




# SILENCERCO

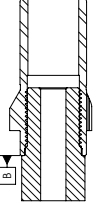
## MUZZLE THREAD GUIDE

**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.

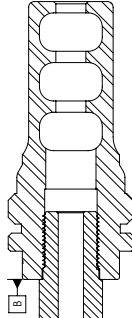
 <b>SILENCERCO, LLC</b> 5750 WOODS LANE WEST VALLEY, UT 84186	
PROPRIETARY AND CONFIDENTIAL THIS DOCUMENT IS THE PROPERTY OF SILENCERCO, LLC UNAUTHORIZED REPRODUCTION IS PROHIBITED	
<b>SECTION 1: RIFLE MUZZLE THREADS</b>	
ENGINEER: JAMES M. JEFFERS	DATE: 11/20/2024
SHEET: D	REVISED: A1
SHEET 1 OF 1	SHEET TOTAL: 1

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	
-500-28 UNF-3A		-500-28 UNS-2A													
THESE DIMENSIONS ARE TO BE USED UNLESS OTHERWISE SPECIFIED		THESE DIMENSIONS ARE TO BE USED UNLESS OTHERWISE SPECIFIED													
PITCH Ø		Ø .4754 ± .0014													
MAJOR Ø		Ø .4957 ± .0033													

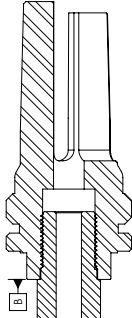
NOTE: 1/2 - 28 (.500-28) RIFLE BARREL THREAD IS MOST COMMONLY USED WITH 22 CALIBER, 9MM, & 30 CALIBER. SILENCERCO OFFERS A MOUNTING OPTION FOR ALL OF OUR PRODUCTS WITH 1/2 - 28 THREADS. ALL SILENCERCO 1/2 - 28 CENTERFIRE RIFLE ACCESSORIES SHOULD BE BEHIND THE THREADS, OR @ LOCATION [B].



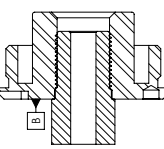
SECTION VIEW WITH 1/2 - 28 9MM 3 LUG MOUNT (AC2604) FOR PISTOL CALIBER & SUBSONIC RIFLE APPLICATIONS.



SECTION VIEW WITH 1/2 - 28 5.56/.223 ASB MUZZLE BRAKE (AC 424). OTHER CALIBER FLASH HIDERS ARE AVAILABLE IN THE 1/2 - 28 THREAD PATTERN, SUCH AS 5.56/9MM (AC 4753), 30 CAL (AC 282), A SINGLE PORT 9MM (AC2628) & A THREAD OVER MUZZLE DEVICE (AC5232).

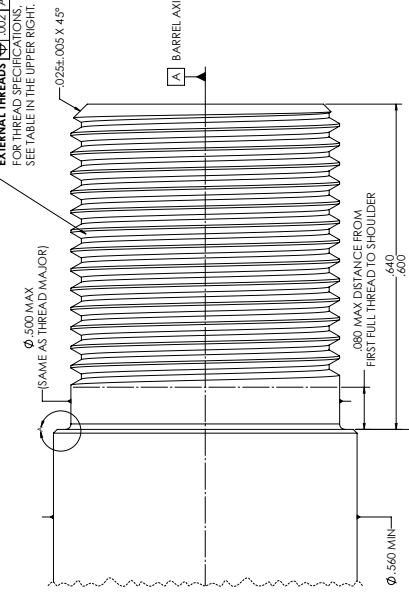


SECTION VIEW WITH 1/2 - 28 5.56/.223 ASB FLASH HIDER (AC 411). OTHER CALIBER FLASH HIDERS ARE AVAILABLE IN THE 1/2 - 28 THREAD PATTERN, SUCH AS 9MM (AC 1570) & 30 CAL (AC 1283). ALSO, 5.56 CAL CLOSED TINE (AC5324).

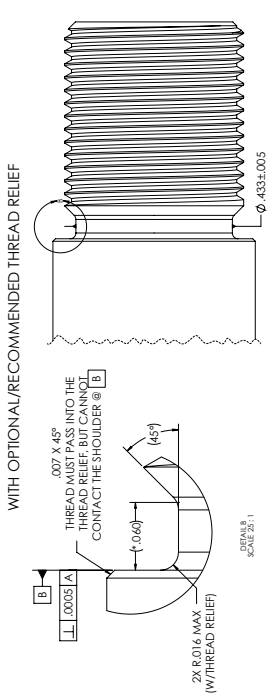


SECTION VIEW WITH 1/2 - 28 ALPHA DIRECT THREAD (AC 633) CHARLIE 1/2 - 28 DT (AC 4740) & BRAVO 1/2 - 28 DT (AC 415). HAVE A SIMILAR INTERIOR THREAD PROFILE.

- MACHINIST NOTES:  
 UNLESS OTHERWISE SPECIFIED:  
 1. REMOVE BURRS/BREAK ALL EDGES TO A MAX OF .005.  
 2. ALL DIMENSIONS ARE TO BE TO THE UNLESS OTHERWISE SPECIFIED.  
 3. DIMENSIONS WITH "±" ARE TO A THEORETICAL INTERSECTION.  
 4. ALL INFA RULES APPLY TO RIFLE BARREL OVERALL LENGTH SELECTION, ASSEMBLY, AND USE.  
 5. CRUSH WASHERS.  
 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. FOR USE WITH MUZZLE DEVICES BETWEEN 25.34 FL INCHES.  
 9. FOR TYPING OF SILENCERCO MUZZLE BRAKES, USE THE SUPPLIED PRECISION SHIMS.



MUZZLE DEVICE SHOULDERING SURFACE [B] .0005 [A]



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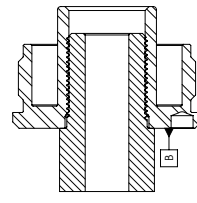
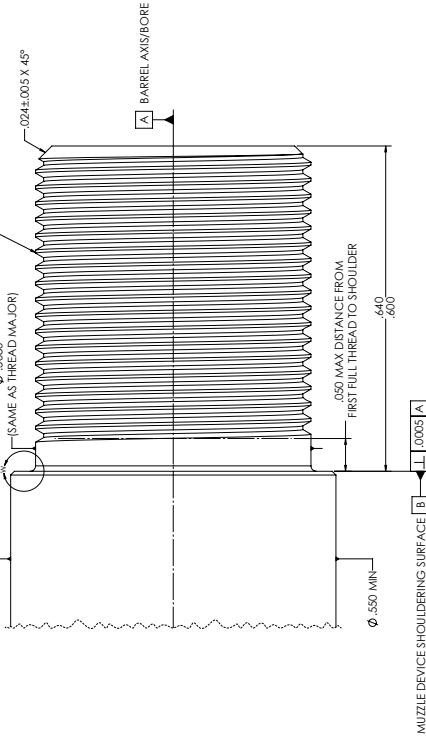
**.500-28 CENTERFIRE RIFLE MUZZLE THREADS**

