

WEDGE/ROLLER COMBINATIONS 170 SERIES

Wedge	Roller Ø	Spring	FCD Min.	FCD Max.
NARROW	0.625	Red/Short	4.200	4.604
NARROW	0.688	Red/Short	4.155	4.555
NARROW	0.750	Red/Short	4.111	4.506
NARROW	0.813	Red/Short	4.067	4.457
NARROW	0.875	Red/Short	4.023	4.408
NARROW	0.938	Red/Short	3.978	4.359
NARROW	1.000	Yellow/Medium	3.934	4.311
NARROW	1.075	Yellow/Medium	3.881	4.254
NARROW	1.156	Yellow/Medium	3.824	4.192
NARROW	1.312	Yellow/Medium	3.714	4.073
MEDIUM	0.625	Yellow/Medium	3.806	4.229
MEDIUM	0.688	Yellow/Medium	3.762	4.179
MEDIUM	0.750	Yellow/Medium	3.719	4.130
MEDIUM	0.813	Yellow/Medium	3.674	4.081
MEDIUM	0.875	Green/Long	3.631	4.033
MEDIUM	0.938	Green/Long	3.587	3.984
MEDIUM	1.000	Green/Long	3.543	3.936
MEDIUM	1.075	Green/Long	3.491	3.878
MEDIUM	1.156	Green/Long	3.435	3.816
MEDIUM	1.312	Green/Long	3.326	3.698
LARGE	0.625	Green/Long	3.428	3.826
LARGE	0.688	Green/Long	3.385	3.778
LARGE	0.750	Green/Long	3.342	3.731
LARGE	0.813	Green/Long	3.298	3.684
LARGE	0.875	Green/Long	3.255	3.637
LARGE	0.938	Green/Long	3.211	3.590
LARGE	1.000	Green/Long	3.168	3.543
LARGE	1.075	Green/Long	3.117	3.488
LARGE	1.156	Green/Long	3.061	3.427
* LARGE	1.312	Green/Long	2.954	3.313
X-LARGE	0.625	Green/Long	3.110	3.494
X-LARGE	0.688	Green/Long	3.066	3.448
X-LARGE	0.750	Green/Long	3.024	3.402
X-LARGE	0.813	Green/Long	2.980	3.355
X-LARGE	0.875	Green/Long	2.938	3.310
X-LARGE	0.938	Green/Long	2.895	3.264
X-LARGE	1.000	Green/Long	2.852	3.219
* X-LARGE	1.075	Green/Long	2.801	3.164
* X-LARGE	1.156	Green/Long	2.746	3.106

