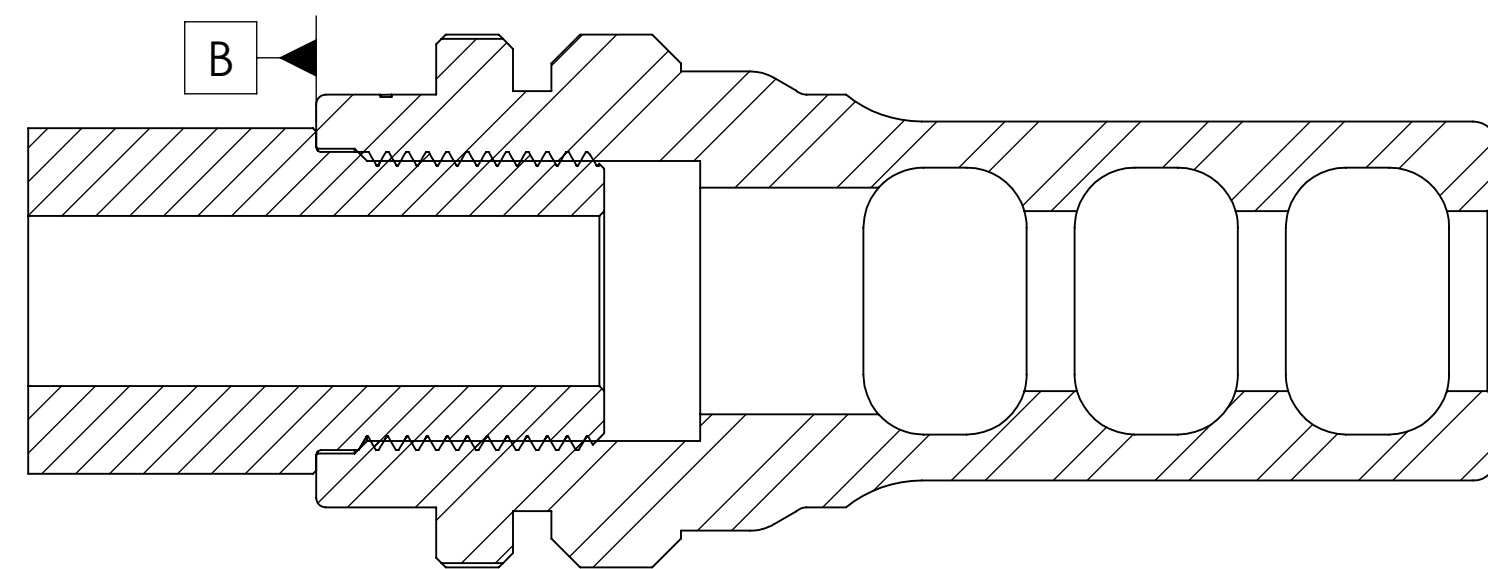
NOTE: 5/8-24 (.625-24) RIFLE BARREL THREAD IS MOST COMMONLY USED WITH 7.62MM/30 CALIBER THROUGH .458 CALIBER.

ALL SILENCERCO 5/8-24 CENTERFIRE RIFLE ACCESSORIES SHOULDER BEHIND THE THREADS, OR @ LOCATION **B**.

THREAD TYPE	.625-24 UNEF-3A	.625-24 UNEF-2A	.625-32 UN-3A
	TIGHTER TOLERANCE & FIT, WILL WORK WITH SILENCERCO ACCESSORIES	RECOMMENDED FOR UNIVERSAL FIT	TIGHTER TOLERANCE & FIT, WILL WORK WITH SILENCERCO ACCESSORIES
PITCH ϕ	$\phi .5964 \pm .0015$	$\phi .5947 \pm .0020$	$\phi .6033 \pm .0013$
MAJOR ϕ	$\phi .6214 \pm .0036$	$\phi .6202 \pm .0036$	$\phi .6220 \pm .0030$
MINOR ϕ	$\phi .5799 \text{ MAX}$	$\phi .5787 \text{ MAX}$	$\phi .5910 \text{ MAX}$

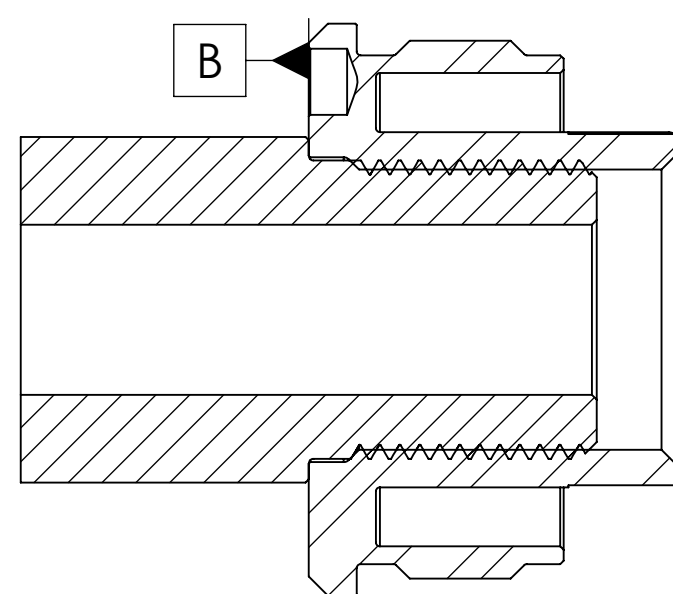


SECTION VIEW WITH 5/8 - 24 45 CAL 3 LUG MOUNT (AC2603). ALSO AVAILABLE IN 5/8 - 24 9MM (AC2609) FOR PISTOL CALIBER & SUBSONIC RIFLE APPLICATIONS.

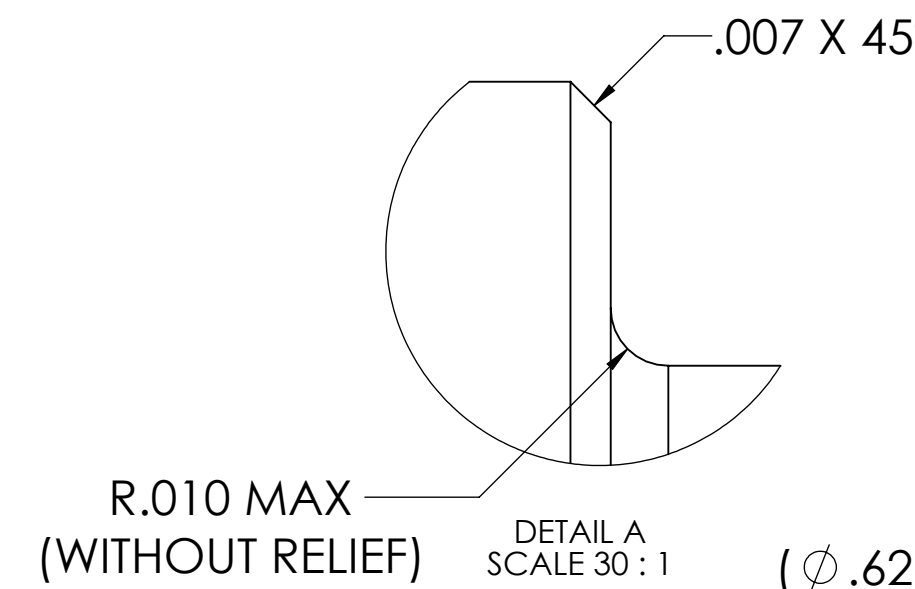


SECTION VIEW WITH 5/8 - 24 7.62/30 CAL ASR MUZZLE BRAKE (AC691). OTHER CALIBER MUZZLE BRAKES ARE AVAILABLE IN THE 5/8 - 24 THREAD PATTERN, SUCH AS: 6.5MM (AC4752), .338 CAL (AC857) & .458 CAL (AC1733).

A 5/8 - 32 .458 CAL ASR MUZZLE BRAKE (AC1557) & 5/8-24 THREAD OVER MUZZLE DEVICE (AC5233) ARE ALSO AVAILABLE.



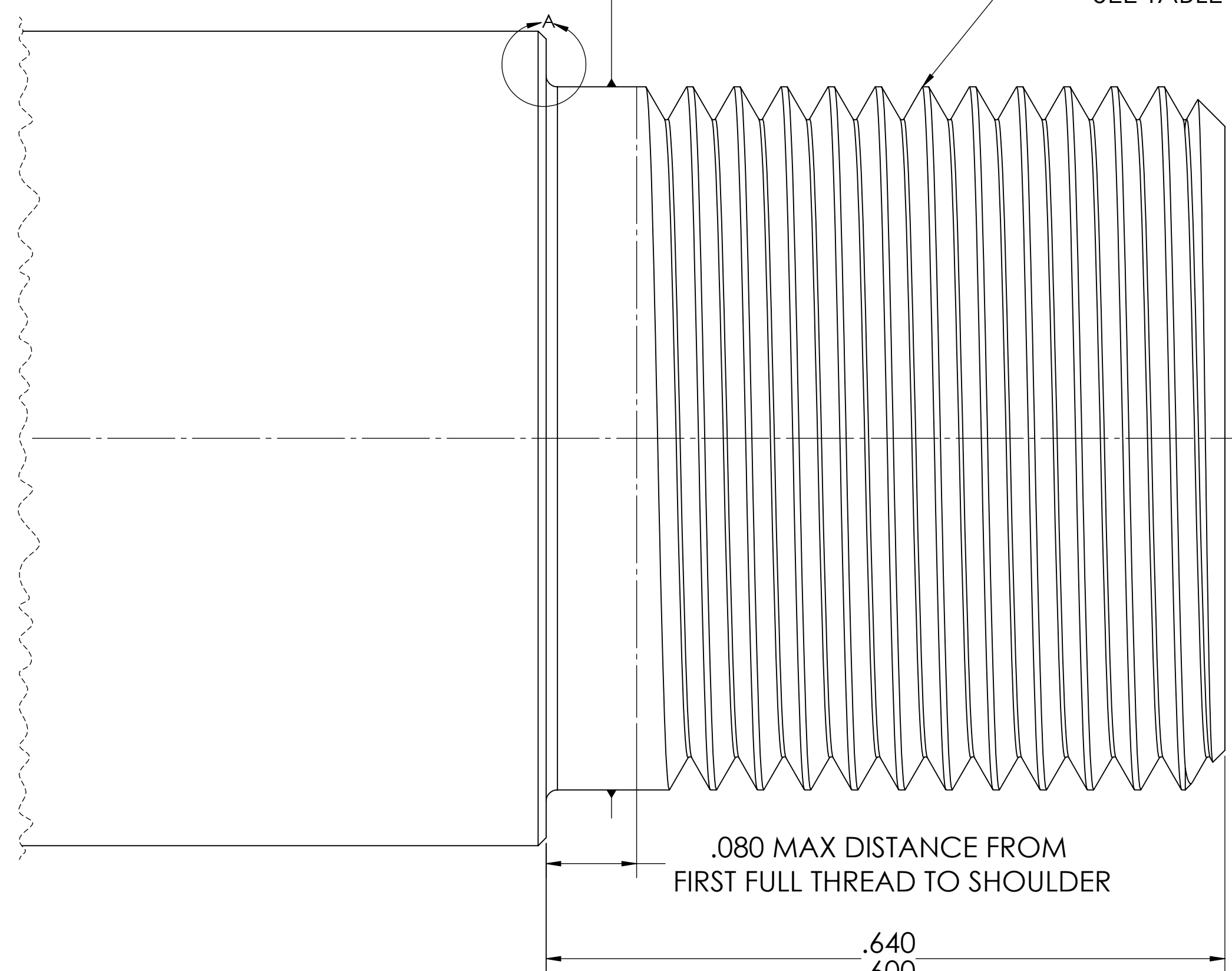
SECTION VIEW WITH 5/8 - 24 ALPHA DIRECT THREAD (AC634) CHARLIE 5/8 - 24 DT(AC4743) & BRAVO 5/8 - 24 DT (AC669) HAVE A SIMILAR INTERIOR THREAD PROFILE.



R.010 MAX (WITHOUT RELIEF) DETAIL A SCALE 30:1

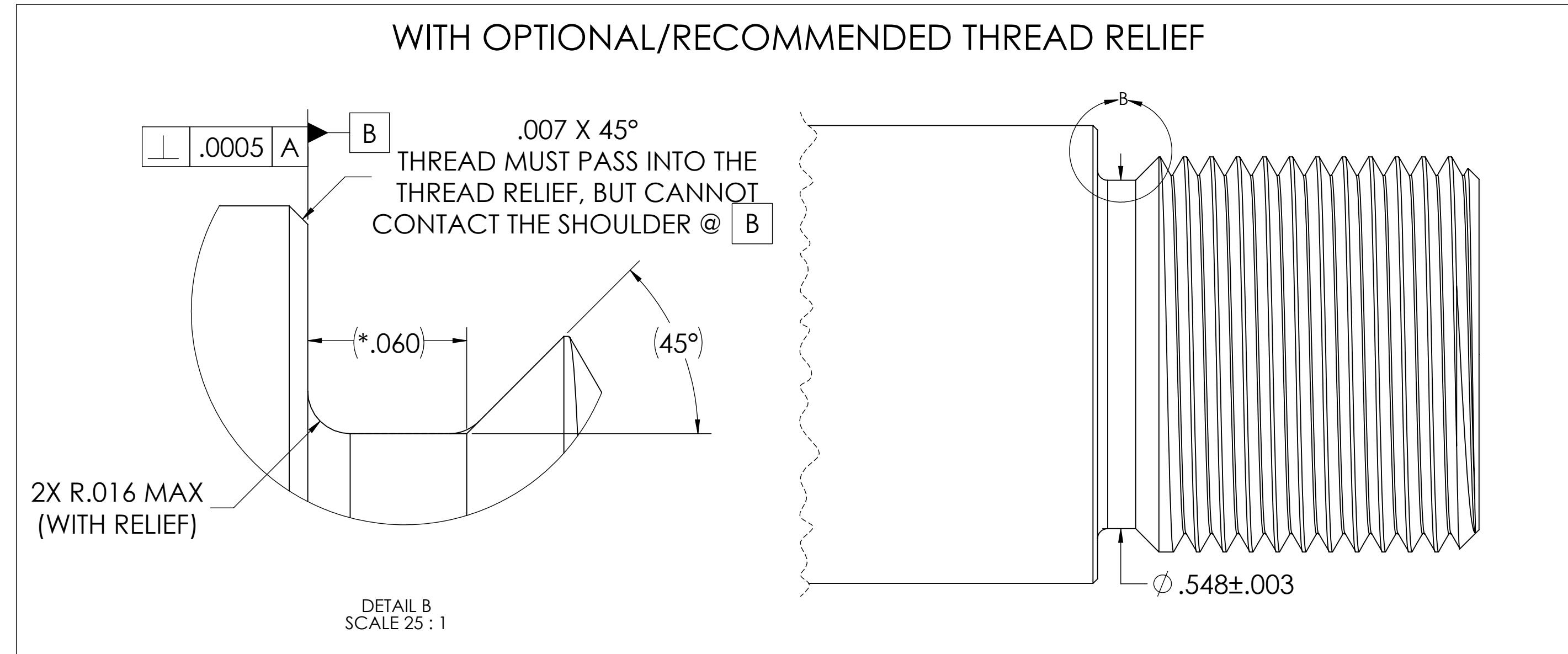
($\phi .621$) SAME AS THREAD MAJOR

EXTERNAL THREADS $\oplus .002$ A FOR THREAD SPECIFICATIONS, SEE TABLE IN THE UPPER RIGHT.



MUZZLE DEVICE SHOULDERING SURFACE **B** $\perp .0005$ A

- MACHINIST NOTES:
UNLESS OTHERWISE SPECIFIED,
1. REMOVE BURRS/BREAK ALL EDGES TO A MAX OF .005.
2. GAGE ALL THREADS BETWEEN 1 TO 3 TURNS MAX OF NO-GO.
3. DIMENSIONS WITH " * " ARE TO A THEORETICAL INTERSECTION.
4. ALL NFA RULES APPLY TO RIFLE BARREL OVERALL LENGTH SELECTION.
- ASSEMBLY NOTES:
5. AVOID USING A CRUSH WASHER.
6. UNLESS TIMING WITH SHIMS, ENSURE THERE'S NO VISIBLE GAP BETWEEN THE MUZZLE DEVICE AND LOCATION **B**.
7. UTILIZE ROCKSET OR ANOTHER HIGH-TEMPERATURE THREAD LOCKER.
8. TORQUE MUZZLE DEVICES BETWEEN 20-30 FT LBS.
9. FOR TIMING OF SILENCERCO MUZZLE BRAKES, USE THE SUPPLIED PRECISION SHIMS.



2X R.016 MAX (WITH RELIEF)

DETAIL B SCALE 25:1

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ANGULAR SURFACE FINISH: OR BETTER PERPENDICULARITY \perp : .001/INCH CIRCULARITY \circ : .0005	ENGINEER DATE SHEET SIZE DRAWING REVISION Jared H. 3/4/2024 D A1

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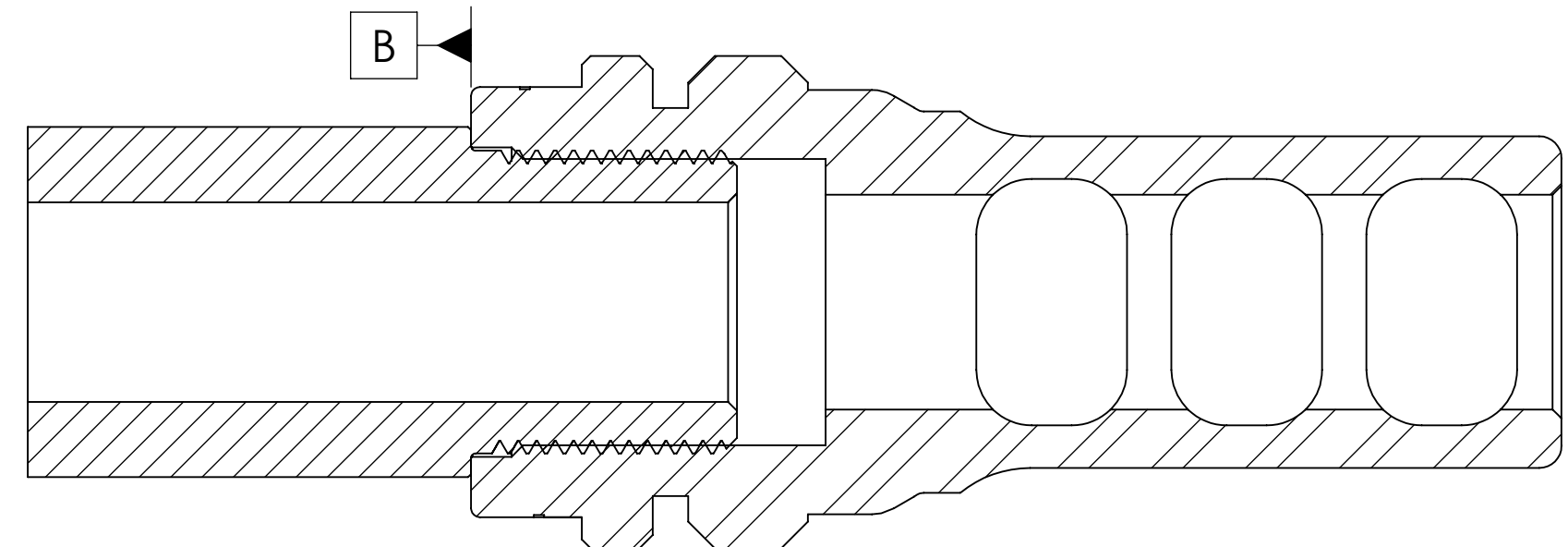
.625-24 & .625-32 CENTERFIRE RIFLE MUZZLE THREADS

SCALE: 10:1 SHEET 6 OF 16

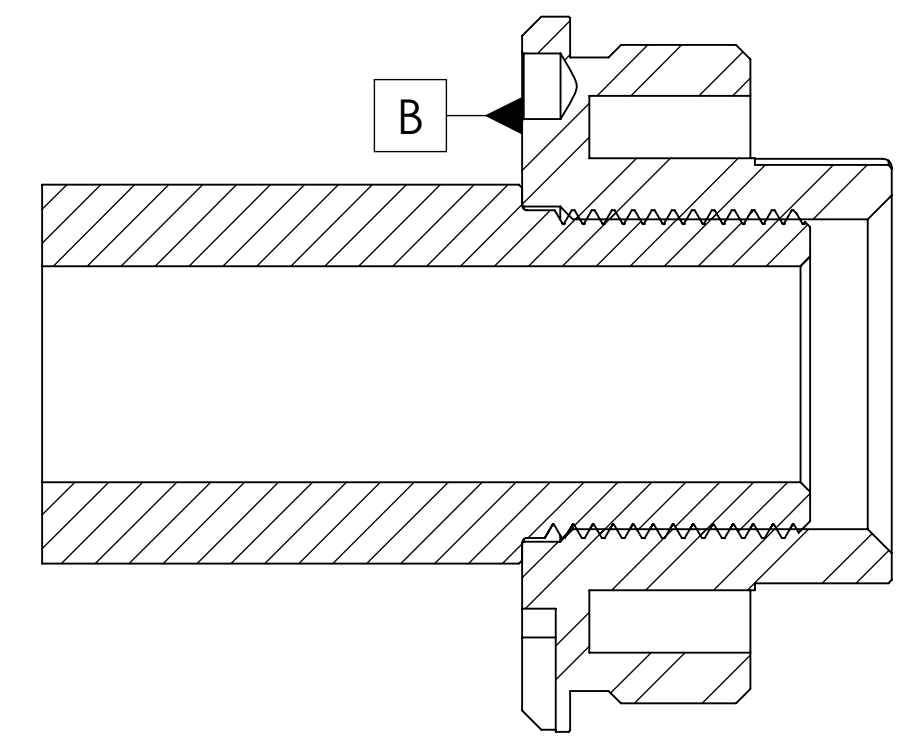
NOTE: 11/16 - 24 (.6875-24) RIFLE BARREL THREADS ARE MOST COMMONLY USED WITH .450 CALIBER RIFLES.

ALL SILENCERCO 11/16 - 24 CENTERFIRE RIFLE ACCESSORIES SHOULDER BEHIND THE THREADS, OR @ LOCATION **B**.