DATE: 10/20/2019  
 DRAWN BY: JAMES H. [REDACTED]  
 CHECKED BY: [REDACTED]  
 SCALE: 1:1  
 SHEET: 1 OF 1

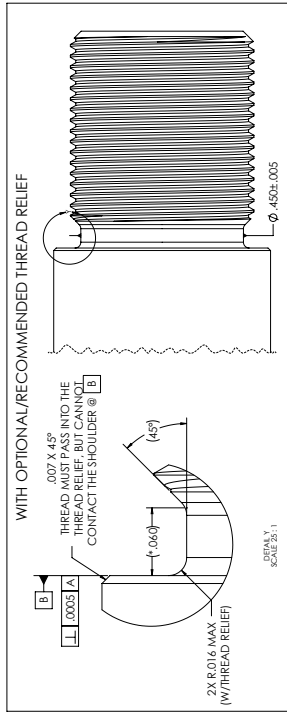
THREAD TYPE	M13X.75 4H6H	M13X.75 4G4G
PITCH $\phi$	$\phi$ .4913 $\pm$ .0013	$\phi$ .4905 $\pm$ .0013
MAJOR $\phi$	$\phi$ .5090 $\pm$ .0028	$\phi$ .5082 $\pm$ .0028

NOTE: M13X.75 RIFLE BARREL THREAD IS MOST COMMONLY USED WITH RIFLE & 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 BEHIND THE THREADS, OR @ LOCATION [B].

EXTERNAL THREADS  $\phi$ .007 [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. ALL DIMENSIONS ARE UNLESS OTHERWISE SPECIFIED.  
 3. DIMENSIONS WITH "T" ARE TO A THEORETICAL INTERSECTION.  
 4. ALL INFA RULES APPLY TO RIFLE BARREL OVERALL LENGTH SELECTION.  
 5. ASSEMBLY USE 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. FOR USE WITH MUZZLE DEVICES BETWEEN 25.34 FLBS.  
 9. FOR TIMING OF SILENCERCO MUZZLE BRAKES, USE THE SUPPLIED PRECISION SHIMS.

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**M13X.75 CENTERFIRE RIFLE MUZZLE THREADS**

DATE: 11/20/24  
 ENGINEER: JAMES H. [REDACTED]  
 DRAWN: [REDACTED]  
 SCALE: 1:1  
 SHEET: 1 OF 1  
 REVISED: [REDACTED]

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

<b>THREAD TYPE</b>	<b>.5625-24 UNF-3A .5625-24 UNF-2A</b>
<b>PITCH Ø</b>	Ø .5322 ± .0020
<b>MAJOR Ø</b>	Ø .5399 ± .0015
<b>MINOR Ø</b>	Ø .5599 ± .0036
	Ø .5577 ± .0036
	Ø .5170 MAX
	Ø .5162 MAX

**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 BEHIND THE THREADS. OR @ LOCATION [B].



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**.5625-24 CENTERFIRE RIFLE MUZZLE THREADS**

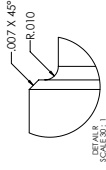
DATE: 11/11/2014  
 ENGINEER: J. HARRIS  
 DRAWN: J. HARRIS  
 SCALE: 1:1  
 SHEET: 1 OF 1

PROPERTY: [ ]  
 PART: [ ]  
 QUANTITY: [ ]  
 DRAWING: [ ]  
 SHEET: [ ]

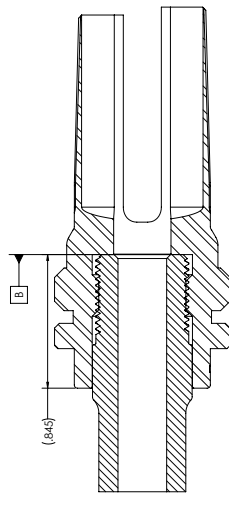
THREAD TYPE	M15 X 1-4H6H	M15 X 1-4G6G
PITCH $\phi$	$\phi$ .5635 $\pm$ .0015	$\phi$ .5624 $\pm$ .0015
MAJOR $\phi$	$\phi$ .5870 $\pm$ .0035	$\phi$ .5860 $\pm$ .0035
MINOR $\phi$	$\phi$ .5479 MAX	$\phi$ .5489 MAX

NOTE: M15X1 RIFLE BARREL THREADS ARE MOST COMMONLY USED WITH 5.56 & .308 CALIBER RIFLES SUCH AS THE M16, M16A1, M16A2, M16A3, M16A4, M16A5, M16A7, M16A8, M16A9, M16A10, M16A12, M16A13, M16A14, M16A15, M16A16, M16A17, M16A18, M16A19, M16A20, M16A21, M16A22, M16A23, M16A24, M16A25, M16A26, M16A27, M16A28, M16A29, M16A30, M16A31, M16A32, M16A33, M16A34, M16A35, M16A36, M16A37, M16A38, M16A39, M16A40, M16A41, M16A42, M16A43, M16A44, M16A45, M16A46, M16A47, M16A48, M16A49, M16A50, M16A51, M16A52, M16A53, M16A54, M16A55, M16A56, M16A57, M16A58, M16A59, M16A60, M16A61, M16A62, M16A63, M16A64, M16A65, M16A66, M16A67, M16A68, M16A69, M16A70, M16A71, M16A72, M16A73, M16A74, M16A75, M16A76, M16A77, M16A78, M16A79, M16A80, M16A81, M16A82, M16A83, M16A84, M16A85, M16A86, M16A87, M16A88, M16A89, M16A90, M16A91, M16A92, M16A93, M16A94, M16A95, M16A96, M16A97, M16A98, M16A99, M16A100.

ALL SILENCERCO M15X1 CENTERFIRE RIFLE ACCESSORIES SHOULD BE ON THE NOSE, OR @ LOCATION [B].



(COSMETIC REPRESENTATION OF COMMON M15X1 BARREL PROFILE)



EXTERNAL THREADS [A] .002 [A]  
FOR THREAD SPECIFICATIONS  
SEE TABLE IN THE UPPER RIGHT.

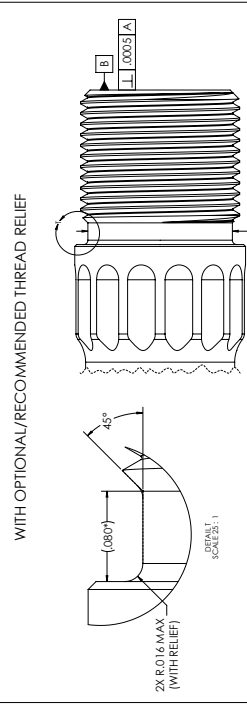
$\phi$  .5871 SAME AS  
THREAD MAJOR

$\phi$  .000  $\pm$  .005 X 45°

[A] BARREL AXIS/BORE

[B] BARREL NOSE [A] .00035 [A]  
MUZZLE DEVICE SHOULDERING SURFACE

.570  
THREAD  
DEPTH



- MACHINIST NOTES:
- UNLESS OTHERWISE SPECIFIED, REMOVE BURRS/BREAK ALL EDGES TO A MAX OF .005.
  - GAGE ALL THREADS BETWEEN 1 TO 3 TURNS MAX OF NO.GO.
  - DIMENSIONS WITH "±" ARE TO A THEORETICAL INTERSECTION.
  - ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED APPLY TO THE BARRE OVERALL LENGTH SELECTION.
  - ASSEMBLY NOTES:
  - AVOID USING A CRUSH WASHER.
  - UTILIZE ROCKSET OR ANOTHER HIGH-TEMPERATURE THREAD LOCKER.
  - FOR TIGHTENING OF SILENCERCO MUZZLE BRAKES, USE THE SUPPLIED PRECISION SHIMS.

