

WEDGE/ROLLER COMBINATIONS 134 SERIES

Wedge	Roller Ø	Spring	FCD Min	FCD Max
NARROW	0.625	Red/Short	1.956	2.324
NARROW	0.688	Red/Short	1.922	2.279
NARROW	0.750	Red/Short	1.889	2.237
NARROW	0.813	Red/Short	1.856	2.194
NARROW	0.875	Red/Short	1.824	2.153
MEDIUM	0.625	Yellow/Medium	1.772	2.281
MEDIUM	0.688	Yellow/Medium	1.739	2.224
MEDIUM	0.750	Yellow/Medium	1.707	2.171
MEDIUM	0.813	Green/Long	1.675	2.119
MEDIUM	0.875	Green/Long	1.644	2.069
LARGE	0.625	Green/Long	1.597	2.150
LARGE	0.688	Green/Long	1.566	2.083
LARGE	0.750	Green/Long	1.535	2.020
LARGE	0.813	Green/Long	1.505	1.959
LARGE	0.875	Green/Long	1.474	1.902
X-LARGE	0.625	Green/Long	1.442	1.863
X-LARGE	0.688	Green/Long	1.391	1.809
X-LARGE	0.750	Green/Long	1.362	1.758
X-LARGE	0.813	Green/Long	1.333	1.707
X-LARGE	0.875	Green/Long	1.304	1.659

REFERENCE DATA SHEETS 134 SERIES**UN, UNC, UNF, UNEF, UNS THREAD SIZES**

Part Data			Roll Data		Attachment Data					
Size	-	TPI	Blank Diameter	# of Starts	OD	Wedge	Roller	Spring	Stock Clearance	
									Collet Side	Non-Collet Side
#0	-	80	0.050	30	1.394	X-LARGE	0.750	Green/Long	0.699	0.479
#1	-	64	0.061	25	1.402	X-LARGE	0.688	Green/Long	0.716	0.496
#1	-	72	0.062	24	1.391	X-LARGE	0.750	Green/Long	0.707	0.487
#2	-	56	0.072	21	1.400	X-LARGE	0.688	Green/Long	0.724	0.504
#2	-	64	0.074	20	1.382	X-LARGE	0.750	Green/Long	0.709	0.489
#3	-	48	0.083	18	1.376	X-LARGE	0.750	Green/Long	0.709	0.489
#3	-	56	0.086	17	1.354	X-LARGE	0.750	Green/Long	0.691	0.471
#4	-	40	0.094	16	1.359	X-LARGE	0.750	Green/Long	0.700	0.480
#4	-	48	0.096	15	1.342	X-LARGE	0.750	Green/Long	0.688	0.468
#5	-	40	0.107	14	1.371	X-LARGE	0.688	Green/Long	0.725	0.505
