

WEDGE/ROLLER COMBINATIONS FOR 151/152

WEDGE	ROLLER Ø	SPRING	FCD MIN	FCD MAX
NARROW	0.625	Red/short	2.372	2.672
NARROW	0.688	Red/short	2.341	2.636
NARROW	0.750	Yellow/medium	2.310	2.601
NARROW	0.813	Yellow/medium	2.279	2.556
NARROW	0.875	Yellow/medium	2.248	2.531
MEDIUM	0.625	Yellow/medium	2.205	2.490
MEDIUM	0.688	Yellow/medium	2.175	2.456
MEDIUM	0.750	Green/long	2.144	2.422
MEDIUM	0.813	Green/long	2.114	2.388
MEDIUM	0.875	Green/long	2.084	2.354
LARGE	0.625	Green/long	2.046	2.320
LARGE	0.688	Green/long	2.016	2.286
LARGE	0.750	Green/long	1.986	2.254
LARGE	0.813	Green/long	1.956	2.220
LARGE	0.875	Green/long	1.927	2.188
X-LARGE	0.625	Green/long	1.897	2.158
X-LARGE	0.688	Green/long	1.867	2.125
X-LARGE	0.750	Green/long	1.838	2.093
X-LARGE	0.813	Green/long	1.808	2.061
X-LARGE	0.875	Green/long	1.779	2.030
AUXILIARY	0.625	Green/long	1.790	2.063
AUXILIARY	0.688	Green/long	1.761	2.031
AUXILIARY	0.750	Green/long	1.732	2.000

REFERENCE DATA SHEETS 151/152

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 Towards Collet	Stock Clearance Away From Collet
#6	- 32	0.116	17	1.802	0.515	X-LARGE	0.750	Green/long	0.942	0.842
#6	- 40	0.120	16	1.826	0.515	X-LARGE	0.688	Green/long	0.973	0.873
#8	- 32	0.142	13	1.743	0.499	X-LARGE	0.813	Green/long	0.909	0.809
#8	- 36	0.144	13	1.788	0.502	X-LARGE	0.750	Green/long	0.958	0.858
#10	- 24	0.161	12	1.801	0.495	X-LARGE	0.688	Green/long	0.980	0.880
#10	- 28	0.164	11	1.702	0.487	AUXILIARY	0.688	Green/long	0.888	0.788
#10	- 32	0.168	11	1.761	0.490	X-LARGE	0.750	Green/long	0.953	0.853
#10	- 36	0.169	11	1.789	0.491	X-LARGE	0.688	Green/long	0.984	0.884
#10	- 40	0.171	11	1.817	0.492	X-LARGE	0.625	Green/long	1.015	0.915
#10	- 48	0.174	10	1.693	0.482	X-LARGE	0.875	Green/long	0.897	0.797
#10	- 56	0.176	10	1.722	0.484	X-LARGE	0.813	Green/long	0.929	0.829
#12	- 24	0.188	10	1.761	0.480	X-LARGE	0.750	Green/long	0.966	0.866
#12	- 28	0.191	10	1.818	0.483	X-LARGE	0.625	Green/long	1.030	0.930
#12	- 32	0.194	9	1.675	0.472	X-LARGE	0.875	Green/long	0.893	0.793
#12	- 36	0.195	9	1.698	0.474	X-LARGE	0.813	Green/long	0.919	0.819
#12	- 40	0.197	9	1.721	0.475	X-LARGE	0.750	Green/long	0.945	0.845