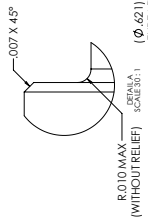
**SILENCERCO, LLC**  
WEST VALLEY, UT 84118

**M15X1 CENTERFIRE RIFLE  
MUZZLE THREADS**

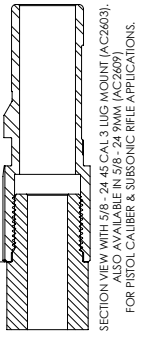
DATE: 11/15/2024  
SCALE: 1:1  
SHEET: 1 OF 1  
REVISED: A1

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 SHOULD BE POSITIONED BEHIND THE THREADS, OR @ LOCATION [B].

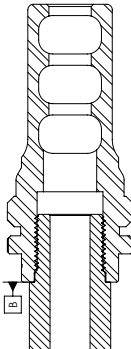
THREAD TYPE	.625-24 UNF-3A	.625-24 UNF-2A	.625-32 UN-3A
PITCH $\phi$	$\phi$ .5964 $\pm$ .0015	$\phi$ .5947 $\pm$ .0020	$\phi$ .6033 $\pm$ .0013
MAJOR $\phi$	$\phi$ .6214 $\pm$ .0036	$\phi$ .6202 $\pm$ .0036	$\phi$ .6270 $\pm$ .0030
MINOR $\phi$	$\phi$ .5797 MAX	$\phi$ .5787 MAX	$\phi$ .5910 MAX



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

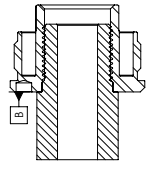


SECTION VIEW WITH 5/8-24 45 CAL 3 LUG MOUNT (AC2603). ALSO AVAILABLE IN 5/8-24 9MM (AC2609). FOR PISTOL CALIBER & SUBSONIC RIFLE APPLICATIONS.



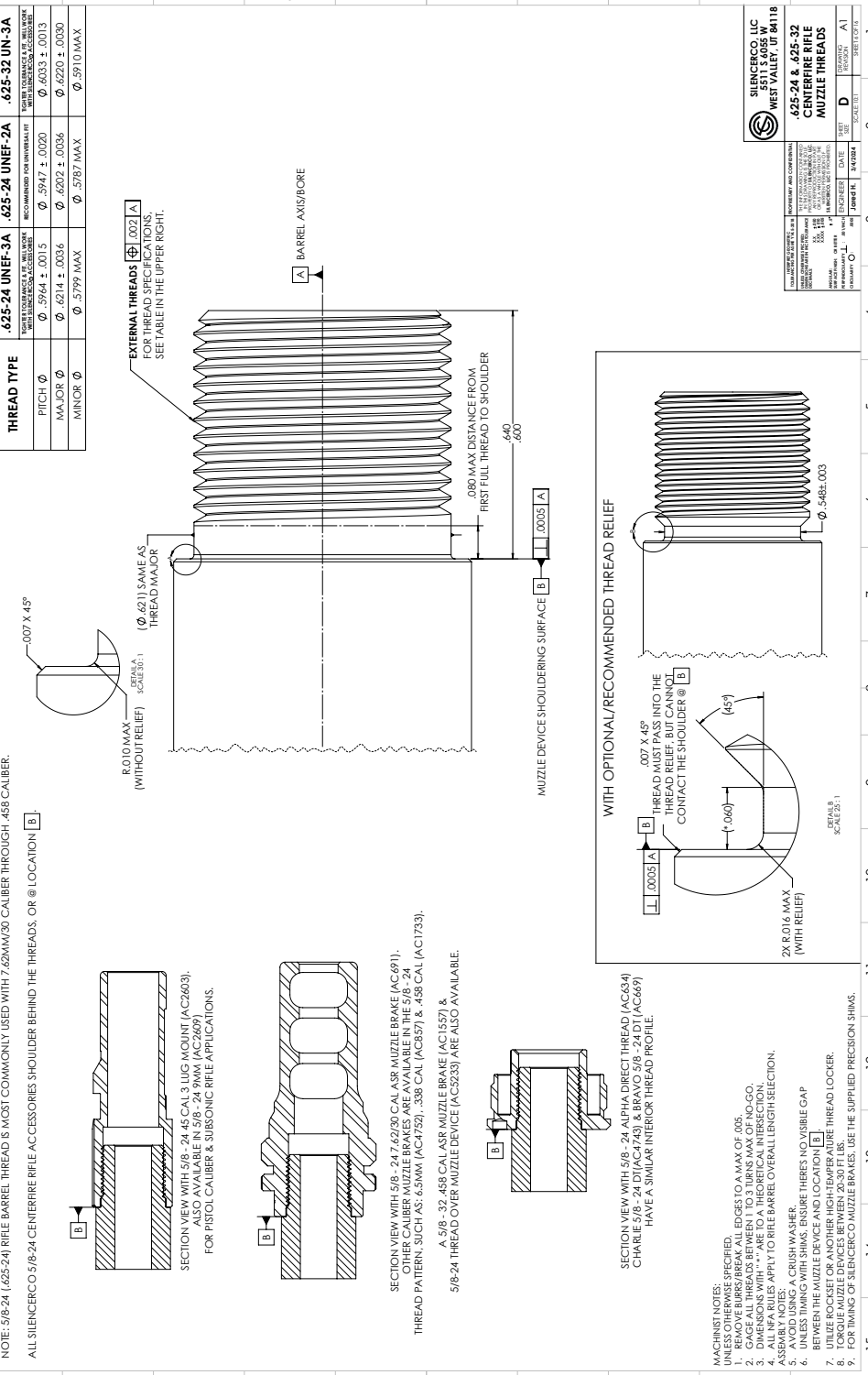
SECTION VIEW WITH 5/8-24 45 CAL 4 LUG MOUNT (AC6911). OTHER CALIBER MUZZLE BRAKES ARE AVAILABLE IN THE 5/8-24 THREAD PATTERN, SUCH AS: 6.5MM (AC4752), .338 CAL (AC6577) & .458 CAL (AC1733).

A 5/8-24 458 CAL ASR MUZZLE BRAKE (AC1557) & 5/8-24 THREAD OVER MUZZLE DEVICE (AC3633) 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.

- MACHINIST NOTES:
1. REMOVE BURRS/BREAK ALL EDGES TO A MAX OF .005.
  2. ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE TO THEORETICAL INTERSECTION.
  3. DIMENSIONS WITH "T" ARE TO A THEORETICAL INTERSECTION.
  4. ALL NFA RULES APPLY TO RIFLE BARREL OVERALL LENGTH SELECTION.
  5. ASSEMBLY NOTES:
    - A. CRUSH WASHER.
    - B. UNLESS TIMING WITH SHIMS. ENSURE THERE'S NO VISIBLE GAP BETWEEN THE MUZZLE DEVICE AND LOCATION [B].
  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.