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

REFERENCE DATA SHEETS 170 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 Towards Collet	Stock Clearance Away From Collet
5/16	- 12	0.256	13	3.027	1.134	LARGE	1.075	Green/Long	2.037	1.937
5/16	- 18	0.274	11	2.853	1.127	X-LARGE	0.750	Green/Long	1.897	1.797
5/16	- 20	0.278	11	2.912	1.125	X-LARGE	0.688	Green/Long	1.963	1.863
5/16	- 24	0.283	11	2.999	1.120	LARGE	1.075	Green/Long	2.060	1.960
5/16	- 27	0.285	11	3.036	1.118	LARGE	0.938	Green/Long	2.102	2.002
5/16	- 28	0.287	11	3.062	1.117	LARGE	0.875	Green/Long	2.131	2.031
5/16	32	0.290	11	3.108	1.113	LARGE	0.813	Green/Long	2.182	2.082
3/8	- 16	0.332	9	2.837	1.098	X-LARGE	0.688	Green/Long	1.935	1.835
3/8	- 18	0.336	9	2.885	1.095	LARGE	1.075	Green/Long	1.991	1.891
3/8	- 20	0.341	9	2.945	1.092	LARGE	1.075	Green/Long	2.059	1.959
3/8	- 24	0.346	9	3.016	1.087	LARGE	0.875	Green/Long	2.140	2.040
3/8	- 27	0.348	9	3.046	1.085	LARGE	0.813	Green/Long	2.175	2.075
3/8	- 28	0.350	9	3.068	1.083	MEDIUM	1.312	Green/Long	2.199	2.099
3/8	- 32	0.353	9	3.106	1.079	LARGE	0.750	Green/Long	2.243	2.143
3/8	- 36	0.354	8	2.780	1.087	X-LARGE	0.750	Green/Long	1.920	1.820
3/8	- 40	0.356	8	2.802	1.086	X-LARGE	0.688	Green/Long	1.945	1.845
7/16	- 14	0.389	8	2.954	1.066	LARGE	0.938	Green/Long	2.104	2.004
7/16	- 16	0.394	8	3.011	1.062	LARGE	0.813	Green/Long	2.170	2.070
7/16	- 18	0.398	8	3.064	1.057	LARGE	0.750	Green/Long	2.232	2.132
7/16	- 20	0.403	8	3.118	1.052	LARGE	0.625	Green/Long	2.294	2.194
7/16	- 24	0.407	7	2.776	1.060	X-LARGE	0.688	Green/Long	1.961	1.861
7/16	- 27	0.410	7	2.807	1.058	LARGE	1.075	Green/Long	1.998	1.898
7/16	- 28	0.412	7	2.823	1.057	LARGE	1.075	Green/Long	2.017	1.917
7/16	- 32	0.415	7	2.853	1.055	LARGE	1.075	Green/Long	2.052	1.952
1/2	- 12	0.444	7	2.942	1.038	LARGE	0.875	Green/Long	2.140	2.040
1/2	- 13	0.448	7	2.985	1.034	MEDIUM	1.312	Green/Long	2.191	2.091
1/2	- 14	0.450	7	3.011	1.032	LARGE	0.750	Green/Long	2.222	2.122
1/2	- 16	0.457	7	3.082	1.026	LARGE	0.688	Green/Long	2.285	2.185
1/2	- 18	0.461	7	3.119	1.022	MEDIUM	1.156	Green/Long	2.321	2.221
1/2	- 20	0.466	6	2.713	1.031	X-LARGE	0.688	Green/Long	1.952	1.852
1/2	- 24	0.470	6	2.754	1.028	LARGE	1.075	Green/Long	2.002	1.902
1/2	- 27	0.473	6	2.781	1.026	LARGE	1.075	Green/Long	2.035	1.935
1/2	- 28	0.475	6	2.795	1.025	LARGE	1.075	Green/Long	2.051	1.951
1/2	- 32	0.475	6	2.821	1.024	LARGE	0.938	Green/Long	2.083	1.983
9/16	- 12	0.506	6	2.898	1.006	LARGE	0.813	Green/Long	2.158	2.058
9/16	- 14	0.513	6	2.956	1.000	LARGE	0.750	Green/Long	2.229	2.129
9/16	- 16	0.520	6	3.016	0.993	MEDIUM	1.156	Green/Long	2.302	2.202
9/16	- 18	0.524	5	2.547	1.002	X-LARGE	0.813	Green/Long	1.841	1.741
9/16	- 20	0.528	6	3.088	0.984	MEDIUM	1.075	Green/Long	2.389	2.289
9/16	- 24	0.527	5	2.583	1.000	X-LARGE	0.750	Green/Long	1.894	1.794
9/16	- 28	0.537	5	2.642	0.995	X-LARGE	0.688	Green/Long	1.960	1.860
9/16	- 32	0.540	5	2.663	0.993	LARGE	1.075	Green/Long	1.987	1.887
5/8	- 11	0.564	5	2.691	0.981	LARGE	1.075	Green/Long	2.004	1.904
5/8	- 12	0.569	5	2.727	0.978	LARGE	1.075	Green/Long	2.050	1.950
5/8	- 14	0.575	5	2.776	0.973	LARGE	0.938	Green/Long	2.111	2.011
5/8	- 16	0.582	5	2.826	0.968	LARGE	0.813	Green/Long	2.174	2.074
5/8	- 18	0.587	5	2.859	0.964	LARGE	0.750	Green/Long	2.216	2.116
5/8	- 20	0.591	5	2.886	0.960	LARGE	0.688	Green/Long	2.250	2.150
5/8	- 24	0.596	5	2.891	0.957	LARGE	0.688	Green/Long	2.265	2.165
5/8	- 27	0.598	5	2.942	0.953	MEDIUM	1.156	Green/Long	2.321	2.221
5/8	- 28	0.600	5	2.954	0.951	MEDIUM	1.156	Green/Long	2.335	2.235
5/8	- 32	0.603	5	2.976	0.948	MEDIUM	1.075	Green/Long	2.363	2.263

