

WEDGE/ROLLER COMBINATIONS 160/162 SERIES

Wedge	Roller Ø	Spring	FCD Min.	FCD Max.
NARROW	0.625	Red/Short	3.447	3.758
NARROW	0.688	Red/Short	3.413	3.719
NARROW	0.750	Red/Short	3.379	3.682
NARROW	0.813	Red/Short	3.345	3.644
NARROW	0.875	Red/Short	3.312	3.606
NARROW	0.938	Red/Short	3.278	3.569
NARROW	1.000	Yellow/Medium	3.245	3.532
NARROW	1.075	Yellow/Medium	3.205	3.488
NARROW	1.156	Yellow/Medium	3.162	3.441
NARROW	1.312	Yellow/Medium	3.080	3.350
MEDIUM	0.625	Yellow/Medium	3.149	3.469
MEDIUM	0.688	Yellow/Medium	3.116	3.431
MEDIUM	0.750	Yellow/Medium	3.083	3.394
MEDIUM	0.813	Green/Long	3.050	3.356
MEDIUM	0.875	Green/Long	3.017	3.320
MEDIUM	0.938	Green/Long	2.985	3.283
MEDIUM	1.000	Green/Long	2.952	3.246
MEDIUM	1.075	Green/Long	2.913	3.203
MEDIUM	1.156	Green/Long	2.871	3.156
MEDIUM	1.312	Green/Long	2.791	3.067
LARGE	0.625	Green/Long	2.867	3.164
LARGE	0.688	Green/Long	2.834	3.128
LARGE	0.750	Green/Long	2.803	3.093
LARGE	0.813	Green/Long	2.770	3.057
LARGE	0.875	Green/Long	2.739	3.022
LARGE	0.938	Green/Long	2.707	2.987
LARGE	1.000	Green/Long	2.675	2.952
LARGE	1.075	Green/Long	2.637	2.911
LARGE	1.156	Green/Long	2.596	2.866
* LARGE	1.312	Green/Long	2.518	2.781
X-LARGE	0.625	Green/long	2.632	2.916
X-LARGE	0.688	Green/long	2.600	2.881
X-LARGE	0.750	Green/long	2.569	2.847
X-LARGE	0.813	Green/long	2.538	2.813
X-LARGE	0.875	Green/long	2.507	2.779
X-LARGE	0.938	Green/long	2.475	2.745
X-LARGE	1.000	Green/long	2.444	2.712
* X-LARGE	1.075	Green/long	2.407	2.672
* X-LARGE	1.156	Green/long	2.367	2.629

* If you are using this wedge and roller combination you may have to modify your cross slide to clear the wedge-roller.