#5	-	44	0.109	14	1.406	X-LARGE	0.625	Green/Long	0.763	0.543
#6	-	32	0.116	13	1.354	X-LARGE	0.688	Green/Long	0.714	0.494
#6	-	40	0.120	12	1.331	X-LARGE	0.750	Green/Long	0.698	0.478
#8	-	32	0.142	10	1.302	X-LARGE	0.750	Green/Long	0.688	0.468
#8	-	36	0.144	10	1.339	X-LARGE	0.688	Green/Long	0.729	0.509
#10	-	24	0.161	9	1.304	X-LARGE	0.750	Green/Long	0.703	0.483
#10	-	28	0.164	8	1.211	X-LARGE	0.875	Green/Long	0.617	0.397
#10	-	32	0.168	8	1.249	X-LARGE	0.813	Green/Long	0.661	0.441
#10	-	36	0.170	8	1.279	X-LARGE	0.750	Green/Long	0.695	0.475
#10	-	40	0.171	8	1.303	X-LARGE	0.688	Green/Long	0.722	0.502
#10	-	48	0.174	8	1.340	X-LARGE	0.625	Green/Long	0.764	0.544
#10	-	56	0.176	8	1.365	X-LARGE	0.625	Green/Long	0.793	0.573
#12	-	24	0.187	7	1.196	X-LARGE	0.875	Green/Long	0.621	0.401
#12	-	28	0.191	7	1.241	X-LARGE	0.813	Green/Long	0.673	0.453
#12	-	32	0.194	7	1.275	X-LARGE	0.688	Green/Long	0.713	0.493
#12	-	36	0.196	7	1.302	X-LARGE	0.688	Green/Long	0.744	0.524
#12	-	40	0.197	7	1.323	X-LARGE	0.625	Green/Long	0.768	0.548
#12	-	48	0.200	7	1.354	LARGE	0.875	Green/Long	0.804	0.584
#12	-	56	0.202	7	1.377	LARGE	0.813	Green/Long	0.831	0.611
1/4	-	20	0.216	6	1.175	X-LARGE	0.875	Green/Long	0.624	0.404
1/4	-	24	0.220	6	1.229	X-LARGE	0.750	Green/Long	0.688	0.468
1/4	-	27	0.223	6	1.259	X-LARGE	0.688	Green/Long	0.724	0.504
1/4	-	28	0.225	6	1.268	X-LARGE	0.688	Green/Long	0.734	0.514
1/4	-	32	0.228	6	1.297	X-LARGE	0.625	Green/Long	0.769	0.549
1/4	-	36	0.230	6	1.320	LARGE	0.875	Green/Long	0.796	0.576
1/4	-	40	0.231	6	1.338	LARGE	0.875	Green/Long	0.817	0.597
1/4	-	48	0.234	6	1.365	LARGE	0.813	Green/Long	0.849	0.629
1/4	-	56	0.236	6	1.384	LARGE	0.750	Green/Long	0.872	0.652