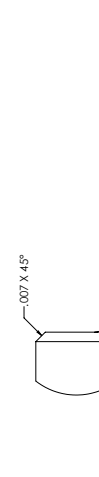
**SILENCERCO, LLC**  
 WEST VALLEY, UT 84118

**.625-24 & .625-32 RIFLE BARREL MUZZLE DEVICES**

DATE: 12/20/2023  
 DRAWN BY: JAMES RE  
 CHECKED BY: JAMES RE  
 SCALE: 1:1  
 SHEET: 1 OF 1

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

THREAD TYPE	.6875-24 UNEF-3A	.6875-24 UNEF-2A
THEORETICAL MAJOR DIAMETER	0.6875	0.6875
THEORETICAL MINOR DIAMETER	0.6562	0.6562
THEORETICAL PITCH DIAMETER	0.6719	0.6719
THEORETICAL PITCH	0.0417	0.0417
RECOMMENDED FOR UNIFORM FIT		
PITCH $\phi$	$\phi$ .6572 $\pm$ .0020	$\phi$ .6572 $\pm$ .0020
MAJOR $\phi$	$\phi$ .6839 $\pm$ .0036	$\phi$ .6827 $\pm$ .0036
MINOR $\phi$	$\phi$ .6579 MAX	$\phi$ .6567 MAX



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 SHOULD BE POSITIONED BEHIND THE THREADS, OR @ LOCATION [B].

SECTION VIEW WITH 11/16 - 24, 4.58 CAL. ASR MUZZLE BRAKE (AC1961).



SECTION VIEW WITH 11/16 - 24 BRAYO DIRECT THREAD (AC2489) CHARLIE 11/16 - 24 DT (AC4741) HAS A SIMILAR INTERIOR THREAD PROFILE.



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



ROTD MAX (WITHOUT RELIEF)



MUZZLE DEVICE SHOULDERING SURFACE [B]



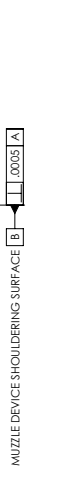
WITH OPTIONAL/RECOMMENDED THREAD RELIEF



THREAD MUST PASS INTO THE THREAD RELIEF, BUT CANNOT CONTACT THE SHOULDER @ [B]



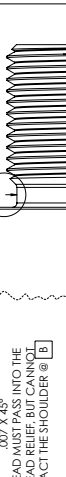
2X R.O.D. (WITH RELIEF)



UNLESS OTHERWISE SPECIFIED, EDGES TO A MAX OF .005.



1. REMOVE BURRS/SHIMS FROM ALL EDGES TO .005.



2. DIMENSIONS WITH "X" ARE TO A THEORETICAL INTERSECTION.



3. ALL NFA RULES APPLY TO RIFLE BARREL OVERALL LENGTH SELECTION.



4. ALWAYS USE A CRUSH WASHER.



5. UNLESS TIMING WITH SHIMS, ENSURE THERE IS NO VISIBLE GAP BETWEEN THE MUZZLE DEVICE AND LOCATION [B].



6. UNLESS TIMING WITH SHIMS, ENSURE THERE IS NO VISIBLE GAP BETWEEN THE MUZZLE DEVICE AND LOCATION [B].



7. UNLESS TIMING WITH SHIMS, ENSURE THERE IS NO VISIBLE GAP BETWEEN THE MUZZLE DEVICE AND LOCATION [B].



8. FOR RIFLE MUZZLE DEVICES BETWEEN 2.580 FT LBS AND 4.500 FT LBS, USE THE SUPPLIED PRECISION SHIMS.



9. FOR BRASS OR SILENCERCO MUZZLE BRAKES, USE THE SUPPLIED PRECISION SHIMS.



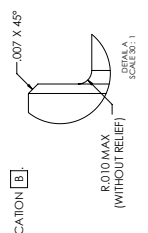
SILENCERCO, LLC  
 WEST VALLEY, UT 84118  
 CENTERFIRE RIFLE  
 .6875-24  
 MUZZLE  
 THREADS

SCALE: 1:1  
 SHEET 1 OF 1

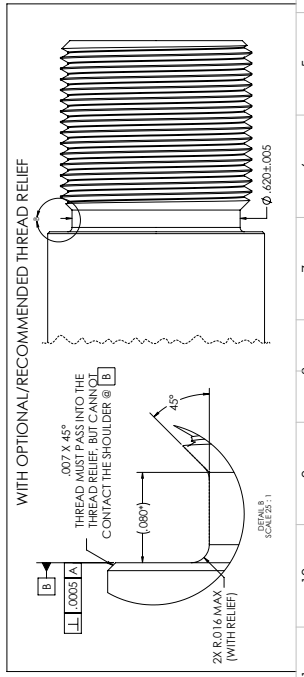
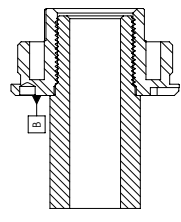
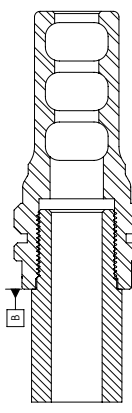
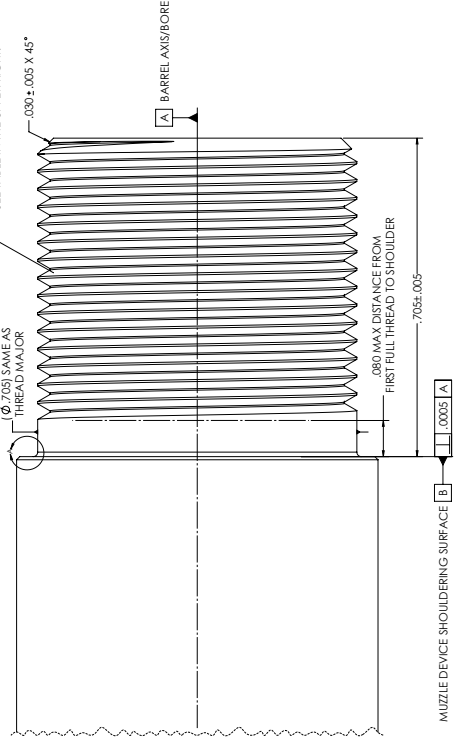
DATE: 11/16/2024  
 ENGINEER: JAMES H. [REDACTED]  
 DRAWN: [REDACTED]

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

THREAD TYPE	M18 X 1-4H6H	M18 X 1-4G6G	M18 X 1.5-4H6H	M18 X 1.5-4G6G
PITCH $\phi$	$\phi .6815 \pm .0015$	$\phi .6806 \pm .0015$	$\phi .6806 \pm .0015$	$\phi .672 \pm .0018$
MAJOR $\phi$	$\phi .7051 \pm .0035$	$\phi .7040 \pm .0035$	$\phi .7040 \pm .0046$	$\phi .7027 \pm .0046$
MINOR $\phi$	$\phi .6660 \text{ MAX}$	$\phi .6650 \text{ MAX}$	$\phi .6447 \text{ MAX}$	$\phi .6434 \text{ MAX}$



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



- MACHINIST NOTES:  
 UNLESS OTHERWISE SPECIFIED, LEADER TO A MAX. OF .05  
 1. ALL DIMENSIONS ARE TO UNLESS OTHERWISE SPECIFIED.  
 2. GAGE ALL THREADS BETWEEN TO 3 TURNS MAX. OF NO. GO.  
 3. DIMENSIONS WITH "++" ARE TO A THEORETICAL INTERSECTION.  
 4. ALL NFA RULES APPLY TO REFLE BARREL OVERALL LENGTH SELECTION.  
 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. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE TO UNLESS OTHERWISE SPECIFIED.  
 9. FOR TIMING OF SILENCER MUZZLE BRAKES, USE THE SUPPLIED PRECISION SHIMS.