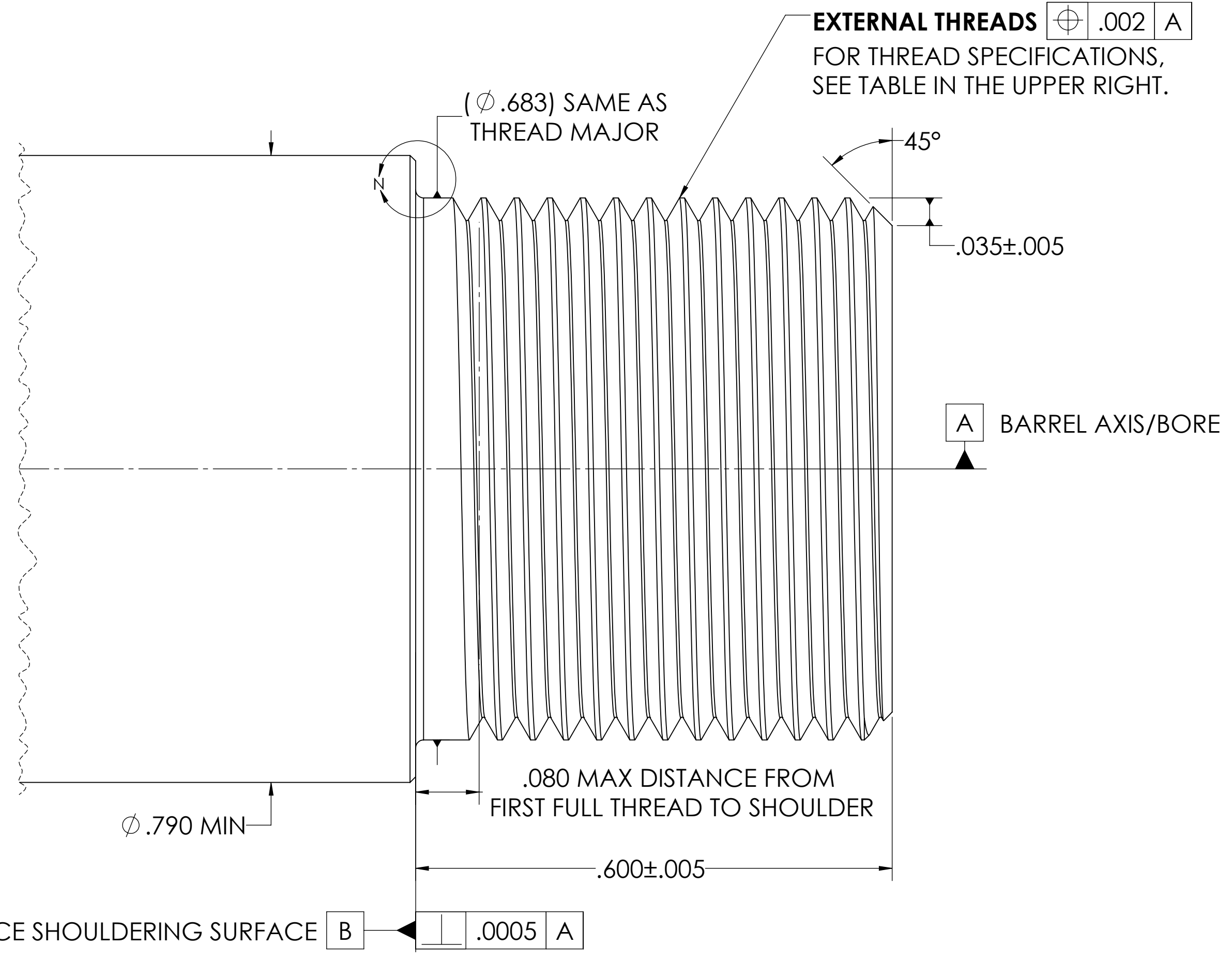
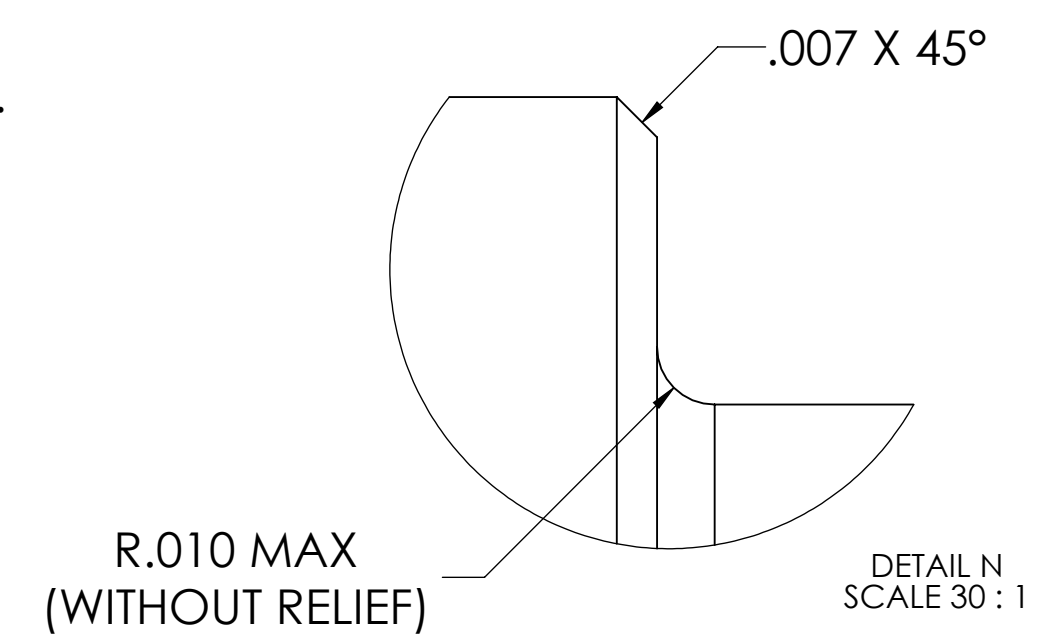
THREAD TYPE	.6875-24 UNEF-3A	.6875-24 UNEF-2A
	TIGHTER TOLERANCE & FIT, WILL WORK WITH SILENCERCO ACCESSORIES	RECOMMENDED FOR UNIVERSAL FIT
PITCH ϕ	$\phi .6589 \pm .0015$	$\phi .6572 \pm .0020$
MAJOR ϕ	$\phi .6839 \pm .0036$	$\phi .6827 \pm .0036$
MINOR ϕ	$\phi .6379$ MAX	$\phi .6367$ MAX



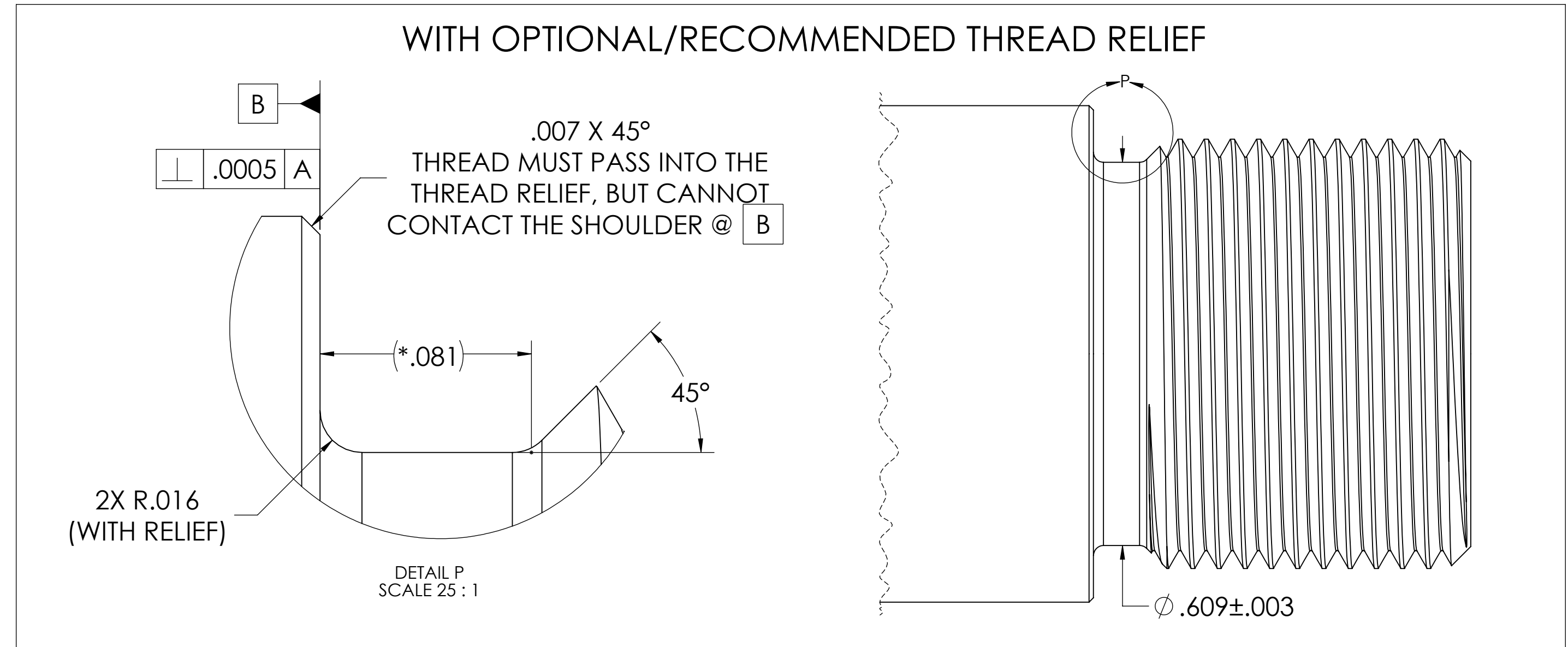
SECTION VIEW WITH 11/16 - 24 .458 CAL ASR MUZZLE BRAKE (AC1961).



SECTION VIEW WITH 11/16 - 24 BRAVO DIRECT THREAD (AC2439)
CHARLIE 11/16 - 24 DT(AC4741) HAS A SIMILAR INTERIOR THREAD PROFILE.



MUZZLE DEVICE SHOULDERING SURFACE **B** \perp .0005 **A**



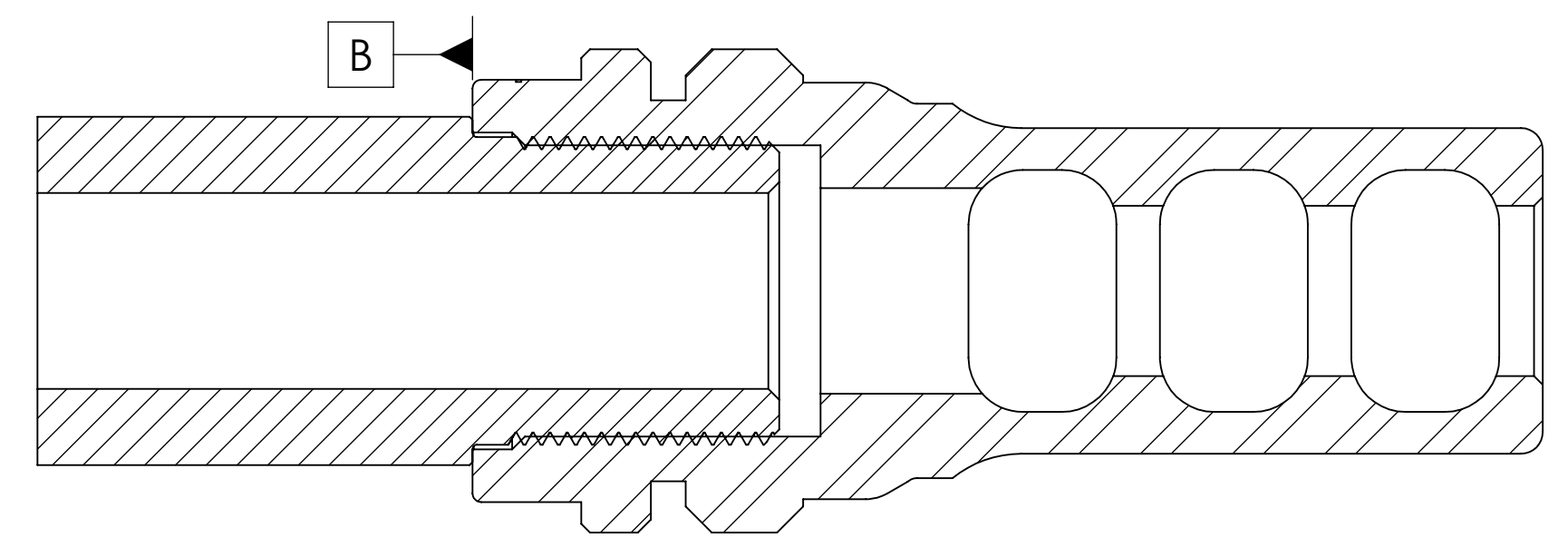
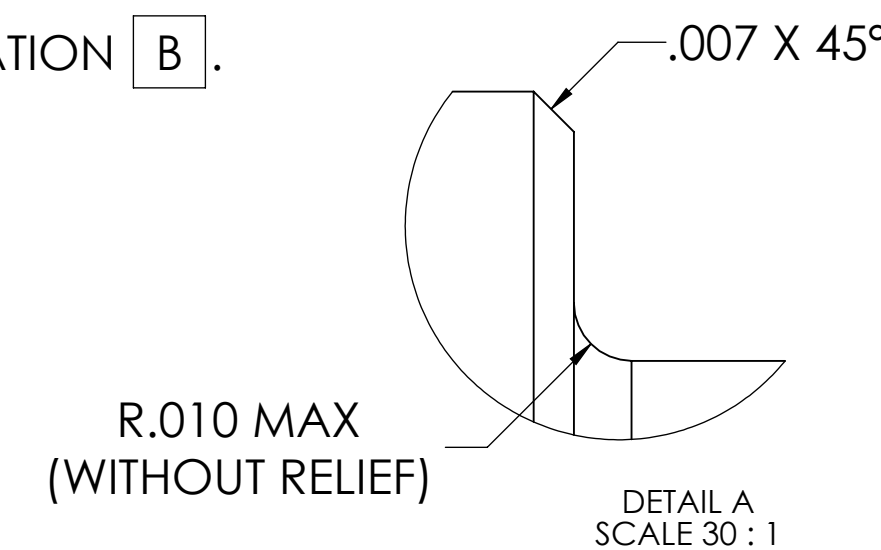
- MACHINIST NOTES:**
UNLESS OTHERWISE SPECIFIED,
1. REMOVE BURRS/BREAK ALL EDGES TO A MAX OF .005.
 2. GAGE ALL THREADS BETWEEN 1 TO 3 TURNS MAX OF NO-GO.
 3. DIMENSIONS WITH "*" ARE TO A THEORETICAL INTERSECTION.
 4. ALL NFA RULES APPLY TO RIFLE BARREL OVERALL LENGTH SELECTION.
- ASSEMBLY NOTES:**
5. AVOID USING A CRUSH WASHER.
 6. UNLESS TIMING WITH SHIMS, ENSURE THERE'S NO VISIBLE GAP BETWEEN THE MUZZLE DEVICE AND LOCATION **B**.
 7. UTILIZE ROCKSET OR ANOTHER HIGH-TEMPERATURE THREAD LOCKER.
 8. TORQUE MUZZLE DEVICES BETWEEN 20-30 FT LBS.
 9. FOR TIMING OF SILENCERCO MUZZLE BRAKES, USE THE SUPPLIED PRECISION SHIMS.

INTERPRET GEOMETRIC TOLERANCING PER ASME Y14.5-2018	PROPRIETARY AND CONFIDENTIAL	<p>SILENCERCO, LLC 5511 S 6055 W WEST VALLEY, UT 84118</p>								
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCH TOLERANCE DECIMALS:	THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF SILENCERCO, LLC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF SILENCERCO, LLC IS PROHIBITED.									
ANGULAR: SURFACE FINISH: OR BETTER PERPENDICULARITY: CIRCULARITY:	<table border="1"> <tr> <td>ENGINEER</td> <td>DATE</td> <td>SHEET SIZE</td> <td>DRAWING REVISION</td> </tr> <tr> <td>Jared H.</td> <td>3/4/2024</td> <td>D</td> <td>A1</td> </tr> </table>	ENGINEER	DATE	SHEET SIZE	DRAWING REVISION	Jared H.	3/4/2024	D	A1	<p>.6875-24 CENTERFIRE RIFLE MUZZLE THREADS</p> <p>SCALE: 10:1</p>
ENGINEER	DATE	SHEET SIZE	DRAWING REVISION							
Jared H.	3/4/2024	D	A1							

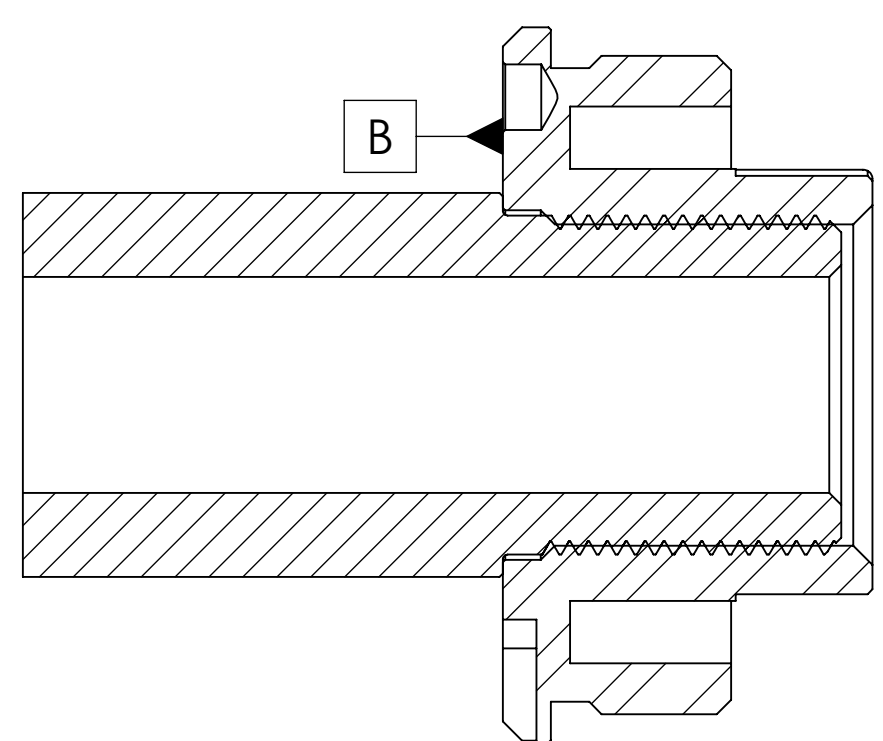
NOTE: M18X1 & M18X1.5 RIFLE BARREL THREADS ARE MOST COMMONLY USED WITH .338 CALIBER RIFLES.

ALL SILENCERCO M18X1 & M18X1.5 CENTERFIRE RIFLE ACCESSORIES SHOULDER BEHIND THE THREADS, OR @ LOCATION **B**.

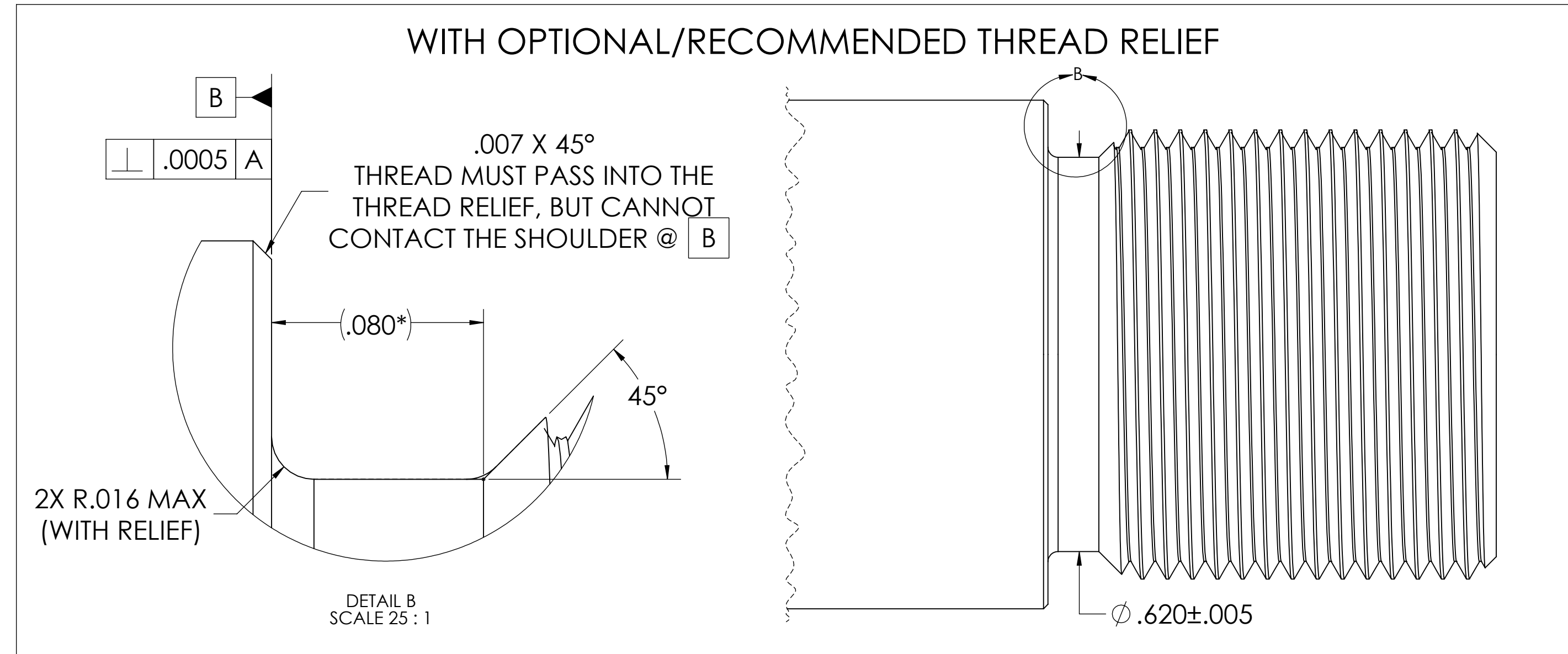
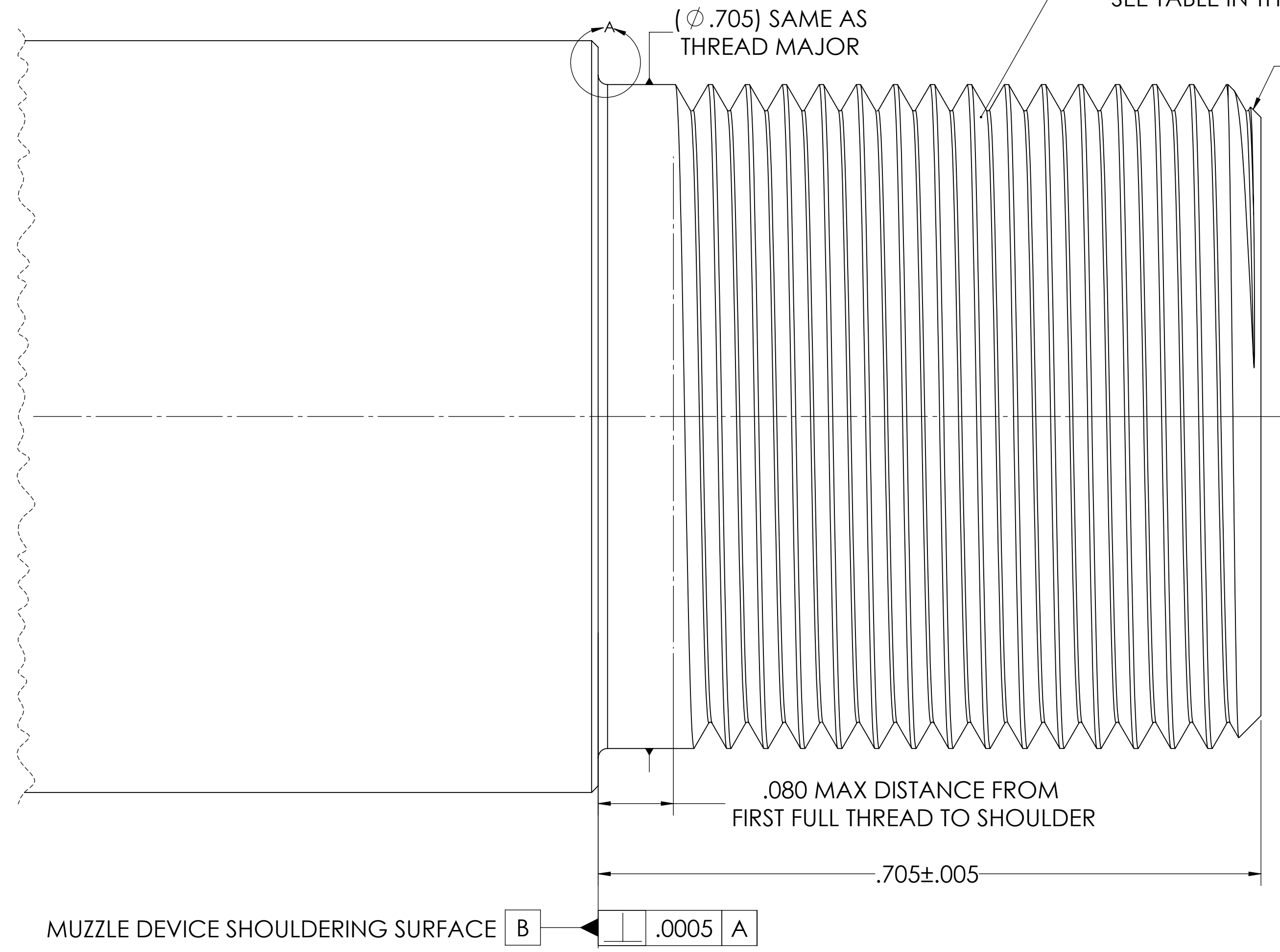
THREAD TYPE	M18 X 1-4H6H	M18 X 1-4G6G	M18 X 1.5-4H6H	M18 X 1.5-4G6G
	TIGHTER TOLERANCE & FIT, WILL WORK WITH SILENCERCO ACCESSORIES	RECOMMENDED FOR UNIVERSAL FIT	TIGHTER TOLERANCE & FIT, WILL WORK WITH SILENCERCO ACCESSORIES	RECOMMENDED FOR UNIVERSAL FIT
PITCH ϕ	$\phi .6815 \pm .0015$	$\phi .6806 \pm .0015$	$\phi .6685 \pm .0018$	$\phi .6672 \pm .0018$
MAJOR ϕ	$\phi .7051 \pm .0035$	$\phi .7040 \pm .0035$	$\phi .7040 \pm .0046$	$\phi .7027 \pm .0046$
MINOR ϕ	$\phi .6660 \text{ MAX}$	$\phi .6650 \text{ MAX}$	$\phi .6447 \text{ MAX}$	$\phi .6434 \text{ MAX}$



SECTION VIEW WITH M18X1 .338 CAL ASR MUZZLE BRAKE (AC856).
A M18X1.5 .338 CAL ASR MUZZLE BRAKE (AC855) IS ALSO AVAILABLE.