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

REFERENCE DATA SHEETS 170 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 Towards Collet	Stock Clearance Away From Collet
11/16	- 12	0.631	5	3.039	0.930	MEDIUM	1.075	Green/Long	2.424	2.324
11/16	- 16	0.645	4	2.511	0.941	LARGE	1.156	Green/Long	1.922	1.822
11/16	- 20	0.653	4	2.559	0.937	LARGE	1.075	Green/Long	1.985	1.885
11/16	- 24	0.656	4	2.582	0.935	LARGE	1.075	Green/Long	2.018	1.918
11/16	- 28	0.662	4	2.613	0.931	LARGE	1.075	Green/Long	2.057	1.957
11/16	- 32	0.665	4	2.630	0.929	LARGE	0.938	Green/Long	2.079	1.979
									-1.200	
3/4	- 10	0.683	4	2.617	0.921	LARGE	1.075	Green/Long	2.044	1.944
3/4	- 12	0.694	4	2.685	0.913	LARGE	0.875	Green/Long	2.133	2.033
3/4	- 14	0.700	4	2.730	0.908	MEDIUM	1.312	Green/Long	2.192	2.092
3/4	- 16	0.708	4	2.761	0.902	LARGE	0.750	Green/Long	2.234	2.134
3/4	- 18	0.710	4	2.788	0.900	LARGE	0.688	Green/Long	2.270	2.170
3/4	- 20	0.716	4	2.808	0.895	MEDIUM	1.156	Green/Long	2.297	2.197
3/4	- 24	0.720	4	2.839	0.891	MEDIUM	1.156	Green/Long	2.338	2.238
3/4	- 27	0.723	4	2.853	0.889	MEDIUM	1.075	Green/Long	2.358	2.258
3/4	- 28	0.725	4	2.861	0.887	MEDIUM	1.075	Green/Long	2.367	2.267
3/4	- 32	0.728	4	2.880	0.884	MEDIUM	1.075	Green/Long	2.392	2.292
13/16	- 12	0.757	4	2.937	0.866	MEDIUM	0.938	Green/Long	2.447	2.347
13/16	- 16	0.770	4	3.012	0.852	MEDIUM	0.813	Yellow/Medium	2.460	2.448
13/16	- 20	0.778	4	3.060	0.842	MEDIUM	0.750	Yellow/Medium	2.460	2.460
13/16	- 28	0.787	4	3.113	0.831	MEDIUM	0.625	Yellow/Medium	2.460	2.460
13/16	- 32	0.790	3	2.348	0.869	LARGE	1.156	Green/Long	1.922	1.822
7/8	- 10	0.806	3	2.333	0.861	X-LARGE	0.750	Green/Long	1.885	1.785
7/8	- 12	0.819	3	2.386	0.854	X-LARGE	0.688	Green/Long	1.959	1.859
7/8	- 14	0.827	3	2.422	0.849	LARGE	1.075	Green/Long	2.009	1.909
7/8	- 16	0.833	3	2.447	0.846	LARGE	1.075	Green/Long	2.045	1.945
7/8	- 18	0.836	3	2.466	0.844	LARGE	0.938	Green/Long	2.073	1.973
7/8	- 20	0.841	3	2.482	0.841	LARGE	0.938	Green/Long	2.096	1.996
7/8	- 24	0.845	3	2.504	0.838	LARGE	0.875	Green/Long	2.128	2.028
7/8	- 27	0.848	3	2.516	0.836	LARGE	0.875	Green/Long	2.146	2.046
7/8	- 28	0.850	3	2.521	0.834	LARGE	0.875	Green/Long	2.152	2.052
7/8	- 32	0.853	3	2.533	0.832	LARGE	0.813	Green/Long	2.170	2.070
15/16	- 12	0.882	3	2.578	0.816	LARGE	0.750	Green/Long	2.213	2.113
15/16	- 16	0.895	3	2.634	0.806	LARGE	0.625	Green/Long	2.295	2.195
15/16	- 20	0.903	3	2.668	0.799	MEDIUM	1.156	Green/Long	2.344	2.244
15/16	- 28	0.912	3	2.711	0.791	MEDIUM	1.075	Green/Long	2.405	2.305
15/16	- 32	0.915	3	2.723	0.789	MEDIUM	1.075	Green/Long	2.422	2.322
1	- 10	0.931	3	2.721	0.782	MEDIUM	1.075	Green/Long	2.398	2.298
1	- 12	0.944	3	2.766	0.771	MEDIUM	0.938	Green/Long	2.460	2.364
1	- 14	0.952	3	2.799	0.764	MEDIUM	0.875	Green/Long	2.460	2.411
1	- 16	0.958	3	2.825	0.758	MEDIUM	0.813	Yellow/Medium	2.460	2.448
1	- 18	0.961	3	2.841	0.754	MEDIUM	0.813	Yellow/Medium	2.460	2.460
1	- 20	0.966	3	2.858	0.750	MEDIUM	0.750	Yellow/Medium	2.460	2.460
1	- 24	0.970	3	2.880	0.745	MEDIUM	0.688	Yellow/Medium	2.460	2.460
1	- 27	0.973	3	2.890	0.742	MEDIUM	0.688	Yellow/Medium	2.460	2.460
1	- 28	0.975	3	2.895	0.740	MEDIUM	0.688	Yellow/Medium	2.460	2.460
1	- 32	0.978	3	2.907	0.737	MEDIUM	0.625	Yellow/Medium	2.460	2.460
1 1/16	- 12	1.007	3	2.955	0.718	NARROW	1.156	Yellow/Medium	2.460	2.460
1 1/16	- 16	1.020	3	3.012	0.703	NARROW	1.000	Yellow/Medium	2.460	2.460
1 1/16	- 18	1.025	3	3.029	0.697	NARROW	1.000	Yellow/Medium	2.460	2.460
1 1/16	- 20	1.028	3	3.044	0.693	NARROW	0.938	Red/Short	2.460	2.460

