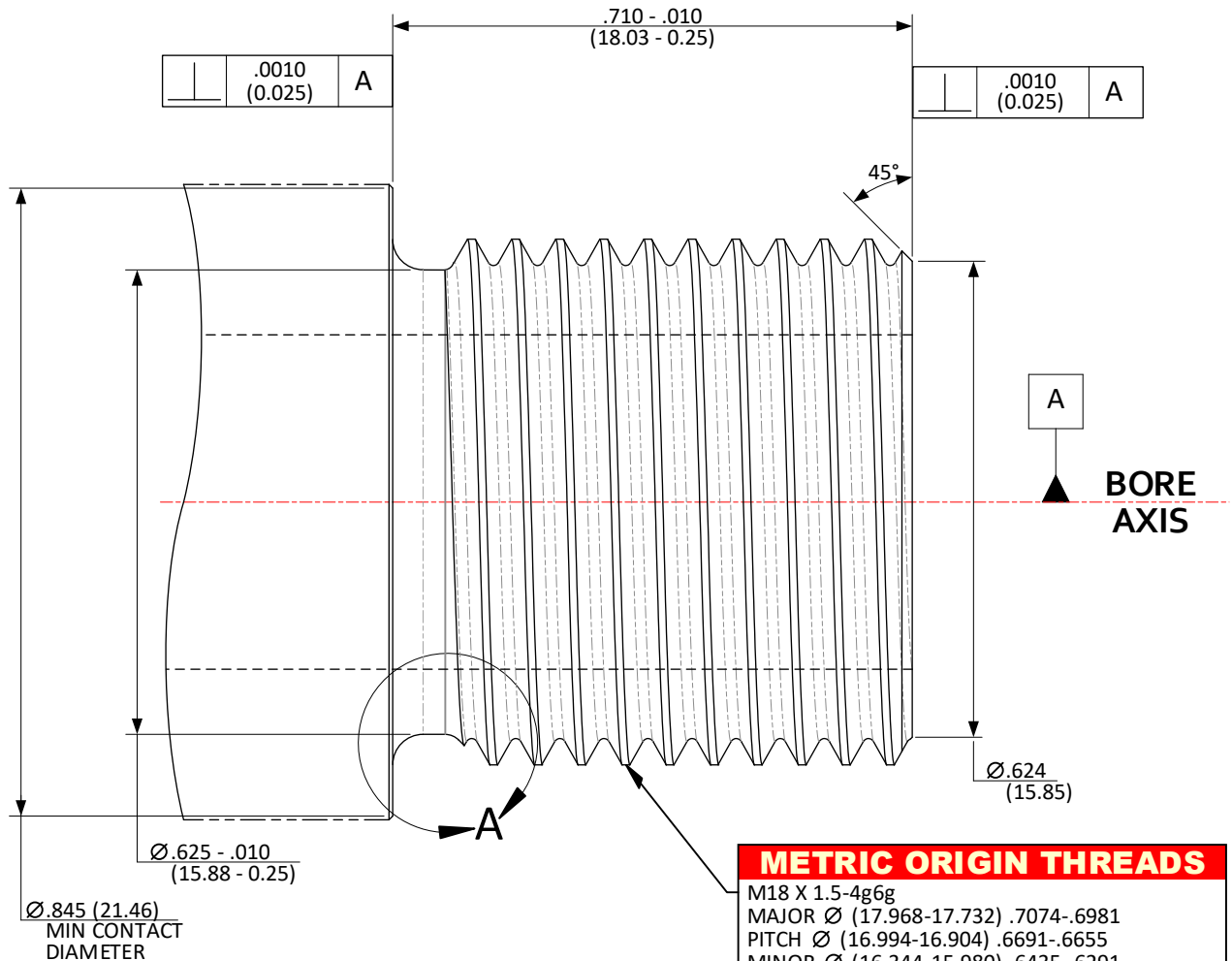


**CFR: M18 X 1.5-4g6g; >.305 (7.75) / ≤.450 (11.43) BORE –
MUZZLE THREADS**

SHEET 1 OF 5



NOTE: IF THE MINIMUM SHOULDER
CONTACT DIAMETER CANNOT BE ACHIEVED,
MUZZLE INDEXING MUST BE USED.

