1. This threading guide contains data for threading firearm barrels that will be compatible with all current production Advanced Armament suppressors and muzzle devices. Many of the thread specifications herein will also be compatible with other manufacturer’s suppressors and muzzle devices. It is the responsibility of the reader to determine if the specifications in this threading guide will work with other manufacturer’s products. Advanced Armament denies any liability for property damage, personal injury, and/or death caused by incompatibility between the thread specifications in this guide and another manufacturer’s products.

2. All muzzle profiling and threading should be performed in a lathe.

3. All threads and coaxial features must align concentrically with the bore axis of the barrel. A mismatch of the barrel bore and suppressor/muzzle device may lead to property damage, personal injury, and/or death.

4. The barrel threads must be machined to the specifications in this threading guide. The use of an improperly threaded barrel with an Advanced Armament suppressor may lead to property damage, personal injury, and/or death.

5. If the host firearm barrel is shortened, it will be necessary to re-crown the muzzle face. Failure to recrown the muzzle face can result in an unstable projectile leaving the muzzle which can result in property damage, personal injury, and/or death.

6. If there are any questions pertaining to the information found in this threading guide, please contact Advanced Armament at 770-925-9988.
0.40-0.438 for indexing on shoulder behind threads

0.460 for indexing on muzzle face.

Hold this surface perpendicular to bore axis if shouldering behind the threads.

Hold muzzle face perpendicular to bore axis if shouldering on the muzzle.

NOTES:

1) CZ-75 and Browning Hi-Power barrels are right at 0.500 diameter. These barrels must be threaded so that they index on the muzzle.

2. DO NOT USE THIS GUIDE FOR A BERETTA 92/M9. The barrel does not meet the 0.56 minimum protrusion criteria. See sheet 3 for Beretta 92/M9.

3. This thread profile can shoulder against the muzzle face or behind the threads.

Advanced Armament Corp.
2408 Tech Center Parkway, Suite 150
Lawrenceville, GA 30043 - 770-925-9988
WWW.ADVANCED-ARMAMENT.COM
NOTES:

THIS THREAD GUIDE IS FOR FULL-SIZED (NOT COMPACT) 9mm AND .40 AUTO BERETTA 92/M9 AND TAURUS PT-92/99 BARRELS.
NOTES:

1) THIS THREAD GUIDE DETAILS A SPECIAL 1/2-28 THREAD FOR 5.56mm/.223 BARRELS. THE THREAD IS DESIGNED TO PROVIDE A BETTER FIT WITH THE 1/2-28-UNEF-3B THREADS IN THE RANGER SILENCER THAN AN INDUSTRY STANDARD CLASS-2B THREAD.
NOTES:

1) THIS THREAD GUIDE DETAILS A BARREL MUZZLE PROFILE WITH 1/2-28-UNEF-2A THREADS AS FOUND ON M4 STYLE RIFLES. THIS THREAD PROFILE IS COMPATIBLE WITH ALL AAC MUZZLE DEVICES.
NOTES:

1) THIS THREAD GUIDE DETAILS A BARREL MUZZLE PROFILE WITH 1/2-28-UNEF-2A THREADS AS FOUND ON M4 STYLE RIFLES. THIS THREAD PROFILE IS COMPATIBLE WITH ALL AAC SPR-M4 MUZZLE DEVICES.
NOTES:
1) THIS THREAD GUIDE DETAILS 1/2-32 AND 1/2-36 THREADS FOR CENTERFIRE PISTOL CALIBER HOSTS. THE 1/2-32 THREAD IS COMMONLY FOUND ON H&K 9mm SMG'S. THE 1/2-36 THREAD IS FOUND ON COLT AND COLT STYLE 9mm AR'S. USE THE SHORTER THREAD LENGTH (.438) FOR USE WITH PISTOL BARRELS. USE THE LONGER LENGTH FOR RIFLE/CARBINE/SMG BARRELS.
GENERAL NOTES:

1) ALL THREADS ARE LEFT HAND.
2) SILENCERS THAT FIT THESE THREADS INDEX ON MUZZLE.