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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 1/16	- 28	1.038	3	3.086	0.681	NARROW	0.875	Red/Short	2.460	2.460
1 1/8	- 10	1.056	3	3.096	0.673	NARROW	0.875	Red/Short	2.460	2.460
1 1/8	- 12	1.069	2	2.094	0.729	X-LARGE	0.750	Green/Long	1.917	1.817
1 1/8	- 14	1.075	2	2.116	0.726	X-LARGE	0.688	Green/Long	1.953	1.853
1 1/8	- 16	1.083	2	2.133	0.722	LARGE	1.075	Green/Long	1.981	1.881
1 1/8	- 18	1.087	2	2.144	0.720	LARGE	1.075	Green/Long	2.001	1.901
1 1/8	- 20	1.091	2	2.155	0.717	LARGE	1.075	Green/Long	2.019	1.919
1 1/8	- 24	1.095	2	2.170	0.715	LARGE	1.075	Green/Long	2.044	1.944
1 1/8	- 28	1.100	2	2.180	0.712	LARGE	1.075	Green/Long	2.061	1.961
1 3/16	- 12	1.132	2	2.220	0.695	LARGE	0.938	Green/Long	2.105	2.005
1 3/16	- 16	1.145	2	2.258	0.686	LARGE	0.813	Green/Long	2.169	2.069
1 3/16	- 18	1.150	2	2.269	0.683	MEDIUM	1.312	Green/Long	2.188	2.088
1 3/16	- 20	1.153	2	2.279	0.681	LARGE	0.750	Green/Long	2.205	2.105
1 3/16	- 28	1.163	2	2.307	0.674	LARGE	0.688	Green/Long	2.251	2.151
1 1/4	- 10	1.181	2	2.314	0.666	LARGE	0.750	Green/Long	2.241	2.141
1 1/4	- 12	1.194	2	2.344	0.657	LARGE	0.625	Green/Long	2.292	2.192
1 1/4	- 14	1.200	2	2.366	0.652	MEDIUM	1.156	Green/Long	2.328	2.228
1 1/4	- 16	1.208	2	2.382	0.646	MEDIUM	1.075	Green/Long	2.355	2.255
1 1/4	- 18	1.212	2	2.394	0.643	MEDIUM	1.075	Green/Long	2.376	2.276
1 1/4	- 20	1.215	2	2.405	0.640	MEDIUM	1.075	Green/Long	2.394	2.294
1 1/4	- 24	1.220	2	2.420	0.636	MEDIUM	1.075	Green/Long	2.419	2.319
1 1/4	- 28	1.225	2	2.432	0.633	MEDIUM	1.075	Green/Long	2.438	2.338
1 5/16	- 12	1.257	2	2.470	0.614	MEDIUM	0.938	Green/Long	2.460	2.380
1 5/16	- 16	1.270	2	2.507	0.602	MEDIUM	0.813	Yellow/Medium	2.460	2.443
1 5/16	- 18	1.275	2	2.519	0.598	MEDIUM	0.813	Yellow/Medium	2.460	2.460
1 5/16	- 20	1.278	2	2.530	0.595	MEDIUM	0.750	Yellow/Medium	2.460	2.460
1 5/16	- 28	1.288	2	2.558	0.586	MEDIUM	0.688	Yellow/Medium	2.460	2.460
1 3/8	- 10	1.306	2	2.564	0.578	MEDIUM	0.750	Yellow/Medium	2.460	2.460
1 3/8	- 12	1.319	2	2.594	0.567	MEDIUM	0.625	Yellow/Medium	2.460	2.460
1 3/8	- 14	1.325	2	2.615	0.560	NARROW	1.156	Yellow/Medium	2.460	2.460
1 3/8	- 16	1.333	2	2.632	0.553	NARROW	1.156	Yellow/Medium	2.460	2.460
1 3/8	- 18	1.337	2	2.644	0.549	NARROW	1.075	Yellow/Medium	2.460	2.460
1 3/8	- 20	1.341	2	2.657	0.545	NARROW	1.075	Yellow/Medium	2.460	2.460
1 3/8	- 24	1.345	2	2.668	0.541	NARROW	1.075	Yellow/Medium	2.460	2.460
1 3/8	- 28	1.350	2	2.682	0.536	NARROW	1.000	Yellow/Medium	2.460	2.460
1 7/16	- 12	1.382	2	2.716	0.515	NARROW	0.938	Red/Short	2.460	2.460
1 7/16	- 16	1.395	2	2.756	0.501	NARROW	0.875	Red/Short	2.460	2.460
1 7/16	- 18	1.400	2	2.770	0.495	NARROW	0.813	Red/Short	2.460	2.460
1 7/16	- 20	1.403	2	2.780	0.492	NARROW	0.813	Red/Short	2.460	2.460
1 7/16	- 28	1.413	2	2.806	0.481	NARROW	0.750	Red/Short	2.460	2.460
1 1/2	- 10	1.431	2	2.818	0.472	NARROW	0.750	Red/Short	2.460	2.460
1 1/2	- 12	1.444	2	2.848	0.459	NARROW	0.750	Red/Short	2.460	2.460
1 1/2	- 14	1.450	2	2.868	0.451	NARROW	0.625	Red/Short	2.460	2.460
1 1/2	- 16	1.458	2	2.884	0.442	NARROW	0.625	Red/Short	2.460	2.460
1 1/2	- 18	1.462	2	2.898	0.437	NARROW	0.625	Red/Short	2.460	2.460
** 1 1/2	- 20	1.466	2	2.908	0.432	NARROW	0.625	Red/Short	2.460	2.460
** 1 1/2	- 24	1.470	2	2.920	0.427	NARROW	0.625	Red/Short	2.460	2.460
** 1 1/2	- 28	1.475	2	2.932	0.421	NARROW	0.625	Red/Short	2.460	2.460
1 9/16	- 12	1.507	1	1.483	0.509	X-LARGE	1.000	Green/Long	1.744	1.644