C.J. Winter Machine Technologies, Inc. 5/21/2026
REFERENCE DATA SHEETS 160/162 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	160SA Series Stock Clearance Towards Collet	160SA Series Stock Clearance Away From Collet	162SA Series Stock Clearance Both Sides
#10	- 24	0.161	16	2.403	1.081	X-LARGE	0.938	Green/Long	1.341	1.241	1.241
#10	- 28	0.164	15	2.323	1.073	* X-LARGE	* 1.075	Green/Long	1.268	1.168	1.168
#10	- 32	0.168	15	2.403	1.079	X-LARGE	0.938	Green/Long	1.355	1.255	1.255
#10	- 36	0.169	14	2.276	1.067	* X-LARGE	* 1.156	Green/Long	1.231	1.131	1.131
#10	- 40	0.171	14	2.313	1.070	* X-LARGE	* 1.075	Green/Long	1.271	1.171	1.171
#10	- 48	0.174	14	2.370	1.074	X-LARGE	1.000	Green/Long	1.334	1.234	1.234
#10	- 56	0.176	14	2.411	1.077	* LARGE	* 1.312	Green/Long	1.379	1.279	1.279
#12	- 24	0.187	13	2.290	1.066	X-LARGE	0.938	Green/Long	1.336	1.236	1.236
#12	- 28	0.191	13	2.364	1.066	X-LARGE	0.938	Green/Long	1.336	1.236	1.236
#12	- 32	0.193	13	2.408	1.069	* LARGE	* 1.312	Green/Long	1.386	1.286	1.286
#12	- 36	0.195	12	2.273	1.056	* X-LARGE	* 1.156	Green/Long	1.255	1.155	1.155
#12	- 40	0.197	12	2.305	1.059	* X-LARGE	* 1.075	Green/Long	1.290	1.190	1.190
#12	- 48	0.200	12	2.353	1.062	X-LARGE	0.938	Green/Long	1.343	1.243	1.243
#12	- 56	0.202	12	2.387	1.064	* LARGE	* 1.312	Green/Long	1.381	1.281	1.281
1/4	- 20	0.216	12	2.350	1.054	X-LARGE	0.938	Green/Long	1.339	1.239	1.239
1/4	- 24	0.220	11	2.312	1.049	X-LARGE	1.000	Green/Long	1.311	1.211	1.211
1/4	- 27	0.223	11	2.360	1.052	X-LARGE	0.938	Green/Long	1.365	1.265	1.265
1/4	- 28	0.224	11	2.369	1.053	X-LARGE	0.875	Green/Long	1.375	1.275	1.275
1/4	- 32	0.227	11	2.410	1.055	X-LARGE	0.813	Green/Long	1.422	1.322	1.322
1/4	- 36	0.229	10	2.234	1.039	* X-LARGE	* 1.156	Green/Long	1.250	1.150	1.150
1/4	- 40	0.231	10	2.261	1.041	* X-LARGE	* 1.075	Green/Long	1.280	1.180	1.180
1/4	- 48	0.234	10	2.301	1.043	X-LARGE	1.000	Green/Long	1.325	1.225	1.225
1/4	- 56	0.235	10	2.329	1.046	X-LARGE	0.938	Green/Long	1.357	1.257	1.257
5/16	- 18	0.274	9	2.334	1.028	* LARGE	* 1.312	Green/Long	1.378	1.278	1.278
5/16	- 20	0.278	9	2.382	1.030	X-LARGE	0.750	Green/Long	1.433	1.333	1.333
5/16	- 24	0.283	9	2.407	1.030	X-LARGE	0.688	Green/Long	1.468	1.368	1.368
5/16	- 27	0.285	8	2.208	1.013	* X-LARGE	* 1.075	Green/Long	1.275	1.175	1.175
5/16	- 28	0.287	8	2.226	1.014	* X-LARGE	* 1.075	Green/Long	1.295	1.195	1.195
5/16	- 32	0.290	8	2.261	1.016	X-LARGE	0.938	Green/Long	1.335	1.235	1.235
5/16	- 36	0.292	8	2.292	1.018	X-LARGE	0.875	Green/Long	1.370	1.270	1.270
5/16	- 40	0.293	8	2.313	1.020	* LARGE	* 1.312	Green/Long	1.395	1.295	1.295
5/16	- 48	0.296	8	2.345	1.021	X-LARGE	0.750	Green/Long	1.432	1.332	1.332
3/8	- 16	0.333	7	2.207	0.992	X-LARGE	1.000	Green/Long	1.305	1.205	1.205
3/8	- 18	0.336	7	2.244	0.995	X-LARGE	0.938	Green/Long	1.351	1.251	1.251
3/8	- 20	0.341	7	2.290	0.996	X-LARGE	0.813	Green/Long	1.404	1.304	1.304
3/8	- 24	0.346	7	2.346	0.999	X-LARGE	0.688	Green/Long	1.470	1.370	1.370
3/8	- 27	0.348	7	2.369	0.999	X-LARGE	0.688	Green/Long	1.491	1.391	1.391
3/8	- 28	0.350	7	2.386	1.000	LARGE	1.075	Green/Long	1.517	1.417	1.417
3/8	- 32	0.353	7	2.389	0.999	LARGE	1.075	Green/Long	1.526	1.426	1.426
3/8	- 36	0.354	7	2.400	0.999	LARGE	1.000	Green/Long	1.541	1.441	1.441
3/8	- 40	0.356	6	2.101	0.975	* X-LARGE	* 1.156	Green/Long	1.245	1.145	1.145
7/16	- 14	0.389	6	2.215	0.969	X-LARGE	0.938	Green/Long	1.365	1.265	1.265
7/16	- 16	0.395	6	2.266	0.971	X-LARGE	0.813	Green/Long	1.427	1.327	1.327
7/16	- 18	0.398	6	2.298	0.972	X-LARGE	0.688	Green/Long	1.467	1.367	1.367
7/16	- 20	0.403	6	2.338	0.973	LARGE	1.075	Green/Long	1.514	1.414	1.414
7/16	- 24	0.408	6	2.379	0.973	LARGE	1.000	Green/Long	1.565	1.465	1.465
7/16	- 27	0.411	6	2.406	0.973	LARGE	0.938	Green/Long	1.597	1.497	1.497
7/16	- 28	0.413	6	2.393	0.972	LARGE	0.938	Green/Long	1.587	1.487	1.487
7/16	- 32	0.414	6	2.416	0.973	LARGE	0.875	Green/Long	1.615	1.515	1.515
1/2	- 12	0.444	5	2.102	0.936	* X-LARGE	* 1.075	Green/Long	1.300	1.200	1.200
1/2	- 13	0.448	5	2.132	0.937	X-LARGE	0.938	Green/Long	1.338	1.238	1.238
1/2	- 14	0.450	5	2.151	0.939	X-LARGE	0.938	Green/Long	1.363	1.263	1.263
1/2	- 16	0.458	5	2.201	0.939	X-LARGE	0.813	Green/Long	1.424	1.324	1.324
1/2	- 18	0.461	5	2.228	0.940	LARGE	1.156	Green/Long	1.460	1.360	1.360
1/2	- 20	0.466	5	2.261	0.941	LARGE	1.075	Green/Long	1.500	1.400	1.400
1/2	- 24	0.470	5	2.295	0.941	LARGE	1.000	Green/Long	1.544	1.444	1.444
1/2	- 27	0.473	5	2.317	0.941	LARGE	0.938	Green/Long	1.572	1.472	1.472
1/2	- 28	0.475	5	2.329	0.941	LARGE	0.938	Green/Long	1.585	1.485	1.485

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** Limited application, will have trouble adjusting penetration rate.