SECTION VIEW WITH M18X1 BRAVO DIRECT THREAD (AC690)
A M18X1.5 BRAVO DIRECT THREAD (AC735) IS ALSO AVAILABLE.



- MACHINIST NOTES:
UNLESS OTHERWISE SPECIFIED,
1. REMOVE BURRS/BREAK ALL EDGES TO A MAX OF .005.
 2. GAGE ALL THREADS BETWEEN 1 TO 3 TURNS MAX OF NO-GO.
 3. DIMENSIONS WITH "*" ARE TO A THEORETICAL INTERSECTION.
 4. ALL NFA RULES APPLY TO RIFLE BARREL OVERALL LENGTH SELECTION.
- ASSEMBLY NOTES:
5. AVOID USING A CRUSH WASHER.
 6. UNLESS TIMING WITH SHIMS, ENSURE THERE'S NO VISIBLE GAP BETWEEN THE MUZZLE DEVICE AND LOCATION **B**.
 7. UTILIZE ROCKSET OR ANOTHER HIGH-TEMPERATURE THREAD LOCKER.
 8. TORQUE MUZZLE DEVICES BETWEEN 20-30 FT LBS.
 9. FOR TIMING OF SILENCERCO MUZZLE BRAKES, USE THE SUPPLIED PRECISION SHIMS.

INTERPRET GEOMETRIC TOLERANCING PER ASME Y14.5-2018	PROPRIETARY AND CONFIDENTIAL
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ANGULAR: $\pm .5^\circ$	ENGINEER: Jared H.
SURFACE FINISH: OR BETTER	DATE: 3/4/2024
PERPENDICULARITY: $\perp .001$ /INCH	SHEET SIZE: D
CIRCULARITY: $\bigcirc .0005$	DRAWING REVISION: A1
	SCALE: 10:1
	SHEET 8 OF 16

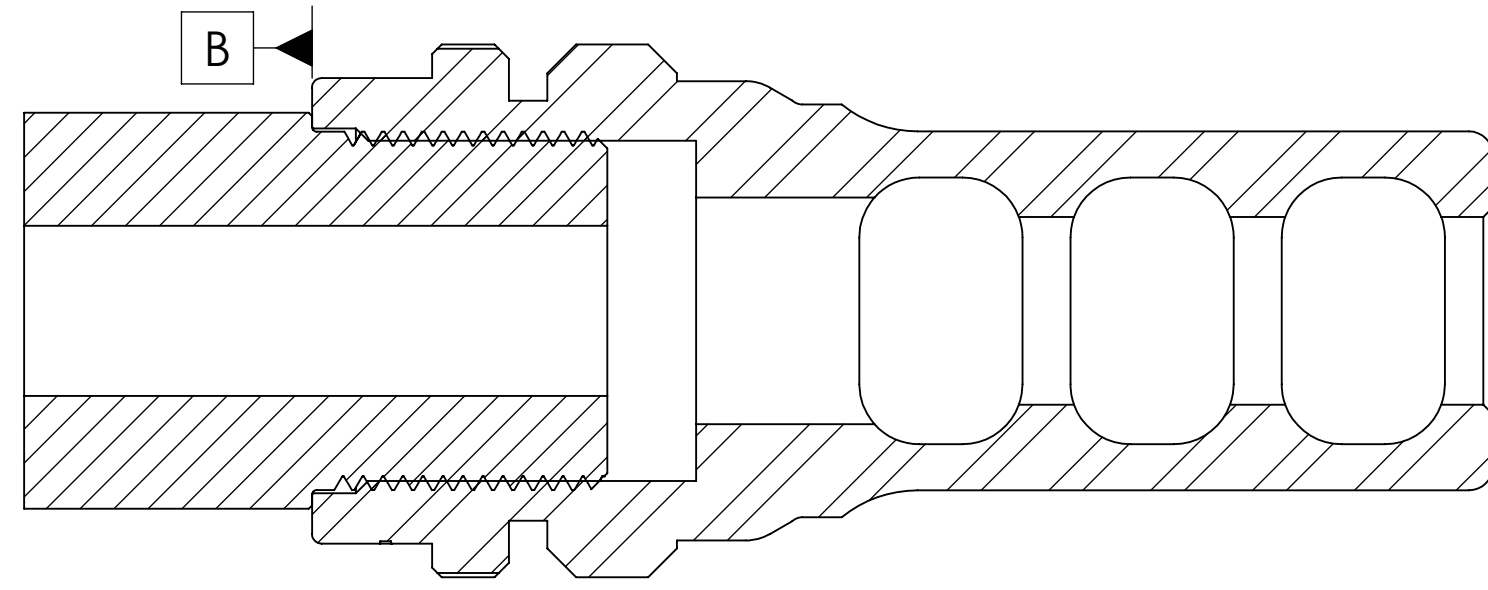
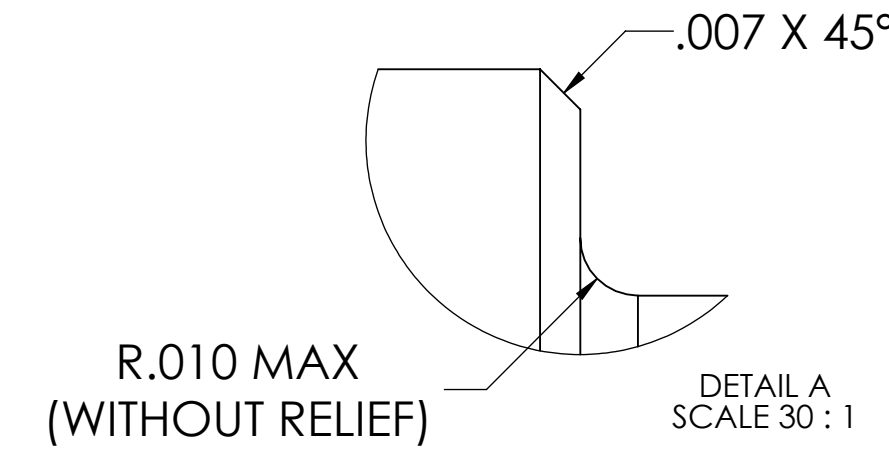
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M18X1/M18X1.5
CENTERFIRE RIFLE MUZZLE
THREADS

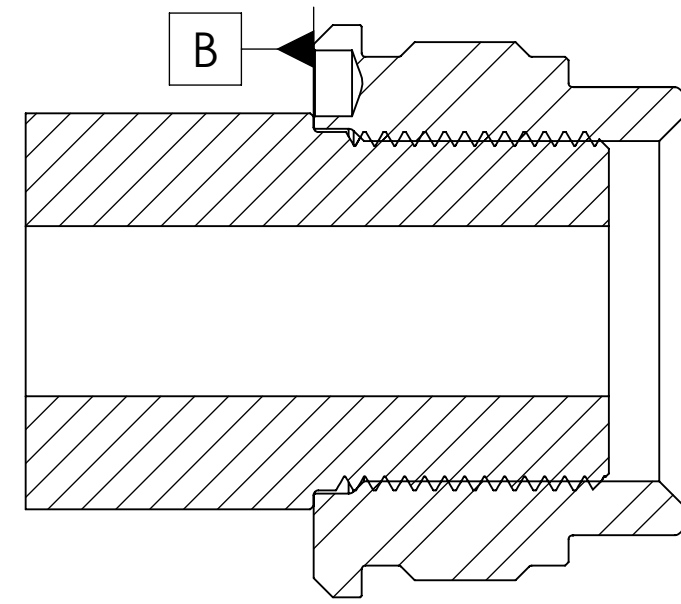
NOTE: 3/4-24 (.750-24) RIFLE BARREL THREADS ARE MOST COMMONLY USED WITH .338 CALIBER TO .458 CALIBER.
 3/4 - 20 (.750-20) RIFLE BARREL THREADS ARE LESS COMMON (BARRETT 98B/OLDER MRAD, ETC.) SILENCERCO OFFERS
 A 3/4 - 20 BRAVO DIRECT THREAD MOUNT (AC4757)

ALL SILENCERCO 3/4 - 24 CENTERFIRE RIFLE ACCESSORIES SHOULD BE POSITIONED BEHIND THE THREADS, OR @ LOCATION **B**.

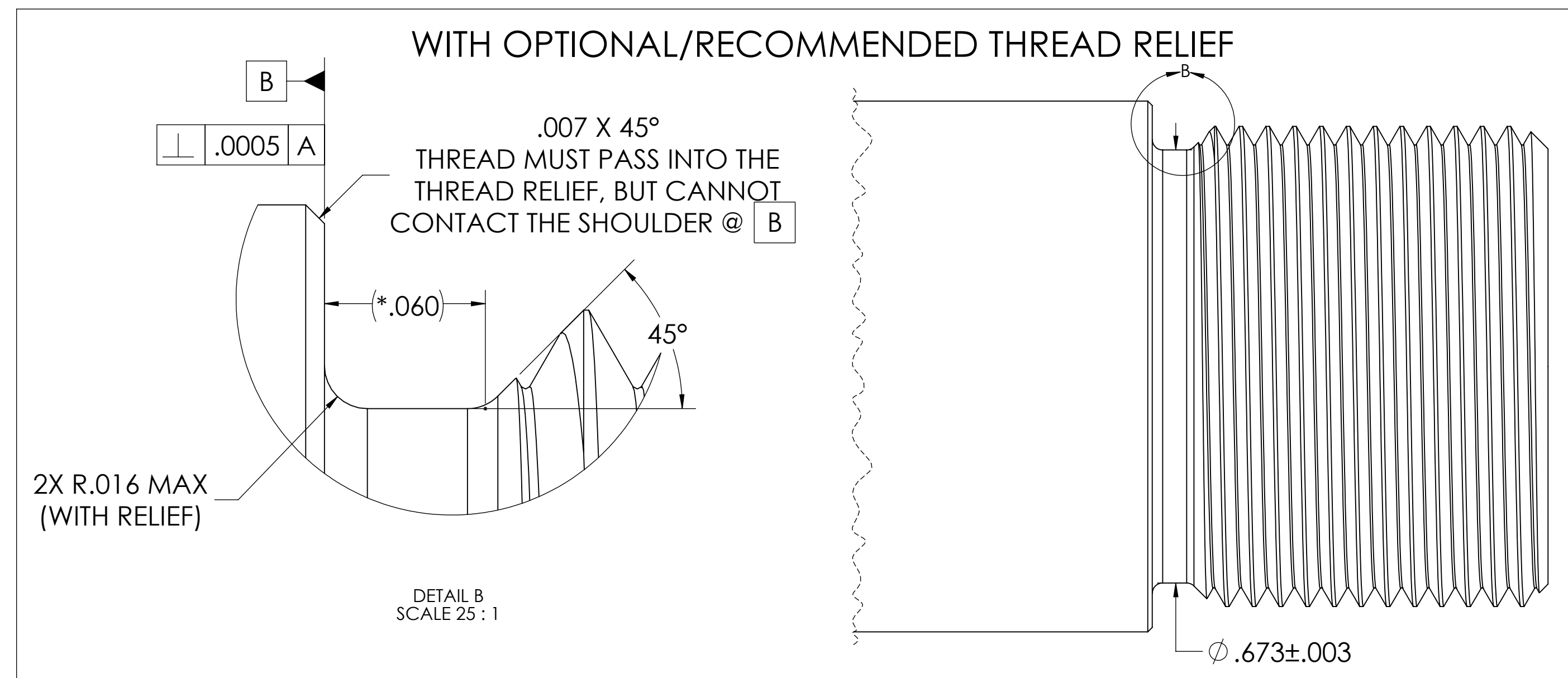
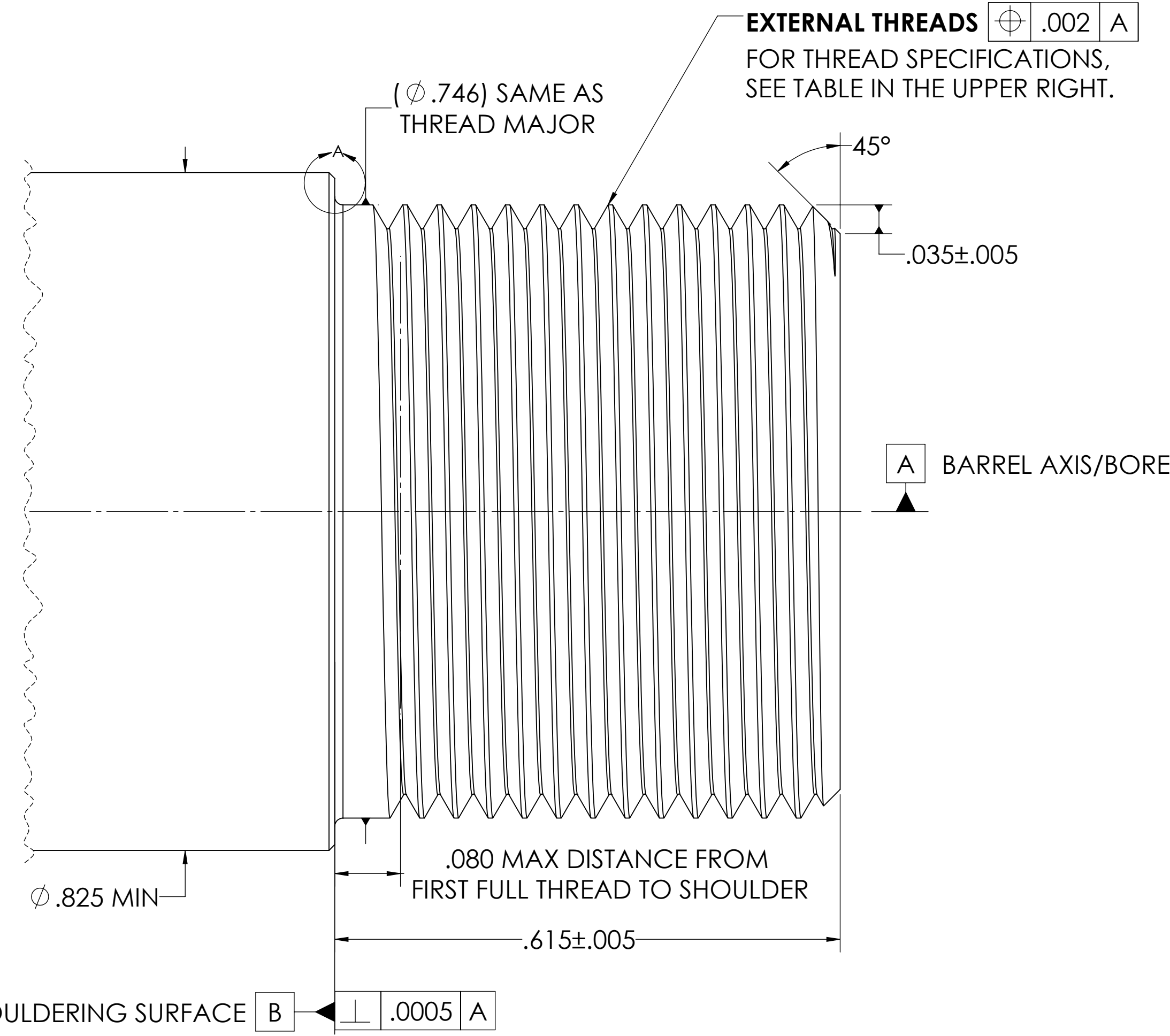
THREAD TYPE	.750-24 UNEF-3A	.750-24 UNEF-2A	.750-20 UNEF-3A
	TIGHTER TOLERANCE & FIT, WILL WORK WITH SILENCERCO ACCESSORIES	RECOMMENDED FOR UNIVERSAL FIT	TIGHTER TOLERANCE & FIT, WILL WORK WITH SILENCERCO ACCESSORIES
PITCH ϕ	$\phi .7213 \pm .0015$	$\phi .7196 \pm .0020$	$\phi .7158 \pm .0016$
MAJOR ϕ	$\phi .7464 \pm .0036$	$\phi .7452 \pm .0036$	$\phi .7459 \pm .0040$
MINOR ϕ	$\phi .7049 \text{ MAX}$	$\phi .7037 \text{ MAX}$	$\phi .6959 \text{ MAX}$



SECTION VIEW WITH 3/4 - 24 .458 CAL ASR MUZZLE BRAKE (AC2631).
 A 3/4 - 24 .338 CAL ASR MUZZLE BRAKE (AC858) IS ALSO AVAILABLE FROM SILENCERCO.



SECTION VIEW WITH 3/4 - 24 ALPHA DIRECT THREAD (AC668)
 CHARLIE 3/4 - 24 DT (AC4742) & BRAVO 3/4 - 24 DT (AC668)
 HAVE A SIMILAR INTERIOR THREAD PROFILE.



- MACHINIST NOTES:
 UNLESS OTHERWISE SPECIFIED,
 1. REMOVE BURRS/BREAK ALL EDGES TO A MAX OF .005.
 2. GAGE ALL THREADS BETWEEN 1 TO 3 TURNS MAX OF NO-GO.
 3. DIMENSIONS WITH " * " ARE TO A THEORETICAL INTERSECTION.
 4. ALL NFA RULES APPLY TO RIFLE BARREL OVERALL LENGTH SELECTION.
 ASSEMBLY NOTES:
 5. AVOID USING A CRUSH WASHER.
 6. UNLESS TIMING WITH SHIMS, ENSURE THERE'S NO VISIBLE GAP BETWEEN THE MUZZLE DEVICE AND LOCATION **B**.
 7. UTILIZE ROCKSET OR ANOTHER HIGH-TEMPERATURE THREAD LOCKER.
 8. TORQUE MUZZLE DEVICES BETWEEN 20-30 FT LBS.
 9. FOR TIMING OF SILENCERCO MUZZLE BRAKES, USE THE SUPPLIED PRECISION SHIMS.

INTERPRET GEOMETRIC TOLERANCING PER ASME Y14.5-2018	PROPRIETARY AND CONFIDENTIAL
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ANGULAR: SURFACE FINISH: OR BETTER PERPENDICULARITY \perp : .001/INCH CIRCULARITY \bigcirc : .0005	ENGINEER: Jared H. DATE: 3/4/2024
	SHEET SIZE: D DRAWING REVISION: A1
	SCALE: 10:1 SHEET 9 OF 16

SILENCERCO, LLC
 5511 S 6055 W
 WEST VALLEY, UT 84118

.750-24/.750-20
CENTERFIRE RIFLE MUZZLE
THREADS



SILENCERCO

MUZZLE THREAD GUIDE

PART 2 OF 2: THIS DOCUMENT SERVES AS A GUIDE DETAILING RECOMMENDED MACHINING TOLERANCES AND THE COMPATIBILITY OF **RIMFIRE & CENTERFIRE PISTOL MUZZLE THREADS** WITH SILENCERCO ACCESSORIES. WHILE THESE SPECIFICATIONS AND TOLERANCES MAY ALIGN WITH SOME OTHER MANUFACTURERS' PRODUCTS AND EXHIBIT COMMONALITY WITH MOST OF SAAMI'S SPECIFICATIONS, THE RESPONSIBILITY FOR ANY DAMAGE, INJURY, OR INCOMPATIBILITY WITH OTHER MANUFACTURERS' PRODUCTS RESTS WITH THE END USER AND/OR THE MACHINIST. IF THE FACTORY BARREL CROWN IS REMOVED DURING THE MACHINING PROCESS, IT IS THE RESPONSIBILITY OF THE MACHINIST TO CUT A NEW CROWN.

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**SECTION 2: RIMFIRE
& CENTERFIRE PISTOL
MUZZLE THREADS**

DRAFTER
Jared H.