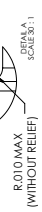
**SILENCERCO, LLC**  
 WEST VALLEY, UT 84118  
 CENTERLINE MUZZLE  
 THREADS  
 SCALE: 3:1  
 SHEET 01 OF 01  
 DATE: 10/20/2024  
 DRAWN BY: JAMES H. JAMES H.  
 CHECKED BY: JAMES H. JAMES H.  
 APPROVED BY: JAMES H. JAMES H.



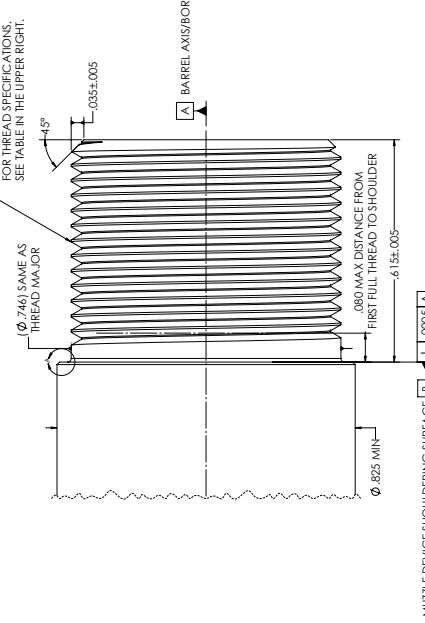
THREAD TYPE	.750-24 UNF-3A	.750-24 UNF-2A	.750-20 UNF-3A
PITCH $\phi$	$\phi$ .7213 $\pm$ .0015	$\phi$ .7192 $\pm$ .0020	$\phi$ .7158 $\pm$ .0016
MAJOR $\phi$	$\phi$ .7464 $\pm$ .0036	$\phi$ .7452 $\pm$ .0036	$\phi$ .7459 $\pm$ .0040
MINOR $\phi$	$\phi$ .7097 MAX	$\phi$ .7037 MAX	$\phi$ .6957 MAX

NOTE: 3/4 - 24 (750-24) RIFLE BARREL THREADS ARE MOST COMMONLY USED WITH .338 CALIBER TO .458 CALIBER.  
 3/4 - 24 (750-24) BARREL THREADS ARE MOST COMMON (BARRETT 7809/OLDER MFRAD, ETC.) SILENCERCO OFFERS  
 A 3/4 - 20 BRAVO DIRECT THREAD MOUNT (AC497)

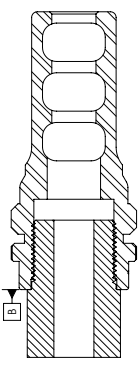
ALL SILENCERCO 3/4 - 24 CENTREFIRE RIFLE ACCESSORIES SHOULD BE POSITIONED BEHIND THE THREADS, OR @ LOCATION [B]



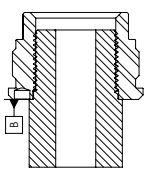
EXTERNAL THREADS [A] FOR THREAD SPECIFICATIONS SEE TABLE IN THE UPPER RIGHT.



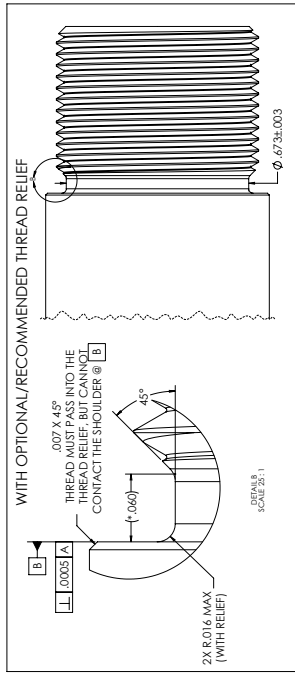
MUZZLE DEVICE SHOULDERING SURFACE [B]



SECTION VIEW WITH 3/4 - 24 .458 CAL ASR MUZZLE BRAKE (AC2631).  
 A 3/4 - 24 .338 CAL ASR MUZZLE BRAKE (AC888) IS ALSO AVAILABLE FROM SILENCERCO.



SECTION VIEW WITH 3/4 - 24 ALPHA DIRECT THREAD (AC468)  
 CHARLIE 3/4 - 24 DT (AC4742) & BRAVO 3/4 - 24 DT (AC668)  
 HAVE A SIMILAR INTERIOR THREAD PROFILE.



WITH OPTIONAL/RECOMMENDED THREAD RELIEF  
 THREAD MUST PASS INTO THE  
 THREAD RELIEF, BUT CANNOT  
 CONTACT THE SHOULDER @ [B]

- MACHINIST NOTES:
- UNLESS OTHERWISE SPECIFIED, EDGES TO A MAX OF .005
  - REMOVE BURRS/SHARP EDGES FROM ALL SURFACES
  - ALL DIMENSIONS WITH "±" ARE TO A THEORETICAL INTERSECTION.
  - ALL NFA RULES APPLY TO RIFLE BARREL OVERALL LENGTH SELECTION.
  - ASSEMBLY USING A CRUSH WASHER.
  - UNLESS TIMING WITH SHIMS, ENSURE THERE'S NO VISIBLE GAP BETWEEN THE MUZZLE DEVICE AND LOCATION [B]
  - UTILIZE ROCKET OR ANOTHER HIGH-TEMPERATURE THREAD LOCKER.
  - FOR RIFLE MUZZLE DEVICES BETWEEN 2.580 FT LBS AND 10.000 FT LBS.
  - FOR BRNO OR SILENCERCO MUZZLE BRAKES, USE THE SUPPLIED PRECISION SHIMS.