#12	- 48	0.200	9	1.758	0.476	X-LARGE	0.688	Green/long	0.988	0.888
#12	- 56	0.202	9	1.784	0.477	X-LARGE	0.625	Green/long	1.017	0.917
1/4	- 20	0.216	9	1.819	0.471	LARGE	0.875	Green/long	1.048	0.948
1/4	- 24	0.220	8	1.672	0.460	X-LARGE	0.813	Green/long	0.910	0.810
1/4	- 27	0.223	8	1.708	0.462	X-LARGE	0.750	Green/long	0.952	0.852
1/4	- 28	0.225	8	1.727	0.462	X-LARGE	0.688	Green/long	0.973	0.873
1/4	- 32	0.228	8	1.761	0.463	X-LARGE	0.625	Green/long	1.013	0.913
1/4	- 36	0.229	8	1.781	0.464	LARGE	0.875	Green/long	1.036	0.936
1/4	- 40	0.231	8	1.801	0.464	LARGE	0.813	Green/long	1.059	0.959
1/4	- 48	0.234	8	1.834	0.464	LARGE	0.750	Green/long	1.098	0.998
1/4	- 56	0.236	7	1.625	0.451	X-LARGE	0.875	Green/long	0.892	0.792
5/16	- 18	0.274	7	1.815	0.444	LARGE	0.750	Green/long	1.099	0.999
5/16	- 20	0.278	7	1.852	0.444	LARGE	0.688	Green/long	1.143	1.043
5/16	- 24	0.283	6	1.636	0.431	X-LARGE	0.813	Green/long	0.937	0.837
5/16	- 27	0.285	6	1.656	0.432	X-LARGE	0.750	Green/long	0.962	0.862
5/16	- 28	0.287	6	1.670	0.432	X-LARGE	0.688	Green/long	0.979	0.879
5/16	- 32	0.290	6	1.696	0.432	X-LARGE	0.625	Green/long	1.010	0.910
5/16	- 36	0.292	6	1.711	0.432	X-LARGE	0.625	Green/long	1.029	0.929
5/16	- 40	0.293	6	1.727	0.433	LARGE	0.875	Green/long	1.048	0.948
5/16	- 48	0.296	6	1.751	0.433	LARGE	0.813	Green/long	1.077	0.977
3/8	- 16	0.332	5	1.576	0.405	X-LARGE	0.813	Green/long	0.914	0.814
3/8	- 18	0.336	5	1.603	0.405	X-LARGE	0.750	Green/long	0.949	0.849
3/8	- 20	0.340	5	1.636	0.406	X-LARGE	0.688	Green/long	0.990	0.890
3/8	- 24	0.346	5	1.676	0.406	LARGE	0.875	Green/long	1.040	0.940
3/8	- 27	0.348	5	1.692	0.406	LARGE	0.813	Green/long	1.060	0.960
3/8	- 28	0.350	5	1.703	0.405	LARGE	0.813	Green/long	1.074	0.974
3/8	- 32	0.353	5	1.726	0.405	LARGE	0.750	Green/long	1.103	1.003
3/8	- 36	0.354	5	1.738	0.405	LARGE	0.688	Green/long	1.118	1.018
3/8	- 40	0.356	5	1.751	0.405	LARGE	0.688	Green/long	1.134	1.034
7/16	- 14	0.389	5	1.846	0.390	MEDIUM	0.813	Green/long	1.236	1.136
7/16	- 16	0.395	4	1.511	0.373	X-LARGE	0.813	Green/long	0.912	0.812
7/16	- 18	0.398	4	1.532	0.374	X-LARGE	0.750	Green/long	0.940	0.840