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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 9/16 - 16	16	1.520	1	1.503	0.504	X-LARGE	0.938	Green/Long	1.789	1.689
1 9/16 - 18	18	1.525	2	3.018	0.374	NARROW	0.625	Red/Short	2.460	2.460
1 9/16 - 20	20	1.528	1	1.515	0.500	X-LARGE	0.875	Green/Long	1.816	1.716
1 5/8 - 10	10	1.556	1	1.524	0.486	X-LARGE	0.875	Green/Long	1.826	1.726
1 5/8 - 12	12	1.569	1	1.549	0.479	X-LARGE	0.813	Green/Long	1.872	1.772
1 5/8 - 14	14	1.575	1	1.559	0.476	X-LARGE	0.750	Green/Long	1.896	1.796
1 5/8 - 16	16	1.583	1	1.567	0.472	X-LARGE	0.750	Green/Long	1.915	1.815
1 5/8 - 18	18	1.587	1	1.574	0.470	X-LARGE	0.688	Green/Long	1.931	1.831
1 5/8 - 20	20	1.591	1	1.579	0.468	X-LARGE	0.688	Green/Long	1.943	1.843
1 5/8 - 24	24	1.595	1	1.585	0.466	X-LARGE	0.688	Green/Long	1.959	1.859
1 11/16 - 12	12	1.632	1	1.608	0.447	LARGE	1.075	Green/Long	1.993	1.893
1 11/16 - 16	16	1.645	1	1.628	0.440	LARGE	1.075	Green/Long	2.039	1.939
1 11/16 - 18	18	1.650	1	1.634	0.437	LARGE	1.075	Green/Long	2.053	1.953
1 11/16 - 20	20	1.653	1	1.640	0.435	LARGE	1.075	Green/Long	2.066	1.966
1 3/4 - 10	10	1.681	1	1.652	0.421	LARGE	0.938	Green/Long	2.079	1.979
1 3/4 - 12	12	1.694	1	1.670	0.414	LARGE	0.875	Green/Long	2.118	2.018
1 3/4 - 14	14	1.700	1	1.680	0.410	LARGE	0.875	Green/Long	2.142	2.042
1 3/4 - 16	16	1.708	1	1.690	0.405	LARGE	0.813	Green/Long	2.163	2.063
1 3/4 - 18	18	1.711	1	1.695	0.403	LARGE	0.813	Green/Long	2.177	2.077
1 3/4 - 20	20	1.716	1	1.702	0.400	MEDIUM	1.312	Green/Long	2.191	2.091
1 13/16 - 12	12	1.757	1	1.733	0.377	LARGE	0.750	Green/Long	2.243	2.143
1 13/16 - 16	16	1.770	1	1.753	0.369	LARGE	0.625	Green/Long	2.289	2.189
1 13/16 - 20	20	1.778	1	1.765	0.363	MEDIUM	1.156	Green/Long	2.316	2.216
1 7/8 - 10	10	1.806	1	1.778	0.349	MEDIUM	1.156	Green/Long	2.330	2.230
1 7/8 - 12	12	1.819	1	1.795	0.340	MEDIUM	1.075	Green/Long	2.368	2.268
1 7/8 - 14	14	1.825	1	1.805	0.336	MEDIUM	1.075	Green/Long	2.392	2.292
1 7/8 - 16	16	1.833	1	1.815	0.330	MEDIUM	1.075	Green/Long	2.413	2.313
1 7/8 - 18	18	1.836	1	1.820	0.328	MEDIUM	1.075	Green/Long	2.427	2.327
1 7/8 - 20	20	1.841	1	1.827	0.324	MEDIUM	1.075	Green/Long	2.441	2.341
1 15/16 - 12	12	1.882	1	1.858	0.300	MEDIUM	0.875	Green/Long	2.460	2.393
1 15/16 - 16	16	1.895	1	1.878	0.290	MEDIUM	0.813	Yellow/Medium	2.460	2.439
1 15/16 - 20	20	1.903	1	1.890	0.284	MEDIUM	0.813	Yellow/Medium	2.460	2.460
2 - 10	10	1.931	1	1.909	0.268	MEDIUM	0.750	Yellow/Medium	2.460	2.460
2 - 12	12	1.944	1	1.924	0.259	MEDIUM	0.750	Yellow/Medium	2.460	2.460
2 - 14	14	1.950	1	1.926	0.254	MEDIUM	0.688	Yellow/Medium	2.460	2.460
2 - 16	16	1.958	1	1.942	0.247	MEDIUM	0.688	Yellow/Medium	2.460	2.460
2 - 18	18	1.961	1	1.949	0.244	MEDIUM	0.625	Yellow/Medium	2.460	2.460
2 - 20	20	1.966	1	1.954	0.241	NARROW	1.156	Yellow/Medium	2.460	2.460
2 1/8 - 12	12	2.069	1	2.049	0.169	NARROW	0.938	Red/Short	2.460	2.460
2 1/8 - 16	16	2.083	1	2.067	0.157	NARROW	0.875	Red/Short	2.460	2.460
2 1/8 - 20	20	2.091	1	2.076	0.150	NARROW	0.813	Red/Short	2.460	2.460
2 1/4 - 10	10	2.181	1	2.159	0.084	NARROW	0.625	Red/Short	2.460	2.460
** 2 1/4 - 12	12	2.194	1	2.174	0.072	NARROW	0.625	Red/Short	2.460	2.460
** 2 1/4 - 14	14	2.200	1	2.184	0.065	NARROW	0.625	Red/Short	2.460	2.460
** 2 1/4 - 16	16	2.208	1	2.192	0.058	NARROW	0.625	Red/Short	2.460	2.460
** 2 1/4 - 18	18	2.211	1	2.198	0.054	NARROW	0.625	Red/Short	2.460	2.460
** 2 1/4 - 20	20	2.216	1	2.203	0.050	NARROW	0.625	Red/Short	2.460	2.460

