

WEDGE/ROLLER COMBINATIONS FOR 141/142

Wedge	Roller Ø	Spring	FCD Min.	FCD Max.
NARROW	0.625	Red/Short	2.002	2.273
NARROW	0.688	Red/Short	1.974	2.241
NARROW	0.750	Yellow/Medium	1.946	2.209
NARROW	0.813	Yellow/Medium	1.918	2.176
NARROW	0.875	Yellow/Medium	1.891	2.145
MEDIUM	0.625	Yellow/Medium	1.853	2.108
MEDIUM	0.688	Yellow/Medium	1.826	2.077
MEDIUM	0.750	Green/Long	1.799	2.046
MEDIUM	0.813	Green/Long	1.772	2.016
MEDIUM	0.875	Green/Long	1.746	1.986
LARGE	0.625	Green/Long	1.713	1.955
LARGE	0.688	Green/Long	1.686	1.925
LARGE	0.750	Green/Long	1.660	1.896
LARGE	0.813	Green/Long	1.634	1.867
LARGE	0.875	Green/Long	1.608	1.838
X-LARGE	0.625	Green/Long	1.579	1.811
X-LARGE	0.688	Green/Long	1.553	1.782
X-LARGE	0.750	Green/Long	1.528	1.754
X-LARGE	0.813	Green/Long	1.502	1.726
X-LARGE	0.875	Green/Long	1.477	1.699

REFERENCE DATA SHEETS 141/142

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	35	1.684	0.532	LARGE	0.750	Green/long	0.769
#1	- 64	0.061	28	1.626	0.521	LARGE	0.875	Green/long	0.720
#1	- 72	0.062	28	1.673	0.527	LARGE	0.750	Green/long	0.769
#2	- 56	0.072	24	1.654	0.520	LARGE	0.813	Green/long	0.758
#2	- 64	0.074	24	1.706	0.526	LARGE	0.688	Green/long	0.813
#3	- 48	0.084	21	1.659	0.516	LARGE	0.750	Green/long	0.772
#3	- 56	0.085	20	1.638	0.513	LARGE	0.813	Green/long	0.755
#4	- 40	0.094	19	1.674	0.514	LARGE	0.688	Green/long	0.795
#4	- 48	0.096	18	1.658	0.511	LARGE	0.750	Green/long	0.784
#5	- 40	0.107	16	1.618	0.502	LARGE	0.813	Green/long	0.752
#5	- 44	0.108	16	1.652	0.506	LARGE	0.688	Green/long	0.789
#6	- 32	0.116	15	1.622	0.499	LARGE	0.750	Green/long	0.762
#6	- 40	0.120	14	1.598	0.495	LARGE	0.813	Green/long	0.745
#8	- 32	0.142	12	1.609	0.487	LARGE	0.750	Green/long	0.775
#8	- 36	0.144	12	1.650	0.491	LARGE	0.625	Green/long	0.820
#10	- 24	0.161	11	1.651	0.484	LARGE	0.625	Green/long	0.830
#10	- 28	0.164	11	1.702	0.488	MEDIUM	0.813	Green/long	0.888
#10	- 32	0.168	10	1.601	0.476	LARGE	0.688	Green/long	0.793
#10	- 36	0.169	10	1.626	0.479	LARGE	0.625	Green/long	0.822
#10	- 40	0.171	10	1.652	0.481	MEDIUM	0.875	Green/long	0.851
#10	- 48	0.174	10	1.693	0.484	MEDIUM	0.813	Green/long	0.897
#10	- 56	0.176	9	1.550	0.468	LARGE	0.813	Green/long	0.758
#12	- 24	0.188	9	1.585	0.466	LARGE	0.688	Green/long	0.790
#12	- 28	0.191	9	1.636	0.471	MEDIUM	0.875	Green/long	0.848
#12	- 32	0.194	9	1.675	0.473	MEDIUM	0.813	Green/long	0.893
#12	- 36	0.195	9	1.698	0.475	MEDIUM	0.750	Green/long	0.920
#12	- 40	0.197	8	1.530	0.457	LARGE	0.813	Green/long	0.755
1/4	- 20	0.216	8	1.617	0.458	LARGE	0.625	Green/long	0.846
1/4	- 24	0.220	8	1.672	0.462	MEDIUM	0.750	Green/long	0.911
1/4	- 27	0.223	8	1.708	0.464	MEDIUM	0.688	Yellow/medium	0.953
1/4	- 28	0.225	7	1.511	0.444	LARGE	0.813	Green/long	0.757
1/4	- 32	0.228	7	1.541	0.446	LARGE	0.688	Green/long	0.793
1/4	- 36	0.229	7	1.558	0.448	LARGE	0.625	Green/long	0.814
1/4	- 40	0.231	7	1.576	0.449	LARGE	0.625	Green/long	0.835
1/4	- 48	0.234	7	1.605	0.451	MEDIUM	0.875	Green/long	0.869
1/4	- 56	0.236	7	1.625	0.453	MEDIUM	0.813	Green/long	0.893
5/16	- 18	0.274	6	1.556	0.428	LARGE	0.625	Green/long	0.840
5/16	- 20	0.278	6	1.588	0.430	MEDIUM	0.813	Green/long	0.879