N/A - Arms will not clear Blank Ø

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REFERENCE DATA SHEETS 160/162 SERIES
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Part Data			Roll Data		Attachment Data						
Size	TPI	Blank Diameter	# of Starts	OD	Gage Setting	Wedge	Roller	Spring	160SA Series Stock Clearance Towards Collet	160SA Series Stock Clearance Away From Collet	162SA Series Stock Clearance Both Sides
1/2	- 32	0.478	5	2.351	0.940	LARGE	0.875	Green/Long	1.613	1.513	1.513
9/16	- 12	0.507	5	2.362	0.926	LARGE	0.875	Green/Long	1.622	1.522	1.522
9/16	- 14	0.513	5	2.412	0.926	LARGE	0.750	Green/Long	1.687	1.587	1.587
9/16	- 16	0.520	4	2.011	0.898	* X-LARGE	* 1.075	Green/Long	1.297	1.197	1.197
9/16	- 18	0.525	4	2.037	0.898	X-LARGE	1.000	Green/Long	1.331	1.231	1.231
9/16	- 20	0.528	4	2.059	0.899	X-LARGE	0.938	Green/Long	1.360	1.260	1.260
9/16	- 24	0.534	4	2.090	0.900	X-LARGE	0.813	Green/Long	1.401	1.301	1.301
9/16	- 27	0.536	4	2.104	0.900	X-LARGE	0.813	Green/Long	1.421	1.321	1.321
9/16	- 28	0.537	4	2.113	0.900	X-LARGE	0.750	Green/Long	1.432	1.332	1.332
9/16	- 32	0.540	4	2.130	0.901	X-LARGE	0.750	Green/Long	1.454	1.354	1.354
5/8	- 11	0.564	4	2.153	0.889	X-LARGE	0.688	Green/Long	1.466	1.366	1.366
5/8	- 12	0.569	4	2.181	0.889	LARGE	1.075	Green/Long	1.504	1.404	1.404
5/8	- 14	0.575	4	2.221	0.889	LARGE	1.000	Green/Long	1.558	1.458	1.458
5/8	- 16	0.583	4	2.261	0.888	LARGE	0.875	Green/Long	1.609	1.509	1.509
5/8	- 18	0.587	4	2.287	0.887	LARGE	0.813	Green/Long	1.644	1.544	1.544
5/8	- 20	0.591	4	2.309	0.886	LARGE	0.750	Green/Long	1.673	1.573	1.573
5/8	- 24	0.596	4	2.341	0.885	LARGE	0.688	Green/Long	1.715	1.615	1.615
5/8	- 27	0.598	4	2.354	0.884	MEDIUM	1.156	Green/Long	1.734	1.634	1.634
5/8	- 28	0.600	4	2.363	0.884	MEDIUM	1.156	Green/Long	1.744	1.644	1.644
5/8	- 32	0.603	4	2.381	0.883	MEDIUM	1.156	Green/Long	1.768	1.668	1.668
11/16	- 12	0.632	4	2.389	0.868	MEDIUM	1.075	Green/Long	1.774	1.674	1.674
11/16	- 16	0.645	3	1.883	0.835	* X-LARGE	* 1.075	Green/Long	1.294	1.194	1.194
11/16	- 20	0.653	3	1.919	0.836	X-LARGE	0.938	Green/Long	1.345	1.245	1.245
11/16	- 24	0.659	3	1.943	0.835	* LARGE	* 1.312	Green/Long	1.379	1.279	1.279
11/16	- 28	0.663	3	1.960	0.835	X-LARGE	0.813	Green/Long	1.404	1.304	1.304
11/16	- 32	0.665	3	1.973	0.836	X-LARGE	0.813	Green/Long	1.422	1.322	1.322
3/4	- 10	0.683	3	1.963	0.824	* LARGE	* 1.312	Green/Long	1.390	1.290	1.290
3/4	- 12	0.694	3	2.011	0.824	LARGE	1.156	Green/Long	1.459	1.359	1.359
3/4	- 14	0.700	3	2.041	0.824	LARGE	1.075	Green/Long	1.503	1.403	1.403
3/4	- 16	0.708	3	2.071	0.822	LARGE	1.000	Green/Long	1.544	1.444	1.444
3/4	- 18	0.710	3	2.086	0.822	LARGE	0.938	Green/Long	1.568	1.468	1.468
3/4	- 20	0.716	3	2.107	0.821	LARGE	0.938	Green/Long	1.596	1.496	1.496
3/4	- 24	0.720	3	2.127	0.820	LARGE	0.875	Green/Long	1.626	1.526	1.526
3/4	- 27	0.723	3	2.140	0.819	LARGE	0.813	Green/Long	1.645	1.545	1.545
3/4	- 28	0.725	3	2.148	0.819	MEDIUM	1.312	Green/Long	1.654	1.554	1.554
3/4	- 32	0.728	3	2.160	0.818	LARGE	0.750	Green/Long	1.672	1.572	1.572
13/16	- 12	0.757	3	2.199	0.804	LARGE	0.688	Green/Long	1.709	1.609	1.609
13/16	- 16	0.770	3	2.258	0.799	MEDIUM	1.075	Green/Long	1.794	1.694	1.694
13/16	- 20	0.778	3	2.294	0.796	MEDIUM	0.938	Green/Long	1.845	1.745	1.745
13/16	- 28	0.788	3	2.335	0.791	MEDIUM	0.875	Green/Long	1.904	1.804	1.804
13/16	- 32	0.790	3	2.348	0.790	MEDIUM	0.813	Green/Long	1.922	1.822	1.822
7/8	- 10	0.806	3	2.333	0.782	MEDIUM	0.875	Green/Long	1.885	1.785	1.785
7/8	- 12	0.819	3	2.386	0.775	MEDIUM	0.750	Yellow/Medium	1.959	1.859	1.859
7/8	- 14	0.827	3	2.400	0.770	MEDIUM	0.688	Yellow/Medium	1.987	1.887	1.887
7/8	- 16	0.833	3	2.415	0.767	MEDIUM	0.625	Yellow/Medium	2.013	1.913	1.913
7/8	- 18	0.835	3	2.420	0.766	NARROW	1.156	Yellow/Medium	2.020	1.927	1.927
7/8	- 20	0.841	2	1.654	0.734	* X-LARGE	* 1.075	Green/Long	1.268	1.168	1.168
7/8	- 24	0.845	2	1.668	0.735	* X-LARGE	* 1.075	Green/Long	1.292	1.192	1.192
7/8	- 27	0.848	2	1.677	0.735	X-LARGE	1.000	Green/Long	1.307	1.207	1.207
7/8	- 28	0.850	2	1.682	0.734	X-LARGE	1.000	Green/Long	1.313	1.213	1.213
7/8	- 32	0.853	2	1.69	0.734	X-LARGE	1.000	Green/Long	1.327	1.227	1.227
15/16	- 12	0.882	2	1.716	0.722	X-LARGE	0.938	Green/Long	1.351	1.251	1.251
15/16	- 16	0.895	2	1.756	0.720	X-LARGE	0.813	Green/Long	1.417	1.317	1.317
15/16	- 20	0.903	2	1.779	0.719	X-LARGE	0.750	Green/Long	1.455	1.355	1.355
15/16	- 28	0.913	2	1.807	0.717	LARGE	1.075	Green/Long	1.501	1.401	1.401
15/16	- 32	0.915	2	1.815	0.717	LARGE	1.075	Green/Long	1.514	1.414	1.414