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

**.750-24/750-20**  
**CENTREFIRE RIFLE**  
**THREADS**  
**MUZZLE**

DATE: 11/11/2014  
 ENGINEER: JAMES H. JENSEN  
 DRAWN: JAMES H. JENSEN  
 CHECKED: JAMES H. JENSEN  
 SCALE: 25:1

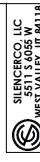
SHEET: 1 OF 1  
 DRAWING: 14118



# 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.



SILENCERCO, LLC  
WEST VALLEY, UT 84118

NOT FOR SALE AND NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.  
DISPATCHER DATE: JUNE 16, 2024  
HANDLING WORK CENTER: SC000001

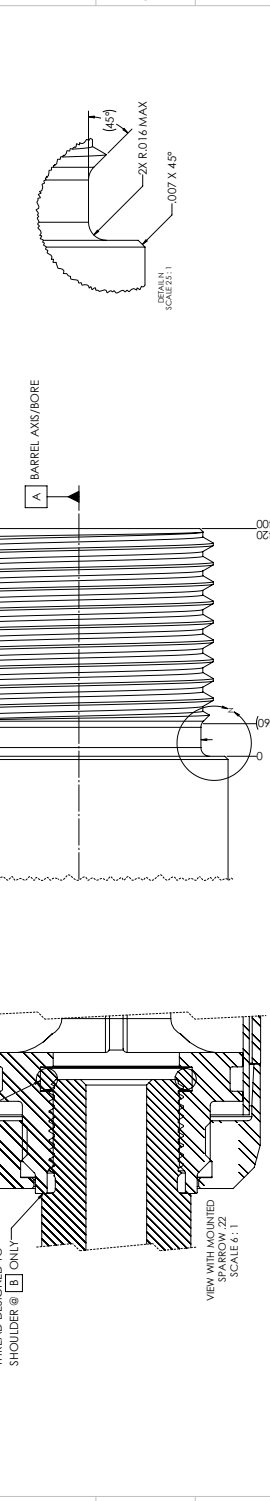
SECTION 2: RIMFIRE & CENTERFIRE PISTOL MUZZLE THREADS  
SHEET D OF D  
REVISED BY A1

DRAWING NO. 24-00001-001

15	14	13	12	11	10	9	8	7	6	5	4	3	2	1
<p>NOTES: 1/2-28 (.500-28) IS A COMMON RIMFIRE BARREL THREAD FOR .17 TO .22 CALIBER CHAMBERED FIREARMS. ALL OF SILENCERCO'S DELTA ADAPTERS &amp; RIMFIRE CANIS ARE EQUIPPED WITH 1/2-28 "SPARROW PROFILE" THREADS. ALL SILENCERCO 1/2-28 RIMFIRE PISTOL ACCESSORIES SHOULD BEHIND THE THREADS, OR @ LOCATION [B].</p>														

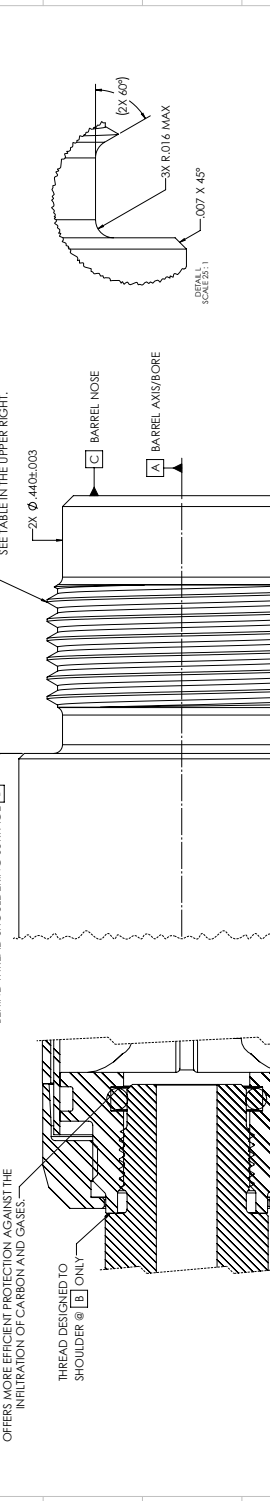
**500-28 STANDARD RIMFIRE MUZZLE THREADS**

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.



**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.



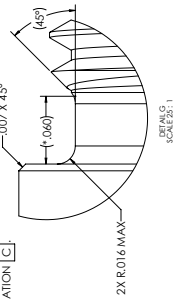
NOTES: UNLESS OTHERWISE SPECIFIED:

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.

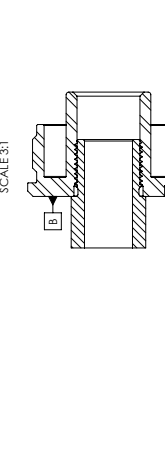
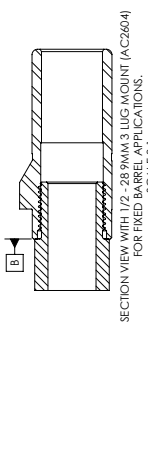
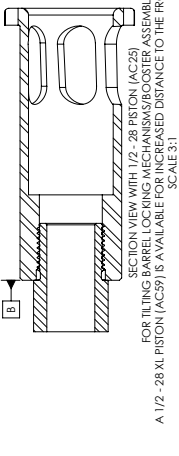
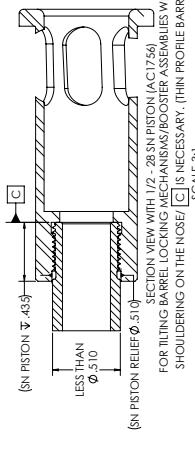
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<p>SILENCERCO, LLC WEST VALLEY, UT 84118</p> <p><b>500-28 RIMFIRE MUZZLE THREADS</b></p> <p>DATE: 11/20/2014 DRAWN: JAMES H. CHECKED: JAMES H. SCALE: 1:1 SHEET 11 OF 16</p>														

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 K J H G F E D C B A

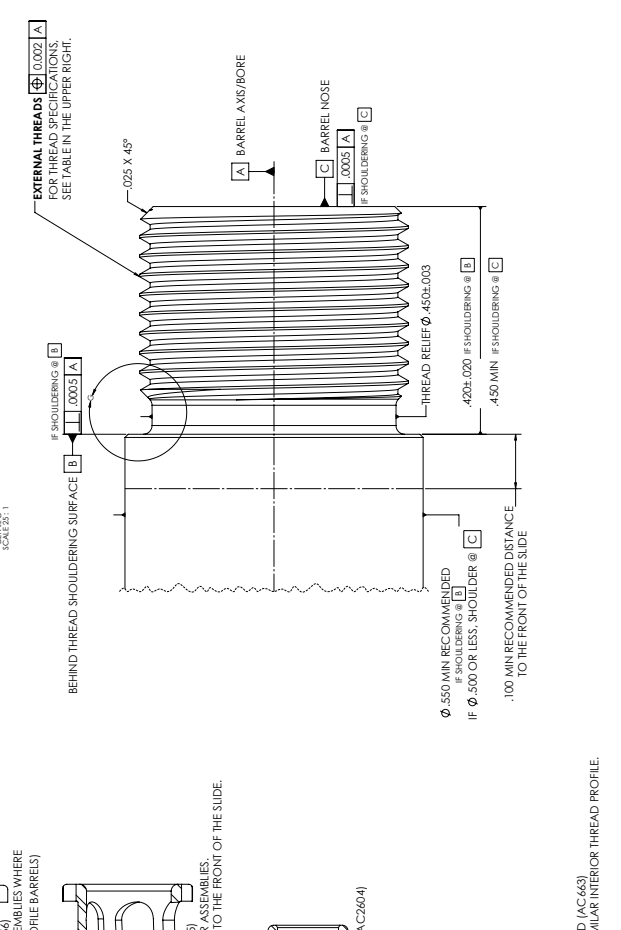
THREAD TYPE	.500-28 UNF-3A	.500-28 UNS-2A
THREADED LENGTH	RECOMMENDED FOR UNIVERSAL FIT	RECOMMENDED FOR UNIVERSAL FIT
PITCH Ø	Ø .4754 ± .0014	Ø .4739 ± .0019
MAJOR Ø	Ø .4967 ± .0032	Ø .4957 ± .0033



NOTE: 1/2-28, 1.625-28 & A COMMON PISTON BARREL THREADS FOR 9MM CHAMBERED HANDGUNS. MOST OF THESE 9MM BARRELS ARE EQUIPPED WITH 1/2-28 THREADS. ALL SILENCER 1/2-28 CENTERPIECE PISTOL ACCESSORIES SHOULD 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].