**Limited Application. Will have trouble adjusting penetration rate.

REFERENCE DATA SHEETS 134 SERIES**UN, UNC, UNF, UNEF, UNS THREAD SIZES**

Part Data			Roll Data		Attachment Data					
Size	-	TPI	Blank Diameter	# of Starts	OD	Wedge	Roller	Spring	Stock Clearance	
									Collet Side	Non-Collet Side
5/16	-	18	0.274	5	1.262	X-LARGE	0.625	Green/Long	0.766	0.546
5/16	-	20	0.278	5	1.292	LARGE	0.875	Green/Long	0.803	0.583
5/16	-	24	0.283	5	1.337	LARGE	0.750	Green/Long	0.858	0.638
5/16	-	27	0.285	5	1.362	LARGE	0.688	Green/Long	0.889	0.669
5/16	-	28	0.288	5	1.369	LARGE	0.688	Green/Long	0.898	0.678
5/16	-	32	0.291	4	1.115	X-LARGE	0.875	Green/Long	0.649	0.429
5/16	-	36	0.292	5	1.412	LARGE	0.625	Green/Long	0.950	0.730
5/16	-	40	0.294	5	1.427	MEDIUM	0.875	Green/Long	0.969	0.749
5/16	-	48	0.297	4	1.160	X-LARGE	0.750	Green/Long	0.707	0.487
3/8	-	16	0.332	4	1.229	X-LARGE	0.625	Green/Long	0.787	0.567
3/8	-	18	0.336	4	1.259	LARGE	0.813	Green/Long	0.826	0.606
3/8	-	20	0.340	4	1.283	LARGE	0.750	Green/Long	0.857	0.637
3/8	-	24	0.346	4	1.320	LARGE	0.688	Green/Long	0.904	0.684
3/8	-	27	0.348	4	1.335	LARGE	0.625	Green/Long	0.924	0.704
3/8	-	28	0.350	4	1.345	LARGE	0.625	Green/Long	0.936	0.716
3/8	-	32	0.353	4	1.365	LARGE	0.625	Green/Long	0.962	0.742
3/8	-	36	0.354	4	1.380	MEDIUM	0.875	Green/Long	0.981	0.761
3/8	-	40	0.356	4	1.392	MEDIUM	0.813	Green/Long	0.996	0.776
7/16	-	14	0.389	3	1.081	X-LARGE	0.750	Green/Long	0.691	0.471
7/16	-	16	0.395	3	1.110	X-LARGE	0.688	Green/Long	0.731	0.511
7/16	-	18	0.398	3	1.132	X-LARGE	0.688	Green/Long	0.761	0.541
7/16	-	20	0.403	3	1.150	X-LARGE	0.625	Green/Long	0.786	0.566
7/16	-	24	0.407	3	1.177	LARGE	0.875	Green/Long	0.823	0.603
7/16	-	27	0.410	3	1.189	LARGE	0.813	Green/Long	0.840	0.620
7/16	-	28	0.412	3	1.197	LARGE	0.813	Green/Long	0.851	0.631
7/16	-	32	0.415	3	1.211	LARGE	0.750	Green/Long	0.870	0.650
1/2	-	12	0.444	3	1.229	LARGE	0.688	Green/Long	0.887	0.667
1/2	-	13	0.448	3	1.250	LARGE	0.688	Green/Long	0.916	0.696
1/2	-	14	0.450	3	1.268	LARGE	0.625	Green/Long	0.940	0.720
1/2	-	16	0.475	3	1.297	MEDIUM	0.875	Green/Long	0.980	0.760
1/2	-	18	0.461	3	1.320	MEDIUM	0.813	Green/Long	1.012	0.792
1/2	-	20	0.466	3	1.338	MEDIUM	0.750	Yellow/Medium	1.037	0.817
1/2	-	24	0.470	3	1.365	MEDIUM	0.688	Yellow/Medium	1.074	0.854
1/2	-	27	0.473	3	1.376	MEDIUM	0.688	Yellow/Medium	1.089	0.869
1/2	-	28	0.475	3	1.384	MEDIUM	0.625	Yellow/Medium	1.100	0.880
1/2	-	32	0.478	3	1.399	MEDIUM	0.625	Yellow/Medium	1.121	0.901
9/16	-	12	0.506	2	0.945	X-LARGE	0.813	Green/Long	0.665	0.445
9/16	-	14	0.513	2	0.970	X-LARGE	0.750	Green/Long	0.705	0.485
9/16	-	16	0.520	2	0.990	X-LARGE	0.688	Green/Long	0.736	0.516
9/16	-	18	0.524	2	1.005	X-LARGE	0.688	Green/Long	0.759	0.539
9/16	-	20	0.528	2	1.017	X-LARGE	0.625	Green/Long	0.778	0.558
9/16	-	24	0.533	2	1.035	LARGE	0.875	Green/Long	0.806	0.586
9/16	-	27	0.535	2	1.043	LARGE	0.875	Green/Long	0.819	0.599
9/16	-	28	0.537	2	1.048	LARGE	0.813	Green/Long	0.827	0.607
9/16	-	32	0.540	2	1.057	LARGE	0.813	Green/Long	0.841	0.621

