

updated
23-Dec-11

Lilja AR-type barrels

blank dia. blank gas sys. length length

AR-15 & M-4

ar24	.975" diameter for 13" then .936" diameter for 1.900" then .875" diameter straight to muzzle. Will finish to 23" (rifle-length gas)	1	24 rifle
ar28	same as AR24 above but for 28" long blank	1	28 rifle
ar750	.975" dia. For 13" then .936" dia. For 1.900" then .750" dia. straight will finish to 23" (rifle-length gas)	1	24 rifle
arclamp	.975" dia. For 13" then .875" dia. For 1.75" then .850" dia. straight	1	28 rifle
arwasp	secondary operation to relieve center section of above contours to .800" diameter (shop note: turn blank end for end prior to turning) can be used on ar10, ar24 & ar750, arclamp contours, reduces weight of ar24 to 3.46 and ar750 to 3.12 pounds in .224 caliber and 24" length	0.975	24 rifle
m4	lightweight 16.5" long barrel for the M4 with a .750" dia. gas block and carbine-length gas tube (shop note: turn to .975" dia. first)	1	16.5 carbine
rf 49	1.00" for 13" then .936" dia. straight	1	28 rifle
ar740	.975" dia. st. for 13" then .750" dia. For 1.9" then 740" dia. st.	1	24 rifle
coltar	copy of original Colt AR lightweight barrel, .625" dia. gas block	1	24 rifle
97524	.975" diameter with 45° section at muzzle (for shop use chambering drop-in barrels)	1	24
mid1	mid-length gas system similar to AR740 contour .740" dia. In front of .750" dia. Gas block, .650" dia. Under hand guard	1	24 mid
mid2	secondary operation to relieve hand guard section of mid1 to .650" (shop note: hold backwards in lathe up to gas block) (shop note: same barrel profile as our Haas program O00303 but on 24" blank)		mid

AR barrels can be fluted on the .975" dia. and/or the smaller dia. forward of the gas block

AR-10

ar1028A	first step of AR10 contour, turns 1.000" dia. To Z -25.5", 1.200 at shank	1.25	28 rifle
ar1028B	second step - turn .875" and .940" dia's., use with ar1028a above (shop note: slide into chuck up to 12" point from chamber end)		
ar1030	1.200" dia. For 17" then .880" dia. st. cylinder	1.25	30 rifle
ar10H1	1.200" dia. for 3" then .825" dia. for 10" then .750" dia. gas block and then .740" dia. to muzzle	1.25	28 rifle
ar10H2	second step of above to turn .740" dia. and gas block	1.25	28 rifle
ar10mid1	1.200" dia. For 3" then .825" dia. To 9.500" then .750" dia. For 1.900" then .740" dia. To muzzle (for mid-length gas system with .750" dia gas block) first step	1.25	28 mid
ar10mid2	second step of above to turn .740" and gas block	1.25	28 mid
DPMStg1	1.200" dia. for 4.5" then taper over 1" to 1.062" dia. to 13" after stg1 above the stg2 OR stg3 below is selected, these are rifle-length gas system positions for the gas block	1.25	28 rifle
DPMStg2	second step for above: .940" dia. gas block section 1.940" long then .922" dia. to muzzle		rifle
DPMStg3	second step for DPMStg1 to have .940" dia. to muzzle (no step down)		rifle

three programs below used for AR10 blanks prior to chambering

	for drop-in's only:		
rf 106	3.000" of 1.200" dia. Then 45° transition to .975" dia. to muzzle 45° at muzzle (set Z zero for 3.000" of 1.200" dia.)	1.25	24
AR2645	same as rf 106 above but for 26" blank (set Z zero for 3.000" of 1.200" dia. for correct position when chambering)	1.25	26
AR2845	same as rf 106 above but for 28" blank (set Z zero for 3.000" of 1.200" dia. for correct position when chambering)	1.25	28

shop note: AR1024 and AR10740 contours with muzzle threading
in Haas lathe