* Limited application, will have trouble adjusting penetration rate.

REFERENCE DATA SHEETS 141/142

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	- 24	0.283	6	1.636	0.433	MEDIUM	0.688	Yellow/medium	0.937
5/16	- 27	0.285	6	1.656	0.434	MEDIUM	0.625	Yellow/medium	0.963
5/16	- 28	0.287	6	1.670	0.434	MEDIUM	0.625	Yellow/medium	0.979
5/16	- 32	0.290	6	1.696	0.434	NARROW	0.875	Yellow/medium	1.010
5/16	- 36	0.292	5	1.426	0.408	LARGE	0.813	Green/long	0.744
5/16	- 40	0.293	5	1.439	0.410	LARGE	0.750	Green/long	0.761
5/16	- 48	0.296	5	1.459	0.412	LARGE	0.750	Green/long	0.786
3/8	- 16	0.332	5	1.576	0.406	MEDIUM	0.750	Green/long	0.914
3/8	- 18	0.336	5	1.603	0.407	MEDIUM	0.688	Yellow/medium	0.950
3/8	- 20	0.340	5	1.636	0.408	MEDIUM	0.625	Yellow/medium	0.990
3/8	- 24	0.346	5	1.676	0.408	NARROW	0.813	Yellow/medium	1.040
3/8	- 28	0.350	5	1.703	0.408	NARROW	0.688	Red/short	1.074
3/8	- 32	0.353	4	1.381	0.380	LARGE	0.813	Green/long	0.758
3/8	- 36	0.354	4	1.390	0.381	LARGE	0.750	Green/long	0.771
3/8	- 40	0.356	4	1.401	0.381	LARGE	0.750	Green/long	0.785
7/16	- 14	0.389	4	1.477	0.374	MEDIUM	0.875	Green/long	0.867
7/16	- 16	0.395	4	1.511	0.375	MEDIUM	0.750	Green/long	0.912
7/16	- 18	0.398	4	1.532	0.376	MEDIUM	0.688	Yellow/medium	0.941
7/16	- 20	0.403	4	1.558	0.376	MEDIUM	0.625	Yellow/medium	0.974
7/16	- 24	0.407	4	1.586	0.376	NARROW	0.875	Yellow/medium	1.012
7/16	- 27	0.410	4	1.604	0.376	NARROW	0.813	Yellow/medium	1.036
7/16	- 28	0.412	4	1.613	0.376	NARROW	0.750	Yellow/medium	1.047
7/16	- 32	0.415	4	1.631	0.375	NARROW	0.750	Yellow/medium	1.070
1/2	- 12	0.444	3	1.261	0.326	X-LARGE	0.625	Green/long	0.699
1/2	- 13	0.448	3	1.279	0.328	LARGE	0.875	Green/long	0.725
1/2	- 14	0.450	3	1.291	0.329	LARGE	0.813	Green/long	0.743
1/2	- 16	0.457	3	1.321	0.331	LARGE	0.750	Green/long	0.784
1/2	- 18	0.461	3	1.336	0.331	LARGE	0.688	Green/long	0.808
1/2	- 20	0.466	3	1.356	0.332	LARGE	0.625	Green/long	0.835
1/2	- 24	0.470	3	1.377	0.333	MEDIUM	0.875	Green/long	0.866
1/2	- 27	0.473	3	1.391	0.333	MEDIUM	0.813	Green/long	0.886
1/2	- 28	0.475	3	1.397	0.333	MEDIUM	0.813	Green/long	0.893
1/2	- 32	0.478	3	1.410	0.333	MEDIUM	0.750	Green/long	0.912
9/16	- 12	0.506	3	1.448	0.322	MEDIUM	0.688	Yellow/medium	0.948
9/16	- 14	0.513	3	1.478	0.322	NARROW	0.875	Yellow/medium	0.993
9/16	- 16	0.520	3	1.508	0.321	NARROW	0.813	Yellow/medium	1.034
9/16	- 18	0.524	3	1.528	0.320	NARROW	0.750	Yellow/medium	1.062
9/16	- 20	0.528	3	1.544	0.320	NARROW	0.688	Red/short	1.085
9/16	- 24	0.533	2	1.045	0.267	X-LARGE	0.875	Green/long	0.596
9/16	- 28	0.537	2	1.057	0.268	X-LARGE	0.813	Green/long	0.616
9/16	- 32	0.540	2	1.065	0.268	X-LARGE	0.750	Green/long	0.629
5/8	- 11	0.564	2	1.079	0.257	X-LARGE	0.750	Green/long	0.632
5/8	- 12	0.569	2	1.091	0.258	X-LARGE	0.688	Green/long	0.654
5/8	- 14	0.575	2	1.110	0.259	X-LARGE	0.625	Green/long	0.687