**Limited Application. Will have trouble adjusting penetration rate.

REFERENCE DATA SHEETS 134 SERIES**UN, UNC, UNF, UNEF, UNS THREAD SIZES**

Part Data				Roll Data		Attachment Data				
Size	-	TPI	Blank Diameter	# of Starts	OD	Wedge	Roller	Spring	Stock Clearance	
									Collet Side	Non-Collet Side
5/8	-	11	0.564	2	1.053	LARGE	0.813	Green/Long	0.826	0.606
5/8	-	12	0.569	2	1.070	LARGE	0.813	Green/Long	0.853	0.633
5/8	-	14	0.575	2	1.095	LARGE	0.688	Green/Long	0.892	0.672
5/8	-	16	0.582	2	1.115	LARGE	0.625	Green/Long	0.923	0.703
5/8	-	18	0.587	2	1.130	LARGE	0.625	Green/Long	0.947	0.727
5/8	-	20	0.590	2	1.142	MEDIUM	0.875	Green/Long	0.966	0.746
5/8	-	24	0.596	2	1.160	MEDIUM	0.875	Green/Long	0.994	0.774
5/8	-	27	0.598	2	1.168	MEDIUM	0.813	Green/Long	1.007	0.787
5/8	-	28	0.600	2	1.173	MEDIUM	0.813	Green/Long	1.014	0.794
5/8	-	32	0.603	2	1.182	MEDIUM	0.750	Yellow/Medium	1.029	0.809
11/16	-	12	0.631	2	1.195	MEDIUM	0.750	Yellow/Medium	1.040	0.820
11/16	-	16	0.645	2	1.240	MEDIUM	0.625	Yellow/Medium	1.111	0.891
11/16	-	20	0.653	2	1.267	NARROW	0.875	Red/Short	1.153	0.933
11/16	-	24	0.658	2	1.285	NARROW	0.813	Red/Short	1.181	0.961
11/16	-	28	0.662	2	1.298	NARROW	0.813	Red/Short	1.202	0.982
11/16	-	32	0.665	2	1.307	NARROW	0.750	Red/Short	1.216	0.996
3/4	-	10	0.683	2	1.283	NARROW	0.875	Red/Short	1.170	0.950
3/4	-	12	0.694	2	1.320	NARROW	0.750	Red/Short	1.228	1.008
3/4	-	14	0.700	2	1.345	NARROW	0.688	Red/Short	1.267	1.047
**3/4	-	16	0.707	2	1.365	NARROW	0.625	Red/Short	1.298	1.078
**3/4	-	18	0.710	2	1.380	NARROW	0.625	Red/Short	1.322	1.102
**3/4	-	20	0.716	2	1.392	NARROW	0.625	Red/Short	1.341	1.121
**3/4	-	24	0.720	2	1.410	NARROW	0.625	Red/Short	1.369	1.149
**3/4	-	27	0.723	2	1.42	NARROW	0.625	Red/Short	1.385	1.165
**3/4	-	28	0.725	2	1.432	NARROW	0.625	Red/Short	1.178	1.178
**3/4	-	32	0.727	2	1.438	NARROW	0.625	Red/Short	1.190	1.190

**Limited Application. Will have trouble adjusting penetration rate.

REFERENCE DATA SHEETS 134 SERIES
NPT, NPTF TAPERED PIPE THREAD SIZES

Part Data		Roll Data		Attachment Data					
Size	- TPI	Blank Diameter @ Y	# of Starts	OD	Wedge	Roller	Spring	Stock Clearance	
								Collet Side	Non-Collet Side
1/16	- 27	0.279	5	1.340	LARGE	0.813	Green/Long	0.837	0.637
1/8	- 27	0.372	4	1.440	MEDIUM	0.750	Yellow/Medium	1.030	0.830
1/4	- 18	0.489	3	1.428	MEDIUM	0.625	Yellow/Medium	1.116	0.916
3/8	- 18	0.625	2	1.229	MEDIUM	0.750	Yellow/Medium	1.053	0.853

REFERENCE DATA SHEETS 134 SERIES
BSPT TAPERED PIPE THREAD SIZES

Part Data		Roll Data		Attachment Data					
Size	- TPI	Blank Diameter @ Y	# of Starts	OD	Wedge	Roller	Spring	Stock Clearance	
								Collet Side	Non-Collet Side
1/8	- 28	0.358	4	1.415	MEDIUM	0.875	Green/Long	0.993	0.793
1/4	- 19	0.482	3	1.418	MEDIUM	0.625	Yellow/Medium	1.102	0.902
3/8	- 19	0.622	2	1.259	MEDIUM	0.688	Yellow/Medium	1.083	0.883

Y Dimension is shown on Gage Setting Chart for NPT, NPTF, & BSPT Thread Sizes

REFERENCE DATA SHEETS 134 SERIES
NPSM STRAIGHT PIPE THREAD SIZES

Part Data				Roll Data		Attachment Data				
Size	-	TPI	Blank Diameter	# of Starts	Roll OD	Wedge	Roller	Spring	Stock Clearance	
									Collet Side	Non-Collet Side
									1/4	18
3/8	-	18	0.625	2	1.203	MEDIUM	0.750	Yellow/Medium	1.057	0.837