DATE
3/4/2024

SHEET
SIZE
D

SCALE: 2:1

DRAWING
REVISION
A1

SHEET 10 OF 16

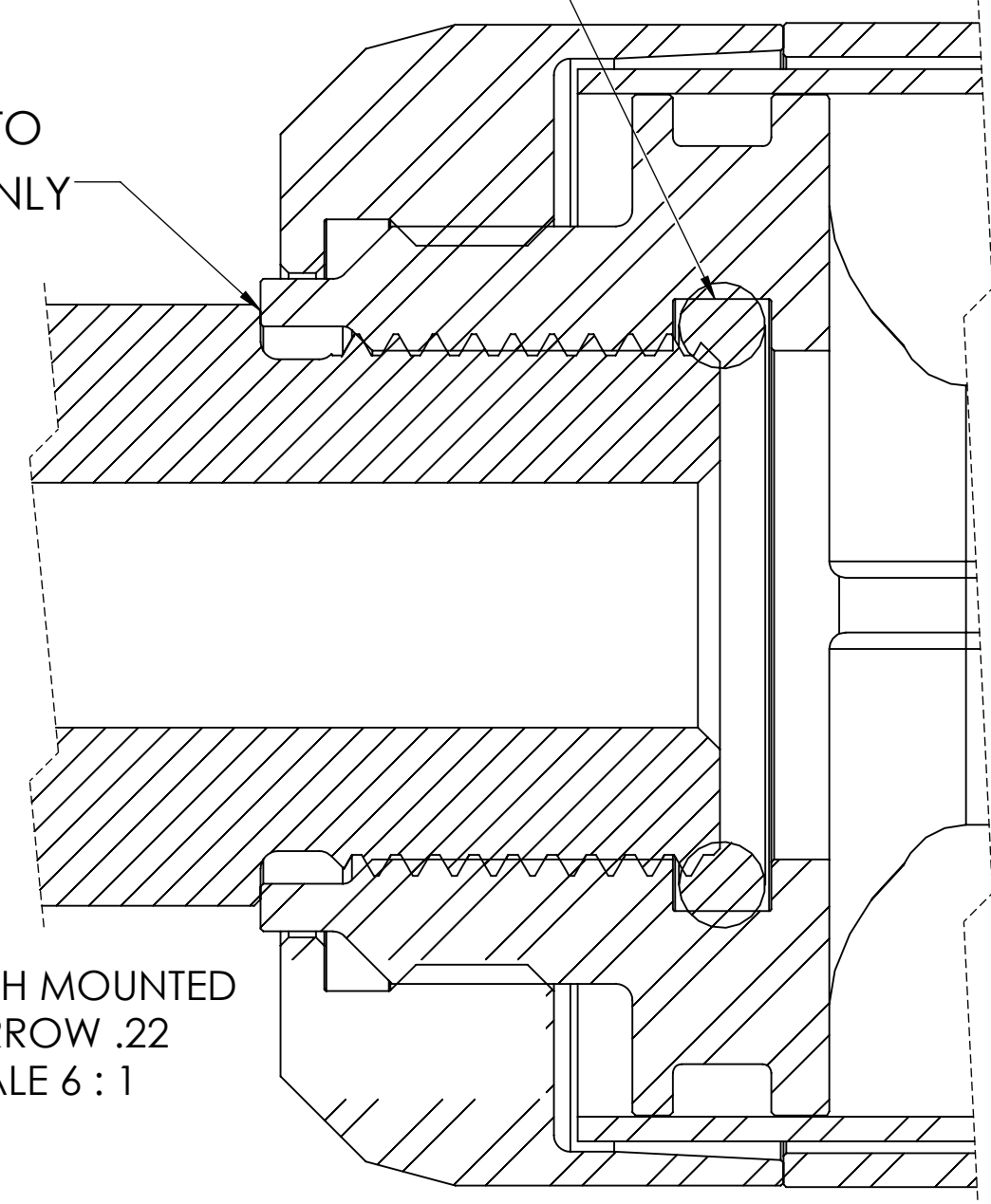
NOTE: 1/2-28 (.500-28) IS A COMMON RIMFIRE BARREL THREAD FOR .17 TO .22 CALIBER CHAMBERED FIREARMS. ALL OF SILENCERCO'S® DELTA ADAPTERS & RIMFIRE CANS ARE EQUIPPED WITH 1/2-28 "SPARROW PROFILE" THREADS. ALL SILENCERCO® 1/2 -28 RIMFIRE PISTOL ACCESSORIES SHOULDER BEHIND THE THREADS, OR @ LOCATION **B**.

.500-28 STANDARD RIMFIRE MUZZLE THREADS

THREADS INTO O-RING, NOT OPTIMAL FOR THE O-RING'S DURABILITY, BUT IT DOES ASSIST IN REDUCING THE PENETRATION OF CARBON AND GASES WITHIN THE THREADS.

THREAD DESIGNED TO SHOULDER @ **B** ONLY

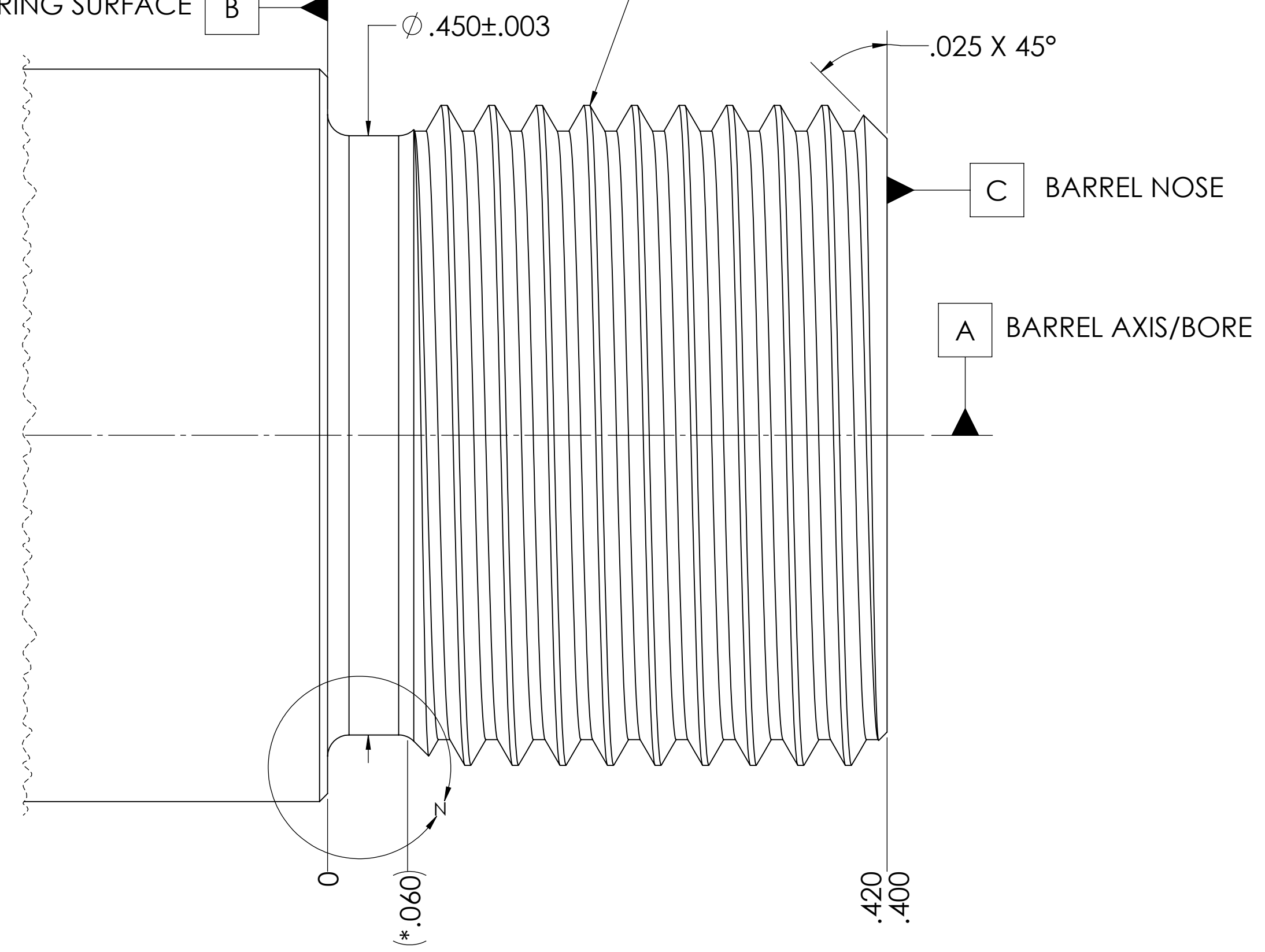
VIEW WITH MOUNTED SPARROW .22 SCALE 6 : 1



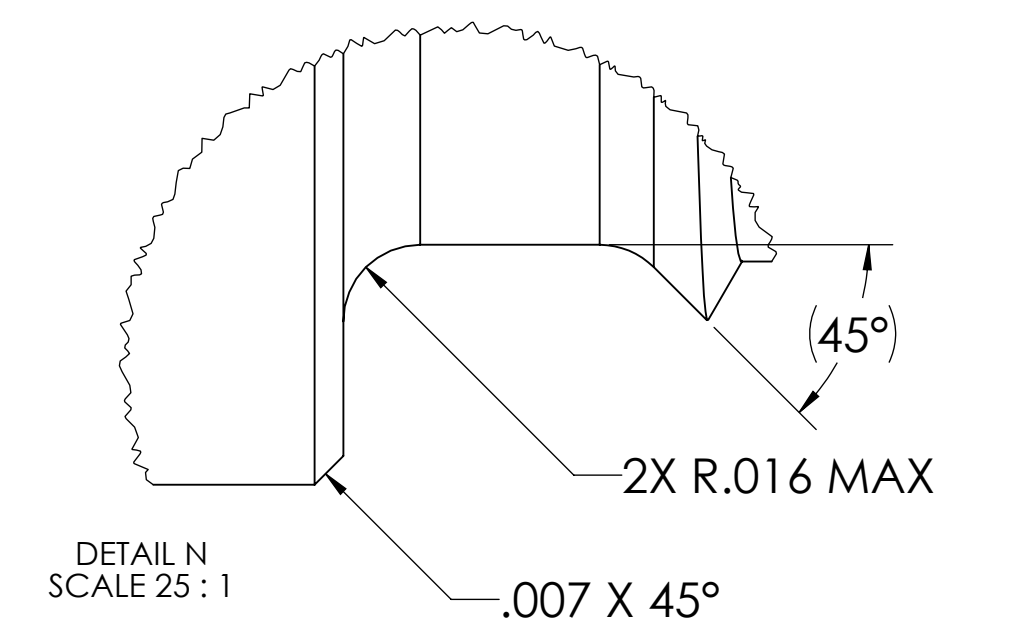
BEHIND THREAD SHOULDERING SURFACE **B**

\perp .0005 **A**

EXTERNAL THREADS \oplus 0.002 **A**
FOR THREAD SPECIFICATIONS, SEE TABLE IN THE UPPER RIGHT.



THREAD TYPE	.500-28 UNEF-3A	.500-28 UNS-2A
	TIGHTER TOLERANCE & FIT, WILL WORK WITH SILENCERCO® ACCESSORIES	
PITCH ϕ	$\phi .4754 \pm .0014$	$\phi .4739 \pm .0019$
MAJOR ϕ	$\phi .4967 \pm .0032$	$\phi .4957 \pm .0033$

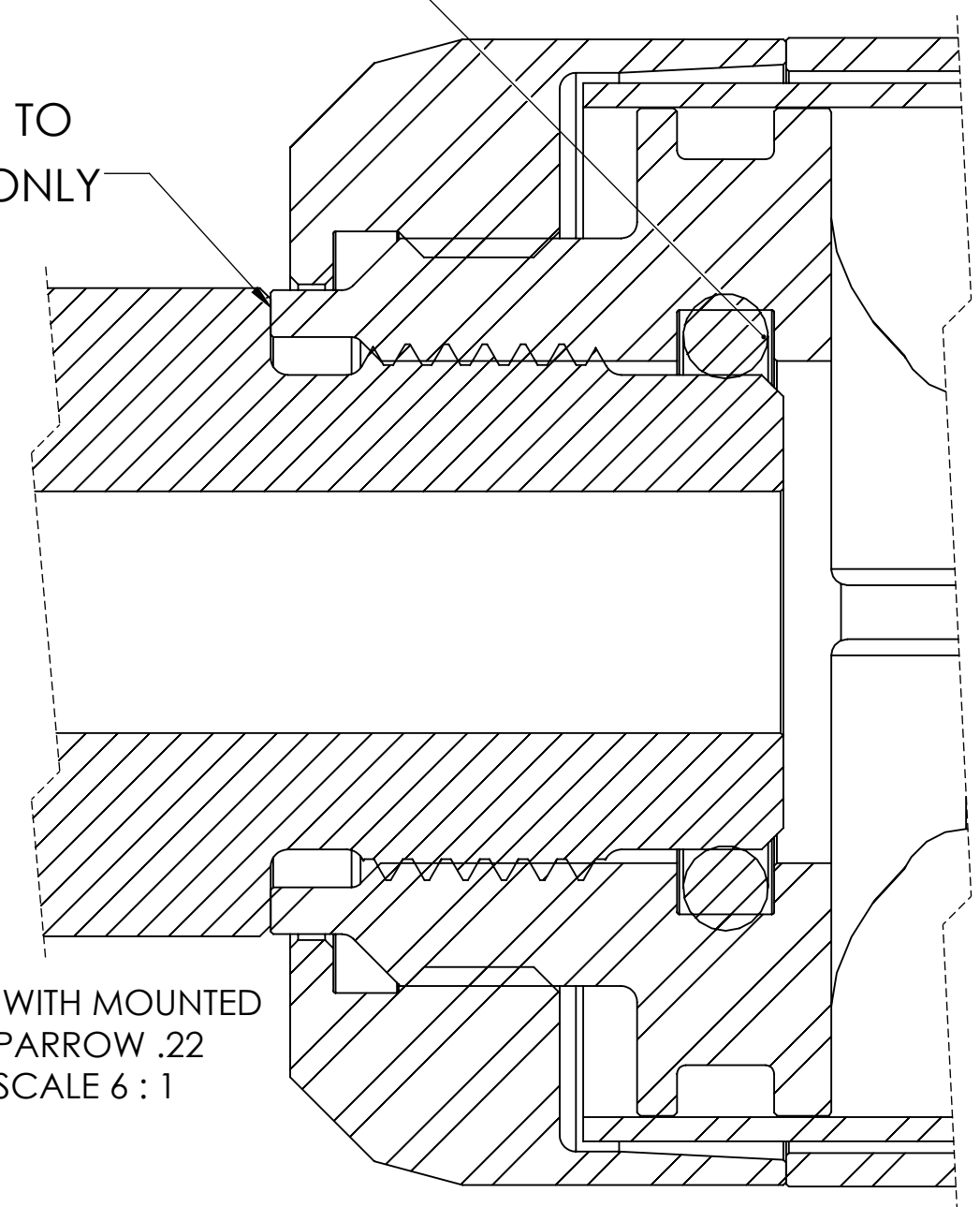


.500-28 "SPARROW PROFILE" RIMFIRE MUZZLE THREADS

O-RING ENGAGEMENT ON THE CYLINDRICAL BOSS OFFERS MORE EFFICIENT PROTECTION AGAINST THE INFILTRATION OF CARBON AND GASES.

THREAD DESIGNED TO SHOULDER @ **B** ONLY

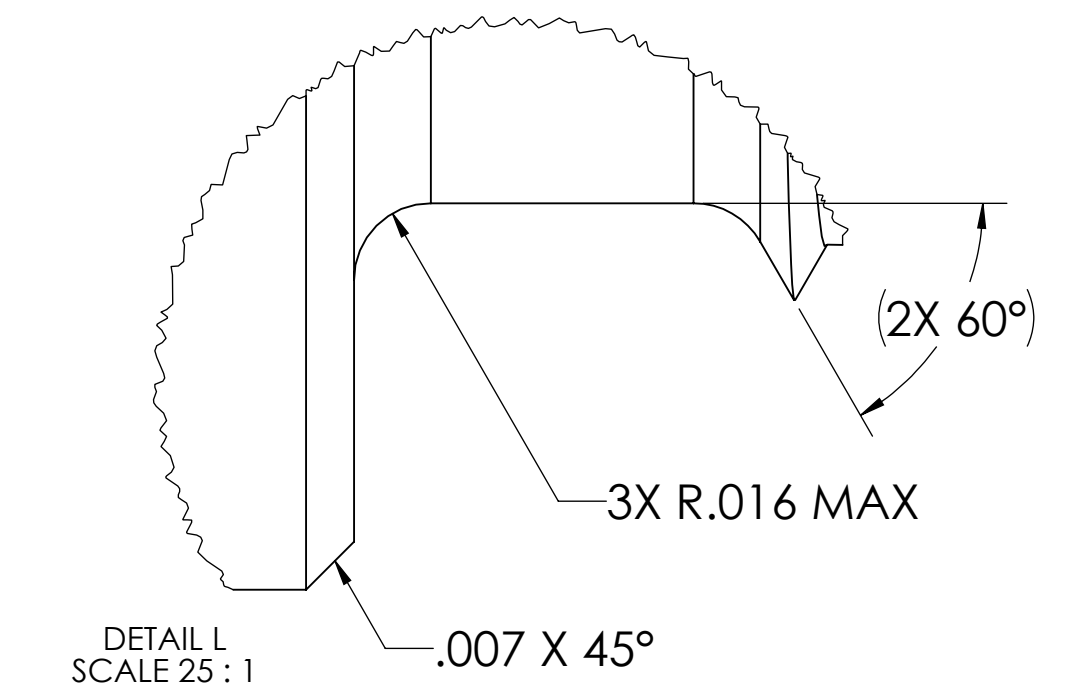
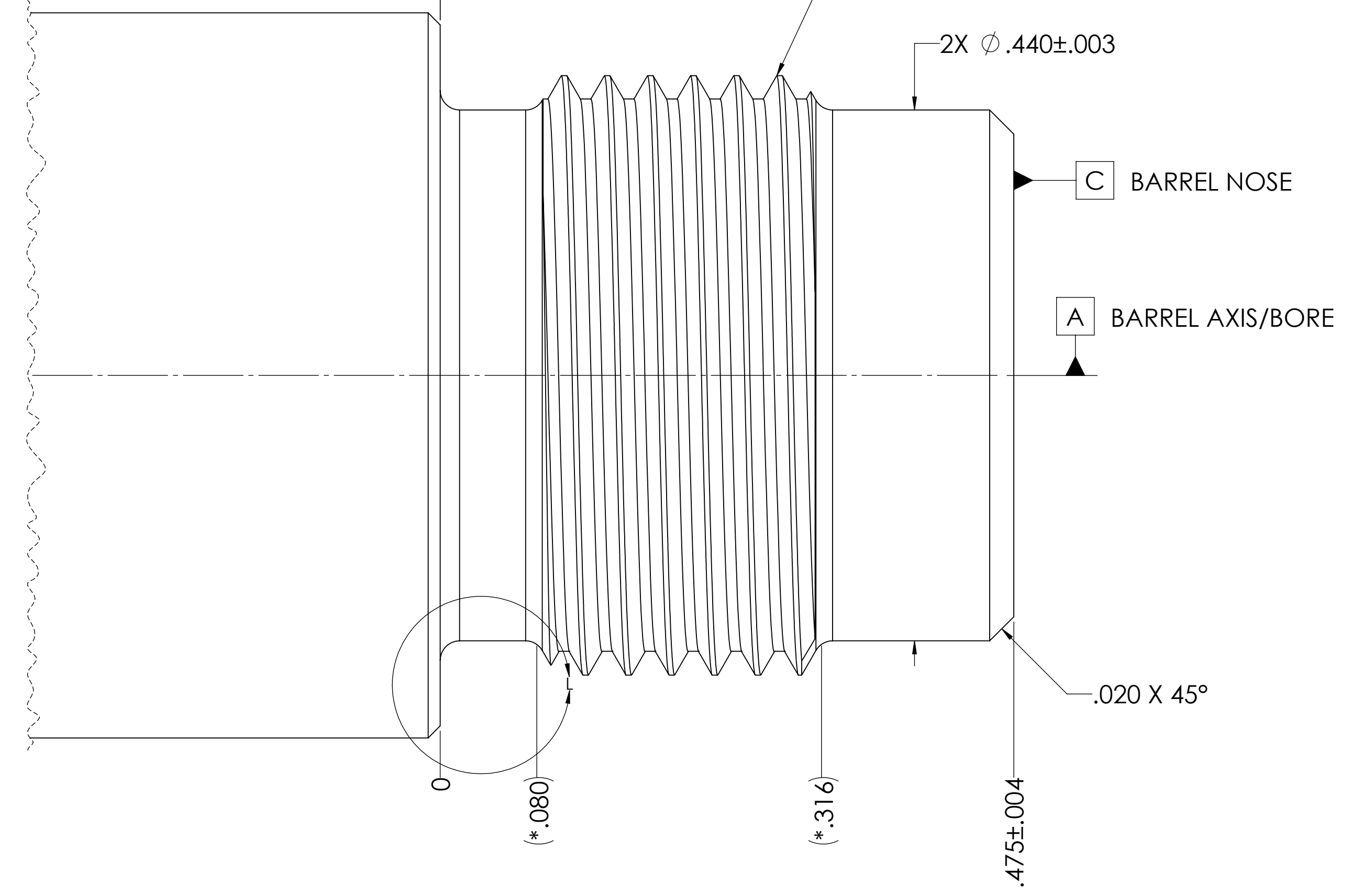
VIEW WITH MOUNTED SPARROW .22 SCALE 6 : 1



BEHIND THREAD SHOULDERING SURFACE **B**

\perp .0005 **A**

EXTERNAL THREADS \oplus 0.002 **A**
FOR THREAD SPECIFICATIONS, SEE TABLE IN THE UPPER RIGHT.



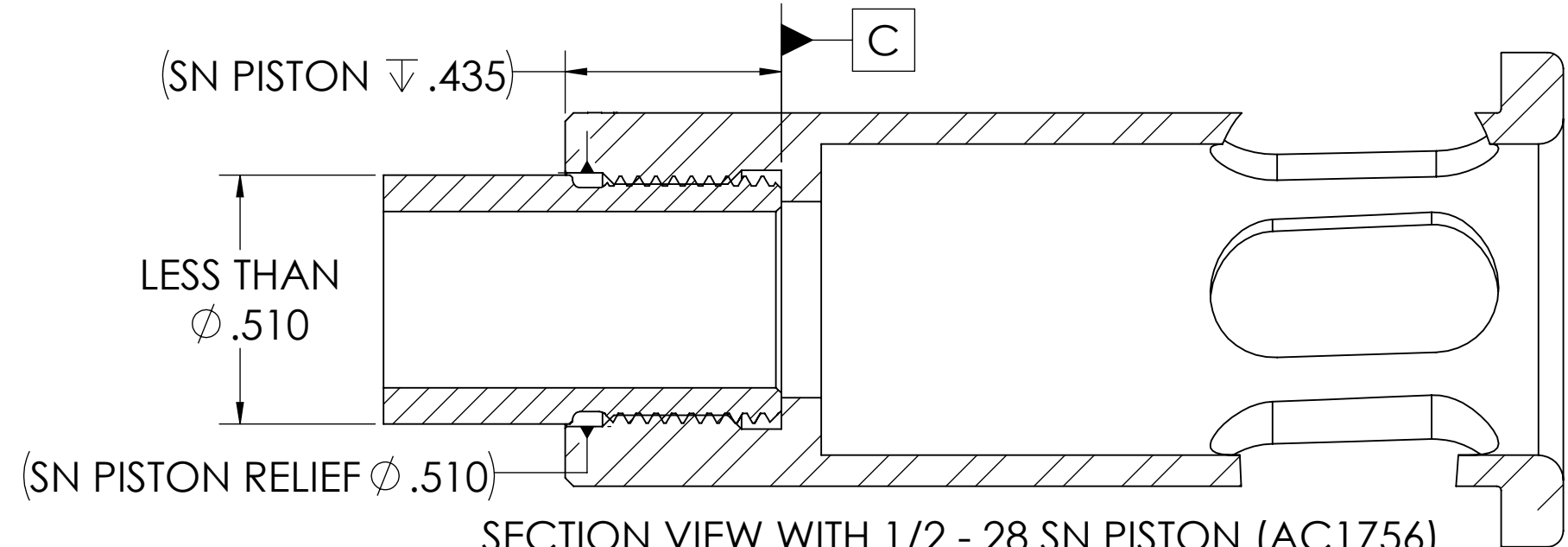
- NOTES:
UNLESS OTHERWISE SPECIFIED:
1. REMOVE BURRS FROM ALL EDGES TO A MAX OF R.005.
 2. GAGE ALL THREADS BETWEEN 1 TO 3 TURNS MAX OF NO-GO.
 3. DIMENSIONS WITH " * " ARE TO A THEORETICAL INTERSECTION.