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1	- 10	0.931	2	1.805	0.707	X-LARGE	0.688	Green/Long	1.482	1.382	1.382
1	- 12	0.944	2	1.841	0.704	LARGE	1.000	Green/Long	1.539	1.439	1.439
1	- 14	0.952	2	1.863	0.702	LARGE	0.938	Green/Long	1.575	1.475	1.475
1	- 16	0.958	2	1.881	0.700	LARGE	0.875	Green/Long	1.604	1.504	1.504
1	- 18	0.961	2	1.891	0.699	LARGE	0.875	Green/Long	1.623	1.523	1.523
1	- 20	0.966	2	1.904	0.698	LARGE	0.813	Green/Long	1.643	1.543	1.543
1	- 24	0.970	2	1.918	0.696	LARGE	0.750	Green/Long	1.667	1.567	1.567
1	- 27	0.973	2	1.927	0.695	LARGE	0.750	Green/Long	1.682	1.582	1.582
1	- 28	0.975	2	1.932	0.695	LARGE	0.750	Green/Long	1.688	1.588	1.588
1	- 32	0.978	2	1.940	0.694	LARGE	0.688	Green/Long	1.702	1.602	1.602
1 1/16	- 12	1.007	2	1.966	0.680	LARGE	0.688	Green/Long	1.726	1.626	1.626
1 1/16	- 16	1.020	2	2.006	0.674	MEDIUM	1.075	Green/Long	1.792	1.692	1.692
1 1/16	- 18	1.025	2	2.019	0.672	MEDIUM	1.000	Green/Long	1.813	1.713	1.713
1 1/16	- 20	1.028	2	2.029	0.671	MEDIUM	1.000	Green/Long	1.830	1.730	1.730
1 1/16	- 28	1.038	2	2.057	0.666	MEDIUM	0.938	Green/Long	1.876	1.776	1.776
1 1/8	- 10	1.056	2	2.055	0.657	MEDIUM	0.938	Green/Long	1.857	1.757	1.757
1 1/8	- 12	1.069	2	2.094	0.650	MEDIUM	0.813	Green/Long	1.917	1.817	1.817
1 1/8	- 14	1.075	2	2.116	0.647	MEDIUM	0.750	Yellow/Medium	1.953	1.853	1.853
1 1/8	- 16	1.083	2	2.133	0.643	MEDIUM	0.688	Yellow/Medium	1.981	1.881	1.881
1 1/8	- 18	1.087	2	2.144	0.640	MEDIUM	0.688	Yellow/Medium	2.001	1.901	1.901
1 1/8	- 20	1.091	2	2.155	0.638	MEDIUM	0.625	Yellow/Medium	2.019	1.919	1.919
1 1/8	- 24	1.095	2	2.170	0.635	NARROW	1.156	Yellow/Medium	2.020	1.944	1.944
1 1/8	- 28	1.100	2	2.180	0.632	NARROW	1.156	Yellow/Medium	2.020	1.961	1.961
1 3/16	- 12	1.132	2	2.220	0.615	NARROW	1.000	Yellow/Medium	2.020	2.005	2.005
1 3/16	- 16	1.145	2	2.258	0.606	NARROW	0.938	Red/Short	2.020	2.020	2.020
1 3/16	- 18	1.150	2	2.269	0.602	NARROW	0.875	Red/Short	2.020	2.020	2.020
1 3/16	- 20	1.153	2	2.279	0.600	NARROW	0.813	Red/Short	2.020	2.020	2.020
1 3/16	- 28	1.163	2	2.307	0.592	NARROW	0.750	Red/Short	2.020	2.020	2.020
1 1/4	- 10	1.181	2	2.314	0.584	NARROW	0.750	Red/Short	2.020	2.020	2.020
1 1/4	- 12	1.194	2	2.344	0.574	NARROW	0.688	Red/Short	2.020	2.020	2.020
1 1/4	- 14	1.200	2	2.366	0.568	NARROW	0.625	Red/Short	2.020	2.020	2.020
** 1 1/4	- 16	1.208	2	2.382	0.562	NARROW	0.625	Red/Short	2.020	2.020	2.020
** 1 1/4	- 18	1.212	2	2.394	0.559	NARROW	0.625	Red/Short	2.020	2.020	2.020
** 1 1/4	- 20	1.216	2	2.405	0.555	NARROW	0.625	Red/Short	2.020	2.020	2.020
** 1 1/4	- 24	1.220	2	2.407	0.552	NARROW	0.625	Red/Short	2.020	2.020	2.020
** 1 1/4	- 28	1.225	2	2.415	0.548	NARROW	0.625	Red/Short	2.020	2.020	2.020
1 5/16	- 16	1.270	1	1.253	0.522	* X-LARGE	* 1.075	Green/Long	1.289	1.189	N/A
1 5/16	- 18	1.275	1	1.259	0.521	* X-LARGE	* 1.075	Green/Long	1.303	1.203	N/A
1 5/16	- 20	1.278	1	1.265	0.521	X-LARGE	1.000	Green/Long	1.316	1.216	N/A
1 5/16	- 28	1.288	1	1.279	0.518	X-LARGE	0.938	Green/Long	1.348	1.248	N/A
1 3/8	- 10	1.306	1	1.277	0.508	X-LARGE	1.000	Green/Long	1.329	1.229	N/A
1 3/8	- 12	1.319	1	1.295	0.505	X-LARGE	0.875	Green/Long	1.368	1.268	N/A
1 3/8	- 14	1.325	1	1.305	0.504	* LARGE	* 1.312	Green/Long	1.392	1.292	N/A
1 3/8	- 16	1.333	1	1.315	0.501	X-LARGE	0.813	Green/Long	1.413	1.313	N/A
1 3/8	- 18	1.337	1	1.322	0.500	X-LARGE	0.813	Green/Long	1.429	1.329	N/A
1 3/8	- 20	1.341	1	1.327	0.499	X-LARGE	0.750	Green/Long	1.441	1.341	N/A
1 3/8	- 24	1.346	1	1.335	0.498	LARGE	1.156	Green/Long	1.459	1.359	1.359
1 3/8	- 28	1.350	1	1.341	0.497	X-LARGE	0.688	Green/Long	1.472	1.372	1.372
1 7/16	- 12	1.382	1	1.358	0.482	X-LARGE	0.625	Green/Long	1.493	1.393	1.393
1 7/16	- 16	1.395	1	1.378	0.478	LARGE	1.000	Green/Long	1.539	1.439	1.439
1 7/16	- 18	1.400	1	1.385	0.477	LARGE	1.000	Green/Long	1.554	1.454	1.454
1 7/16	- 20	1.403	1	1.390	0.476	LARGE	1.000	Green/Long	1.566	1.466	1.466
1 7/16	- 28	1.412	1	1.403	0.473	LARGE	0.938	Green/Long	1.597	1.497	1.497
1 1/2	- 10	1.431	1	1.402	0.462	LARGE	0.938	Green/Long	1.579	1.479	1.479
1 1/2	- 12	1.444	1	1.416	0.457	LARGE	0.875	Green/Long	1.614	1.514	1.514
1 1/2	- 14	1.450	1	1.439	0.456	MEDIUM	1.312	Green/Long	1.651	1.551	1.551