* Limited application, will have trouble adjusting penetration rate.

REFERENCE DATA SHEETS 141/142

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
5/8	- 16	0.582	2	1.130	0.260	LARGE	0.875	Green/long	0.718
5/8	- 18	0.587	2	1.144	0.261	LARGE	0.813	Green/long	0.741
5/8	- 20	0.590	2	1.154	0.261	LARGE	0.813	Green/long	0.758
5/8	- 24	0.596	2	1.170	0.261	LARGE	0.750	Green/long	0.784
5/8	- 27	0.598	2	1.178	0.262	LARGE	0.688	Green/long	0.798
5/8	- 28	0.600	2	1.182	0.261	LARGE	0.688	Green/long	0.803
5/8	- 32	0.603	2	1.190	0.261	LARGE	0.625	Green/long	0.817
11/16	- 12	0.631	2	1.216	0.250	LARGE	0.625	Green/long	0.841
11/16	- 16	0.645	2	1.255	0.249	MEDIUM	0.750	Green/long	0.906
11/16	- 20	0.653	2	1.279	0.248	MEDIUM	0.688	Yellow/medium	0.945
11/16	- 24	0.658	2	1.295	0.248	MEDIUM	0.625	Yellow/medium	0.971
11/16	- 28	0.662	2	1.307	0.247	MEDIUM	0.625	Yellow/medium	0.991
11/16	- 32	0.665	2	1.315	0.247	NARROW	0.875	Yellow/medium	1.004
3/4	- 10	0.683	2	1.309	0.236	MEDIUM	0.625	Yellow/medium	0.976
3/4	- 12	0.694	2	1.341	0.234	NARROW	0.813	Yellow/medium	1.029
3/4	- 14	0.700	2	1.360	0.232	NARROW	0.750	Yellow/medium	1.062
3/4	- 16	0.707	2	1.380	0.230	NARROW	0.688	Red/short	1.093
3/4	- 18	0.710	2	1.394	0.230	NARROW	0.625	Red/short	1.116
3/4	- 20	0.716	2	1.404	0.228	NARROW	0.625	Red/short	1.133
* 3/4	- 24	0.720	2	1.419	0.226	NARROW	0.625	Red/short	1.158
* 3/4	- 27	0.723	2	1.427	0.225	NARROW	0.625	Red/short	1.172
* 3/4	- 28	0.725	2	1.432	0.224	NARROW	0.625	Red/short	1.178
* 3/4	- 32	0.727	2	1.438	0.224	NARROW	0.625	Red/short	1.190

* Limited application, will have trouble adjusting penetration rate.

