

WEDGE/ROLLER COMBINATIONS 125 SERIES

WEDGE	ROLLER Ø	SPRING	FCD MIN	FCD MAX
NARROW	0.426	Red/Short	1.358	1.546
NARROW	0.469	Red/Short	1.345	1.531
NARROW	0.486	Red/Short	1.332	1.516
NARROW	0.531	Red/Short	1.319	1.502
NARROW	0.548	Red/Short	1.306	1.487
NARROW	0.594	Red/Short	1.293	1.472
NARROW	0.611	Red/Short	1.280	1.458
MEDIUM	0.426	Red/Short	1.248	1.483
MEDIUM	0.469	Red/Short	1.235	1.466
MEDIUM	0.486	Red/Short	1.222	1.450
MEDIUM	0.531	Green/Long	1.210	1.434
MEDIUM	0.548	Green/Long	1.197	1.418
MEDIUM	0.594	Green/Long	1.185	1.402
MEDIUM	0.611	Green/Long	1.172	1.387
LARGE	0.426	Green/Long	1.144	1.362
LARGE	0.469	Green/Long	1.131	1.347
LARGE	0.486	Green/Long	1.119	1.332
LARGE	0.531	Green/Long	1.107	1.317
LARGE	0.548	Green/Long	1.095	1.302
LARGE	0.594	Green/Long	1.083	1.287
LARGE	0.611	Green/Long	1.071	1.273
X-LARGE	0.426	Green/Long	1.016	1.220
X-LARGE	0.469	Green/Long	1.004	1.205
X-LARGE	0.486	Green/Long	0.993	1.192
X-LARGE	0.531	Green/Long	0.981	1.178
X-LARGE	0.548	Green/Long	0.970	1.164
X-LARGE	0.594	Green/Long	0.958	1.150
X-LARGE	0.611	Green/Long	0.947	1.137

REFERENCE DATA SHEETS 125 SERIES**UN, UNC, UNF, UNEF, UNS THREAD SIZES**

Part Data				Roll Data		Attachment Data				
Size	-	TPI	Blank Diameter	# of Starts	OD	Gage Setting	Wedge	Roller	Spring	Stock Clearance
#0	-	80	0.050	21	1.010	0.464	X-LARGE	0.486	Green/Long	0.405
#1	-	64	0.061	18	1.035	0.465	X-LARGE	0.426	Green/Long	0.439
#1	-	72	0.062	17	1.024	0.463	X-LARGE	0.426	Green/Long	0.430
#2	-	56	0.072	15	1.034	0.461	X-LARGE	0.426	Green/Long	0.448
#2	-	64	0.074	15	1.066	0.466	LARGE	0.611	Green/Long	0.483
#3	-	48	0.083	13	1.029	0.456	X-LARGE	0.426	Green/Long	0.452
#3	-	56	0.086	13	1.065	0.461	LARGE	0.611	Green/Long	0.493
#4	-	40	0.094	12	1.058	0.454	LARGE	0.611	Green/Long	0.490
#4	-	48	0.096	11	1.013	0.446	X-LARGE	0.426	Green/Long	0.449
#5	-	40	0.107	10	1.012	0.442	X-LARGE	0.426	Green/Long	0.457
#5	-	44	0.109	10	1.033	0.440	X-LARGE	0.426	Green/Long	0.481
#6	-	32	0.116	9	0.974	0.431	X-LARGE	0.469	Green/Long	0.424
#6	-	40	0.120	9	1.027	0.440	LARGE	0.611	Green/Long	0.485
#8	-	32	0.142	7	0.939	0.417	X-LARGE	0.469	Green/Long	0.415
#8	-	36	0.144	7	0.962	0.421	X-LARGE	0.426	Green/Long	0.442
#10	-	24	0.161	7	1.051	0.428	LARGE	0.486	Green/Long	0.540
#10	-	28	0.164	6	0.929	0.408	X-LARGE	0.469	Green/Long	0.424
#10	-	32	0.168	6	0.961	0.412	X-LARGE	0.426	Green/Long	0.463
#10	-	36	0.170	6	0.976	0.414	LARGE	0.611	Green/Long	0.482
#10	-	40	0.171	6	0.992	0.417	LARGE	0.594	Green/Long	0.501
#10	-	48	0.174	6	1.016	0.420	LARGE	0.486	Green/Long	0.530
#10	-	56	0.176	6	1.034	0.422	LARGE	0.469	Green/Long	0.552
#12	-	24	0.187	6	1.057	0.419	LARGE	0.426	Green/Long	0.572
#12	-	28	0.191	5	0.909	0.395	X-LARGE	0.426	Green/Long	0.431
#12	-	32	0.194	5	0.931	0.399	X-LARGE	0.426	Green/Long	0.459
#12	-	36	0.196	5	0.943	0.400	X-LARGE	0.426	Green/Long	0.475
#12	-	40	0.197	5	0.957	0.403	LARGE	0.611	Green/Long	0.492
#12	-	48	0.200	5	0.977	0.405	LARGE	0.548	Green/Long	0.517
#12	-	56	0.202	5	0.992	0.407	LARGE	0.486	Green/Long	0.536
1/4	-	20	0.216	5	1.011	0.402	LARGE	0.469	Green/Long	0.550
1/4	-	24	0.220	5	1.045	0.383	MEDIUM	0.611	Green/Long	0.593
1/4	-	27	0.224	5	1.073	0.410	MEDIUM	0.469	Green/Long	0.627
1/4	-	28	0.225	4	0.863	0.376	X-LARGE	0.469	Green/Long	0.419
1/4	-	32	0.228	4	0.880	0.379	X-LARGE	0.426	Green/Long	0.442
1/4	-	36	0.230	4	0.890	0.380	X-LARGE	0.426	Green/Long	0.456
1/4	-	40	0.231	4	0.901	0.382	X-LARGE	0.426	Green/Long	0.470
1/4	-	48	0.234	4	0.918	0.384	LARGE	0.611	Green/Long	0.492
1/4	-	56	0.236	4	0.929	0.385	LARGE	0.548	Green/Long	0.507