* If you are using this wedge/roller combination you may have to modify your cross slide to clear the roller.

** Limited application, will have trouble adjusting penetration rate.

N/A - Arms will not clear Blank Ø

C.J. Winter Machine Technologies, Inc. 5/21/2026
REFERENCE DATA SHEETS 160/162 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	160SA Series Stock Clearance Towards Collet	160SA Series Stock Clearance Away From Collet	162SA Series Stock Clearance Both Sides
1 1/2 - 16		1.458	1	1.440	0.452	LARGE	0.750	Green/Long	1.663	1.563	1.563
1 1/2 - 18		1.462	1	1.447	0.451	LARGE	0.750	Green/Long	1.679	1.579	1.579
1 1/2 - 20		1.466	1	1.452	0.449	LARGE	0.750	Green/Long	1.691	1.591	1.591
1 1/2 - 24		1.470	1	1.459	0.448	LARGE	0.688	Green/Long	1.708	1.608	1.608
1 1/2 - 28		1.475	1	1.466	0.446	LARGE	0.688	Green/Long	1.722	1.622	1.622
				1.423							
1 9/16 - 12		1.507	1	1.483	0.430	MEDIUM	1.156	Green/Long	1.743	1.643	1.643
1 9/16 - 16		1.520	1	1.503	0.424	MEDIUM	1.075	Green/Long	1.789	1.689	1.689
1 9/16 - 18		1.525	1	1.509	0.422	MEDIUM	1.075	Green/Long	1.803	1.703	1.703
1 9/16 - 20		1.528	1	1.515	0.421	MEDIUM	1.000	Green/Long	1.816	1.716	1.716
1 5/8 - 10		1.556	1	1.524	0.407	MEDIUM	1.000	Green/Long	1.826	1.726	1.726
1 5/8 - 12		1.569	1	1.549	0.400	MEDIUM	0.938	Green/Long	1.872	1.772	1.772
1 5/8 - 14		1.575	1	1.559	0.397	MEDIUM	0.875	Green/Long	1.896	1.796	1.796
1 5/8 - 16		1.583	1	1.567	0.393	MEDIUM	0.813	Green/Long	1.915	1.815	1.815
1 5/8 - 18		1.587	1	1.574	0.391	MEDIUM	0.813	Green/Long	1.931	1.831	1.831
1 5/8 - 20		1.591	1	1.579	0.389	NARROW	1.312	Yellow/Medium	1.943	1.843	1.843
1 5/8 - 24		1.595	1	1.585	0.387	MEDIUM	0.750	Yellow/Medium	1.959	1.859	1.859
1 11/16 - 12		1.632	1	1.603	0.368	MEDIUM	0.688	Yellow/Medium	1.988	1.888	1.888
1 11/16 - 16		1.645	1	1.628	0.360	NARROW	1.156	Yellow/Medium	2.020	1.939	1.939
1 11/16 - 18		1.650	1	1.634	0.357	NARROW	1.156	Yellow/Medium	2.020	1.953	1.953
1 11/16 - 20		1.653	1	1.640	0.356	NARROW	1.075	Yellow/Medium	2.020	1.966	1.966
1 3/4 - 10		1.681	1	1.652	0.341	NARROW	1.075	Yellow/Medium	2.020	1.979	1.979
1 3/4 - 12		1.694	1	1.670	0.333	NARROW	1.000	Yellow/Medium	2.020	2.018	2.018
1 3/4 - 14		1.700	1	1.680	0.329	NARROW	0.938	Red/Short	2.020	2.020	2.020
1 3/4 - 16		1.708	1	1.686	0.325	NARROW	0.938	Red/Short	2.020	2.020	2.020
1 3/4 - 18		1.711	1	1.695	0.322	NARROW	0.875	Red/Short	2.020	2.020	2.020
1 3/4 - 20		1.716	1	1.702	0.319	NARROW	0.875	Red/Short	2.020	2.020	2.020
1 13/16 - 12		1.757	1	1.733	0.296	NARROW	0.750	Red/Short	2.020	2.020	2.020
1 13/16 - 16		1.770	1	1.753	0.286	NARROW	0.688	Red/Short	2.020	2.020	2.020
1 13/16 - 20		1.778	1	1.765	0.280	NARROW	0.625	Red/Short	2.020	2.020	2.020
** 1 7/8 - 10		1.806	1	1.778	0.265	NARROW	0.625	Red/Short	2.020	2.020	2.020
** 1 7/8 - 12		1.819	1	1.795	0.256	NARROW	0.625	Red/Short	2.020	2.020	2.020
** 1 7/8 - 14		1.825	1	1.805	0.251	NARROW	0.625	Red/Short	2.020	2.020	2.020
** 1 7/8 - 16		1.833	1	1.815	0.245	NARROW	0.625	Red/Short	2.020	2.020	2.020
** 1 7/8 - 18		1.836	1	1.820	0.242	NARROW	0.625	Red/Short	2.020	2.020	2.020
** 1 7/8 - 20		1.841	1	1.827	0.239	NARROW	0.625	Red/Short	2.020	2.020	2.020

* If you are using this wedge/roller combination you may have to modify your cross slide to clear the roller.