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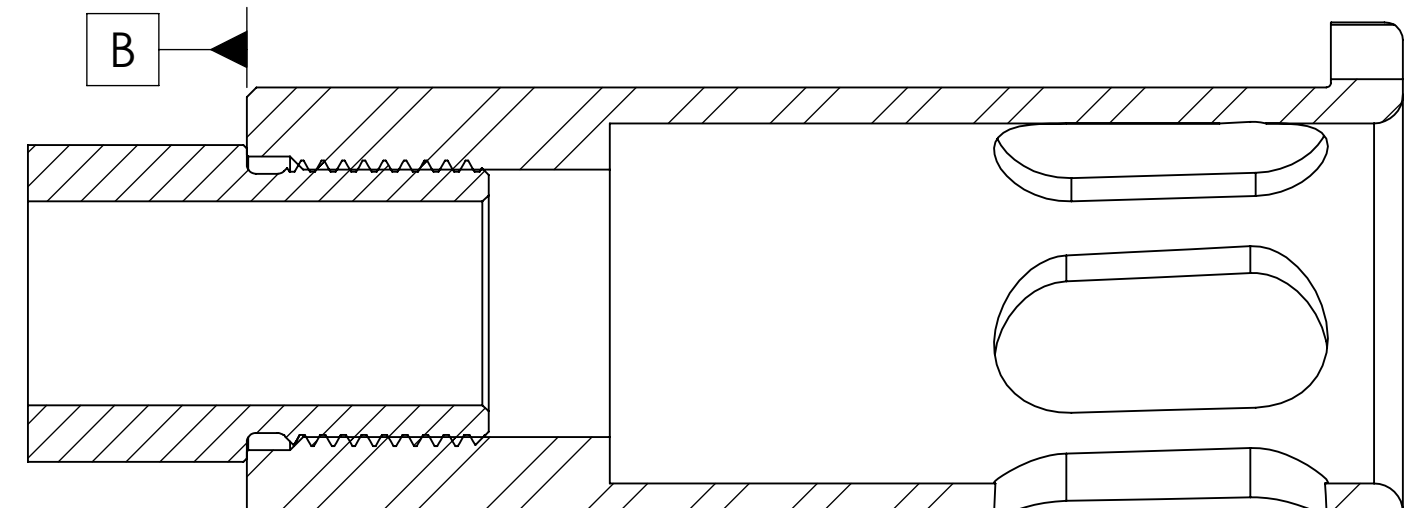
INTERPRET GEOMETRIC TOLERANCING PER ASME Y14.5-2018	PROPRIETARY AND CONFIDENTIAL	THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF SILENCERCO, LLC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF SILENCERCO, LLC IS PROHIBITED.	.500-28 RIMFIRE MUZZLE THREADS	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCH TOLERANCE DECIMALS: X.X ±.050 X.XX ±.010 X.XXX ±.005	ANGULAR SURFACE FINISH: OR BETTER PERPENDICULARITY \perp : .001/INCH CIRCULARITY \bigcirc : .0005		ENGINEER Jared H.	DATE 3/4/2024
		DRAWING REVISION A1	SHEET 11 OF 16	

NOTE: 1/2-28 (.500-28) IS A COMMON PISTOL BARREL THREAD FOR 9MM CHAMBERED HANDGUNS. MOST OF SILENCERCO'S® 9MM BARRELS ARE EQUIPPED WITH 1/2-28 THREADS. ALL SILENCERCO® 1/2 -28 CENTERFIRE PISTOL ACCESSORIES SHOULDER BEHIND THE THREADS, OR @ LOCATION [B]. WITH THE EXCEPTION OF THE 1/2 - 28 SN (AC1756) PISTON WHICH SHOULDERS ON THE NOSE OR LOCATION [C].

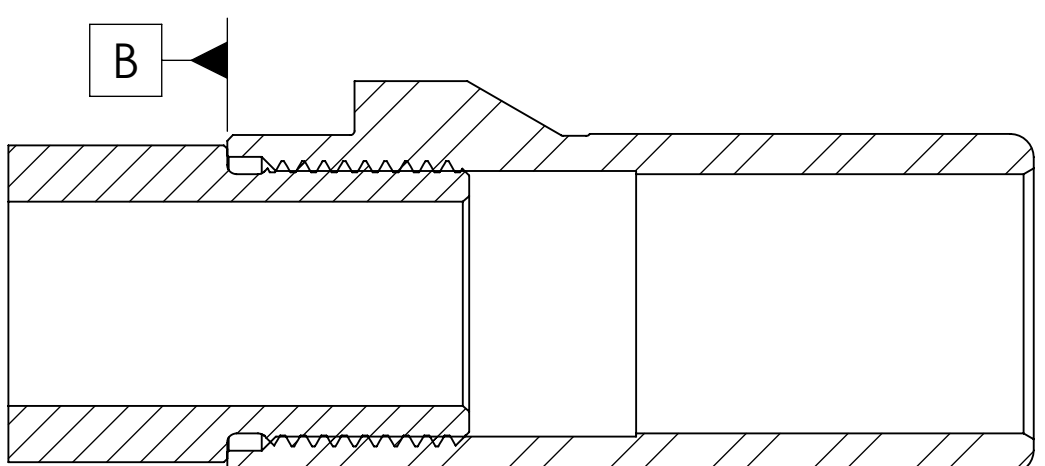
THREAD TYPE	.500-28 UNEF-3A	.500-28 UNS-2A
		TIGHTER TOLERANCE & FIT. WILL WORK WITH SILENCERCO® ACCESSORIES
PITCH ϕ	$\phi .4754 \pm .0014$	$\phi .4739 \pm .0019$
MAJOR ϕ	$\phi .4967 \pm .0032$	$\phi .4957 \pm .0033$



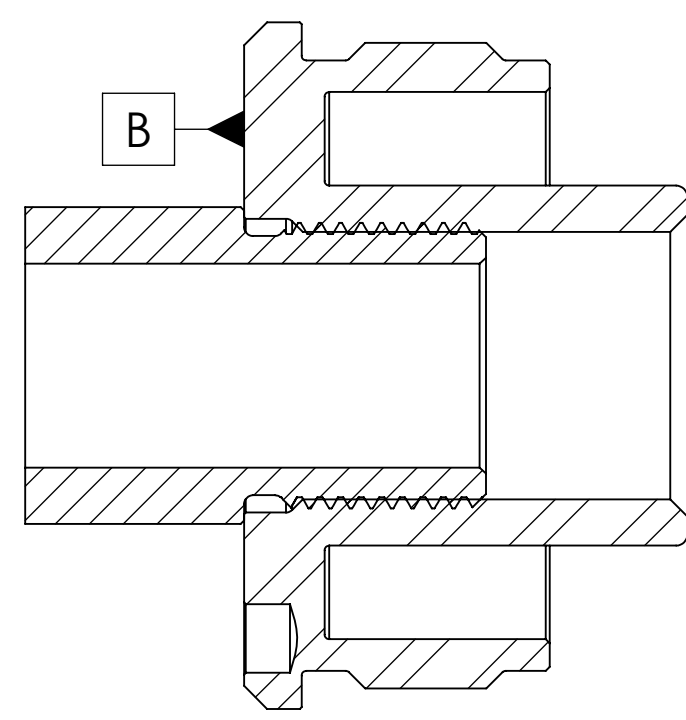
SECTION VIEW WITH 1/2 - 28 SN PISTON (AC1756) FOR TILTING BARREL LOCKING MECHANISMS/BOOSTER ASSEMBLIES WHERE SHOULDERS ON THE NOSE/ [C] IS NECESSARY. (THIN PROFILE BARRELS)
SCALE 3:1



SECTION VIEW WITH 1/2 - 28 PISTON (AC25) FOR TILTING BARREL LOCKING MECHANISMS/BOOSTER ASSEMBLIES. A 1/2 - 28 XL PISTON (AC59) IS AVAILABLE FOR INCREASED DISTANCE TO THE FRONT OF THE SLIDE.
SCALE 3:1

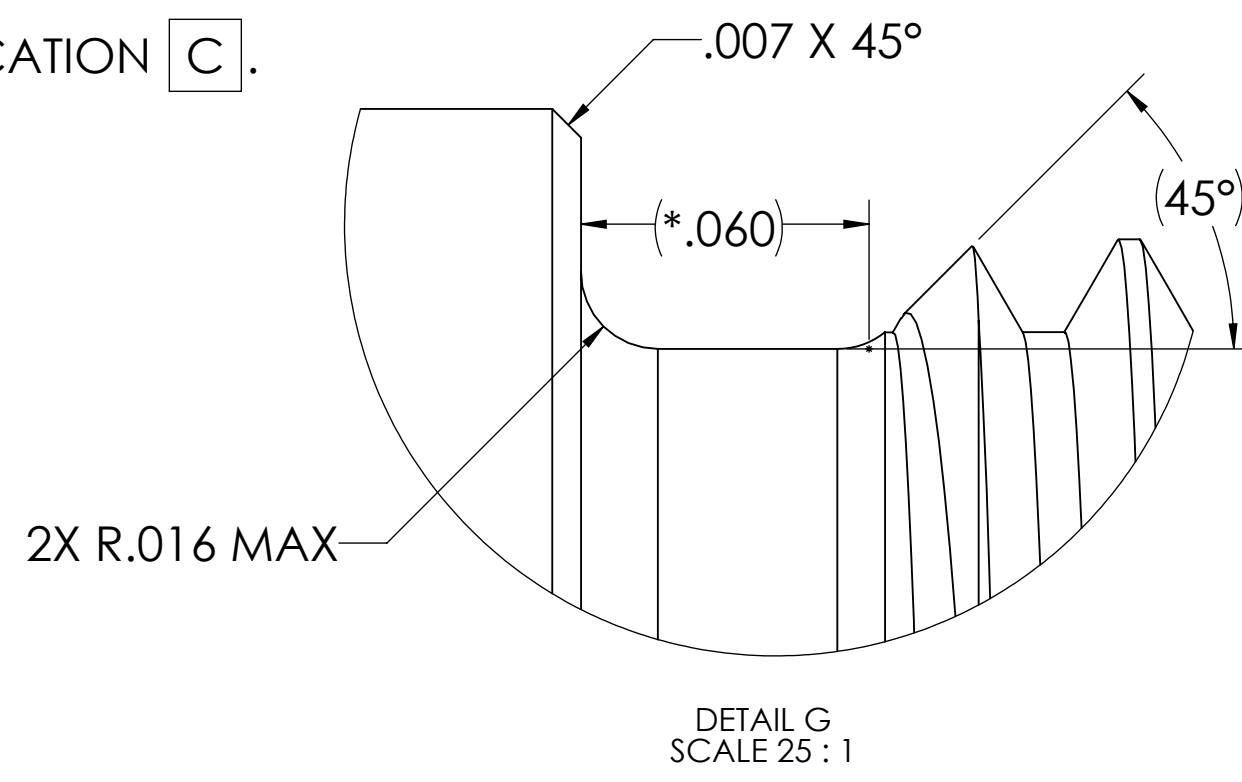


SECTION VIEW WITH 1/2 - 28 9MM 3 LUG MOUNT (AC2604) FOR FIXED BARREL APPLICATIONS.
SCALE 3:1



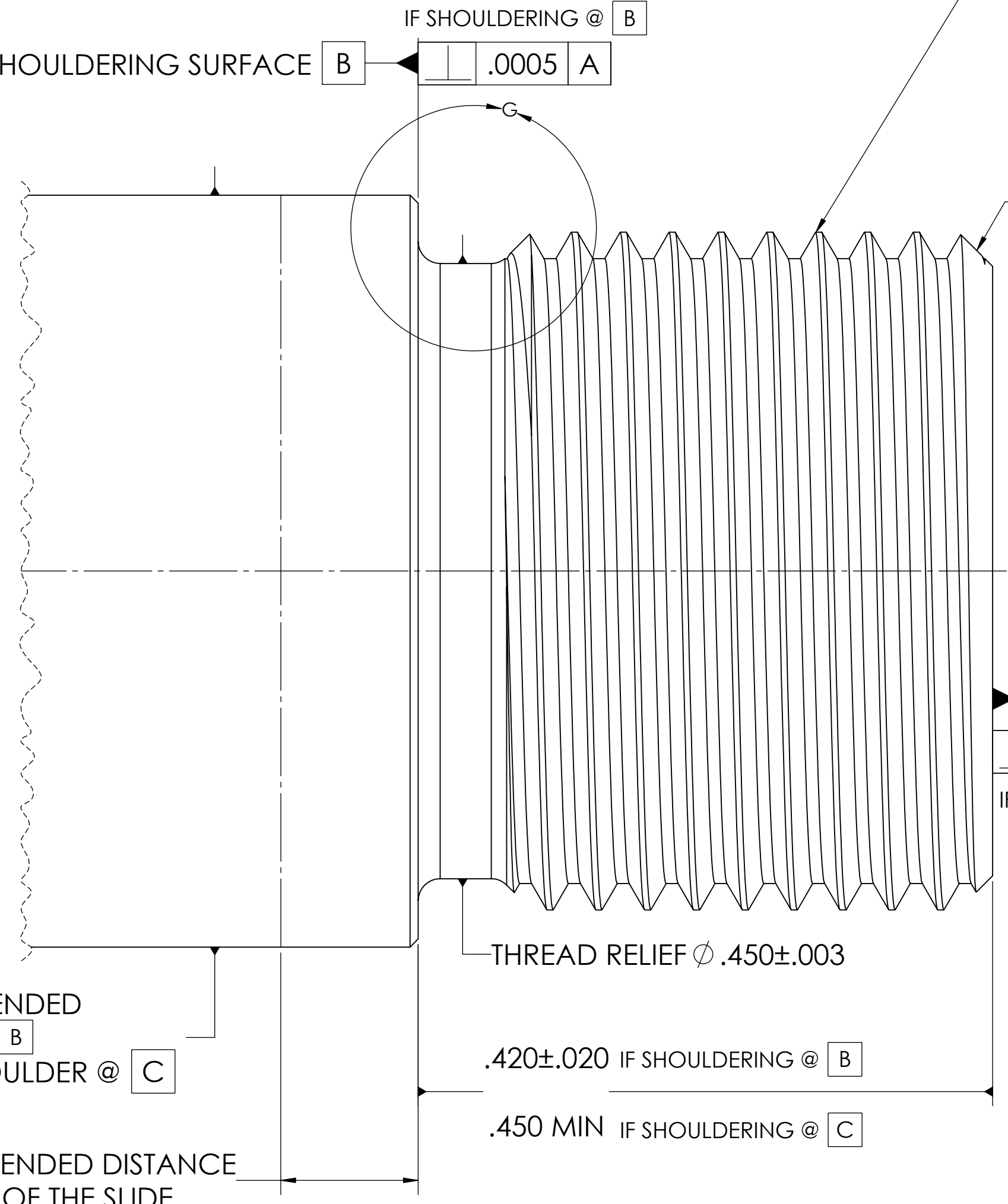
SECTION VIEW WITH 1/2 - 28 ALPHA DIRECT THREAD (AC663) CHARLIE 1/2 - 28 DT(AC4740) & BRAVO 1/2 - 28 DT (AC1415) HAVE A SIMILAR INTERIOR THREAD PROFILE. FOR FIXED BARREL APPLICATIONS.
SCALE 3:1

- NOTES:
UNLESS OTHERWISE SPECIFIED:
1. REMOVE BURRS FROM ALL EDGES TO A MAX OF R.005.
 2. GAGE ALL THREADS BETWEEN 1 TO 3 TURNS MAX OF NO-GO.
 3. DIMENSIONS WITH " * " ARE TO A THEORETICAL INTERSECTION.



IF SHOULDERS @ [B] BEHIND THREAD SHOULDERS SURFACE [B] .0005 [A]

EXTERNAL THREADS ϕ 0.002 [A] FOR THREAD SPECIFICATIONS, SEE TABLE IN THE UPPER RIGHT.



[A] BARREL AXIS/BORE
[C] BARREL NOSE
.0005 [A]
IF SHOULDERS @ [C]

ϕ .550 MIN RECOMMENDED IF SHOULDERS @ [B]
IF ϕ .500 OR LESS, SHOULDERS @ [C]
.100 MIN RECOMMENDED DISTANCE TO THE FRONT OF THE SLIDE

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ANGULAR: SURFACE FINISH: OR BETTER PERPENDICULARITY: .001/INCH CIRCULARITY: .0005	ENGINEER: Jared H. DATE: 3/4/2024	SHEET SIZE: D	DRAWING REVISION: A1
SCALE: 10:1		SHEET 12 OF 16	