REFERENCE DATA SHEETS 141/142**NPT, NPTF TAPERED PIPE THREAD SIZES**

Part Data			Roll Data			Attachment Data				
Size	Pitch		Blank Diameter at "Y"	# of Starts	OD Large End	Gage Setting at "Y"	Wedge	Roller	Spring	Stock Clearance
1/16	-	27	0.279	6	1.615	0.431	MEDIUM	0.813	Green/long	0.892
1/8	-	27	0.372	4	1.440	0.376	LARGE	0.688	Green/long	0.810
1/4	-	18	0.489	3	1.428	0.326	MEDIUM	0.813	Green/long	0.895
3/8	-	18	0.625	2	1.229	0.252	LARGE	0.625	Green/long	0.833

REFERENCE DATA SHEETS 141/142**BSPT TAPERED PIPE THREAD SIZES**

Part Data			Roll Data			Attachment Data				
Size	Pitch		Blank Diameter at "Y"	# of Starts	OD Large End	Gage Setting at "Y"	Wedge	Roller	Spring	Stock Clearance
1/16	-	28	0.281	6	1.626	0.432	MEDIUM	0.750	Green/long	0.912
1/8	-	28	0.360	4	1.405	0.378	LARGE	0.750	Green/long	0.770
1/4	-	19	0.484	3	1.418	0.328	MEDIUM	0.813	Green/long	0.891
3/8	-	19	0.622	2	1.227	0.254	LARGE	0.625	Green/long	0.838

"Y" dimension is shown in accompanying drawing.

REFERENCE DATA SHEETS 141/142**NPS, NPSM STRAIGHT PIPE THREAD SIZES**

Part Data			Roll Data		Attachment Data					
Size	TPI		Blank Diameter	# of Starts	OD	Gage Setting	Wedge	Roller	Spring	Stock Clearance
1/8	-	27	0.371	4	1.440	0.378	LARGE	0.625	Green/long	0.824
1/4	-	18	0.488	3	1.420	0.328	MEDIUM	0.750	Green/long	0.907
3/8	-	18	0.624	2	1.219	0.254	LARGE	0.625	Green/long	0.842

REFERENCE DATA SHEETS 141/142**BSPP STRAIGHT PIPE THREAD SIZES**

Part Data			Roll Data		Attachment Data					
Size	TPI		Blank Diameter	# of Starts	OD	Gage Setting	Wedge	Roller	Spring	Stock Clearance
1/16	-	28	0.281	6	1.621	0.430	MEDIUM	0.750	Green/long	0.916
1/8	-	28	0.358	4	1.395	0.379	LARGE	0.750	Green/long	0.769
1/4	-	19	0.482	3	1.402	0.329	MEDIUM	0.813	Green/long	0.888
3/8	-	19	0.620	2	1.211	0.255	LARGE	0.625	Green/long	0.835