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.

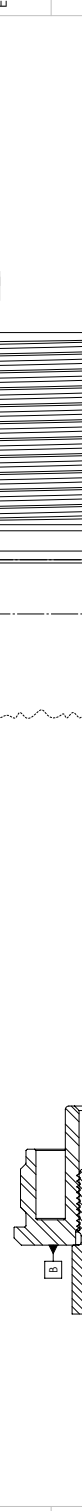
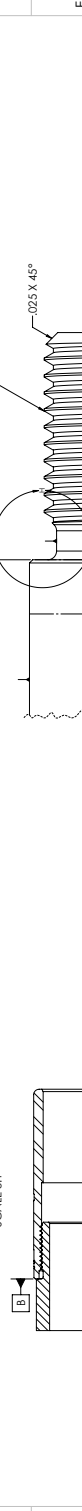


**SILENCER, LLC**  
WEST VALLEY UT 84118  
**500-28 CENTERPIECE PISTON THREADS**  
SCALE 3:1  
DATE: 01/15/2018  
DRAWN: JAC  
CHECKED: JAC

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
		<b>THREAD TYPE</b>		<b>.500-36 UNS-2A</b>	<b>.500-32 UN-2A</b>									
		PITCH $\phi$		$\phi .4793 \pm .0017$	$\phi .4739 \pm .0019$									
		MAJOR $\phi$		$\phi .4962 \pm .0028$	$\phi .4957 \pm .0033$									

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 (COLIC® ETC.).  
 SILENCERCOO DOES NOT OFFER PISTOL BARRELS THREADED IN 1/2-.32 OR 1/2-.36. ALL SILENCERCOO 1/2-.32 & 1/2-.36 ACCESSORIES SHOULD BE THREADED IN 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 (HRK® ETC.).  
 SILENCERCOO 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).



EXTERNAL THREADS  $\phi$  .0021 A FOR THREAD SPECIFICATIONS SEE TABLE IN THE UPPER RIGHT.

PISTON/THREAD MOUNT SHOULDERING SURFACE B

$\phi .550$  MIN. RECOMMENDED .100 MIN. RECOMMENDED DISTANCE TO THE FRONT OF THE SLIDE

102.5 X 45°

$\phi .450 \pm .003$

$\pm .0003$  A

.440

BARREL AXIS/BORE

SECTION VIEW WITH 1/2-.36 ALPHA DIRECT THREAD (AC150) FOR FIXED BARREL APPLICATIONS. SCALE: 3:1

SECTION VIEW WITH 1/2-.32 ALPHA DIRECT THREAD (AC150) 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.

SILENCERCOO, LLC  
 WEST VALLEY, UT 84118

.500-.32 & .500-.34  
 CENTERFIRE PISTOL  
 MUZZLE THREADS

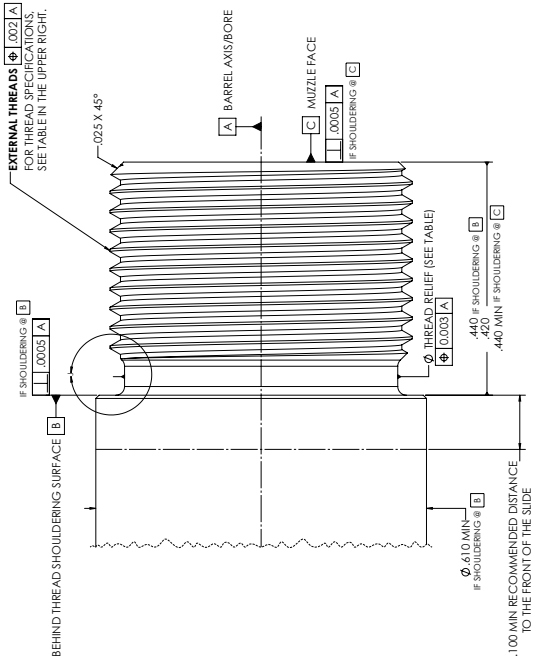
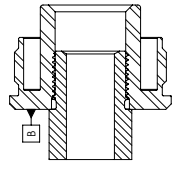
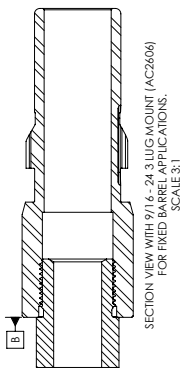
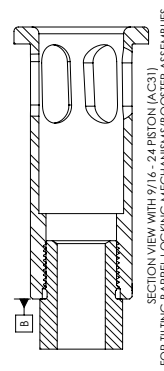
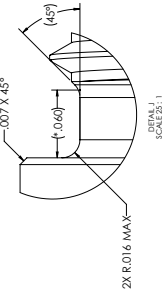
DATE: 11/11/2014  
 DRAWN BY: JAMES H. JENSEN  
 CHECKED BY: JAMES H. JENSEN  
 SCALE: 3:1

REVISED: 11/11/2014  
 SHEET: D  
 DRAWING: A1

THREAD TYPE	.5625-24 UNF-3A	.5625-24 UNS-2A	.5625-28 UN-2A
PITCH $\phi$	$\phi$ .5399 ± .0015	$\phi$ .5322 ± .0020	$\phi$ .5363 ± .0018
MAJOR $\phi$	$\phi$ .5589 ± .0036	$\phi$ .5398 ± .0036	$\phi$ .5518 ± .0032
THREAD RELIEF $\phi$	$\phi$ .497 ± .003	$\phi$ .497 ± .003	$\phi$ .505 ± .003

NOTE: 9/16-24 (.5625-24) IS A COMMON BARREL THREAD FOR 40 S&W AND 10MM CHAMBERED HANDGUNS, ESPECIALLY IN AFTERMARKET BARRELS. THIS IS NOT THE CASE FOR ALL (.5625) BARRELS ARE EQUIPPED WITH 9/16-24 THREADS. ALL SILENCERCO 9/16-24 ACCESSORIES SHOULD BEHIND THE THREADS, OR @ LOCATION B.