** Limited application, will have trouble adjusting penetration rate.

N/A - Arms will not clear Blank Ø

C.J. Winter Machine Technologies, Inc. 5/21/2026
REFERENCE DATA SHEETS 160/162 SERIES
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	160SA Series Stock Clearance Towards Collet	160SA Series Stock Clearance Away Form Collet	162SA Series Stock Clearance Both Sides
1/8 -	27	0.372	6	2.153	0.970	* X-LARGE	* 1.075	Green/Long	1.283	1.183	1.183
1/4 -	18	0.489	5	2.366	0.934	LARGE	0.938	Green/Long	1.593	1.493	1.493
3/8 -	18	0.625	4	2.420	0.872	MEDIUM	1.075	Green/Long	1.783	1.683	1.683
1/2 -	14	0.774	3	2.271	0.797	MEDIUM	1.156	Green/Long	1.766	1.666	1.666
3/4 -	14	0.985	2	1.941	0.688	LARGE	0.813	Green/Long	1.646	1.546	1.546
** 1 -	11 1/2	1.235	2	2.420	0.549	NARROW	0.625	Red/Short	2.020	2.020	2.020
1 1/4 -	11 1/2	1.579	1	1.580	0.395	MEDIUM	0.938	Green/Long	1.860	1.760	1.760
** 1 1/2 -	11 1/2	1.818	1	1.830	0.258	NARROW	0.625	Red/Short	2.020	2.020	2.020

REFERENCE DATA SHEETS 160/162
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	160SA Series Stock Clearance Towards Collet	160SA Series Stock Clearance Away Form Collet	162SA Series Stock Clearance Both Sides
1/8 -	28	0.360	6	2.103	0.971	* X-LARGE	* 1.156	Green/Long	1.228	1.128	1.128
1/4 -	19	0.484	5	2.352	0.936	LARGE	0.938	Green/Long	1.585	1.485	1.485
3/8 -	19	0.622	4	2.420	0.873	MEDIUM	1.075	Green/Long	1.791	1.691	1.691
1/2 -	14	0.779	3	2.291	0.795	MEDIUM	1.075	Green/Long	1.800	1.700	1.700
3/4 -	14	0.995	2	1.987	0.685	LARGE	0.688	Green/Long	1.711	1.611	1.611
** 1 -	11	1.250	2	2.420	0.539	NARROW	0.625	Red/Short	2.020	2.020	2.020
1 1/4 -	11	1.591	1	1.608	0.389	MEDIUM	0.875	Green/Long	1.909	1.809	1.809
** 1 1/2 -	11	1.823	1	1.840	0.253	NARROW	0.625	Red/Short	2.020	2.020	2.020

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

* If you are using this wedge and roller combination you may have to modify your cross slide to clear the wedge-roller.

** Limited application, will have trouble adjusting penetration rate.

C.J. Winter Machine Technologies, Inc. 5/21/2026
REFERENCE DATA SHEETS 160/162 SERIES
STRAIGHT PIPE THREAD SIZES

Part Data			Roll Data		Attachment Data						
Size	TPI	Blank Diameter	# of Starts	Roll OD	Gage Setting	Wedge	Roller	Spring	160SA Series Stock Clearance Towards Collet	160SA Series Stock Clearance Away From Collet	162SA Series Stock Clearance Both Sides
1/8	- 27	0.371	6	2.166	0.973	X-LARGE	1.000	Green/Long	1.310	1.210	1.210
1/4	- 18	0.488	5	2.367	0.935	LARGE	0.875	Green/Long	1.614	1.514	1.514
3/8	- 18	0.624	4	2.406	0.872	MEDIUM	1.075	Green/Long	1.789	1.689	1.689
1/2	- 14	0.775	3	2.265	0.797	MEDIUM	1.075	Green/Long	1.787	1.687	1.687
3/4	- 14	0.985	2	1.931	0.689	LARGE	0.750	Green/Long	1.664	1.564	1.564
** 1	- 11 1/2	1.235	2	2.399	0.546	NARROW	0.625	Red/Short	2.020	2.020	2.020
1 1/4	- 11 1/2	1.580	1	1.555	0.395	MEDIUM	0.938	Green/Long	1.870	1.770	1.770
** 1 1/2	- 11 1/2	1.819	1	1.794	0.257	NARROW	0.625	Red/Short	2.020	2.020	2.020

REFERENCE DATA SHEETS 160/162
BSPP STRAIGHT PIPE THREAD SIZES

Part Data			Roll Data		Attachment Data						
Size	TPI	Blank Diameter	# of Starts	Roll OD	Gage Setting	Wedge	Roller	Spring	160SA Series Stock Clearance Towards Collet	160SA Series Stock Clearance Towards Collet	162SA Series Stock Clearance Both Sides
1/8	- 28	0.358	7	2.400	0.997	LARGE	1.075	Green/Long	1.534	1.434	1.434
1/4	- 19	0.482	5	2.337	0.937	LARGE	0.938	Green/Long	1.583	1.483	1.483
3/8	- 19	0.620	4	2.420	0.875	MEDIUM	1.075	Green/Long	1.804	1.704	1.704
1/2	- 14	0.777	3	2.269	0.796	MEDIUM	1.075	Green/Long	1.797	1.697	1.697
3/4	- 14	0.993	2	1.945	0.686	LARGE	0.750	Green/Long	1.689	1.589	1.589
** 1	- 11	1.248	2	2.420	0.538	NARROW	0.625	Red/Short	2.020	2.020	2.020
1 1/4	- 11	1.589	1	1.563	0.390	MEDIUM	0.875	Green/Long	1.889	1.789	1.789
** 1 1/2	- 11	1.821	1	1.795	0.256	NARROW	0.625	Red/Short	2.020	2.020	2.020

* If you are using this wedge and roller combination you may have to modify your cross slide to clear the wedge-roller.