NOTES FOR M13.5 X 1 LEFT HAND THREAD:

1) 0.625" MINIMUM RECOMMENDED DISTANCE BETWEEN MUZZLE AND SLIDE FOR H&K USP SERIES, GLOCKS, AND WALTHER P99/PPQ.
2) 0.580" MINIMUM RECOMMENDED DISTANCE BETWEEN MUZZLE AND SLIDE OF SIG 226, 228, 229.
3) MINIMUM BARREL DIAMETER - Ø13.5mm (0.531"

NOTES FOR M14.5 X 1 LEFT HAND THREAD:

1) 0.625" MINIMUM RECOMMENDED DISTANCE BETWEEN MUZZLE AND SLIDE FOR H&K USP SERIES AND GLOCKS.
2) MINIMUM BARREL DIAMETER - Ø14.5mm (0.571"

NOTES FOR M16 X 1 LEFT HAND THREAD:

1) 0.688" MINIMUM RECOMMENDED DISTANCE BETWEEN MUZZLE AND SLIDE FOR H&K USP SERIES AND GLOCKS.
2) MINIMUM BARREL DIAMETER - Ø16.0mm (0.630"

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**THREAD GUIDE**

**TITLE:** METRIC LEFT HAND THREADS FOR CENTERFIRE PISTOL CALIBER HOSTS

**SCALE:** 10 : 1

**DATE:** 03/13

**DRAWN BY:** Advanced Armament Corp.

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**THREAD**

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<tr>
<th>M13.5 X 1-4g6g LH</th>
<th>M14.5 X 1-4g6g LH</th>
<th>M16 X 1-4g6g LH</th>
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<tbody>
<tr>
<td>MAJOR Ø</td>
<td>13.474mm-13.294mm</td>
<td>14.474mm-14.294mm</td>
</tr>
<tr>
<td>PITCH Ø</td>
<td>12.824mm-12.749mm</td>
<td>13.824mm-13.749mm</td>
</tr>
<tr>
<td>MINOR Ø</td>
<td>12.391mm-12.133mm</td>
<td>13.391mm-13.133mm</td>
</tr>
<tr>
<td>DIM A</td>
<td>0.472 +0.000/-0.001</td>
<td>0.514 +0.000/-0.001</td>
</tr>
<tr>
<td>DIM B</td>
<td>0.472 ±0.002</td>
<td>0.512 ±0.002</td>
</tr>
<tr>
<td>DIMC</td>
<td>0.532 +0.000/-0.001</td>
<td>0.570 +0.000/-0.001</td>
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</tbody>
</table>

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**GENERAL SPECIFICATION FOR SMALL ARMS AND AIRCRAFT ARMAMENT SUBSYSTEMS (MIL-W-13855) APPLIES.**

**UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES.**

**threads.com**

**PROPRIETARY AND CONFIDENTIAL**

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF ADVANCED ARMAMENT CORPORATION. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF ADVANCED ARMAMENT CORPORATION IS PROHIBITED.
NOTE:

1) 9/16 INCH DIAMETER THREADS ARE TYPICALLY ONLY USED ON SOME .40/10mm PISTOL BARRELS.
NOTES:

1) THIS THREAD CAN BE USED FOR A .45 AUTO BARREL.

2) THIS IS THE BEST THREAD FOR MOST 1911 BARRELS, SIG .45 AUTO PISTOLS, AND SPRINGFIELD XD BARRELS.

3) THIS THREAD PROFILE IS DESIGNED TO INDEX ON THE MUZZLE FACE.

4) THIS THREAD IS OPTIMIZED FOR PISTONS CONTAINING AN O-RING THAT BARS AGAINST THE Ø0.582-0.590 DIAMETER.
NOTES:

1) THIS THREAD CAN BE USED FOR ANY .45 AUTO BARREL.

2) THIS IS THE BEST THREAD FOR MOST 1911 BARRELS, SIG .45 AUTO PISTOLS, AND SPRINGFIELD XD BARRELS.