METRIC ORIGIN THREADS

M18 X 1.5-4g6g
MAJOR Ø (17.968-17.732) .7074-.6981
PITCH Ø (16.994-16.904) .6691-.6655
MINOR Ø (16.344-15.980) .6435-.6291

⊕	Ø .007 (0.18)	Ⓟ	1.000 (25.40)	A
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**METRIC UNITS OF MEASURE ARE THE BASE
VALUES FOR DIMENSIONS ON THESE THREADS.
US CUSTOMARY VALUES ARE PRESENTED FOR
CONVENIENCE AND ARE CALCULATED AND
ROUNDED FROM THE ORIGINAL METRIC VALUES.**

DO NOT SCALE FROM DRAWING

NOTES:

DATUM "A" FEATURE IS DEFINED AS THE LAST 3.0000 INCHES (76.200)
OF THE BORE AT THE MUZZLE END OF THE BARREL.

(XX.XX) = MILLIMETERS

DRAWING PREPARED USING THE DIMENSIONING CONVENTIONS DEFINED
IN ASME Y14.5-2018.

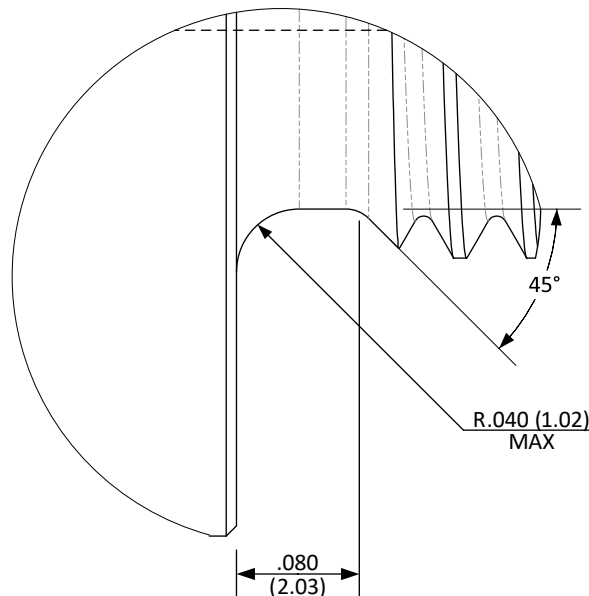
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

.X	±.1 (3)	ANGLES	±0.5°
.XX	±.01 (0.3)	FILLET RADII	.005-.010 (0.13-0.25)
.XXX	±.005 (0.13)	BREAK EDGE	.005-.010 (0.13-0.25)
.XXXX ±.0005 (0.013)		SURFACE FINISH	12.5/ (3.175/)

**CFR: M18 X 1.5-4g6g; >.305 (7.75) / ≤.450 (11.43) BORE –
MUZZLE THREAD RELIEF**

SHEET 2 OF 5

DETAIL A



DO NOT SCALE FROM DRAWING

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

NOTES:

(XX.XX) = MILLIMETERS

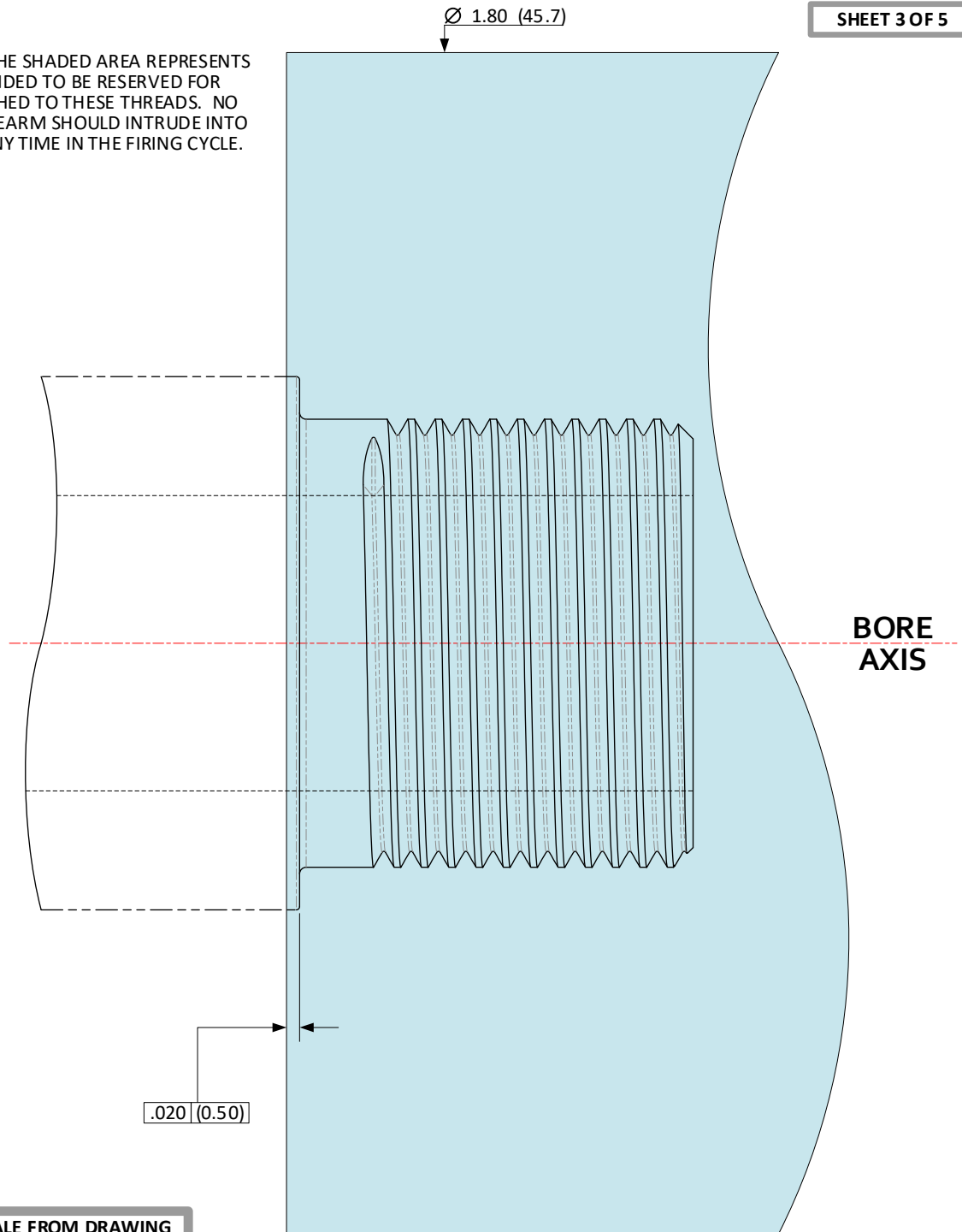
DRAWING PREPARED USING THE DIMENSIONING CONVENTIONS DEFINED
IN ASME Y14.5-2018.

.X	±.1 (3)	ANGLES	±0.5°
.XX	±.01 (0.3)	FILLET RADII	.005-.010 (0.13-0.25)
.XXX	±.005 (0.13)	BREAK EDGE	.005-.010 (0.13-0.25)
.XXXX	±.0005 (0.013)	SURFACE FINISH	$\sqrt{125}$ ($\sqrt{3.175}$)

CFR: M18 X 1.5-4g6g; >.305 (7.75) / ≤.450 (11.43) BORE – EXCLUSION ZONE

SHEET 3 OF 5

AS REFERENCE, THE SHADED AREA REPRESENTS
A ZONE INTENDED TO BE RESERVED FOR
DEVICES ATTACHED TO THESE THREADS. NO
PART OF THE FIREARM SHOULD INTRUDE INTO
THIS AREA AT ANY TIME IN THE FIRING CYCLE.



DO NOT SCALE FROM DRAWING

NOTES:

(XX.XX) = MILLIMETERS

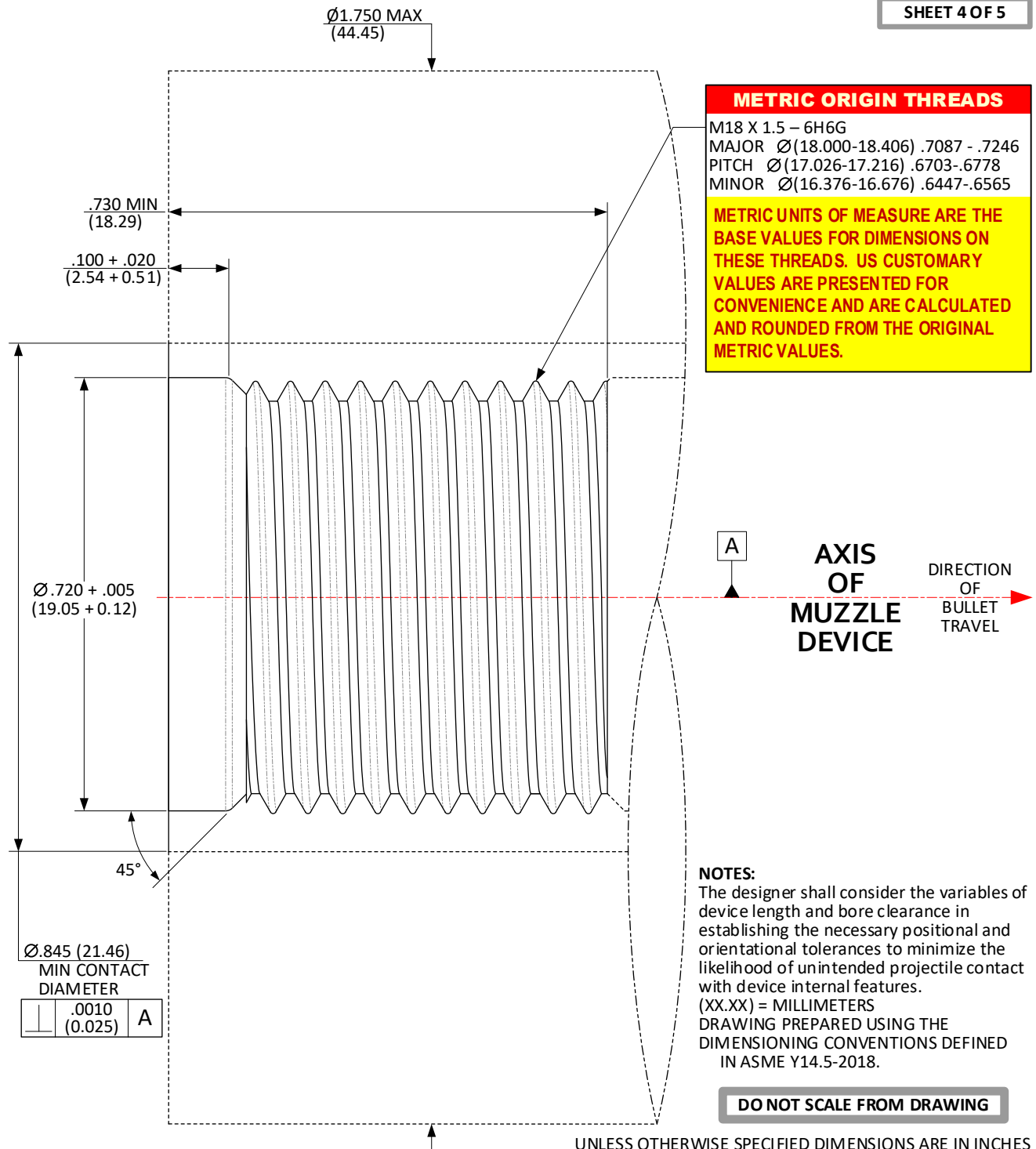
DRAWING PREPARED USING THE DIMENSIONING
CONVENTIONS DEFINED IN ASME Y14.5-2018.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

.X ±.1 (3)	ANGLES ±0.5°
.XX ±.01 (0.3)	FILLET RADII .005-.010 (0.13-0.25)
.XXX ±.005 (0.13)	BREAK EDGE .005-.010 (0.13-0.25)
.XXXX ±.0005 (0.013)	SURFACE FINISH $\sqrt{\text{V}}$ ($\sqrt{\text{V}}$)