REFERENCE DATA SHEETS 151/152

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 Towards Collet	Stock Clearance Away From Collet
7/16	- 20	0.403	4	1.558	0.374	X-LARGE	0.688	Green/long	0.974	0.874
7/16	- 24	0.407	4	1.586	0.374	X-LARGE	0.625	Green/long	1.011	0.911
7/16	- 27	0.410	4	1.604	0.374	LARGE	0.875	Green/long	1.035	0.935
7/16	- 28	0.412	4	1.613	0.373	LARGE	0.875	Green/long	1.047	0.947
7/16	- 32	0.415	4	1.631	0.373	LARGE	0.813	Green/long	1.070	0.970
1/2	- 12	0.444	4	1.681	0.360	LARGE	0.688	Green/long	1.119	1.019
1/2	- 13	0.448	4	1.705	0.359	LARGE	0.625	Green/long	1.151	1.051
1/2	- 14	0.450	4	1.721	0.359	LARGE	0.625	Green/long	1.172	1.072
1/2	- 16	0.457	4	1.761	0.356	MEDIUM	0.813	Green/long	1.224	1.124
1/2	- 18	0.461	4	1.781	0.354	MEDIUM	0.750	Green/long	1.252	1.152
1/2	- 20	0.466	4	1.808	0.352	MEDIUM	0.688	Yellow/medium	1.287	1.187
1/2	- 24	0.470	4	1.836	0.350	MEDIUM	0.625	Yellow/medium	1.324	1.224
1/2	- 27	0.473	3	1.391	0.332	AUXILIARY	0.688	Green/long	0.884	0.784
1/2	- 28	0.475	3	1.397	0.332	X-LARGE	0.875	Green/long	0.893	0.793
1/2	- 32	0.478	3	1.410	0.332	X-LARGE	0.813	Green/long	0.912	0.812
9/16	- 12	0.506	3	1.448	0.320	X-LARGE	0.750	Green/long	0.948	0.848
9/16	- 14	0.513	3	1.478	0.320	X-LARGE	0.688	Green/long	0.991	0.891
9/16	- 16	0.520	3	1.508	0.318	X-LARGE	0.625	Green/long	1.032	0.932
9/16	- 18	0.524	3	1.528	0.318	LARGE	0.813	Green/long	1.062	0.962
9/16	- 20	0.528	3	1.544	0.317	LARGE	0.813	Green/long	1.085	0.985
9/16	- 24	0.533	3	1.568	0.316	LARGE	0.688	Green/long	1.119	1.019
9/16	- 27	0.535	3	1.578	0.315	LARGE	0.688	Green/long	1.134	1.034
9/16	- 28	0.537	3	1.586	0.314	LARGE	0.688	Green/long	1.145	1.045
9/16	- 32	0.540	3	1.598	0.313	LARGE	0.625	Green/long	1.162	1.062
5/8	- 11	0.564	3	1.619	0.302	LARGE	0.625	Green/long	1.172	1.072
5/8	- 12	0.569	3	1.637	0.300	MEDIUM	0.875	Green/long	1.200	1.100
5/8	- 14	0.575	3	1.665	0.297	MEDIUM	0.813	Green/long	1.241	1.141
5/8	- 16	0.582	3	1.695	0.294	MEDIUM	0.688	Yellow/medium	1.283	1.183
5/8	- 18	0.587	3	1.716	0.292	MEDIUM	0.625	Yellow/medium	1.313	1.213
5/8	- 20	0.590	3	1.731	0.290	MEDIUM	0.625	Yellow/medium	1.335	1.235
5/8	- 24	0.596	3	1.755	0.286	NARROW	0.875	Yellow/medium	1.369	1.269
5/8	- 27	0.598	3	1.765	0.285	NARROW	0.813	Yellow/medium	1.383	1.283
5/8	- 28	0.600	3	1.773	0.284	NARROW	0.813	Yellow/medium	1.394	1.294
5/8	- 32	0.603	3	1.785	0.282	NARROW	0.750	Yellow/medium	1.412	1.312
11/16	- 12	0.631	3	1.824	0.267	NARROW	0.688	Red/short	1.449	1.349
11/16	- 16	0.645	2	1.255	0.248	X-LARGE	0.875	Green/long	0.906	0.806
11/16	- 20	0.653	2	1.279	0.247	X-LARGE	0.750	Green/long	0.945	0.845
11/16	- 24	0.658	2	1.295	0.246	X-LARGE	0.688	Green/long	0.971	0.871
11/16	- 28	0.662	2	1.307	0.245	X-LARGE	0.688	Green/long	0.991	0.891
11/16	- 32	0.665	2	1.315	0.244	X-LARGE	0.625	Green/long	1.004	0.904
3/4	- 10	0.683	2	1.309	0.234	X-LARGE	0.688	Green/long	0.976	0.876
3/4	- 12	0.694	2	1.341	0.231	X-LARGE	0.625	Green/long	1.029	0.929
3/4	- 14	0.700	2	1.360	0.230	LARGE	0.813	Green/long	1.061	0.961
3/4	- 16	0.707	2	1.380	0.228	LARGE	0.750	Green/long	1.093	0.993
3/4	- 18	0.710	2	1.394	0.227	LARGE	0.750	Green/long	1.114	1.014
3/4	- 20	0.716	2	1.404	0.225	LARGE	0.688	Green/long	1.133	1.033
3/4	- 24	0.720	2	1.419	0.223	LARGE	0.625	Green/long	1.157	1.057
3/4	- 27	0.723	2	1.427	0.222	LARGE	0.625	Green/long	1.170	1.070
3/4	- 28	0.725	2	1.432	0.221	LARGE	0.625	Green/long	1.178	1.078
3/4	- 32	0.727	2	1.440	0.221	MEDIUM	0.875	Green/long	1.192	1.092