REFERENCE DATA SHEETS 134 SERIES
BSPP STRAIGHT PIPE THREAD SIZES

Part Data				Roll Data		Attachment Data				
Size	-	TPI	Blank Diameter	# of Starts	Roll OD	Wedge	Roller	Spring	Stock Clearance	
									Collet Side	Non-Collet Side
1/8	-	28	0.360	4	1.372	MEDIUM	0.875	Green/Long	0.971	0.751
1/4	-	19	0.484	3	1.372	MEDIUM	0.688	Yellow/Medium	1.085	0.865
3/8	-	19	0.620	2	1.161	MEDIUM	0.813	Green/Long	1.012	0.792

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REFERENCE DATA SHEETS 134 SERIES
METRIC THREAD SIZES

Part Data				Roll Data		Attachment Data				
Size	X	Pitch	Blank Diameter	# of Starts	OD	Wedge	Roller	Spring	Stock Clearance	
									Collet Side	Non-Collet Side
M1.6	X	0.35	0.051	29	1.394	X-LARGE	0.750	Green/Long	0.699	0.479
M2	X	0.4	0.066	22	1.357	X-LARGE	0.813	Green/Long	0.676	0.456
M2.5	X	0.45	0.084	17	1.347	X-LARGE	0.750	Green/Long	0.683	0.463
M3	X	0.5	0.103	14	1.355	X-LARGE	0.750	Green/Long	0.708	0.488
M3.5	X	0.6	0.120	12	1.347	X-LARGE	0.688	Green/Long	0.715	0.495
M4	X	0.7	0.137	10	1.276	X-LARGE	0.813	Green/Long	0.659	0.439
M5	X	0.8	0.173	8	1.302	X-LARGE	0.688	Green/Long	0.719	0.499
M6	X	1	0.208	7	1.355	LARGE	0.875	Green/Long	0.802	0.582
M8	X	1	0.286	5	1.362	LARGE	0.688	Green/Long	0.888	0.668
M8	X	1.25	0.280	5	1.308	LARGE	0.875	Green/Long	0.821	0.601
M10	X	0.75	0.372	3	1.085	X-LARGE	0.750	Green/Long	0.702	0.482
M10	X	1.25	0.359	4	1.362	LARGE	0.625	Green/Long	0.954	0.734
M10	X	1.5	0.352	4	1.319	LARGE	0.688	Green/Long	0.899	0.679
M12	X	1	0.444	3	1.289	MEDIUM	0.875	Green/Long	0.972	0.752
M12	X	1.25	0.437	3	1.257	LARGE	0.625	Green/Long	0.928	0.708
M12	X	1.5	0.431	3	1.226	LARGE	0.750	Green/Long	0.885	0.665
M12	X	1.75	0.424	3	1.194	LARGE	0.813	Green/Long	0.841	0.621
M14	X	2	0.497	3	1.398	MEDIUM	0.625	Yellow/Medium	1.111	0.891
M15	X	1	0.562	2	1.096	LARGE	0.688	Green/Long	0.897	0.677
M16	X	1.5	0.588	2	1.132	LARGE	0.625	Green/Long	0.948	0.728
M16	X	2	0.575	2	1.089	LARGE	0.750	Green/Long	0.881	0.661
M17	X	1	0.641	2	1.253	MEDIUM	0.625	Yellow/Medium	1.133	0.913
M18	X	1.5	0.667	2	1.289	NARROW	0.813	Red/Short	1.184	0.964