.500-28 CENTERFIRE PISTOL MUZZLE THREADS

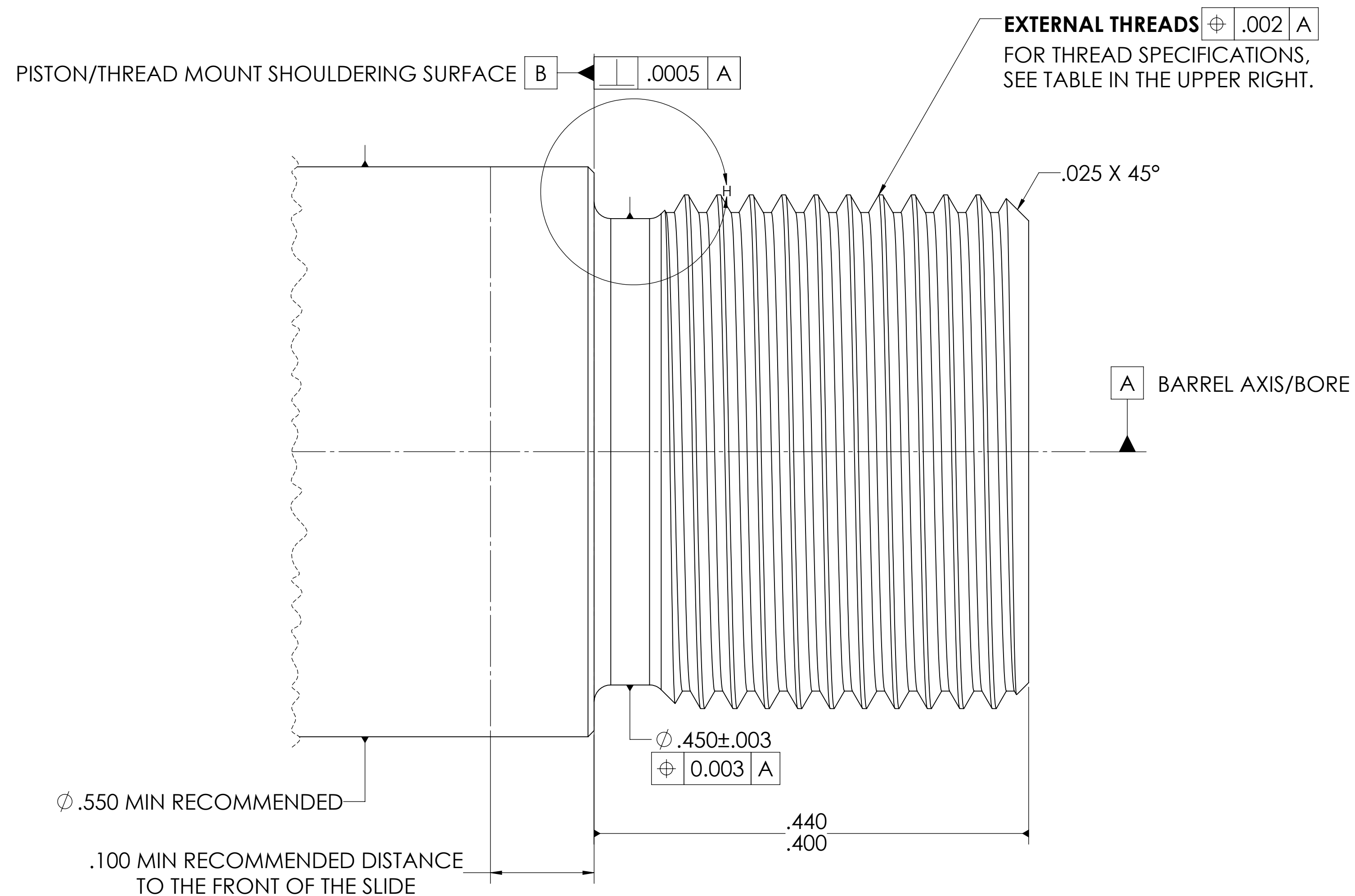
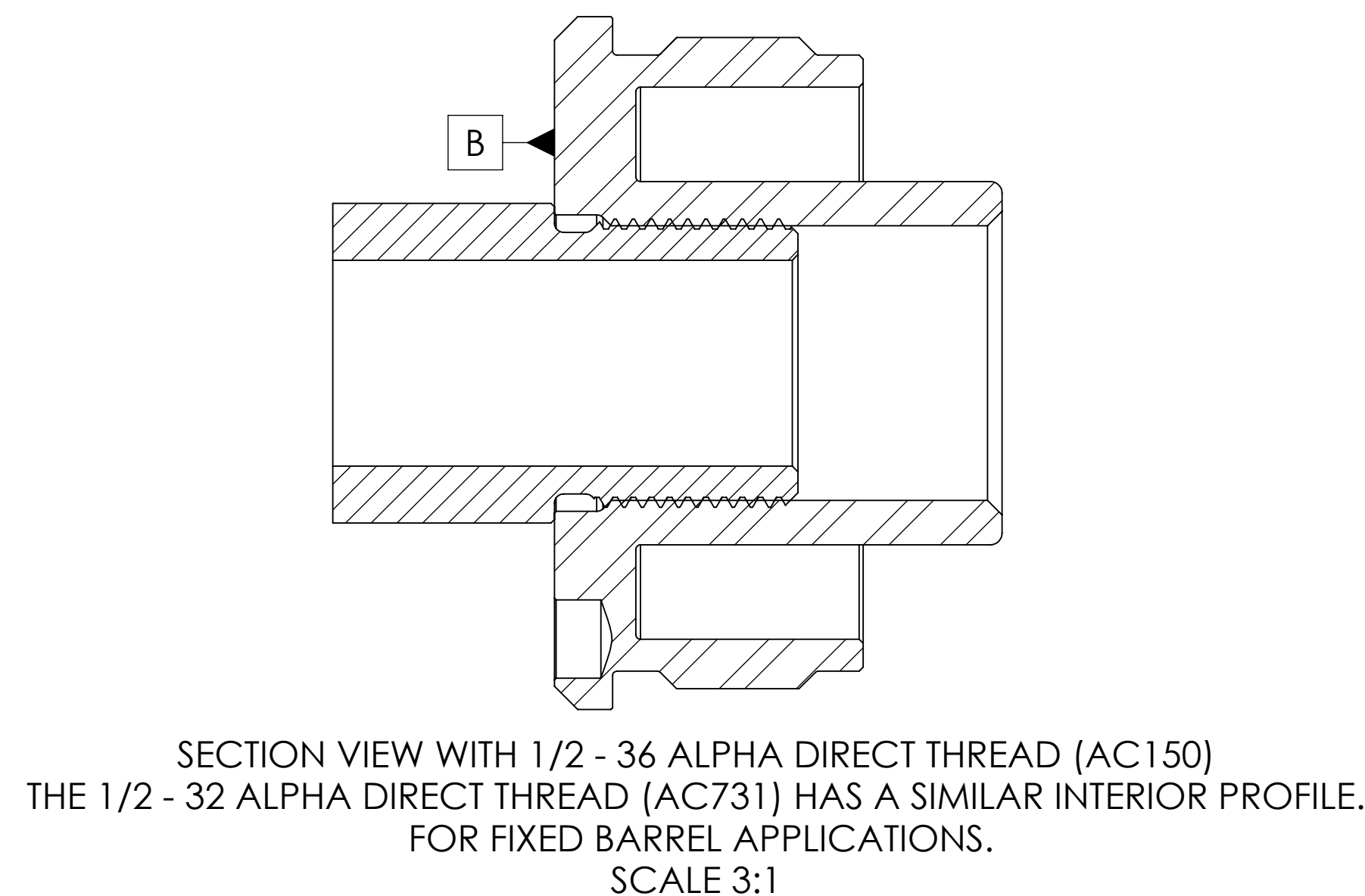
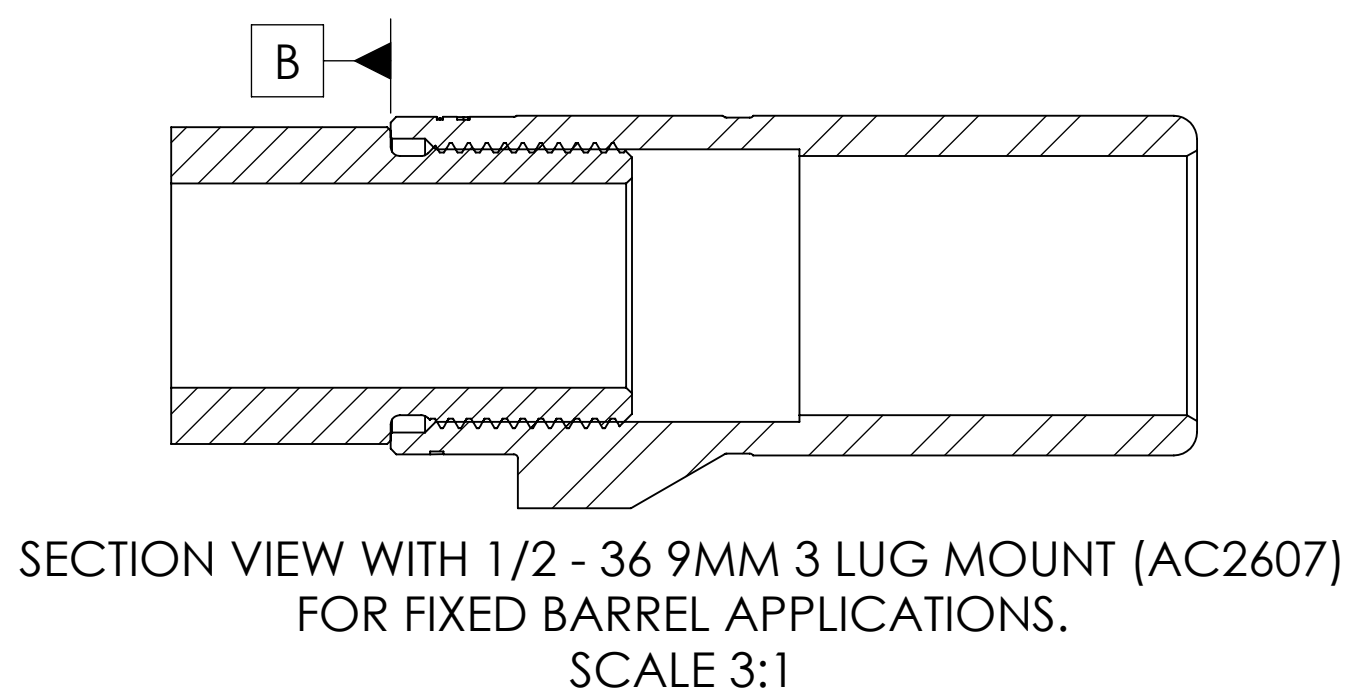
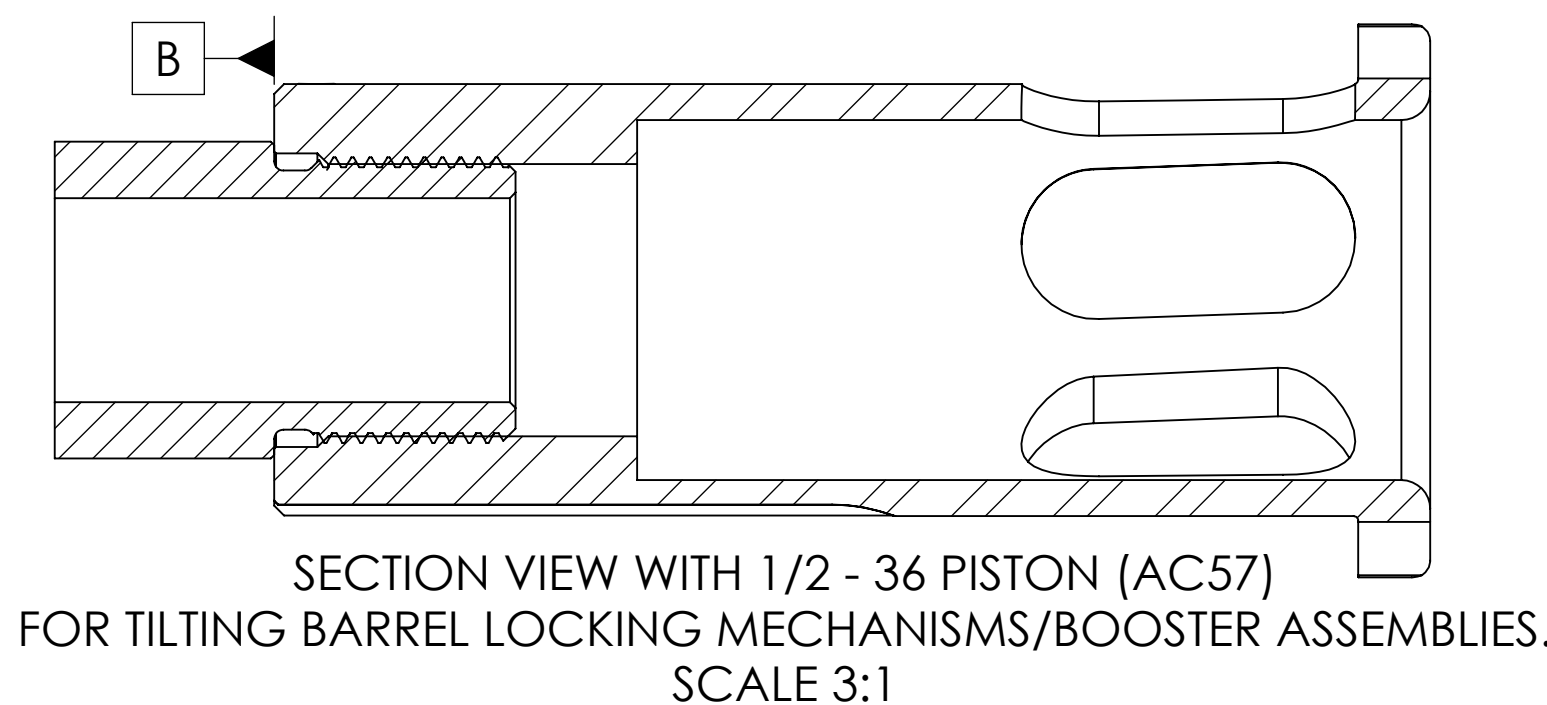
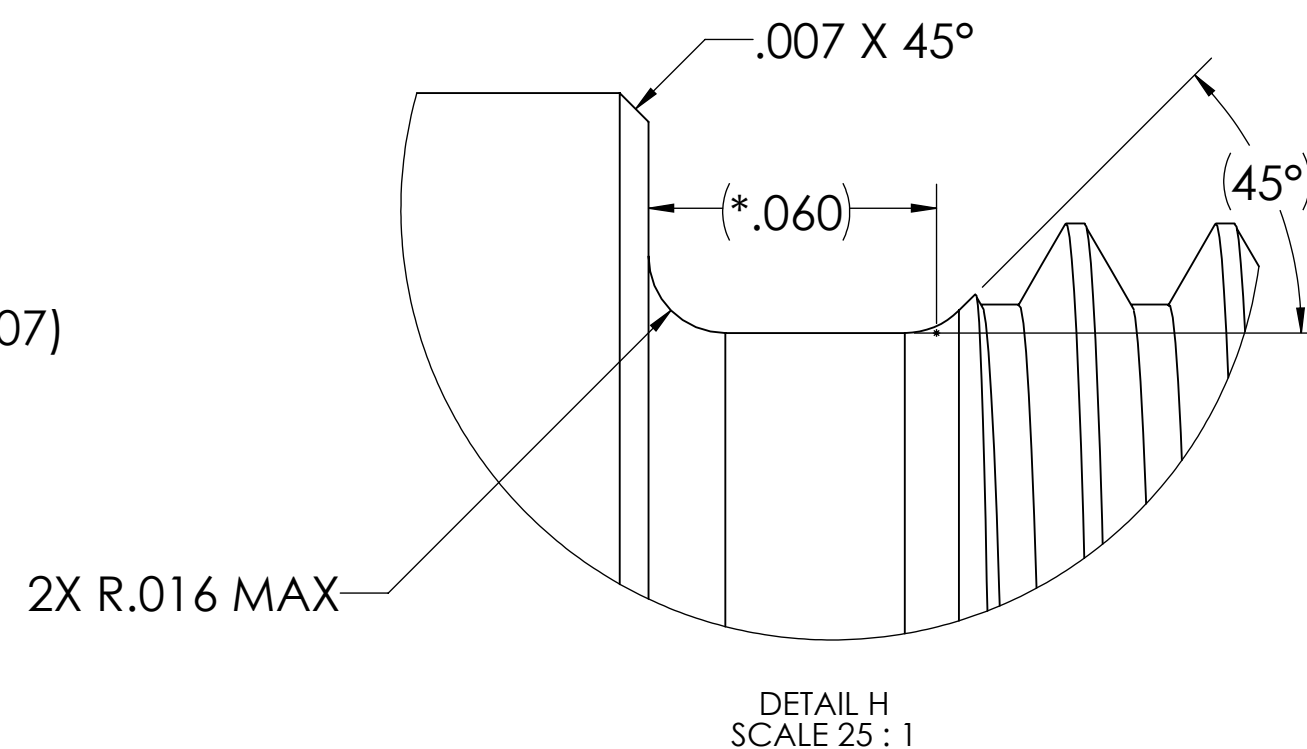
NOTE: 1/2 -36 (.500 -36) IS A RARE BARREL THREAD, FOR USE WITH 9MM CHAMBERED HANDGUNS AND IS MORE COMMONLY USED IN PISTOL CALIBER CARBINES (COLT® ETC).

SILENCERCO® DOESN'T OFFER PISTOL BARRELS THREADED IN 1/2 -32 OR 1/2 -36, ALL SILENCERCO® 1/2 -32 & 1/2 -36 ACCESSORIES SHOULD BE POSITIONED BEHIND THE THREADS, OR @ LOCATION **B**.

1/2 -32 (.500 -32) PISTOL BARREL THREADS ARE NOT COMMON AND ARE SEEN MORE IN PISTOL CALIBER CARBINE APPLICATIONS (H&K® ETC.).

SILENCERCO® OFFERS AN ALPHA DIRECT THREAD MOUNT FOR 1/2 -32 THREAD PATTERN (AC731), THE 1/2 -36 THREAD PATTERN IS OFFERED IN ALPHA DIRECT THREAD (AC150), 9MM 3 -LUG MUZZLE DEVICE (AC2607) AND AS A PISTON (AC57).

THREAD TYPE	.500-36 UNS-2A	.500-32 UN-2A
PITCH ϕ	$\phi .4793 \pm .0017$	$\phi .4739 \pm .0019$
MAJOR ϕ	$\phi .4962 \pm .0028$	$\phi .4957 \pm .0033$



NOTES:

UNLESS OTHERWISE SPECIFIED:

1. REMOVE BURRS FROM ALL EDGES TO A MAX OF R.005.
2. GAGE ALL THREADS BETWEEN 1 TO 3 TURNS MAX OF NO-GO.
3. DIMENSIONS WITH " * " ARE TO A THEORETICAL INTERSECTION.

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WEST VALLEY, UT 84118

INTERPRET GEOMETRIC TOLERANCING PER ASME Y14.5-2018	PROPRIETARY AND CONFIDENTIAL						
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ANGULAR: SURFACE FINISH: OR BETTER PERPENDICULARITY: CIRCULARITY:	<table border="1"> <tr> <td>XX</td> <td>±.050</td> </tr> <tr> <td>XX</td> <td>±.010</td> </tr> <tr> <td>XX</td> <td>±.005</td> </tr> </table>	XX	±.050	XX	±.010	XX	±.005
XX	±.050						
XX	±.010						
XX	±.005						
PERPENDICULARITY: .001/INCH	ENGINEER: Jared H. DATE: 3/4/2024						
CIRCULARITY: .0005	SHEET SIZE: D DRAWING REVISION: A1						

.500-32 & .500-36
CENTERFIRE PISTOL
MUZZLE THREADS

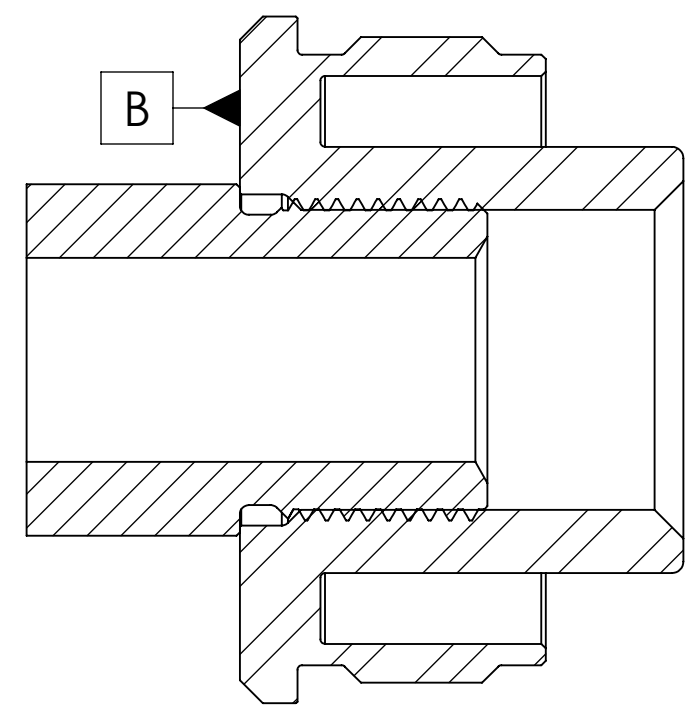
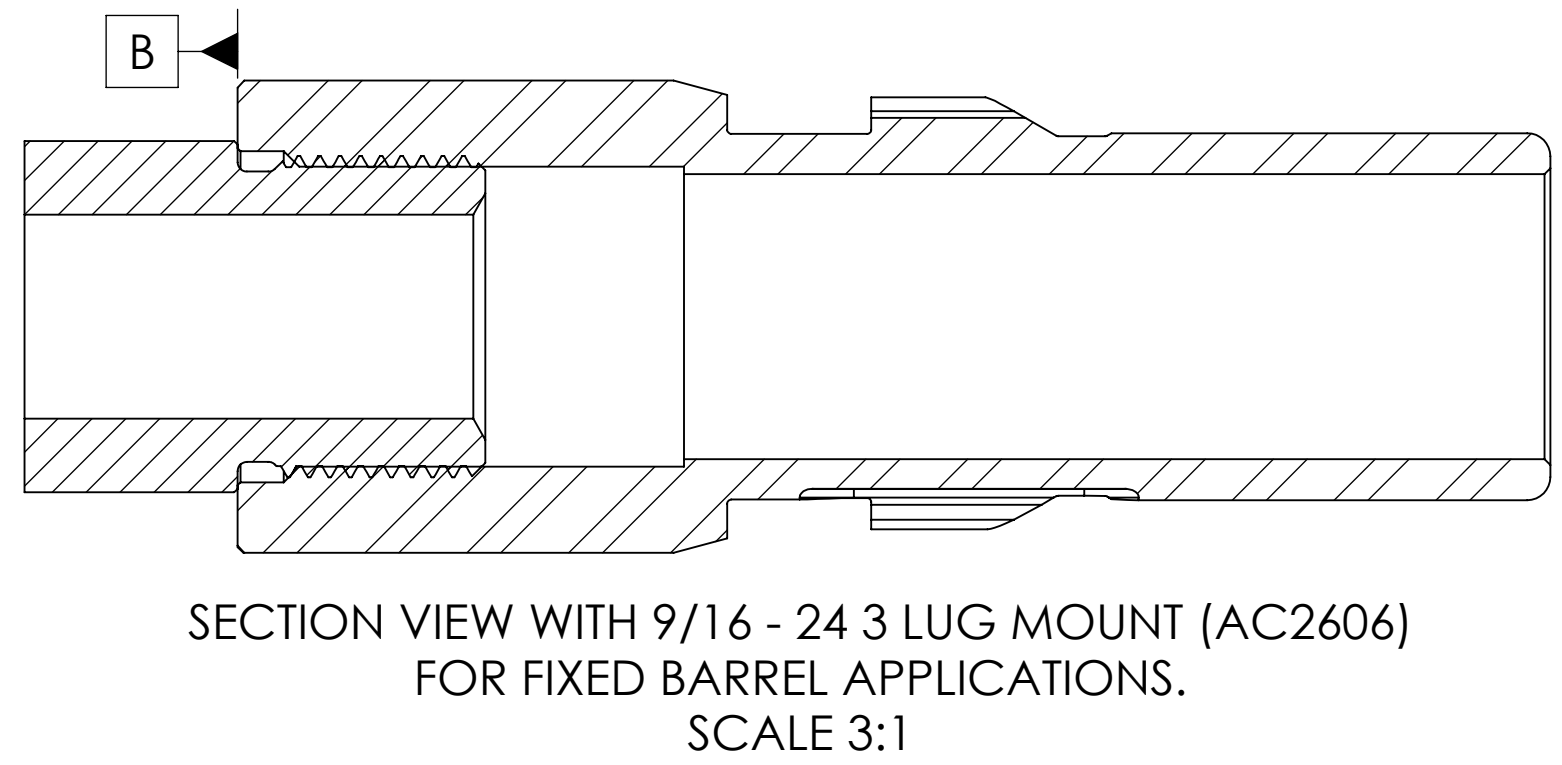
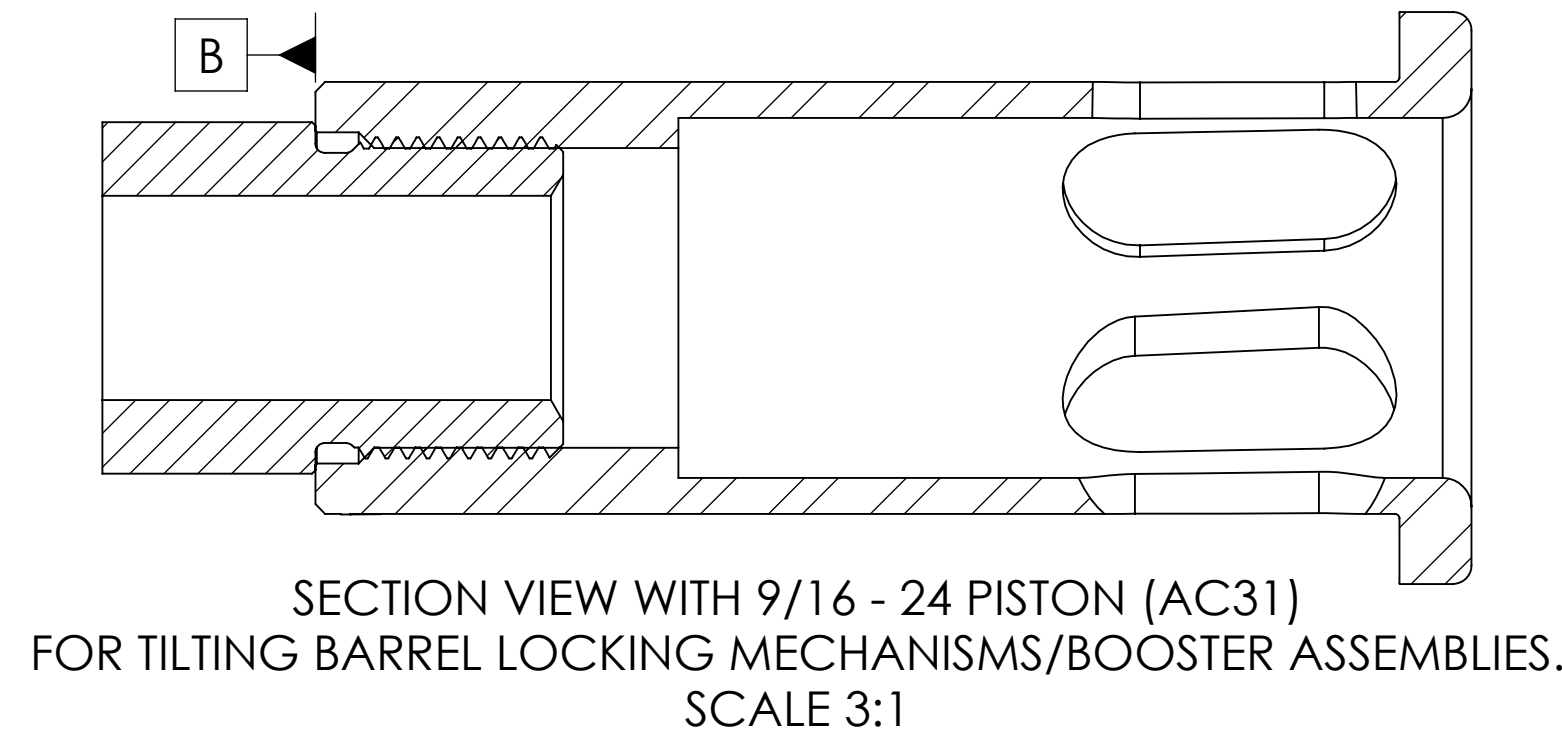
SCALE: 10:1

