



**NOTES:**

**Rifle:**

1. No Thread relief (shims will mis-align if a thread relief is made)
2. Barrel diameter should be at minimum 0.10 larger than thread major
3. Shoulder should be sharp .005 break max

**Pistol:**

4. Thread relief is optional
5. 45ACP barrels can align on barrel face and do not need thread shoulder
6. Shoulder should be sharp .005 break max

**Pistols**

**.22LR:** 1/2-28 UNEF 2A  
 L = 0.400 ±.005  
 P.D. = 0.4757/0.4720  
 Ø D1 (Major)=0.4989/0.4924  
 Ø D2 = 0.600 Minimum

**9mm:** 1/2-28 UNEF 2A  
 L = 0.450 ±.010  
 P.D. = 0.4757/0.4720  
 Ø D1 (Major)= 0.4989/0.4924  
 Ø D2 = 0.600 Minimum

**.40S&W:** 9/16-24 UNEF 2A  
 L = 0.450 ±.010  
 P.D. = 0.5342/0.5303  
 Ø D1 (Major)= 0.5613/0.5541  
 Ø D2 = 0.660 Minimum

**.45ACP:** 37/64-28 (.578-28) UNEF 2A  
 L = 0.450 ±.010  
 P.D. = 0.5538/0.5501  
 Ø D1 (Major)= 0.5770/0.5705  
 Ø D2 = see note

**Rifles**

**.22LR:** 1/2-28 UNEF 2A  
 L = 0.400 ±.005  
 P.D. = 0.4757/0.4720  
 Ø D1 (Major)=0.4989/0.4924  
 Ø D2 = 0.600 Minimum

**.223/556:** 1/2-28 UNEF 2A  
 L = 0.600 ±.010  
 P.D. = 0.4757/0.4720  
 Ø D1 (Major)= 0.4989/0.4924  
 Ø D2 = 0.600 Minimum

**30CAL:** 5/8-24 UNEF 2A  
 L = 0.600 ±.010  
 P.D. = 0.5967/0.5927  
 Ø D1 (Major)= 0.6238/0.6166  
 Ø D2 = 0.725 Minimum

**338CAL:** 3/4-24 UNS 2A  
 L = 0.600 ±.010  
 P.D. = 0.7217/0.7176  
 Ø D1 (Major)= 0.7488/0.7416  
 Ø D2 = .850 Minimum



Boise, Idaho  
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**TOLERANCES: UNLESS OTHERWISE SPECIFIED**  
 X.XX ± .010  
 X.XXX ± .005  
 Y.Y° ± .25°  
 All dimensions are in INCHES

**DRAWN BY:** NBY  
**SIZE:** A  
**MATERIAL:**

**DATE:** 5/3/2017  
**REV:** 1  
**FINISH:**

**FILE NAME:**  
**PART NO:**

**Barrel Threading**

Insert Part Number