** Limited application, will have trouble adjusting penetration rate.

C.J. Winter Machine Technologies, Inc. 5/21/2026
REFERENCE DATA SHEETS 160/162 SERIES
METRIC THREAD SIZES

Part Data			Roll Data		Attachment Data							
Size	Pitch	Blank Diameter	# of Starts	OD	Gage Setting	Wedge	Roller	Spring	160SA Series Stock Clearance Towards Collet	160SA Series Stock Clearance Away From Collet	162SA Series Stock Clearance Both Sides	
M6	X 1	0.208	12	2.37	1.059	X-LARGE	0.938	Green/Long	1.357	1.257	1.257	
M8	X 1	0.287	8	2.219	1.013	* X-LARGE	* 1.075	Green/Long	1.285	1.185	1.185	
M8	X 1.25	0.280	9	2.401	1.031	X-LARGE	0.750	Green/Long	1.454	1.354	1.354	
M10	X 0.75	0.372	6	2.188	0.976	X-LARGE	0.938	Green/Long	1.345	1.245	1.245	
M10	X 1.25	0.359	7	2.419	0.997	LARGE	1.000	Green/Long	1.551	1.451	1.451	
M10	X 1.5	0.352	7	2.352	0.996	X-LARGE	0.688	Green/Long	1.472	1.372	1.372	
M11	X 0.75	0.411	6	2.412	0.974	LARGE	0.875	Green/Long	1.608	1.508	1.508	
M11	X 1	0.405	6	2.366	0.974	LARGE	1.000	Green/Long	1.550	1.450	1.450	
M11	X 1.5	0.392	6	2.252	0.971	X-LARGE	0.813	Green/Long	1.411	1.311	1.311	
M12	X 1	0.445	5	2.169	0.944	* LARGE	* 1.312	Green/Long	1.392	1.292	1.292	
M12	X 1.25	0.437	5	2.121	0.942	X-LARGE	1.000	Green/Long	1.332	1.232	1.232	
M12	X 1.5	0.431	5	2.074	0.940	* X-LARGE	* 1.075	Green/Long	1.273	1.173	1.173	
M12	X 1.75	0.424	6	2.419	0.967	LARGE	0.875	Green/Long	1.606	1.506	1.506	
M14	X 1.5	0.510	5	2.416	0.927	LARGE	0.750	Green/Long	1.693	1.593	1.593	
M14	X 2	0.497	5	2.372	0.931	LARGE	0.875	Green/Long	1.625	1.525	1.525	
M15	X 1	0.562	4	2.207	0.895	LARGE	1.000	Green/Long	1.548	1.448	1.448	
M16	X 1.5	0.588	4	2.289	0.887	LARGE	0.813	Green/Long	1.645	1.545	1.545	
M16	X 2	0.575	4	2.213	0.889	LARGE	1.000	Green/Long	1.545	1.445	1.445	
M17	X 1	0.641	3	1.892	0.839	X-LARGE	1.000	Green/Long	1.312	1.212	1.212	
M18	X 1.5	0.667	3	1.953	0.832	* LARGE	* 1.312	Green/Long	1.388	1.288	1.288	
M20	X 1	0.759	3	2.246	0.805	MEDIUM	1.075	Green/Long	1.784	1.684	1.684	
M20	X 1.5	0.746	3	2.189	0.810	LARGE	0.688	Green/Long	1.703	1.603	1.603	
M20	X 2.5	0.720	3	2.075	0.816	LARGE	1.000	Green/Long	1.540	1.440	1.440	
M22	X 1.5	0.825	3	2.419	0.771	MEDIUM	0.625	Yellow/Medium	2.011	1.911	1.911	
M22	X 2.5	0.799	3	2.311	0.785	MEDIUM	0.938	Green/Long	1.855	1.755	1.755	
M24	X 2	0.890	2	1.736	0.720	* LARGE	* 1.312	Green/Long	1.383	1.283	1.283	
M25	X 1.5	0.943	2	1.853	0.706	LARGE	1.000	Green/Long	1.564	1.464	1.464	
M27	X 2	1.008	2	1.972	0.679	MEDIUM	1.156	Green/Long	1.737	1.637	1.637	
M30	X 1.5	1.140	2	2.247	0.609	NARROW	0.938	Red/Short	2.020	2.020	2.020	
M30	X 2	1.127	2	2.209	0.618	NARROW	1.075	Yellow/Medium	2.020	1.992	1.992	
M35	X 1.5	1.336	1	1.320	0.500	X-LARGE	0.813	Green/Long	1.424	1.324	1.324	
M36	X 2	1.363	1	1.341	0.489	X-LARGE	0.688	Green/Long	1.460	1.360	1.360	
M39	X 2	1.481	1	1.459	0.442	LARGE	0.688	Green/Long	1.696	1.596	1.596	
M40	X 1.5	1.533	1	1.517	0.418	MEDIUM	1.000	Green/Long	1.818	1.718	1.718	
M42	X 2	1.599	1	1.577	0.385	MEDIUM	0.813	Green/Long	1.932	1.832	1.832	
M45	X 1.5	1.730	1	1.714	0.311	NARROW	0.813	Red/Short	2.020	2.020	2.020	

* If you are using this wedge and roller combination you may have to modify your cross slide to clear the wedge-roller.