3) THIS THREAD PROFILE IS DESIGNED TO INDEX ON THE MUZZLE FACE.
NOTES:

1) THIS THREAD GUIDE DETAILS A SPECIAL 5/8-24 THREAD FOR 7.62mm BARRELS. THE THREAD IS DESIGNED TO PROVIDE A BETTER FIT WITH THE 5/8-24-UNEF-3B THREADS IN AAC DIRECT THREAD RIFLE SILENCERS THAN THE INDUSTRY STANDARD CLASS-2B THREAD.
NOTES:

1) THIS THREAD GUIDE DETAILS A BARREL MUZZLE PROFILE WITH 5/8-24-UNEF-2A THREADS AS FOUND INDUSTRY WIDE ON MOST THREADED 7.62mm RIFLE BARRELS. THIS THREAD PROFILE IS COMPATIBLE WITH ALL AAC MUZZLE DEVICES.
2.53\(+0.02\) HOLD \(\phi 0.750\) +0.000/-0.002 TO THIS MINIMUM LENGTH

0.100 MAX TO FIRST FULL THREAD

0.6250-24-UNEF-2A
MAJOR \(\phi 0.6238-0.6166\)
PITCH \(\phi 0.5967-0.5927\)
MINOR \(\phi 0.5787-0.5656\)

0.005-0.010 X 45°

0.021\(+0.000\) -0.010

0.0005 A

ANGLES

BORE AXIS

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

FILLET RADIUS 0.005-0.010
BREAK EDGE 0.005-0.010
SURFACE FINISH 125

GENERAL SPECIFICATION FOR SMALL ARMS AND AIRCRAFT ARMAMENT SYSTEMS (MIL-W-13885) APPLIES.

ASME Y14.5M-1994 APPLIES.

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0.6250-24-UNEF-2A FOR SCAR HEAVY FLASH HIDER

REV: 01

DATE: 03/13

SCALE: 4:1

MLD: 03/13

TITLE: 0.6250-24-UNEF-2A FOR SCAR HEAVY FLASH HIDER

PART NO.: 01

THREAD GUIDE

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TITLE: "B"

PART NO.: 'B'

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PART NO.: 01

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PART NO.: 01

THREA
NOTES:

1) THIS THREAD GUIDE DETAILS A BARREL MUZZLE PROFILE DESIGNED SPECIFICALLY FOR THE AAC NO-RING 7.62mm FLASH HIDER PART NUMBER - 102388.
NOTES:

1) THIS METRIC RIFLE BARREL THREAD PROFILE IS OPTIMIZED FOR USE WITH AAC DIRECT THREAD RIFLE SILENCERS.
NOTES:

1) THIS THREAD GUIDE DETAILS A BARREL MUZZLE PROFILE WITH M18 X 1.5 THREADS FOR AAC DIRECT THREAD SILENCERS. THIS IS NOT THE ACCURACY INTERNATIONAL PROFILE, WHICH IS OPTIMIZED FOR FAST ATTACH MUZZLE BRAKE MOUNTING. THIS PROFILE HAS A LONGER SECTION OF THREAD TO PROVIDE BETTER SECURITY AND ALIGNMENT.
NOTES:

1) THIS THREAD GUIDE DETAILS A 3/4-24-UNS-2A THREAD FOR 7.62mm AND LARGER CALIBER RIFLE BARRELS. THE THREAD IS DESIGNED TO BE COMPATIBLE WITH ALL AAC MUZZLE DEVICES. THERE IS AN UNTHREADED SECTION OF BARREL THAT IS THE SAME DIAMETER AS THE THREAD FOR EASY INSTALLATION AND SUPPORT OF ALIGNMENT SHIMS.
1) THIS THREAD GUIDE DETAILS A SPECIAL 3/4-24 THREAD FOR 7.62mm BARRELS. THE THREAD IS DESIGNED TO PROVIDE A BETTER FIT WITH THE 3/4-24-UNEF-3B THREADS USED IN AAC DIRECT THREAD SILENCERS THAN THE INDUSTRY STANDARD 3/4-24 CLASS-2B THREAD.