

updated:
13-Jan-12

Lilja special rimfire contours and factory rimfire contours

desig.	DESCRIPTION	blank length	blank dia.
rf 1	.990" for 4" then .875" straight	28	1
rf 2	.990" HV, 3" of .990" to .625" at 28"	28	1
rf 3	1.200" for 4" then .875" straight with radius in corner	28	1.25
rf 4	.900" for 3" then .835" dia. straight	28	1
rf 5	1.200" for 3" then .880" dia. straight	28	1.25
rf 6	1.200" dia. For 3" then 1" dia. straight	28	1.25
rf 7	1.200" dia. For 3" then .900" dia. straight	28	1.25
rf 8	1.250" for 3" then 1.125" dia. straight	28	1.25
rf 9	1.200" for 4" then 1.000" straight with radius in corner	30	1.25
rf 10	1.200" for 3" then .940" dia. straight with radius in corner	28	1.25
rf 11	1.200" for 3" then .875" straight with radius in corner	28	1.25
rf 12	1.050" for 4" then straight taper to .900" at 28"	30	1.25
rf 13	1.200" for 4" then straight taper to .825" at 28"	28	1.25
rf 14	.920" for 4" then st. taper to .725" at 24"	24	1
rf 15	.937" for 3" then st. taper to .725" at 26" (.707" at 28" , .009" / inch)	28	1
rf 16	1.075" for 3" then st. taper to .564" at 24" (.024" / inch)	24	1.25
rf 17	.815" for 4" then st. taper to .750" at 24"	24	1
rf 18	1.200" for 3" then .800" straight with radius in corner	28	1.25
rf 19	1.200" for 4" then .930" dia. straight with radius in corner	28	1.25
rf 20	1.200" for 4" then .875" dia. straight with radius in corner	30	1.25
rf 21	1.200" for 3" then .850" dia. st w/radius in corner	28	1.25
rf 22	.930" for 2.5" then st. taper to .700" at 23" (.689" at 24")	24	1
rf 23	.958" for 3.5" then .939" st. w/radius in corner	28	1
rf 24	.990" for 3" then st. taper to .750" at 27" (also same as Cooper Varmint taper)	28	1
	see also rf 119		
rf 25	1.100" for 4" then st. taper to .750" at 26" (.718" at 28")	28	1.25
rf 26	.900" for 3" then st. taper to .750" at 27" (.744" at 28")	28	1
rf 27	.850" for 3" then .775" dia. straight w/radius in corner	28	1
rf 28	.940" for 4" then .900" st.	28	1
rf 29	.990" for 5" then .950" dia. st. w/radius in corner	28	1
rf 30	.950" for 5" then .890" dia. St.	28	1
rf 31	1.150" for 3" then .875" dia. St.	28	1.25
rf 32	1.150" for 13" then .900" dia. St. w/ radius in corner	28	1.25
rf 33	1.200" for 3" then .860" dia. St. w/radius in corner	28	1.25
rf 34	.985" for 3" then st. taper to .785" at 28" (29" blank)	29	1
rf 35	.850" for 5" then .790" dia. straight	28	1
rf 36	1.060" for 3" then st. taper to .875" at 27"	28	1.25
rf 37	1.250" for 3" then .750" dia. straight w/radius in corner	28	1.25
rf 38	.985" for 2.62" then .945" dia. Straight (similar to rf 104)	28	1
rf 39	.945" for 6" then .866" straight w/ radius in corner	28	1
rf 40	1.200" for 4" then .980" dia. straight with radius in corner	28	1.25
rf 41	1.100" for 4" then st. taper to .800" at 26" (.773" at 28")	28	1.25
rf 42	1.200" dia. for 4" then .850" dia. straight	28	1.25
rf 43	1.200" for 3" then st. taper to 1" at 6" then 1" dia. Straight	28	1.25
rf 44	1.200" for 2.5" then st. taper from 1.050" to .950" w/radius in corner	28	1.25
rf 45	1.200" for 5" then .815" dia. straight with radius in corner	28	1.25