SHEET 13 OF 16

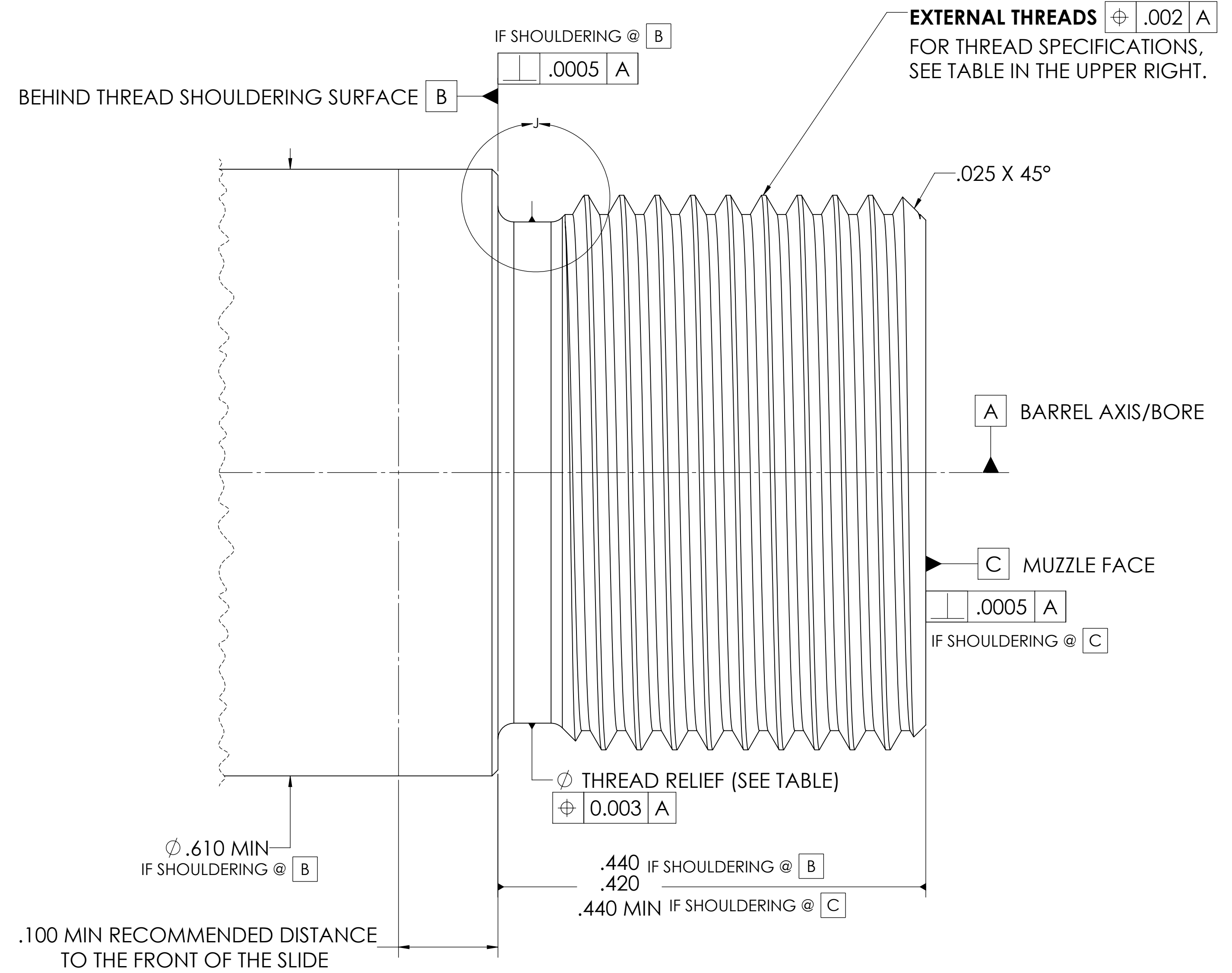
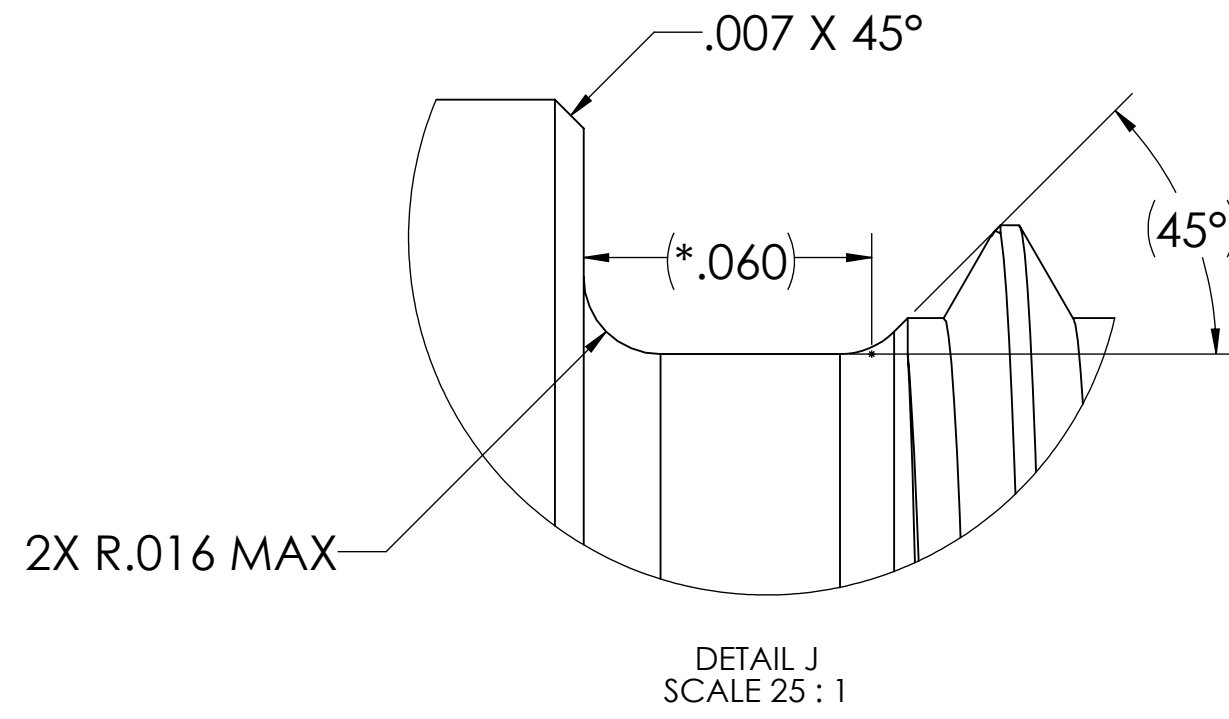
NOTE: 9/16-24 (.5625-24) IS A COMMON BARREL THREAD FOR 40 S&W AND 10MM CHAMBERED HANDGUNS, ESPECIALLY IN AFTERMARKET BARRELS. SILENCERCO'S® GLOCK® 23 (AC1757) & GLOCK® 22 (AC50) BARRELS ARE EQUIPPED WITH 9/16-24 THREADS. ALL SILENCERCO® 9/16-24 ACCESSORIES SHOULD BE LOCATED @ LOCATION B

9/16-28 (.5625-28) BARREL THREADS ARE NOT COMMON AND ARE SEEN MORE IN RIFLE APPLICATIONS (SAVAGE ETC.) SILENCERCO DOESN'T OFFER MOUNTS IN THE 9/16-28 THREAD PATTERN.

THREAD TYPE	.5625-24 UNEF-3A	.5625-24 UNS-2A	.5625-28 UN-2A
	TIGHTER TOLERANCE & FIT, WILL WORK WITH SILENCERCO® ACCESSORIES	RECOMMENDED FOR UNIVERSAL FIT	NOT CURRENTLY COMPATIBLE WITH SILENCERCO® ACCESSORIES
PITCH ϕ	ϕ .5339 \pm .0015	ϕ .5322 \pm .0020	ϕ .5363 \pm .0018
MAJOR ϕ	ϕ .5589 \pm .0036	ϕ .5338 \pm .0036	ϕ .5518 \pm .0032
THREAD RELIEF ϕ	ϕ .497 \pm .003	ϕ .497 \pm .003	ϕ .505 \pm .003



CHARLIE 9/16-24 DT(AC4744) & BRAVO 9/16-24 DT (AC2435) HAVE A SIMILAR INTERIOR THREAD PROFILE.



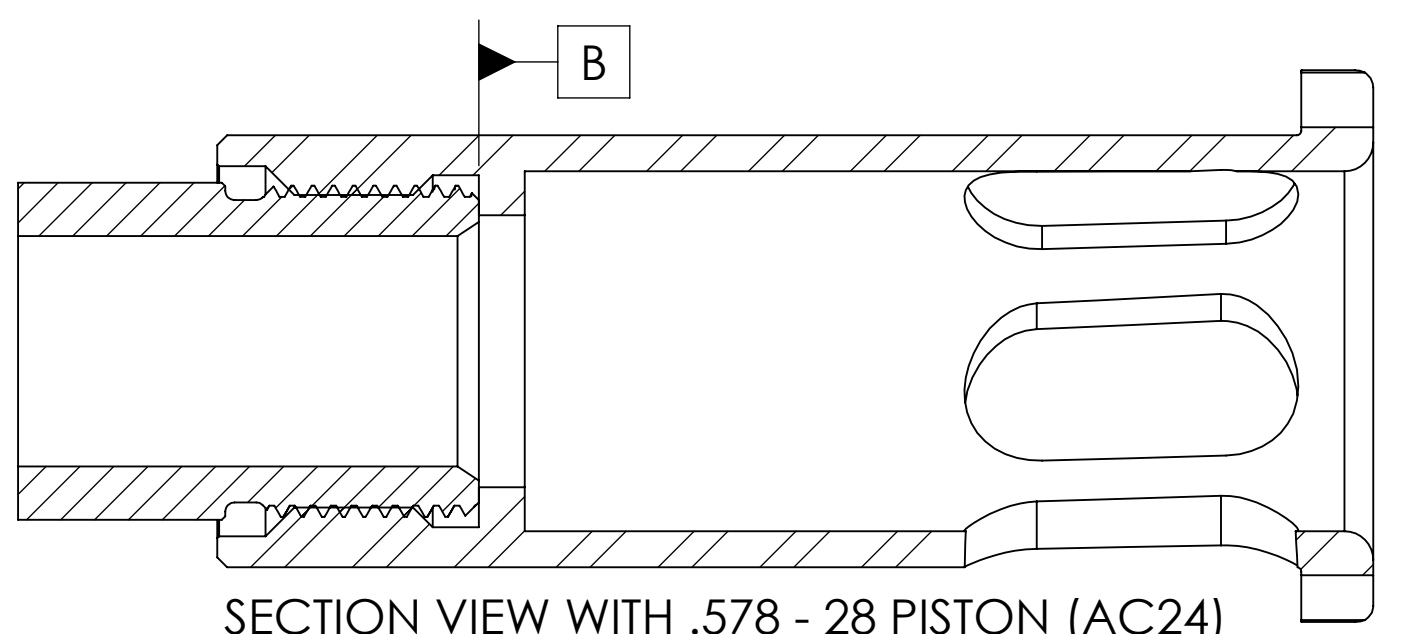
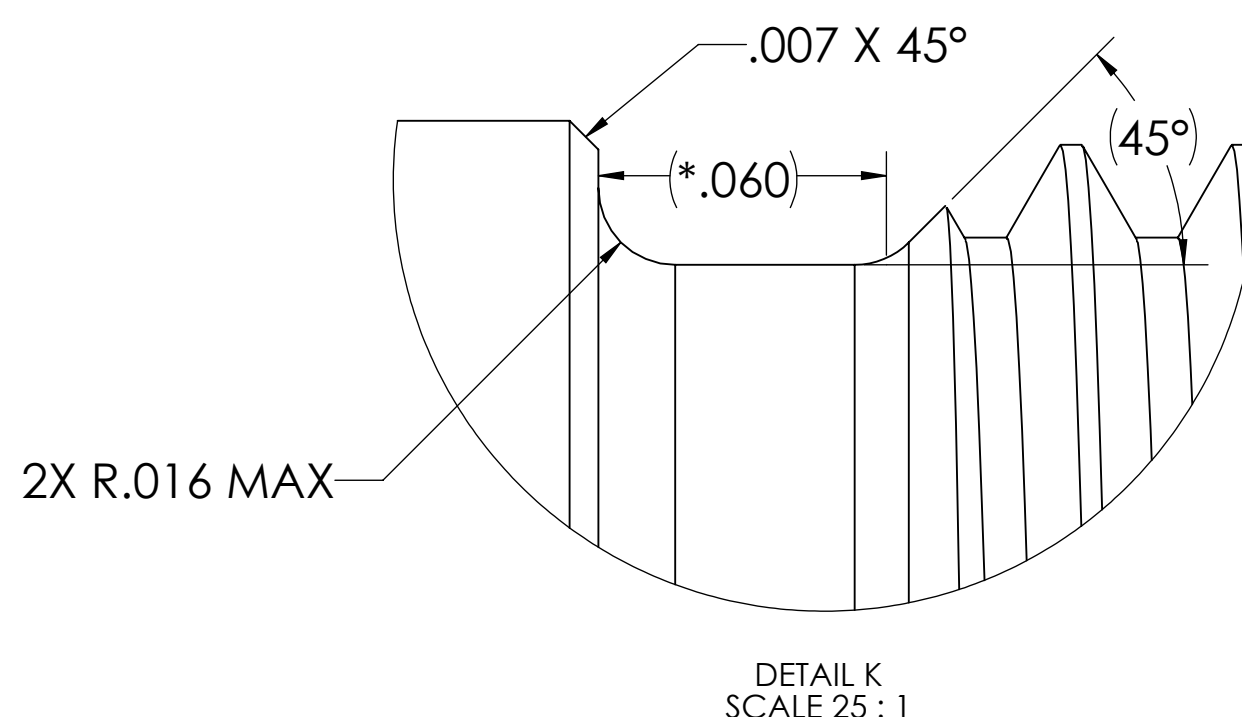
- NOTES:
- UNLESS OTHERWISE SPECIFIED:
1. REMOVE BURRS FROM ALL EDGES TO A MAX OF R.005.
 2. GAGE ALL THREADS BETWEEN 1 TO 3 TURNS MAX OF NO-GO.
 3. DIMENSIONS WITH " * " ARE TO A THEORETICAL INTERSECTION.

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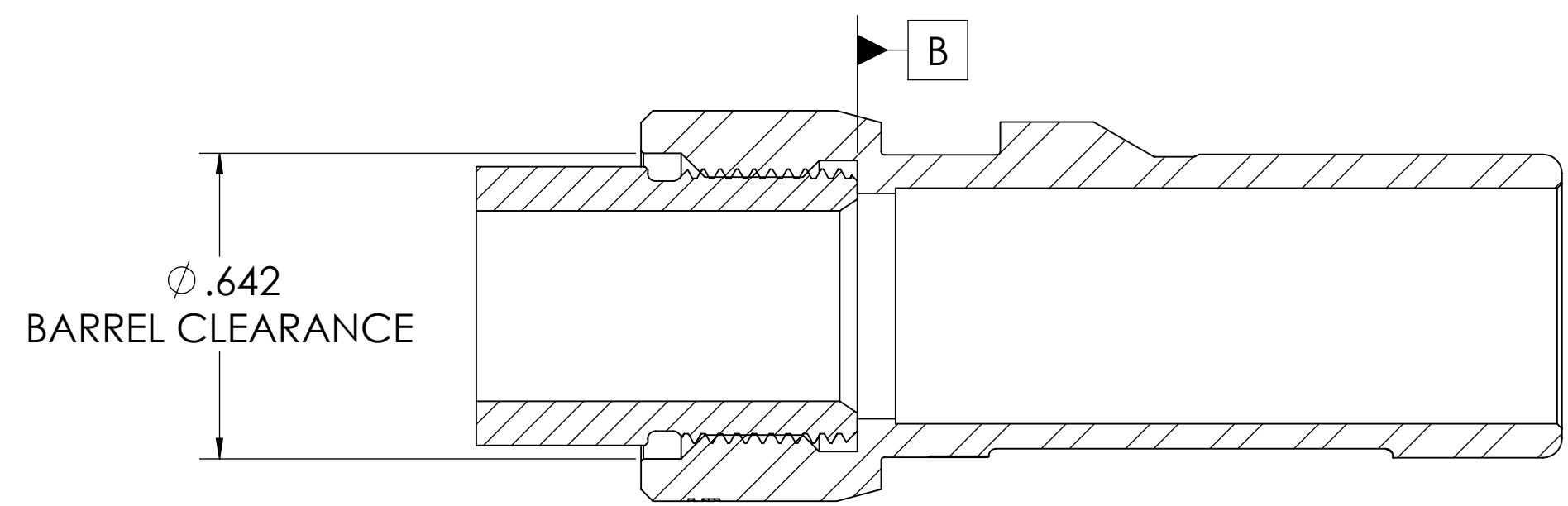
INTERPRET GEOMETRIC TOLERANCING PER ASME Y14.5-2018	PROPRIETARY AND CONFIDENTIAL	.5625-24 & .5625-28	CENTERFIRE PISTOL MUZZLE THREADS
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCH TOLERANCE DECIMALS: X.X ±.050 X.XX ±.010 X.XXX ±.005	THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF SILENCERCO, LLC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF SILENCERCO, LLC IS PROHIBITED.		
ANGULAR: SURFACE FINISH: OR BETTER PERPENDICULARITY: .001/INCH CIRCULARITY: .005	ENGINEER: Jared H. DATE: 3/4/2024	SHEET SIZE: D	DRAWING REVISION: A1
SCALE: 10:1		SHEET 14 OF 16	

NOTE: .578-28 IS A COMMON PISTOL BARREL THREAD FOR 45ACP CHAMBERED HANDGUNS. SILENCERCO'S® 45 CALIBER PISTOL BARRELS ARE EQUIPPED WITH .578-28 THREADS. ALL SILENCERCO® .578-28 CENTERFIRE PISTOL ACCESSORIES SHOULDER ON THE NOSE OF THE THREADS, OR @ LOCATION B.

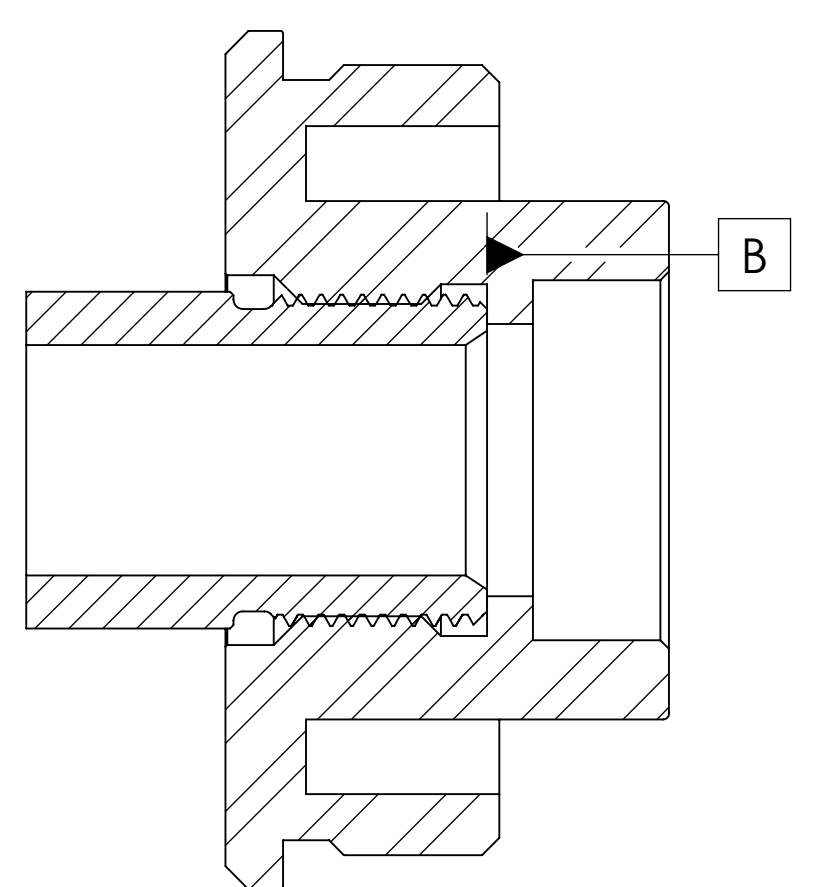
THREAD TYPE	.578-28 UNS-3A	.578-28 UNS-2A
	TIGHTER TOLERANCE & FIT, WILL WORK WITH SILENCERCO® ACCESSORIES	RECOMMENDED FOR UNIVERSAL FIT
PITCH ϕ	$\phi .5534 \pm .0014$	$\phi .5518 \pm .0019$
MAJOR ϕ	$\phi .5748 \pm .0032$	$\phi .5736 \pm .0032$



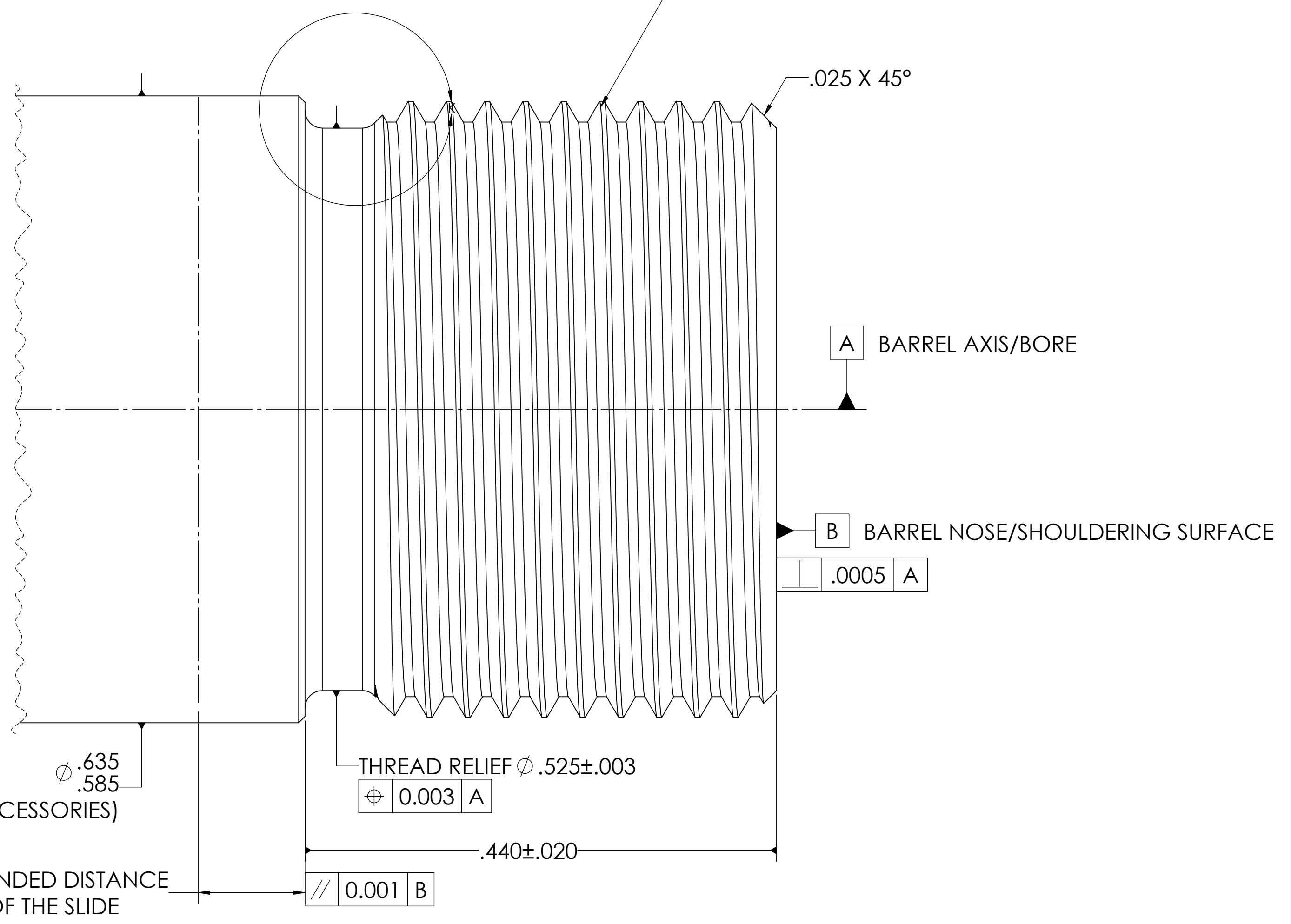
SECTION VIEW WITH .578 - 28 PISTON (AC24) FOR TILTING BARREL LOCKING MECHANISMS/BOOSTER ASSEMBLIES. A .578 - 28 XL PISTON (AC1346) IS AVAILABLE FOR INCREASED DISTANCE TO THE FRONT OF THE SLIDE. SCALE 3:1



SECTION VIEW WITH .578 - 28 .45 CALIBER 3 LUG MOUNT (AC2605) FOR FIXED BARREL APPLICATIONS. SCALE 3:1



SECTION VIEW WITH .578 - 28 BRAVO DIRECT THREAD (AC1564) FOR FIXED BARREL APPLICATIONS. SCALE 3:1



EXTERNAL THREADS $\oplus 0.002$ A
FOR THREAD SPECIFICATIONS, SEE TABLE IN THE UPPER RIGHT.