* 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.

**REFERENCE DATA SHEETS 170 SERIES
STRAIGHT PIPE THREAD SIZES**

Part Data			Roll Data		Attachment Data					
Size	TPI	Blank Diameter	# of Starts	Roll OD	Gage Setting	Wedge	Roller	Spring	Stock Clearance Towards Collet	Stock Clearance Away From Collet
1/2 -	14	0.775	4	3.020	0.850	MEDIUM	0.813	Yellow/Medium	2.460	2.442
3/4 -	14	0.985	3	2.896	0.737	MEDIUM	0.688	Yellow/Medium	2.460	2.460
1 -	11 1/2	1.235	2	2.421	0.629	MEDIUM	1.075	Green/Long	2.413	2.313
1 1/4 -	11 1/2	1.580	1	1.555	0.474	X-LARGE	0.813	Green/Long	1.870	1.570
1 1/2 -	11 1/2	1.819	1	1.794	0.341	MEDIUM	1.156	Green/Long	2.348	2.248

**REFERENCE DATA SHEETS 170 SERIES
BSPP STRAIGHT PIPE THREAD SIZES**

Part Data			Roll Data		Attachment Data					
Size	TPI	Blank Diameter	# of Starts	Roll OD	Gage Setting	Wedge	Roller	Spring	Stock Clearance Towards Collet	Stock Clearance Away From Collet
1/2 -	14	0.777	4	3.026	0.848	MEDIUM	0.813	Yellow/Medium	2.460	2.454
3/4 -	14	0.993	3	2.926	0.730	MEDIUM	0.625	Yellow/Medium	2.460	2.460
1 -	11	1.248	2	2.443	0.622	MEDIUM	1.075	Green/Long	2.428	2.328
1 1/4 -	11	1.589	1	1.563	0.469	X-LARGE	0.750	Green/Long	1.889	1.789
1 1/2 -	11	1.821	1	1.795	0.340	MEDIUM	1.075	Green/Long	2.353	2.253

C. J. Winter Machine Technologies, Inc. 5/21/2026
REFERENCE DATA SHEETS 170 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	Stock Clearance Towards Collet	Stock Clearance Away Form Collet
1/2 - 14		0.774	4	3.028	0.852	MEDIUM	0.875	Green/Long	2.460	2.423
3/4 - 14		0.985	3	2.910	0.739	MEDIUM	0.750	Yellow/Medium	2.460	2.460
1 - 11 1/2		1.235	2	2.436	0.632	MEDIUM	1.075	Green/Long	2.373	2.273
1 1/4 - 11 1/2		1.579	1	1.580	0.474	X-LARGE	0.813	Green/Long	1.860	1.760
1 1/2 - 11 1/2		1.818	1	1.830	0.342	MEDIUM	1.156	Green/Long	2.349	2.249

REFERENCE DATA SHEETS 170 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 Towards Collet	Stock Clearance
1/2 - 14		0.779	4	3.047	0.847	MEDIUM	0.813	Yellow/Medium	2.460	2.456
3/4 - 14		0.995	3	2.966	0.727	NARROW	1.156	Yellow/Medium	2.460	2.460
1 - 11		1.250	2	2.471	0.620	MEDIUM	1.075	Green/Long	2.433	2.333
1 1/4 - 11		1.591	1	1.608	0.468	X-LARGE	0.750	Green/Long	1.909	1.809
1 1/2 - 11		1.823	1	1.840	0.338	MEDIUM	1.075	Green/Long	2.373	2.273

"Y" dimension is shown in accompanying drawing.