** Limited application, will have trouble adjusting penetration rate.

American National Standard Taper Pipe Threads MTK ROLL ARMS

Part Data				Roll Data			Attachment Data				
Size	TPI	Form	Blank Diameter at Y	# of Starts	OD Large End	Standard Work Face	Gage Setting at Y	Wedge	Roller	Spring	Stock Clearance 162 Series
1/8	- 27	NPT/NPTF	0.372	6	2.153	0.375	0.971	X-LARGE	0.625	Green/Long	1.052
1/4	- 18	NPT/NPTF	0.489	5	2.366	0.562	0.934	MEDIUM	1.075	Green/Long	1.351
3/8	- 18	NPT/NPTF	0.625	4	2.420	0.562	0.872	MEDIUM	0.688	Green/Long	1.541
1/2	- 14	NPT/NPTF	0.774	3	2.271	0.712	0.797	NARROW	1.312	Green/Long	1.513
3/4	- 14	NPT/NPTF	0.985	2	1.941	0.724	0.688	MEDIUM	1.000	Green/Long	1.394

British Standard Taper Pipe Threads (55 degrees) MTK ROLL ARMS

Part Data				Roll Data			Attachment Data				
Size	TPI	Form	Blank Diameter at Y	# of Starts	OD Large End	Standard Work Face	Gage Setting at Y	Wedge	Roller	Spring	Stock Clearance 162 Series
1/8	- 28	BSPT	0.360	6	2.103	0.344	0.972	X-LARGE	0.750	Green/Long	0.999
1/4	- 19	BSPT	0.484	5	2.352	0.512	0.936	MEDIUM	1.075	Green/Long	1.342
3/8	- 19	BSPT	0.622	4	2.420	0.526	0.873	MEDIUM	0.688	Green/Long	1.549
1/2	- 14	BSPT	0.779	3	2.291	0.698	0.795	MEDIUM	0.688	Green/Long	1.547
3/4	- 14	BSPT	0.995	2	1.987	0.750	0.685	MEDIUM	0.875	Green/Long	1.459

American National Standard Taper Pipe Threads MTQ ROLL ARMS

Part Data				Roll Data			Attachment Data				
Size	TPI	Form	Blank Diameter at Y	# of Starts	OD Large End	Standard Work Face	Gage Setting at Y	Wedge	Roller	Spring	Stock Clearance 162 Series
1/4	- 18	NPT/NPTF	0.489	5	2.366	0.562	0.934	X-LARGE	0.813	Green/Long	1.251
3/8	- 18	NPT/NPTF	0.625	4	2.420	0.562	0.872	LARGE	0.875	Green/Long	1.441
1/2	- 14	NPT/NPTF	0.774	3	2.271	0.712	0.797	LARGE	0.938	Green/Long	1.433
3/4	- 14	NPT/NPTF	0.985	2	1.941	0.724	0.688	LARGE	1.156	Green/Long	1.314
1	- 11 1/2	NPT/NPTF	1.235	2	2.420	0.900	0.548	NARROW	0.875	Red/Short	1.900

British Standard Taper Pipe Threads (55 degrees) MTQ ROLL ARMS

Part Data				Roll Data			Attachment Data				
Size	TPI	Form	Blank Diameter at Y	# of Starts	OD Large End	Standard Work Face	Gage Setting at Y	Wedge	Roller	Spring	Stock Clearance 162 Series
1/4	- 19	BSPT	0.484	5	2.352	0.512	0.936	X-LARGE	0.813	Green/Long	1.228
3/8	- 19	BSPT	0.622	4	2.420	0.526	0.873	LARGE	0.875	Green/Long	1.433
1/2	- 14	BSPT	0.779	3	2.291	0.698	0.795	LARGE	0.875	Green/Long	1.456
3/4	- 14	BSPT	0.995	2	1.987	0.750	0.685	LARGE	1.000	Green/Long	1.369
1	- 11	BSPT	1.250	2	2.420	0.888	0.538	NARROW	0.813	Red/Short	1.900

Additional stock clearance is attainable through roll arm modification. Contact C.J. Winter Machine Works for more information.

"Y" dimension is shown in accompanying drawing.

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

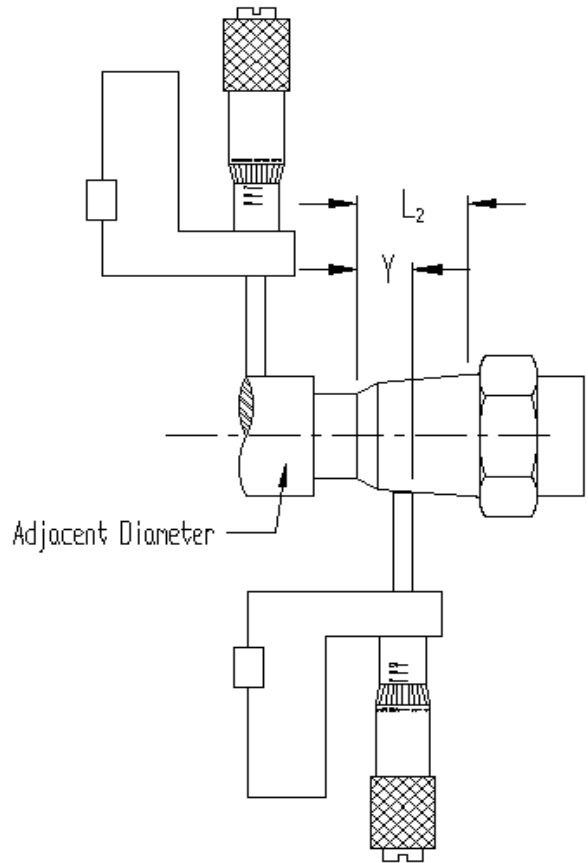
OPTIONAL GAGE SETTING USING AN ADJACENT DIAMETER

- 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