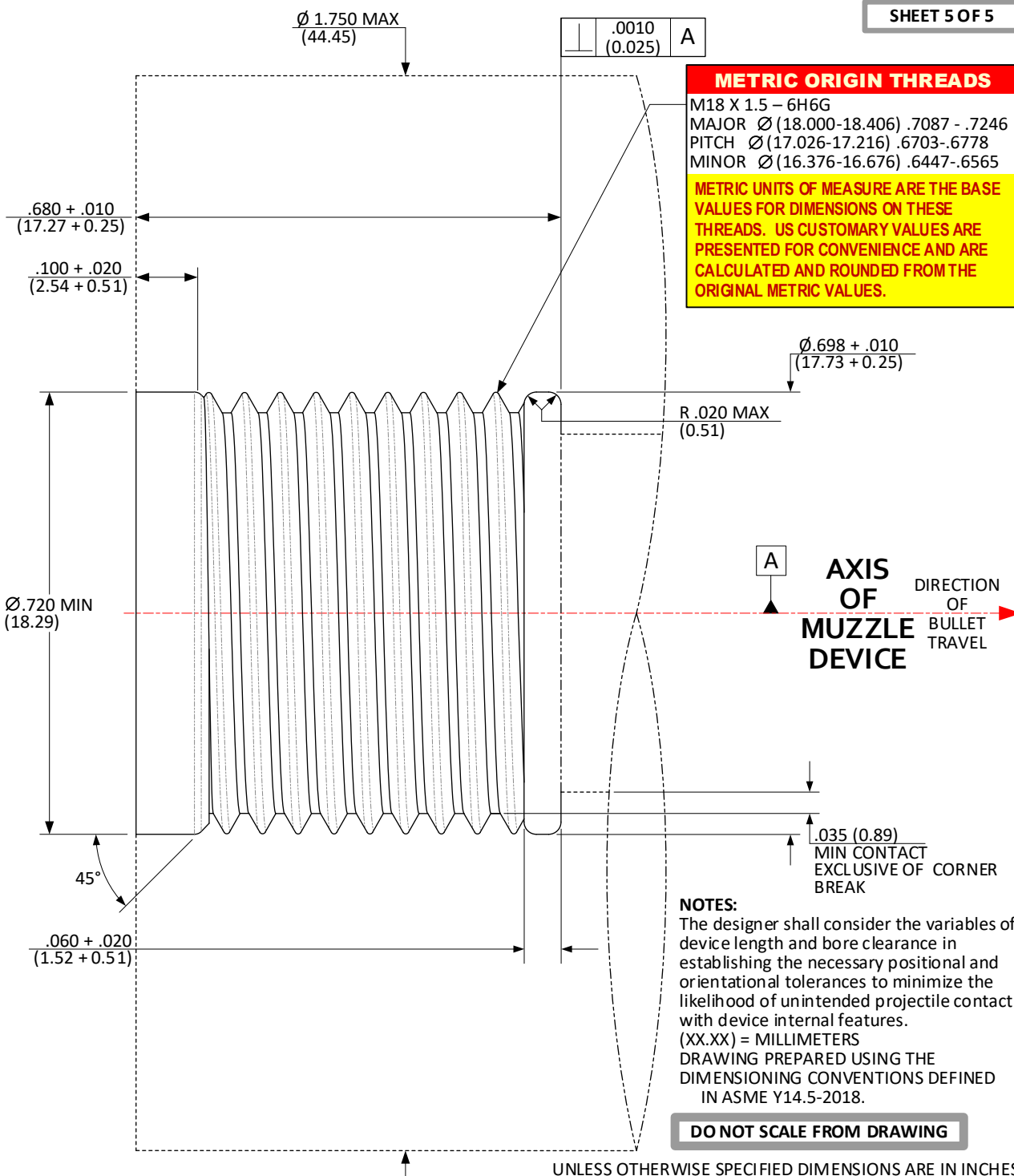
**CFR: M18 X 1.5-6H6G; >.305 (7.75) / ≤.450 (11.43) BORE –
SOCKET THREADS; SHOULDER INDEXING**

SHEET 4 OF 5



**CFR: M18 X 1.5-6H6G; >.305 (7.75) / ≤.450 (11.43) BORE –
SOCKET THREADS; MUZZLE INDEXING**

SHEET 5 OF 5



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

.X ±.1 (3)	ANGLES ±0.5°
.XX ±.01 (0.3)	FILLET RADII .005-.010 (0.13-0.25)
.XXX ±.005 (0.13)	BREAK EDGE .005-.010 (0.13-0.25)
.XXXX ±.0005 (0.013)	SURFACE FINISH $\sqrt{125}$ ($\sqrt{1.175}$)