REFERENCE DATA SHEETS 125 SERIES**UN, UNC, UNF, UNEF, UNS THREAD SIZES**

Part Data		Roll Data		Attachment Data					
Size	- TPI	Blank Diameter	# of Starts	OD	Gage Setting	Wedge	Roller	Spring	Stock Clearance
5/16	- 18	0.274	4	1.038	0.383	MEDIUM	0.531	Green/Long	0.632
5/16	- 20	0.278	4	1.059	0.384	MEDIUM	0.426	Red/Short	0.660
5/16	- 24	0.283	3	0.818	0.349	X-LARGE	0.426	Green/Long	0.429
5/16	- 27	0.286	3	0.831	0.354	X-LARGE	0.437	Green/Long	0.458
5/16	- 28	0.288	3	0.835	0.351	X-LARGE	0.426	Green/Long	0.454
5/16	- 32	0.291	3	0.848	0.352	X-LARGE	0.426	Green/Long	0.473
5/16	- 36	0.292	3	0.855	0.354	LARGE	0.611	Green/Long	0.483
5/16	- 40	0.294	3	0.863	0.355	LARGE	0.594	Green/Long	0.495
5/16	- 48	0.297	3	0.875	0.356	LARGE	0.548	Green/Long	0.512
3/8	- 16	0.333	3	0.946	0.349	MEDIUM	0.611	Green/Long	0.595
3/8	- 18	0.336	3	0.962	0.350	MEDIUM	0.548	Green/Long	0.618
3/8	- 20	0.341	3	0.981	0.351	MEDIUM	0.469	Red/Short	0.645
3/8	- 24	0.346	3	1.005	0.351	MEDIUM	0.426	Red/Short	0.679
3/8	- 27	0.349	3	1.019	0.355	NARROW	0.611	Red/Short	0.699
3/8	- 28	0.349	3	1.023	0.355	NARROW	0.562	Red/Short	0.703
3/8	- 32	0.353	3	1.035	0.351	NARROW	0.548	Red/Short	0.722
3/8	- 36	0.354	3	1.043	0.352	NARROW	0.531	Red/Short	0.733
3/8	- 40	0.356	3	1.051	0.352	NARROW	0.486	Red/Short	0.745
7/16	- 16	0.395	2	0.755	0.299	LARGE	0.625	Green/Long	0.466
7/16	- 18	0.398	2	0.766	0.301	LARGE	0.611	Green/Long	0.484
7/16	- 20	0.403	2	0.779	0.302	LARGE	0.548	Green/Long	0.505
7/16	- 24	0.407	2	0.792	0.303	LARGE	0.531	Green/Long	0.527
7/16	- 27	0.411	2	0.804	0.303	LARGE	0.469	Green/Long	0.546
7/16	- 28	0.413	2	0.807	0.303	LARGE	0.469	Green/Long	0.551
7/16	- 32	0.416	2	0.815	0.304	LARGE	0.426	Green/Long	0.565
1/2	- 12	0.444	2	0.841	0.293	MEDIUM	0.611	Green/Long	0.589
1/2	- 13	0.448	2	0.853	0.293	MEDIUM	0.548	Green/Long	0.609
1/2	- 14	0.450	2	0.861	0.294	MEDIUM	0.531	Green/Long	0.622
1/2	- 16	0.458	2	0.880	0.293	MEDIUM	0.469	Red/Short	0.654
1/2	- 18	0.465	2	0.891	0.291	MEDIUM	0.426	Red/Short	0.676
1/2	- 20	0.466	2	0.904	0.293	NARROW	0.611	Red/Short	0.693
1/2	- 24	0.470	2	0.918	0.293	NARROW	0.594	Red/Short	0.716
1/2	- 27	0.474	2	0.929	0.295	NARROW	0.531	Red/Short	0.734
1/2	- 28	0.475	2	0.932	0.292	NARROW	0.531	Red/Short	0.738
1/2	- 32	0.478	2	0.940	0.291	NARROW	0.486	Red/Short	0.752