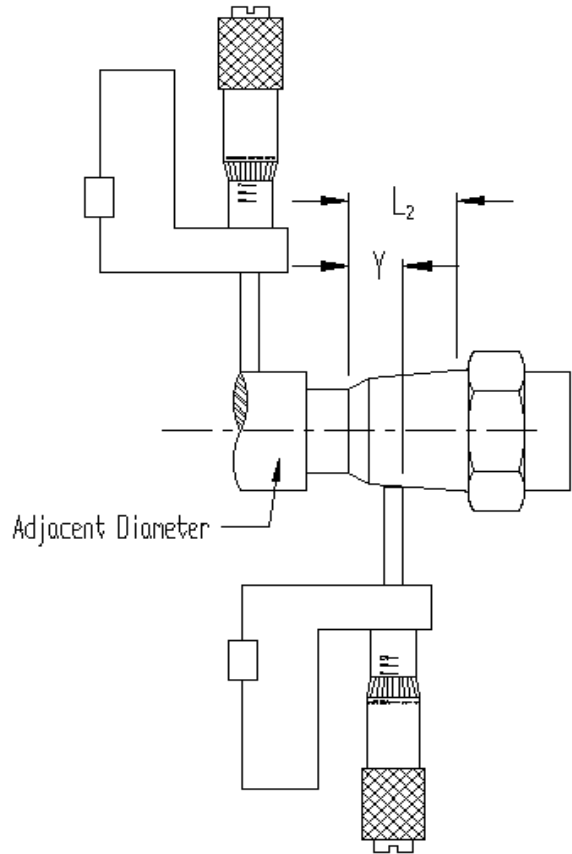
GAGE SETTING CHART FOR NPT, NPTF & BSPT TAPERED PIPE THREAD SIZES**OPTIONAL GAGE SETTING USING AN ADJACENT DIAMETER**

- 1) Take the difference between the blank diameter at Y and the adjacent diameter.
- 2) Divide the difference by 2 and subtract it from the original gage dimension. The result is your corrected gage dimension.

Example using 141 SA

1/4 - 18 NPT B.D. at Y	= .489
Adjacent Diameter	= .625
Difference	= .136
Difference/2	= .068
Original Gage Setting	= .324
minus Difference/2	- .068
Correct Gage Setting	= .256

Note: If the adjacent diameter is smaller than the blank diameter at Y, add the difference instead of subtracting.



BLANK SPECIFICATIONS				GAGE SPECIFICATIONS							
PIPE SIZE NPT & NPTF	Y	L2	B.D. @ Y	125 Series	141/142	145	151/152	160/162/163 Series	165 Series	170 Series	172/173 Series
1/16-27	.130	.261	.279	.385	.431	.437	.431	-	.800	-	-
1/8-27	.132	.264	.372	.345	.376	.385	.398	.970	.753	-	-
1/4-18	.200	.402	.489	.286	.326	.328	.340	.934	.692	-	-
3/8-18	.203	.408	.625	-	.252	.265	.267	.872	.603	-	-
1/2-14	.266	.534	.774	-	-	-	.195	.797	.518	.852	.852
3/4-14	.273	.546	.985	-	-	-	-	.688	.403	.739	.738
1" -11 1/2	.341	.683	1.235	-	-	-	-	.549	-	.632	.632
1 1/4-11 1/2	.353	.707	1.579	-	-	-	-	.395	-	.474	.329
1 1/2-11 1/2	.362	.724	1.818	-	-	-	-	.258	-	.342	.342

BLANK SPECIFICATIONS				GAGE SPECIFICATIONS							
PIPE SIZE BSPT	Y	L2	B.D. @ Y	125 Series	141/142	145	151/152	160/162/163 Series	165 Series	170 Series	172/173 Series
1/16-28	.1563	.255	.281	.387	.432	.450	.430	-	.803	-	-
1/8-28	.1563	.255	.360	.350	.378	.377	.408	.971	.762	-	-
1/4-19	.2367	.381	.484	.484	.328	.328	.344	.936	.696	-	-
3/8-19	.2500	.394	.622	-	.254	.254	.273	.873	.605	-	-
1/2-14	.3214	.517	.779	-	-	-	.195	.795	.512	.847	.847
3/4-14	.3750	.571	.995	-	-	-	-	.685	.408	.727	.727
1" -11	.4091	.659	1.250	-	-	-	-	.539	-	.620	.620
1 1/4-11	.5000	.750	1.591	-	-	-	-	.389	-	.468	.314
1 1/2-11	.5000	.750	1.823	-	-	-	-	.253	-	.338	.338