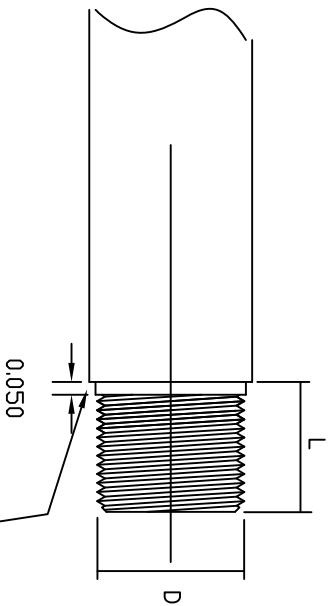


## HANDGUNS



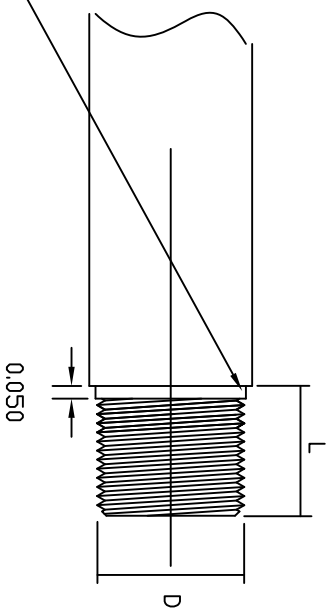
.22LR: 1/2-28 (2A)  
 L = 0.400 Maximum  
 D = 0.5 inch nominal  
 Major: .499 max, .493 min  
 PD: .4757 max, .472 min

9mm: 1/2-28 (2A)  
 L = 0.450 ±0.010 inch  
 D = 0.5 inch nominal  
 Major: .499 max, .493 min  
 PD: .4757 max, .472 min

.40S&W: 9/16-24 (2A)  
 L = 0.450 ±0.010 inch  
 D = 0.562 inch nominal  
 Major: .561 max, .554 min  
 PD: .5342 max, .5302 min

.45ACP: 37/64-28 (2A) (.578-28)  
 L = 0.450 ±0.010 inch  
 D = 0.578 inch nominal  
 Major: .5769 max, .5704 min  
 PD: .5537 max, .5499 min

## RIFLES



.22LR: 1/2-28 (2A)  
 L = 0.400 Maximum  
 D = 0.5 inch nominal  
 Major: .499 max, .493 min  
 PD: .4757 max, .472 min

.223 (5.56mm): 1/2-28 (2A)  
 L = 0.600 ±0.025 inch  
 D = 0.5 inch nominal  
 Major: .499 max, .493 min  
 PD: .4757 max, .472 min

.30 caliber: 5/8-24 (2A)  
 L = 0.600 ±0.025 inch  
 D = 0.625 inch nominal  
 Major: .624 max, .617 min  
 PD: .5967 max, .5927 min

- NOTES:
- Rifle:
1. No thread relief
  2. Barrel diameter must be greater than thread major diameter.
  3. Leave shoulder sharp.

- Pistol:
1. Thread relief optional but not encouraged
  2. 1911 .578-28 barrels align on the barrel face and have no shoulder at back.
  3. If barrel diameter greater than thread major diameter, leave shoulder sharp.
  4. Be sure back of threads (shoulder area) will clear recoil spring guide rod during cycling. On Glock & SIG pistols, this is generally 0.2 inch.

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES

TOLERANCE DN:

.XX .XXX ANGLES  
 ± .01 ± .005 ± 30'  
 100/ UNLESS NOTED

CONCENTRIC WITHIN .003 T.I.R.  
 WORK TO DIMENSIONS  
 DD NDT SCALE



**GEMTECH**  
 BOISE, IDAHO

DESIGNED BY	DATE	DRAWING TITLE
GREG LATKA	06-01-07	GEMTECH BARREL THREADING
P. DATER	DATE	PART NUMBER
REVISION	7-10-11	
B		
SCALE:		MATERIAL
2 TO 1		