rf 46	.900" for 3" then straight taper to .600" at 24" (.540" at 28")	28	1
rf 47	1.200" for 2.5" then straight taper from 1.050" to .950" at 30"	31	1.25
rf 48	1.100" for 4" then straight taper to .755" at 27" (.740" at 28", .015"/inch)	28	1.25
rf 49	1.00" for 13" then .936" dia. straight	28	1
rf 50	1.00" for 3" then taper over .5" to .770" dia. then .770" dia. to muzzle	28	1
rf 51	1.220" for 3" then taper over .5" down to .850" dia to muzzle	28	1.25
rf 52	1.060" for 3" then st. taper to .632" at 28" (.700" at 24") .017" per inch taper (rf 52 is the same as taper 6)	28	1.25
rf 53	.970" for 3" then st. taper to .700" at 25.5" (.670" at 28" .012" per inch taper) similar to rf 83	28	1
rf 54	.975" for 3" then st. taper to .875" at 28" (.004" per inch taper)	28	1
rf 55	1.126" for 2.5" then a st. taper to .868" at 27" (.858" at 28", .010"/inch taper)	28	1.25
rf 56	.950" for 2.5" then st. taper to .825" at 26" (.815" at 28", .005"/inch)	28	1
rf 57	1.050" for 2.5" then straight taper to .850" at 30"	31	1
rf 58	1.00" for 3" then taper to .850" at 4.5" then .850" dia. straight to muzzle	28	1
rf 59	1.00" dia. 3.8" then .950" dia. straight	31	1.25
rf 60	1.00 for 5" then .900" dia. straight	28	1
rf 61	1" dia. for 3" then .825" dia. straight	28	1
rf 62	1.250" for 4" then .900" dia. straight with radius in corner	28	1.25
rf 63	1.125" for 3" then straight taper to .950" at 27" (.943" at 28")	28	1.25
rf 64	1.200" for 4" then .825" dia. straight with radius in corner	28	1.25
rf 65	.980" for 2.5" then taper over 5" length to .880" then st. taper to .750" at 24"	24	1
rf 66	1.000" for 20" then 1.200" dia. straight (shop note: run backwards)	28	1.25
rf 67	.960" for 2.5" then st. taper to .552" at 28" (.600" at 25" - .016"/inch taper)	28	1
rf 68	1.200" dia. for 4" then .800" dia. st. w/radius in corner	28	1.25
rf 69	reverse taper with both ends at .950" dia. and smallest dia. in center .700" .950" for 3" then taper to .700" over 1" then taper up to .950" over 17" to muzzle	28	1
rf 70	1.040" dia. for 3" taper to .875" dia. at 6" then .875" dia. st.	28	1.25
rf 71	1.000" dia. for 3" then st. taper to .710" at 28" (.011"/inch taper)	28	1
rf 72	same as rf 69 but smallest dia. is .760"	28	1
rf 73	.875" dia. for 2.5" then st. taper to .738" at 24" (.750" at 22")	24	1
rf 74	1.035" dia. for 3" then st. taper to .860" at 27" (.853" at 28")	28	1.25
rf 75	1.000" for 2.5" then .780" dia. st. with 45° chamfer in corner	24	1
rf 76	.975" for 3" then st. taper to .760" at 24" (.800" at 20") (can use for Rem 504)	24	1
rf 77	1.050" for 4" then st. taper to .900" at 28" (.882" at 30") (similar to rf 12)	31	1.25
rf 78	.995" dia. for 3" then .500" dia. st. with radius in corner	28	1
rf 79	.890" for 3.25" then st. taper to .740" over 4.75" then st. taper to .670" at 28"	28	1
rf 80	.950" for 3" then st. taper to .650" at 24" (.593" at 28")	28	1
rf 81	1.150" for 5" then .875" dia. st. with radius in corner	28	1.25
rf 82	.982" dia. for 4.5" then st. taper to .940" at 24.5" (.932" at 28")	28	1
rf 83	.985" dia. For 2.5" then st. taper to .665" at 28" (.012" per inch) similar to rf 53	28	1
rf 84	1.060" for 3" then st. taper to .815" at 28" (.785" at 31")	31	1.25
rf 85	1.085" for 6" then st. taper to .875" at 28" (.847" at 31") (BSA Martini)	31	1.25
rf 86	1.000" for 5" then taper over 1" to .940" cylinder for 17" then taper over 1" up to 1.013" for 4" (reverse taper)	28	1.25
rf 87	1.000" for 3.5" then drop to .800" dia. Then taper up to .900" over 19" then .900" to muzzle (reverse taper)	28	1
rf 88	.900" for 4" then taper over 4" to .750" then .750" to muzzle	28	1
rf 89	1.000" for 4" then taper over 1" to .850" then taper over 18.5" to .650" then taper up to 1.000" over 1.5" then 1.000" to muzzle (reverse taper)	28	1
rf 90	.791" for 5.142" then taper down to .709" dia. Straight cyl. For 17.716" then	28	1