A BARREL AXIS/BORE

B BARREL NOSE/SHOULDERING SURFACE

.0005 A

THREAD RELIEF $\phi .525 \pm .003$
 $\oplus 0.003$ A

// 0.001 B

($\phi .640$ MAX FOR FITMENT WITH SILENCERCO ACCESSORIES)

.100 MIN RECOMMENDED DISTANCE TO THE FRONT OF THE SLIDE

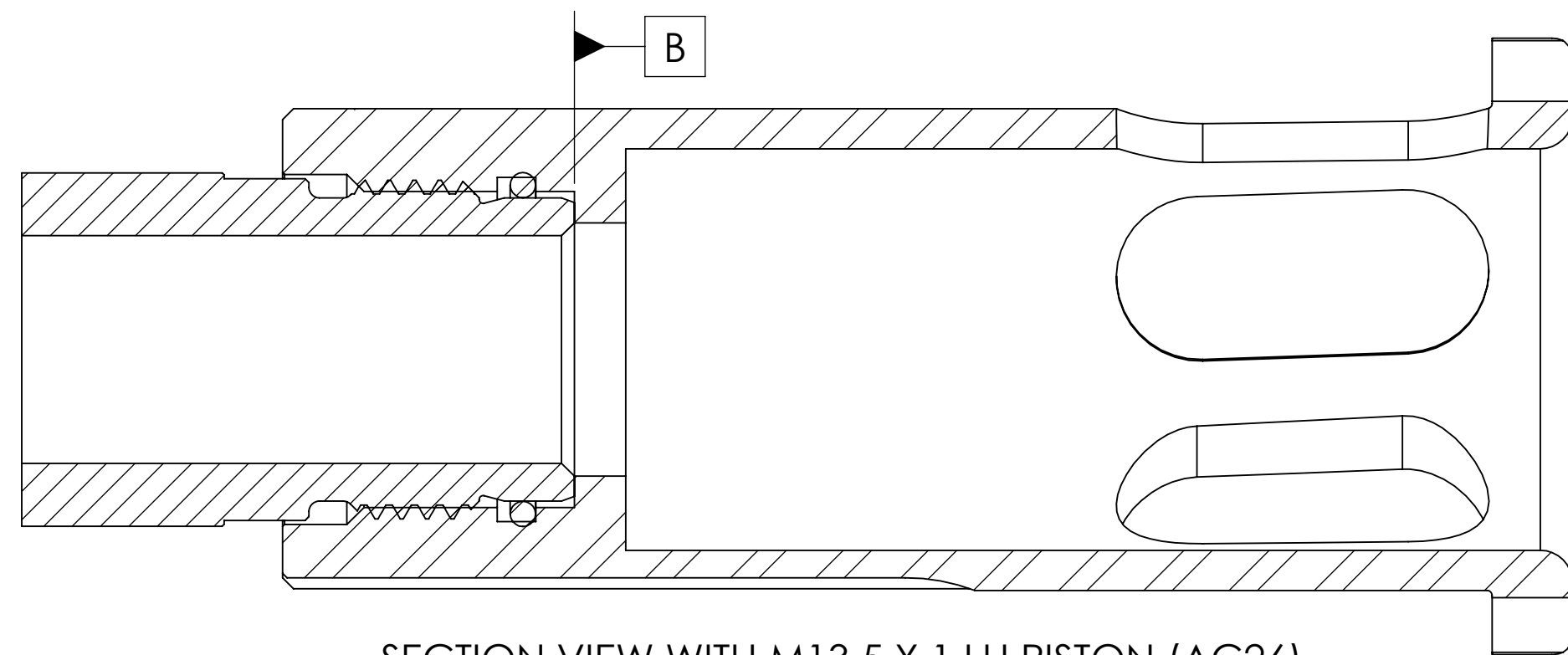
- NOTES:
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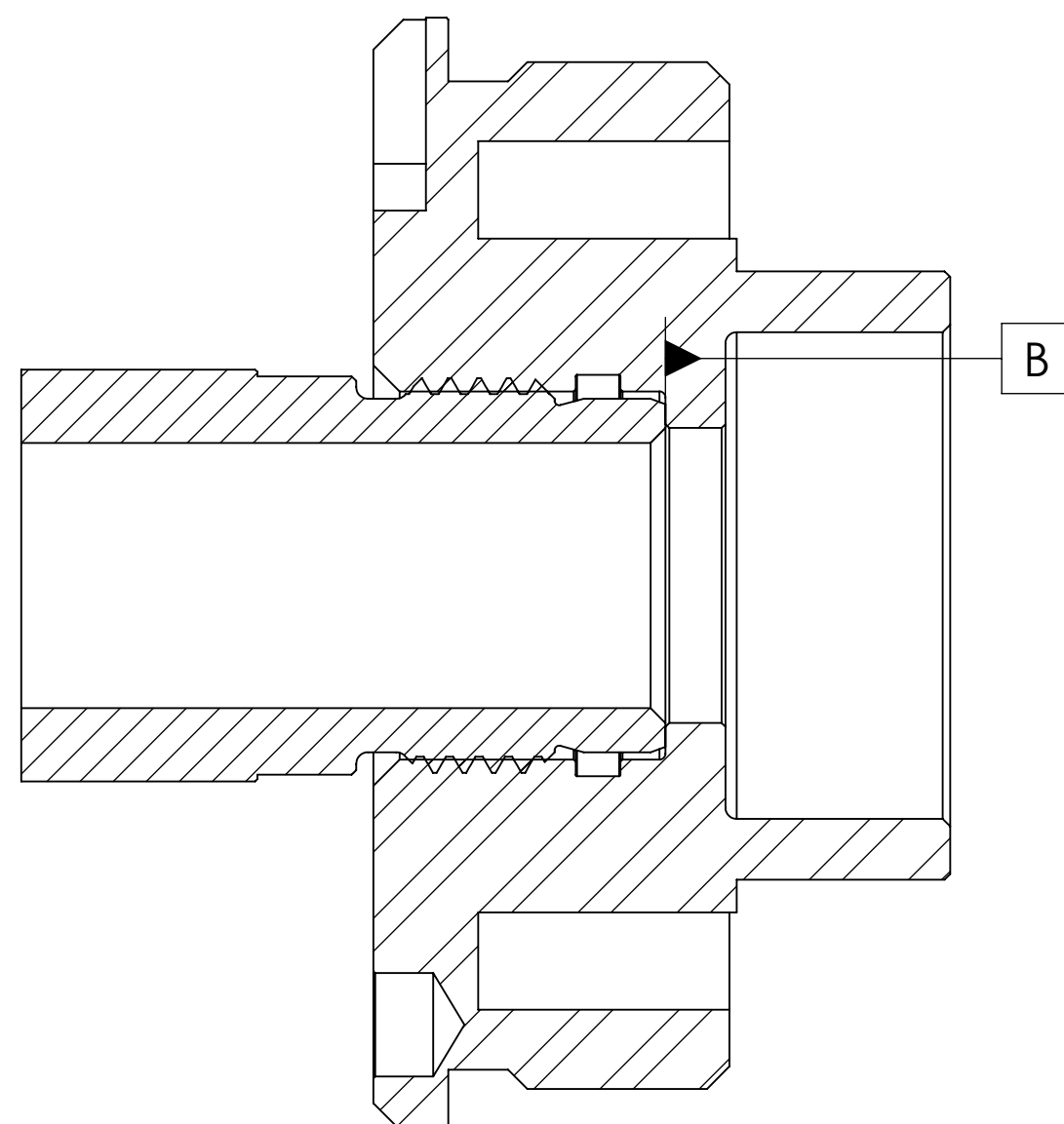
.578-28
CENTERFIRE PISTOL
MUZZLE THREADS

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PERPENDICULARITY: .001/INCH CIRCULARITY: .0005	SHEET SIZE: D DRAWING REVISION: A1
	SCALE: 10:1 SHEET 15 OF 16

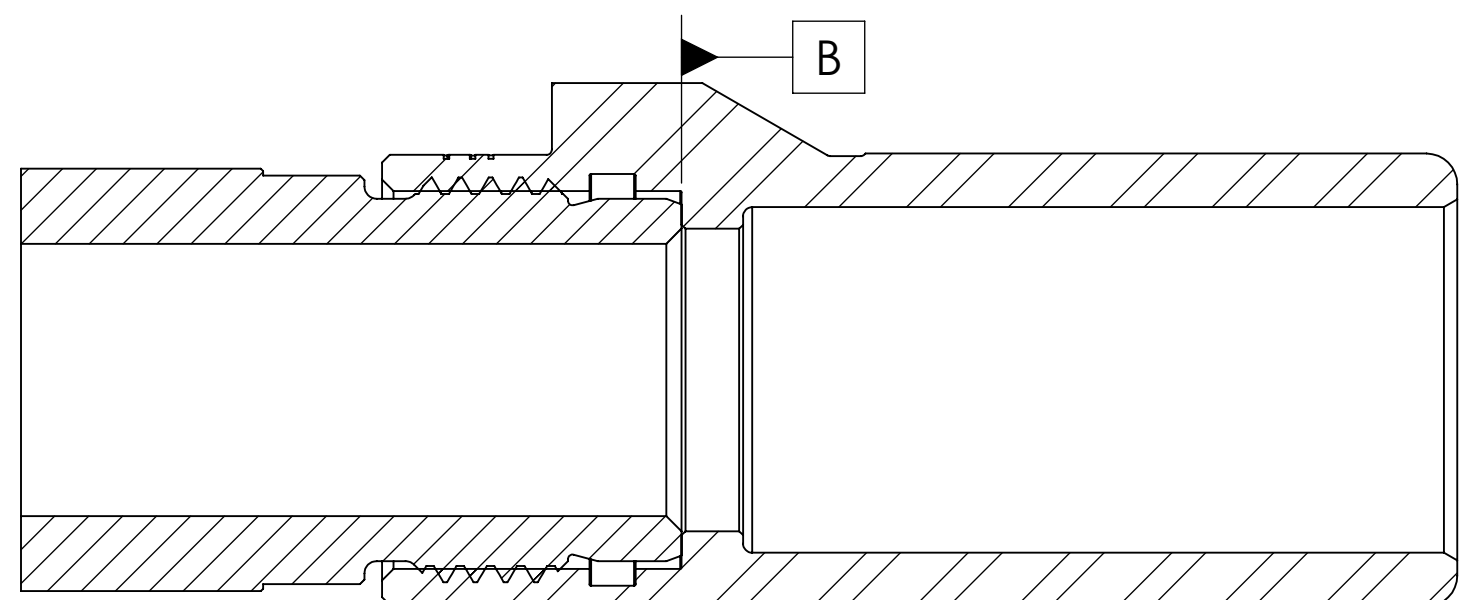
NOTE: M13.5 X 1LH IS A COMMON PISTOL BARREL THREAD FOR 9MM CHAMBERED HANDGUNS, MOST COMMONLY H&K® PLATFORMS. ALL SILENCERCO® METRIC CENTERFIRE PISTOL ACCESSORIES SHOULDER ON THE NOSE OF THE THREADS, OR @ LOCATION B.



SECTION VIEW WITH M13.5 X 1 LH PISTON (AC26) FOR TILTING BARREL LOCKING MECHANISMS/BOOSTER ASSEMBLIES. OTHER SIMILAR PISTONS INCLUDE: M13.5 X 1LH XL PISTON (AC626), M14.5 X 1LH (AC27), M16 X 1LH (AC28) & M16 X 1RH (AC29).



SECTION VIEW WITH M13.5 X 1LH BRAVO THREAD MOUNT M13.5 x 1LH (AC1563) FOR FIXED BARREL APPLICATIONS.

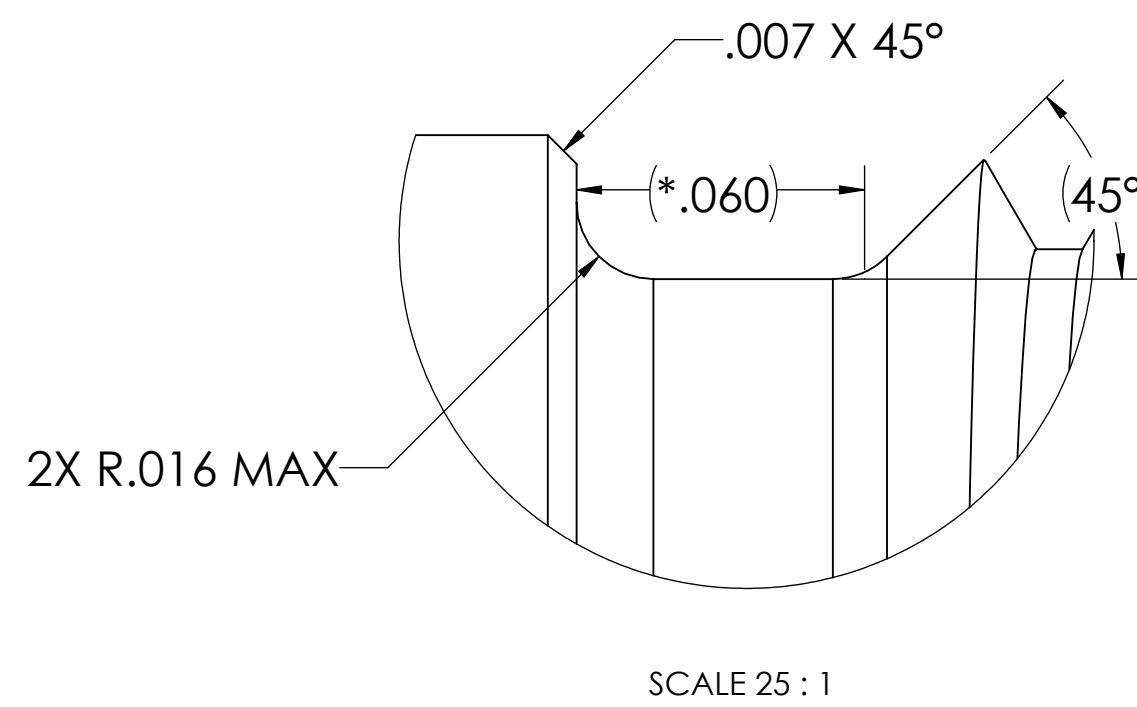


SECTION VIEW WITH M13.5 X 1LH 3 LUG MOUNT (AC2602) FOR FIXED BARREL APPLICATIONS. SILENCERCO ALSO OFFERS A 3 LUG MOUNT IN M16 X 1LH 45ACP (AC2608)

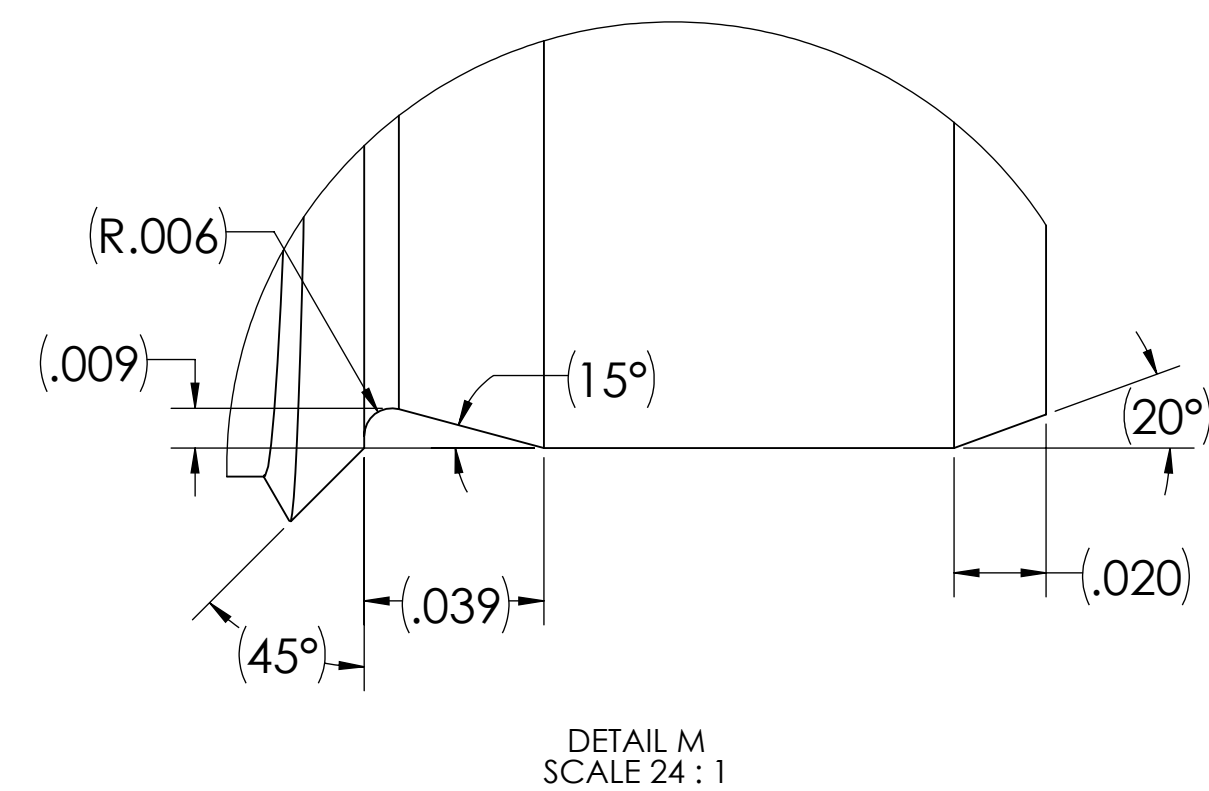
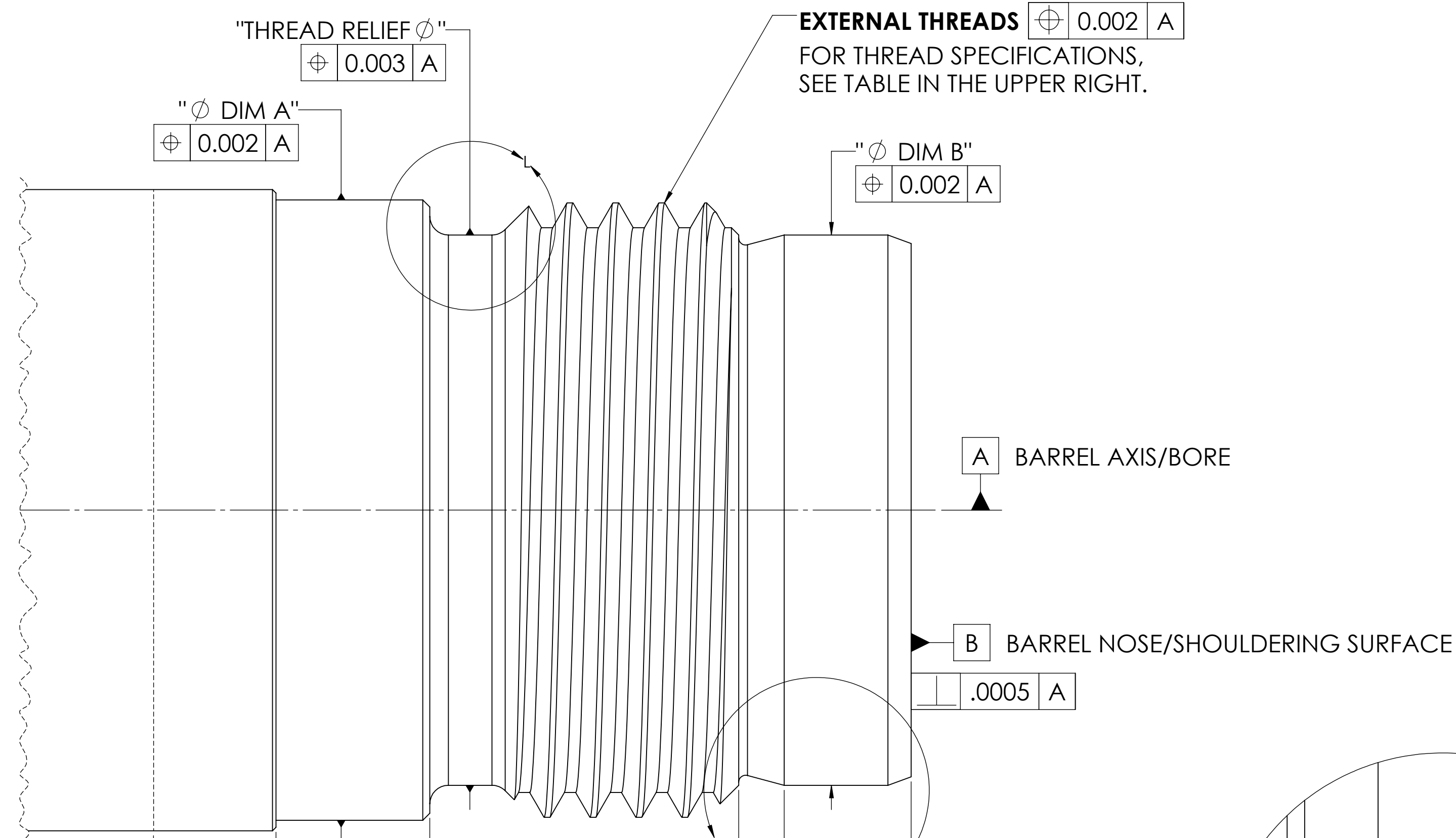
NOTES:

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THREAD TYPE	M13.5X1-4G6G LH	M14.5X1-4G6G LH	M16X1-4G6G LH	M16X1-4G6G RH
PITCH ϕ	$\phi .5034 \pm .0015$	$\phi .5428 \pm .0015$	$\phi .6018 \pm .0015$	$\phi .6018 \pm .0015$
MAJOR ϕ	$\phi .5269 \pm .0035$	$\phi .5663 \pm .0035$	$\phi .6254 \pm .0035$	$\phi .6254 \pm .0035$
"THREAD RELIEF ϕ "	$\phi .472 \pm .002$	$\phi .512 \pm .002$	$\phi .571 \pm .002$	$\phi .571 \pm .002$
"MINIMUM BARREL ϕ "	$\phi .530$	$\phi .568$	$\phi .626$	$\phi .626$
"DIM A"	$\phi .5305 \pm .0005$	$\phi .5685 \pm .0005$	$\phi .6265 \pm .0005$	$\phi .6265 \pm .0005$
"DIM B"	$\phi .4715 \pm .0005$	$\phi .5135 \pm .0005$	$\phi .5715 \pm .0005$	$\phi .5715 \pm .0005$
"DIM C"	.625	.625	.690	.690



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M13.5, 14.5 & 16X1 LH CENTERFIRE PISTOL MUZZLE THREADS

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CIRCULARITY: .0005	
DRAFTER: Jared H.	DATE: 3/4/2024
SHEET SIZE: D	DRAWING REVISION: A1
SCALE: 10:1	SHEET 16 OF 16