REFERENCE DATA SHEETS 125 SERIES
NPT, NPTF TAPERED PIPE THREAD SIZES

Part Data		Roll Data			Attachment Data				
Size	TPI	Blank Diameter at "Y"	# of Starts	OD Large End	Gage Setting at "Y"	Wedge	Roller	Spring	Stock Clearance
1/16	- 27	0.279	4	1.063	0.385	MEDIUM	0.426	Red/Short	0.673
1/8	- 27	0.372	3	1.072	0.345	NARROW	0.426	Red/Short	0.775
1/4	- 18	0.286	2	0.942	0.286	LARGE	0.469	Green/Long	0.548

REFERENCE DATA SHEETS 125 SERIES
BSPT TAPERED PIPE THREAD SIZES

Part Data		Roll Data			Attachment Data				
Size	TPI	Blank Diameter at "Y"	# of Starts	OD Large End	Gage Setting at "Y"	Wedge	Roller	Spring	Stock Clearance
1/16	- 28	0.281	4	1.084	0.389	NARROW	0.611	Red/Short	0.696
1/8	- 28	0.360	3	1.046	0.350	NARROW	0.531	Red/Short	0.737
1/4	- 19	0.484	2	0.935	0.288	NARROW	0.500	Red/Short	0.741

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

**REFERENCE DATA SHEETS 125 SERIES
NPSM STRAIGHT PIPE THREAD SIZES**

Part Data		Roll Data			Attachment Data				
Size	TPI	Blank Diameter at "Y"	# of Starts	OD Large End	Gage Setting at "Y"	Wedge	Roller	Spring	Stock Clearance
1/8	- 27	0.371	3	1.083	0.346	NARROW	0.426	Red/Short	0.785
1/4	- 18	0.488	2	0.947	0.286	NARROW	0.469	Red/Short	0.755

**REFERENCE DATA SHEETS 125 SERIES
BSPP STRAIGHT PIPE THREAD SIZES**

Part Data		Roll Data			Attachment Data				
Size	TPI	Blank Diameter at "Y"	# of Starts	OD Large End	Gage Setting at "Y"	Wedge	Roller	Spring	Stock Clearance
1/16	- 28	0.281	4	1.081	0.388	NARROW	0.611	Red/Short	0.693
1/8	- 28	0.358	3	1.046	0.350	NARROW	0.531	Red/Short	0.735
1/4	- 19	0.482	2	0.935	0.288	NARROW	0.500	Red/Short	0.739