	taper up to .748" dia. For 5.142" (reverse taper)		
rf 91	1.00" dia. for 3" then taper over .5" to .825" dia. St. cyl for 20" then taper up to .5" the 1" dia. straight for 4" (reverse taper)	28	1
rf 92	.900" dia. For 2.5" then st. taper to .735" over 6.5" then st. taper to .600" over 12" .566" dia. Muzzle at 24"	24	1
rf 93	1.250" for 3" then st taper to .825" over 3" then .825" st. to muzzle	28	1.25
rf 94	.815" for 3" then st. taper to .625" at 27" (.617" at 28")	28	1
rf 95	.950" for 9" then st. taper to .850" at 30" (.845" at 31")	31	1
rf 96	.995" for 3.5" then st. taper to .875" at 22" (.862" at 24")	24	1
rf 97	.990" for 4" then .820" dia. st with radius in corner	28	1
rf 98	.990" for 4" then .750" dia. st with radius in corner	28	1
rf 99	1.000" for 4" then st. taper to .620" at 30"	30	1
rf 100	.900" dia. cylinder with 4" of .935" dia. at muzzle end	24	1
rf 101	.875" dia. for 21" then taper up to .940" dia. over 2" then .940" st. to muzzle (reverse taper)	28	1
rf 102	1.125" for 3" then .850" dia. st. w/radius in corner	28	1.125
rf 103	.980" dia. for 2.5" then st. taper to .643" at 24"	24	1
rf 104	.992" for 3" then .950" dia. st. w/radius in corner (similar to rf 38)	28	1
rf 105	1.200" for 3" then .975" dia. st. with 45° transition	28	1.25
rf 106	same as rf 105 but 24" blank and 45° at muzzle	24	1.25
rf 107	1.170" for 5.0" the drop to 1.090" for 19" then back up to 1.170"	28	1.25
rf 108	1.25" dia. For 4" then .925" dia. St W/radius in corner	31	1.25
rf 109	.950" for 2.5" then st. taper to .650" at 30" (.640" at 31")	31	1
rf 110	.950" for 2.5" then st. taper to .672" at 28"	28	1
rf 111	.960" for 4" then st. taper to .750" at 24" (.715" at 28")	28	1
rf 112	1.170" for 5" then drop to 1.070" then taper back to 1.170" over 15" then 1.170" st.	28	1.25
rf 113	1.000" for 5.0" then radius down to .670" then taper up to .800" over 18" then short taper up to 1.150" straight cylinder for 4.0" to muzzle (Eck)	28	1.25
rf 114	1.000" for 6.0" then taper down to .633" for 16.25" then taper up to .750" .750" for 5.75" (Altius)	28	1.25
rf 115	same as rf 114 above except that center section is 18.25" long and each end cylinder is 1.00" shorter (Altius)	28	1.25
rf 116	1.200" for 4" then .900" st w/radius in corner	28	1.25
rf 117	.990" for 2.5" then st. taper to .682" at 28"	28	1
rf 118	.995" for 3.5" then st. taper to .780" at 28"	28	1
rf 119	same as rf 24 but for 24" long blank (muzzle dia. .780" at 24")	24	1
rf 120	.990" for 4" then radius down to .630" for 16.75" then taper up to .800" over 1.375" .800" dia/ for 5.875"	28	1
rf 121	same as rf 120 except .630" dia. changed to .710" dia.	28	1
rf 122	.900" for 3" then st. taper to .585" at 24" (.630" at 21") this blank to be used for our CZ 455 drop-in's	24	1
rf 123	.950" dia. straight cylinder (for G&H barrels)	28	1
sund24	Sundberg taper, .900" for 5.5" then straight taper to .700" at 24"	24	1
sund26	Sundberg taper for 26" finish	26	1
sund28	Sundberg taper , .900" for 5.5" then straight taper to .660" at 28"	28	1
Anschutz			
ans1710	copy of Anschutz model 1710: 1.000" for 2.75" then taper to .810" over 4" then straight taper to .654" at 28" (original .685" at 24") This contour is almost identical to the barrel used on the M. 1432 22 Hornet, (within .010" or less at any point)	28	1