REFERENCE DATA SHEETS 151/152

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 Towards Collet	Stock Clearance Away From Collet
13/16 - 12	0.757	2	1.466	0.206	MEDIUM	0.813	Green/long	1.216	1.116
13/16 - 16	0.770	2	1.505	0.200	MEDIUM	0.688	Yellow/medium	1.281	1.181
13/16 - 20	0.778	2	1.529	0.196	MEDIUM	0.625	Yellow/medium	1.320	1.220
13/16 - 28	0.788	2	1.557	0.191	NARROW	0.875	Yellow/medium	1.366	1.266
13/16 - 32	0.790	2	1.565	0.189	NARROW	0.813	Yellow/medium	1.379	1.279
7/8 - 10	0.806	2	1.555	0.182	MEDIUM	0.625	Yellow/medium	1.346	1.246
7/8 - 12	0.819	2	1.591	0.174	NARROW	0.813	Yellow/medium	1.404	1.304
7/8 - 14	0.827	2	1.615	0.169	NARROW	0.688	Red/short	1.442	1.342
7/8 - 16	0.832	2	1.631	0.166	NARROW	0.688	Red/short	1.469	1.369
7/8 - 18	0.836	2	1.644	0.163	NARROW	0.625	Red/short	1.489	1.389
7/8 - 20	0.841	2	1.654	0.160	NARROW	0.625	Red/short	1.508	1.408
7/8 - 24	0.845	2	1.668	0.157	NARROW	0.625	Red/short	1.531	1.431
7/8 - 27	0.848	2	1.677	0.155	NARROW	0.625	Red/short	1.545	1.445
7/8 - 28	0.850	2	1.682	0.153	NARROW	0.625	Red/short	1.553	1.453
7/8 - 32	0.853	2	1.690	0.151	NARROW	0.625	Red/short	1.567	1.467

C.J. Winter Machine Works Inc. 5/21/2026
REFERENCE DATA SHEETS 151/152
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 Towards Collet	Stock Clearance Away From Collet
1/16	- 27	0.279	6	1.615	0.430	X-LARGE	0.875	Green/long	0.892	0.792
1/8	- 27	0.372	5	1.808	0.398	LARGE	0.625	Green/long	1.178	1.078
1/4	- 18	0.489	4	1.875	0.340	MEDIUM	0.625	Yellow/medium	1.343	1.243
3/8	- 18	0.625	3	1.836	0.270	NARROW	0.750	Yellow/medium	1.440	1.340
1/2	- 14	0.774	2	1.523	0.198	MEDIUM	0.750	Green/long	1.258	1.158

REFERENCE DATA SHEETS 151/152
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 Towards Collet	Stock Clearance Away From Collet
1/16	- 28	0.281	6	1.626	0.430	X-LARGE	0.813	Green/long	0.912	0.812
1/8	- 28	0.360	5	1.754	0.402	LARGE	0.688	Green/long	1.119	1.019
1/4	- 19	0.484	4	1.875	0.343	MEDIUM	0.625	Yellow/medium	1.348	1.248
3/8	- 19	0.622	3	1.832	0.272	NARROW	0.688	Red/short	1.443	1.343
1/2	- 14	0.779	2	1.534	0.196	MEDIUM	0.688	Yellow/medium	1.283	1.183

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

**REFERENCE DATA SHEETS 151/152
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 Towards Collet	Stock Clearance Away From Collet	
1/8 - 27	0.371	5	1.802	0.399	MEDIUM	0.875	Green/long	1.186	1.086	
1/4 - 18	0.488	4	1.865	0.341	NARROW	0.875	Yellow/medium	1.352	1.252	
3/8 - 18	0.624	3	1.828	0.270	NARROW	0.688	Red/short	1.462	1.362	
1/2 - 14	0.775	2	1.51	0.198	MEDIUM	0.750	Green/long	1.272	1.172	

**REFERENCE DATA SHEETS 151/152
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 Towards Collet	Stock Clearance Away From Collet	
1/16 - 28	0.281	6	1.621	0.430	X-LARGE	0.813	Green/long	0.916	0.816	
1/8 - 28	0.358	5	1.743	0.403	LARGE	0.688	Green/long	1.117	1.017	
1/4 - 19	0.482	4	1.870	0.344	NARROW	0.875	Yellow/medium	1.356	1.256	
3/8 - 19	0.620	3	1.816	0.273	NARROW	0.750	Yellow/medium	1.440	1.340	
1/2 - 14	0.777	2	1.513	0.197	MEDIUM	0.688	Yellow/medium	1.281	1.181	

C.J. Winter Machine Works Inc. 5/21/2026
REFERENCE DATA SHEETS 151/152
METRIC THREAD SIZES