REFERENCE DATA SHEETS 125 SERIES
METRIC THREAD SIZES

Part Data				Roll Data		Attachment Data				
Size	X	Pitch	Blank Diameter	# of Starts	OD	Gage Setting	Wedge	Roller	Spring	Stock Clearance
M1.6	X	0.35	0.051	21	1.031	0.468	X-LARGE	0.426	Green/Long	0.426
M2	X	0.4	0.066	17	1.071	0.469	X-LARGE	0.426	Green/Long	0.480
M2.5	X	0.45	0.084	13	1.049	0.460	X-LARGE	0.426	Green/Long	0.475
M3	X	0.5	0.103	10	0.985	0.442	X-LARGE	0.426	Green/Long	0.428
M3.5	X	0.6	0.120	9	1.029	0.444	LARGE	0.611	Green/Long	0.487
M4	X	0.7	0.136	8	1.042	0.440	LARGE	0.548	Green/Long	0.515
M5	X	0.8	0.173	6	0.994	0.419	LARGE	0.594	Green/Long	0.501
M6	X	1	0.208	5	0.988	0.405	LARGE	0.531	Green/Long	0.525
M8		1	0.286	3	0.829	0.353	X-LARGE	0.426	Green/Long	0.445
M8	X	1.25	0.280	4	1.067	0.387	MEDIUM	0.426	Red/Short	0.670
M10	X	0.75	0.372	2	0.729	0.309	X-LARGE	0.426	Green/Long	0.436
M10	X	1	0.365	3	1.065	0.351	NARROW	0.469	Red/Short	0.760
M10	X	1.25	0.359	3	1.037	0.351	NARROW	0.548	Red/Short	0.719
M10	X	1.5	0.352	3	1.008	0.351	MEDIUM	0.426	Red/Short	0.678
M12	X	1	0.444	2	0.868	0.302	MEDIUM	0.486	Red/Short	0.641
M12	X	1.25	0.438	2	0.851	0.302	MEDIUM	0.548	Green/Long	0.612
M12	X	1.5	0.432	2	0.832	0.301	LARGE	0.426	Green/Long	0.581
M12	X	1.75	0.426	2	0.813	0.300	LARGE	0.469	Green/Long	0.550

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

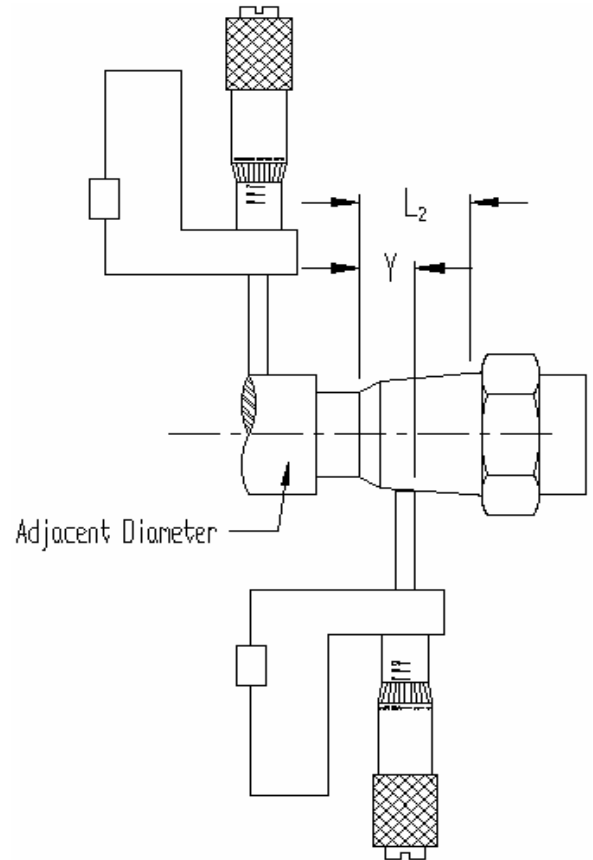
- 1) Take the difference between the blank diameter at Y and the adjacent diameter.
- 2) Divide the difference by 2 and subtract it from the original gage dimension. The result is your corrected gage dimension.

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
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	0.426	-
3/8-18	.203	.408	.625	-	.252	.265	.267	.872	.603	-
1/2-14	.266	.534	.774	-	-	-	.195	.797	.518	.852
3/4-14	.273	.546	.985	-	-	-	-	.688	.403	.739
1" -11 1/2	.341	.683	1.235	-	-	-	-	.549	-	.632
1 1/4-11 1/2	.353	.707	1.579	-	-	-	-	.395	-	.474
1 1/2-11 1/2	.362	.724	1.818	-	-	-	-	.258	-	.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
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
3/4-14	.3750	.571	.995	-	-	-	-	.685	.408	.727
1" -11	.4091	.659	1.250	-	-	-	-	.539	-	.620
1 1/4-11	.5000	.750	1.591	-	-	-	-	.389	-	.468
1 1/2-11	.5000	.750	1.823	-	-	-	-	.253	-	.338