REFERENCE DATA SHEETS 170 SERIES
METRIC THREAD SIZES

Part Data			Roll Data		Attachment Data						
Size	Pitch	Blank Diameter	# of Starts	OD	Gage Setting	Wedge	Roller	Spring	Stock Clearance Towards Collet	Stock Clearance Away From Collet	
M10	X 0.75	0.368	8	2.885	1.078	LARGE	1.000	Green/Long	2.038	1.938	
M10	X 1.25	0.359	9	3.110	1.076	LARGE	0.750	Green/Long	2.242	2.142	
M10	X 1.5	0.352	8	2.738	1.088	X-LARGE	0.813	Green/Long	1.858	1.758	
M12	X 1	0.444	7	3.036	1.033	LARGE	0.688	Green/Long	2.259	2.159	
M12	X 1.25	0.437	7	2.970	1.040	LARGE	0.813	Green/Long	2.181	2.081	
M12	X 1.5	0.431	7	2.903	1.045	LARGE	0.938	Green/Long	2.102	2.002	
M12	X 1.75	0.424	7	2.837	1.051	LARGE	1.075	Green/Long	2.024	1.924	
M14	X 1.5	0.511	6	2.968	1.000	LARGE	0.688	Green/Long	2.245	2.145	
M14	X 2	0.497	6	2.846	1.013	LARGE	0.938	Green/Long	2.099	1.999	
M15	X 1	0.563	5	2.764	0.979	LARGE	0.938	Green/Long	2.105	2.005	
M16	X 1.5	0.590	5	2.867	0.962	LARGE	0.750	Green/Long	2.223	2.123	
M16	X 2	0.575	5	2.766	0.974	LARGE	0.938	Green/Long	2.098	1.998	
M17	X 1	0.641	4	2.522	0.943	X-LARGE	0.688	Green/Long	1.942	1.842	
M18	X 1.5	0.666	4	2.600	0.929	LARGE	1.000	Green/Long	2.035	1.935	
M20	X 1	0.759	4	2.995	0.859	MEDIUM	0.875	Green/Long	2.460	2.433	
M20	X 1.5	0.746	4	2.919	0.872	MEDIUM	1.000	Green/Long	2.433	2.333	
M20	X 2.5	0.720	4	2.767	0.896	LARGE	0.750	Green/Long	2.232	2.132	
M22	X 1.5	0.825	3	2.425	0.850	LARGE	1.075	Green/Long	2.017	1.917	
M22	X 2.5	0.799	4	3.082	0.831	MEDIUM	0.688	Yellow/Medium	2.460	2.460	
M24	X 2	0.890	3	2.604	0.811	LARGE	0.688	Green/Long	2.251	2.151	
M25	X 1.5	0.943	3	2.780	0.770	MEDIUM	0.938	Green/Long	2.460	2.391	