REFERENCE DATA SHEETS 141/142

METRIC THREAD SIZES

Part Data			Roll Data		Attachment Data				
Size	Pitch	Blank Diameter	# of Starts	OD	Gage Setting	Wedge	Roller	Spring	Stock Clearance
M1.6	X 0.35	0.051	34	1.669	0.530	LARGE	0.813	Green/long	0.754
M2	X 0.4	0.066	26	1.638	0.521	LARGE	0.813	Green/long	0.737
M2.5	X 0.45	0.084	21	1.695	0.520	LARGE	0.688	Green/long	0.811
M3	X 0.5	0.103	17	1.676	0.511	LARGE	0.688	Green/long	0.809
M3.5	X 0.6	0.120	14	1.612	0.496	LARGE	0.813	Green/long	0.760
M4	X 0.7	0.137	13	1.693	0.498	MEDIUM	0.875	Green/long	0.856
M5	X 0.8	0.173	10	1.658	0.480	MEDIUM	0.875	Green/long	0.855
M6	X 1	0.208	8	1.580	0.458	LARGE	0.688	Green/long	0.807
M8	X 0.75	0.293	5	1.429	0.408	LARGE	0.750	Green/long	0.747
M8	X 1	0.286	6	1.657	0.433	MEDIUM	0.625	Yellow/medium	0.963
M8	X 1.25	0.280	6	1.601	0.431	MEDIUM	0.813	Green/long	0.894
M10	X 0.75	0.372	4	1.458	0.381	MEDIUM	0.875	Green/long	0.855
M10	X 1.25	0.359	4	1.382	0.376	LARGE	0.813	Green/long	0.754
M10	X 1.5	0.352	5	1.679	0.405	NARROW	0.813	Yellow/medium	1.039
M12	X 1	0.444	3	1.301	0.335	LARGE	0.750	Green/long	0.764
*M12	X 1.25	0.437	4	1.697	0.368	NARROW	0.625	Red/short	1.148
M12	X 1.5	0.431	4	1.659	0.369	NARROW	0.688	Red/short	1.098
M12	X 1.75	0.424	4	1.621	0.370	NARROW	0.750	Yellow/medium	1.048
M14	X 1.5	0.510	3	1.480	0.324	NARROW	0.875	Yellow/medium	0.997
M14	X 2	0.497	3	1.423	0.324	MEDIUM	0.750	Green/long	0.916
M15	X 1	0.562	2	1.104	0.266	X-LARGE	0.625	Green/long	0.685
M16	X 1.5	0.588	2	1.144	0.260	LARGE	0.813	Green/long	0.740
M16	X 2	0.575	2	1.106	0.258	X-LARGE	0.688	Green/long	0.678
M17	X 1	0.641	2	1.261	0.252	MEDIUM	0.750	Green/long	0.921
M18	X 1	0.680	2	1.340	0.241	NARROW	0.813	Yellow/medium	1.039
M18	X 1.5	0.667	2	1.302	0.244	MEDIUM	0.625	Yellow/medium	0.977

*Limited Application. Will have trouble adjusting penetration rate.

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

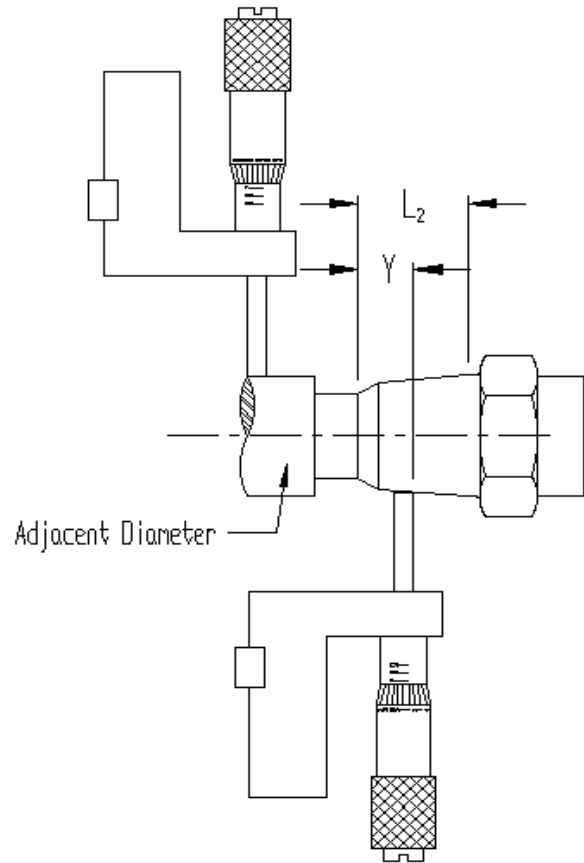
- 1) Take the difference between the blank diameter at Y and the adjacent diameter.
- 2) Divide the difference by 2 and subtract it from the original gage dimension. The result is your corrected gage dimension.

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
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