ansm54m	copy of Anschutz model 54 M Sporter (original was 22 WMR) .990" dia. for 2.62" then radius over 4" to .720" dia. at tangent point then st. taper to .585" at 24" (.558" dia. at 28" blank length, blank has 3" long shank of .990" dia.)	28	1
m164	copy of Savage/Anschutz M. 164 .875" for 2.5" .661" at radius tangent, .629" at 28" (original .636" at 22")	28	1
anscsite	.923" straight with 3.8" long 1.014" diameter bulge for front site at muzzle (shop note: run backwards in lathe)	31	1.25
ans1907	.94" dia. For 2.5" then center section diameter of .885" for 21.5" then .940" dia. at muzzle for 4" (reverse taper)	28	1
90024	turn to .900: dia. with 45° cone at muzzle (for shop use making drop-in's)	24	1
90028	turn to .900: dia. with 45° cone at muzzle (for shop use making drop-in's)	28	1
Browning			
brown52	Browning / Winchester model 52 contour .555" muzzle dia., .830" at radius .965" dia. shank (see also Winchester M. 52 contour below)	28	1.25
bpr22	Browning BPR 22 WMR .900" for 2.5" then st. taper to .555" (.530" at 24")	24	1
abolt22	Browning A-Bolt 22 rimfire contour .970" to .765" over 4.25" then st. taper to .610" at original muzzle length of 22", .570" at 28"	28	1
Brno			
brno1	copy of Brno model 1 profile: .985" dia. at chamber end, taper down to .720" over 3" length, st taper to .530" at 28" (original had rear site hump - this program does not, was .565" muzzle dia. at 23")	28	1
Cooper Arms			
ca150	Cooper Arms CA150 barrel contour .940" for 2.5" then st. taper to .510" at 28"	28	1
rf 24	Cooper Varmint taper: .990" for 3" then st. taper to .750" at 27"	28	1
rf 119	same as rf 24 above but for 24" long blank, muzzle dia. .980" at 24"	24	1
CZ			
cz527	copy of CZ model 527 .980" dia. Shank, .780" dia. At radius tangent to .570" at muzzle (original 22" fin) (same contour also used on 7.62x39 centerfire rifles)	24	1
cz455	slightly larger copy of the CZ model 455 .22 LR sporter barrel, .900" dia. for 3" then st. taper to .520" at 24" (.575" at 21")	24	1
rf 122	see dimensions above - used for our CZ 455 drop-in barrel	24	1
Kimber			
kimber22	Kimber contour, .965" dia. Shank with .595" muzzle, .765" dia. At radius tangent	24	1
kimvrmt	Kimber varmint taper: 1.050" for 3.5" st. taper to .685" at 26" (.653" at 38")	28	1.25
kim82	.970" for 2.5" then st. taper to .600" at 23" (.525" at 28")	28	1
Remington			
504tt	Remington 504 target taper, .975" for 3" then st. taper to .600" at 21", .538" at 24"	24	1
504tt45	same as 504tt above with 45° on muzzle end for drop-in's	24	1
97524	turn to .975: dia. with 45° cone at muzzle (for shop use making drop-in's)	24	1
504sport	Remington 504 copy of factory sporter contour	24	1
504remtt	Remington 504 copy of factory target taper	24	1
remttlg	Remington 504 target taper for a 28" long blank (.990" for 2.5", .800" at 28")	28	1
504lgtt	Remington 504 our target taper: .975" for 3" then st. taper to .600" at 28"	28	1
975-45	.975" straight cylinder with 45° on muzzle end for drop-in's	24	1

Ruger		
77vrmt	Ruger 77/22 Varmint taper, .920" to .650" at 24"	24 1
77vrmt45	same as above but with 45° chamfer on muzzle (for shop use when chambering)	24 1
77vrmt28	Ruger 77/22 varmint taper, .920" to .600" at 28"	28 1
Rugersp	Ruger drop-in Sporter contour, turn to .510" at 24", 2.5" long shank needs to be trimmed to 2.5" long shank	24 1
ruger23	Ruger drop-in Sporter contour like rugersp for 23" blank and 2" long shank	23 1
ruger26	Ruger drop-in sporter contour like ruger23 for 26" long blank and 2.5" shank, trim .5" from shank end	26 1
ruger28	same as ruger26 but for 28" long blank	28 1
92024	turn to .920: dia. with 45° cone at muzzle (for shop use making drop-in's)	24 1
92028	turn to .920: dia. with 45° cone at muzzle (for shop use making drop-in's)	28 1
Sako		
p94sport	copy of Sako P94 Finfire & Quad Sporter contour (.575" at 24")	24 1
p94sp185	same as above but for 21" long barrel (recontour of finished Quad barrel, hold on shank)	21 1
90024	turn to .900: dia. with 45° cone at muzzle (for shop use making drop-in's)	24 1
90028	turn to .900: dia. with 45° cone at muzzle (for shop use making drop-in's)	28 1
Weatherby		
mkxxll	Copy of Weatherby/Anschutz model Mark XXII 17 HMR barrel .875" dia. at chamber st. taper to .750" over 2.5" then st. taper to muzzle dia. of .630" at 23"	24 1
Winchester		
win52	Winchester M. 52 contour w/ 1.010" shank to .520" at 28", .690" at radius tangent (see also Browning M. 52 contour above)	28 1.25
win52t	Win M. 52 Target taper: 1.030" for 2.5" then st. taper to .880" then st. taper to .725" at 28" (will make finish barrel length up to 26")	28 1.25
52tt	1.010" for 2.5" then st. taper to .875" at 28"	28 1.25

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