Part Data				Roll Data		Attachment Data					
Size	X	Pitch	Blank Diameter	# of Starts	OD	Gage Setting	Wedge	Roller	Spring	Stock Clearance Towards Collet	Stock Clearance Away From Collet
M3	X	0.5	0.103	17	1.674	0.510	AUXILIARY	0.750	Green/long	0.808	0.708
M3.5	X	0.6	0.120	15	1.716	0.507	AUXILIARY	0.688	Green/long	0.864	0.764
M4	X	0.7	0.137	13	1.693	0.498	AUXILIARY	0.750	Green/long	0.856	0.756
M5	X	0.8	0.173	10	1.658	0.479	AUXILIARY	0.750	Green/long	0.855	0.755
M6	X	1	0.208	8	1.580	0.457	AUXILIARY	0.750	Green/long	0.807	0.707
M8	X	1	0.286	6	1.658	0.431	X-LARGE	0.750	Green/long	0.963	0.863
M8	X	1.25	0.280	6	1.601	0.429	X-LARGE	0.875	Green/long	0.894	0.794
M10	X	0.75	0.372	4	1.458	0.380	AUXILIARY	0.750	Green/long	0.855	0.755
M10	X	1.25	0.359	5	1.728	0.402	LARGE	0.750	Green/long	1.100	1.000
M10	X	1.5	0.352	5	1.680	0.403	LARGE	0.875	Green/long	1.040	0.940
M12	X	1	0.444	4	1.735	0.362	MEDIUM	0.875	Green/long	1.198	1.098
M12	X	1.25	0.437	4	1.697	0.365	LARGE	0.625	Green/long	1.148	1.048
M12	X	1.5	0.431	4	1.659	0.366	LARGE	0.750	Green/long	1.098	0.998
M12	X	1.75	0.424	4	1.621	0.367	LARGE	0.875	Green/long	1.047	0.947
M14	X	1.5	0.510	3	1.480	0.321	X-LARGE	0.625	Green/long	0.998	0.898
M14	X	2	0.497	3	1.423	0.322	X-LARGE	0.813	Green/long	0.916	0.816
M15	X	1	0.562	3	1.656	0.304	MEDIUM	0.813	Green/long	1.237	1.137
M16	X	1.5	0.588	3	1.717	0.291	MEDIUM	0.625	Yellow/medium	1.313	1.213
M16	X	2	0.575	3	1.659	0.297	MEDIUM	0.813	Green/long	1.231	1.131
M17	X	1	0.641	2	1.261	0.251	X-LARGE	0.813	Green/long	0.921	0.821
M18	X	1.5	0.667	2	1.302	0.242	X-LARGE	0.688	Green/long	0.977	0.877
M20	X	1	0.759	2	1.497	0.206	MEDIUM	0.688	Yellow/medium	1.276	1.176
M20	X	1.5	0.746	2	1.459	0.211	MEDIUM	0.875	Green/long	1.213	1.113
M20	X	2.5	0.720	2	1.383	0.221	LARGE	0.750	Green/long	1.088	0.988
M22	X	1.5	0.825	2	1.617	0.170	NARROW	0.688	Red/short	1.449	1.349
M22	X	2.5	0.799	2	1.541	0.185	MEDIUM	0.625	Yellow/medium	1.324	1.224

GAGE SETTING CHART FOR NPT, NPTF & BSPT TAPERED PIPE THREAD SIZES

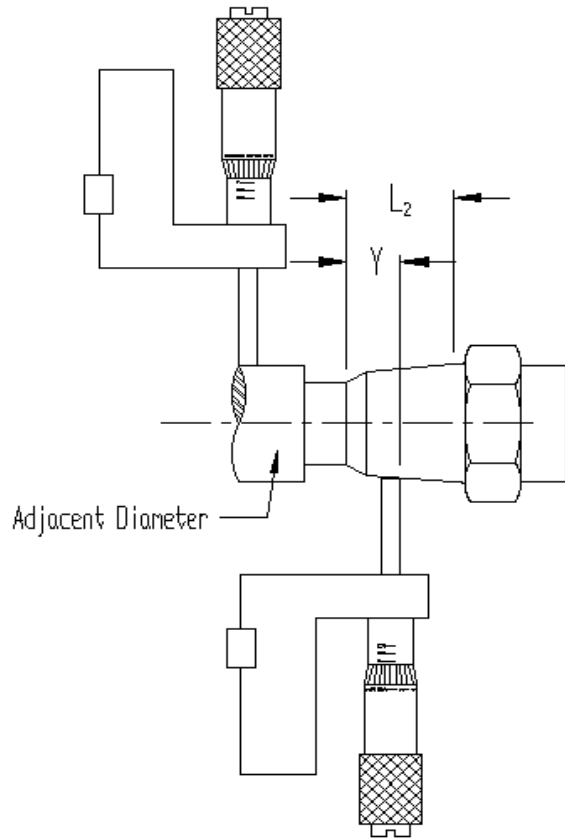
OPTIONAL GAGE SETTING USING AN ADJACENT DIAMETER

- 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