M27	X 2	1.008	3	2.959	0.717	NARROW	1.156	Yellow/Medium	2.460	2.460	
M30	X 1.5	1.140	2	2.247	0.689	LARGE	0.875	Green/Long	2.154	2.054	
M30	X 2	1.127	2	2.209	0.699	LARGE	1.075	Green/Long	2.013	1.913	
M33	X 2	1.245	2	2.445	0.622	MEDIUM	1.000	Green/Long	2.446	2.346	
M35	X 1.5	1.336	2	2.641	0.550	NARROW	1.075	Yellow/Medium	2.460	2.460	
M36	X 2	1.363	2	2.681	0.531	NARROW	1.000	Yellow/Medium	2.460	2.460	
**M39	X 2	1.481	2	2.917	0.424	NARROW	0.625	Red/Short	2.460	2.460	
M40	X 1.5	1.533	1	1.517	0.497	* LARGE	* 1.312	Green/Long	1.818	1.718	
M42	X 2	1.599	1	1.577	0.464	X-LARGE	0.688	Green/Long	1.932	1.832	
M45	X 1.5	1.730	1	1.714	0.392	LARGE	0.750	Green/Long	2.212	2.112	
M48	X 2	1.835	1	1.813	0.330	MEDIUM	1.000	Green/Long	2.405	2.305	
M50	X 1.5	1.927	1	1.911	0.268	MEDIUM	0.750	Yellow/Medium	2.460	2.460	
M55	X 1.5	2.124	1	2.108	0.125	NARROW	0.750	Red/Short	2.460	2.460	

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

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

**REFERENCE DATA SHEETS 170 SERIES
METRIC THREAD SIZES**

Part Data			Roll Data		Attachment Data					
Size	Pitch	Blank Diameter	# of Starts	OD	Gage Setting	Wedge	Roller	Spring	Stock Clearance Towards Collet	Stock Clearance Away From Collet
M56	X 2	2.150	1	2.128	0.107	NARROW	0.688	Red/Short	2.460	2.460

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

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

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

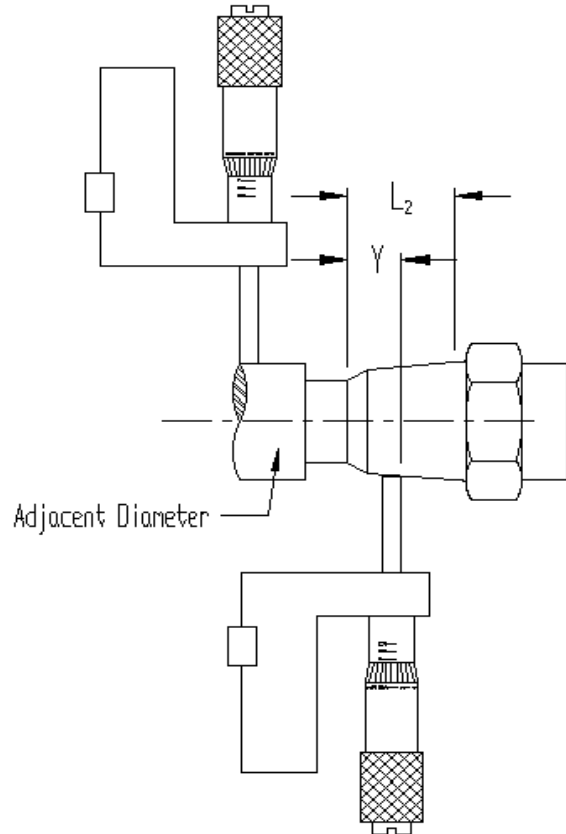
OPTIONAL GAGE SETTING USING AN ADJACENT DIAMETER

- 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

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