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



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

**.5625-24 & .5625-28**  
**CENTERFIRE PISTOL**  
**MUZZLE THREADS**

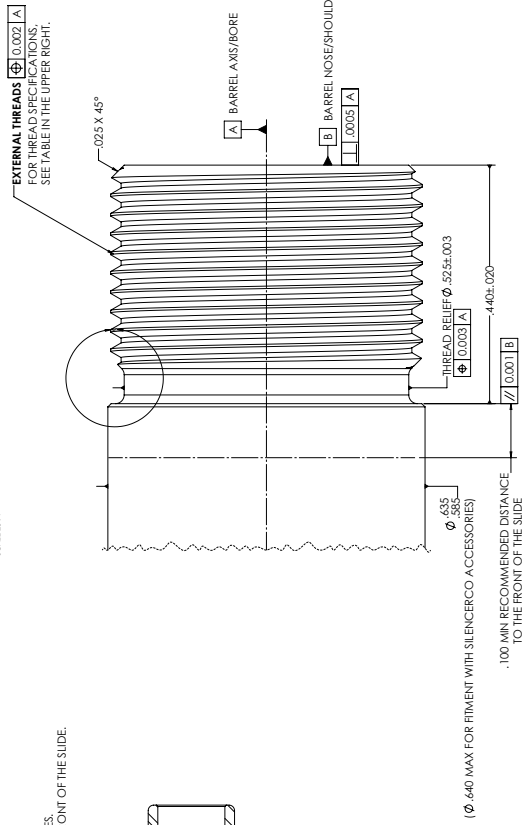
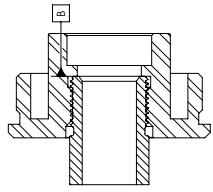
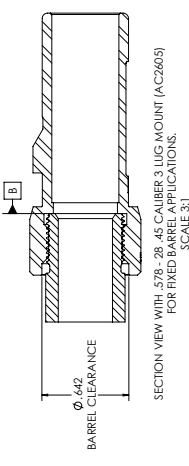
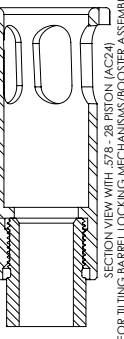
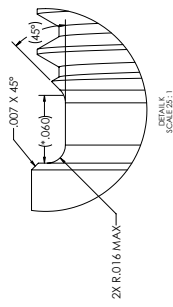
DATE: 11/15/2018  
DRAWN BY: JAMES H. HARRIS  
CHECKED BY: JAMES H. HARRIS  
SCALE: 3:1  
SHEET: D  
REVISED: A1

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.

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

THREAD TYPE	.578-28 UNS-3A	.578-28 UNS-2A
PITCH $\phi$	$\phi .5534 \pm .0014$	$\phi .5518 \pm .0019$
MAJOR $\phi$	$\phi .5749 \pm .0032$	$\phi .5736 \pm .0032$

NOTE: .578-28 IS A COMMON PISTOL BARREL THREAD FOR .45ACP CALIBERED HANDGUNS. SILENCERCO .45 CALIBER PISTOL BARRELS ARE EQUIPPED WITH .578-28 THREADS. ALL SILENCERCO .578-28 CENTERFIRE PISTOL ACCESSORIES SHOULD BE LOCATED AT LOCATION B.



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

**.578-28 CENTERFIRE PISTOL MUZZLE THREADS**

DATE: 11/20/2018  
REVISED: 11/20/2018  
SCALE: 3:1

DESIGNED BY: JAMES H. [A]  
CHECKED BY: [D]  
DRAWN BY: [D]  
REVISED BY: [A]

PROPERTY OF: [A]

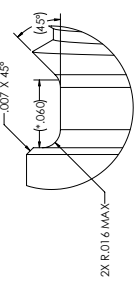
DATE: 11/20/2018  
SCALE: 3:1

PROPERTY OF: [A]

- 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.

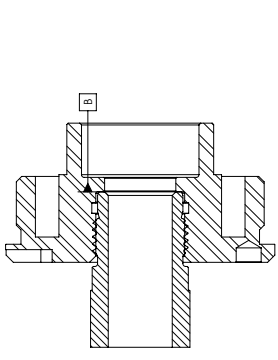
NOTE: M13.5X 1 LH IS A COMMON PISTOL BARREL THREAD FOR 9MM CHAMBERED HANDGUNS. MOST COMMONLY H&G PLATFORMS. ALL SILENCER CO. METRIC CENTERFIRE PISTOL ACCESSORIES SHOULDER ON THE NOSE OF THE THREADS. ON @ LOCATION [B].

THREAD TYPE	M13.5X1-4G6G LH	M14.5X1-4G6G LH	M16X1-4G6G LH	M16X1-4G6G RH
PITCH $\phi$	$\phi$ .5034 $\pm$ .0015	$\phi$ .5428 $\pm$ .0015	$\phi$ .6018 $\pm$ .0015	$\phi$ .6018 $\pm$ .0015
MAJOR $\phi$	$\phi$ .5269 $\pm$ .0035	$\phi$ .5663 $\pm$ .0035	$\phi$ .6254 $\pm$ .0035	$\phi$ .6254 $\pm$ .0035
THREAD RELIEF $\phi$ **	$\phi$ .472 $\pm$ .002	$\phi$ .512 $\pm$ .002	$\phi$ .571 $\pm$ .002	$\phi$ .571 $\pm$ .002
*MINIMUM BARREL $\phi$ **	$\phi$ .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

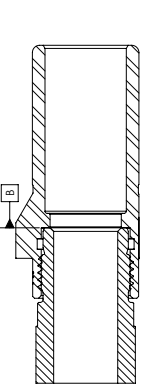


SCALE 28:1

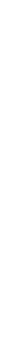
SECTION VIEW WITH M13.5 X 1 LH PISTON (AC26) FOR TILTING BARREL LOCKING MECHANISMS/BOOSTER ASSEMBLIES. OTHER SIMILAR PISTONS INCLUDE: M13.5 X 1 LH XL PISTON (AC626), M14.5 X 1 LH (AC27), M16 X 1 LH (AC28) & M16 X 1 RH (AC29).



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



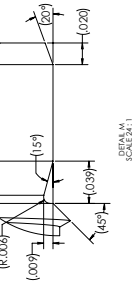
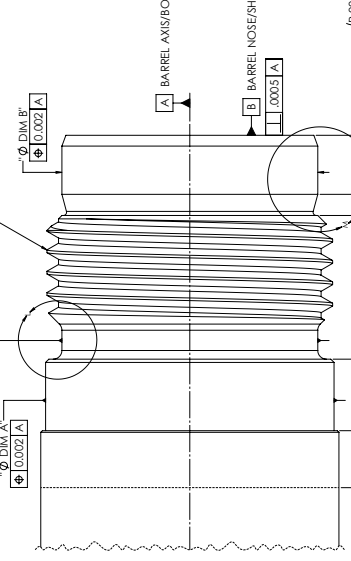
SECTION VIEW WITH M13.5 X 1 LH 3 LUG MOUNT (AC2602) FOR FIXED BARREL APPLICATIONS. SILENCER CO. ALSO OFFERS A 3 LUG MOUNT IN M16 X 1 LH 45ACP (AC2608)



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.

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



SCALE 28:1



SILENCER CO. INC  
WEST VALLEY, UT 84118  
M13.5, 14.5 & 16X1 LH  
CENTERFIRE PISTOL  
MUZZLE THREADS

DESIGNER	DATE	SCALE	SHEET	DRAWING	REV
JAMES H.	11/2008	SCALE 28:1	2	D	A1

QUANTITY OF 10