



R&L RELEASING TAP HOLDER

The patented unique releasing mechanism of the Somma R & L Tap Holder is unequalled for dependability and accuracy which resulted in its selection for usage as original equipment by many machine tool manufacturers.

FEATURES

- For right or left hand threading
- Eases tap into work for better matching of threads
- No spring plungers to wear or break
- No. 000 size is extremely sensitive for small taps when used on high speed machines
- Simple operation (see diagrams below)

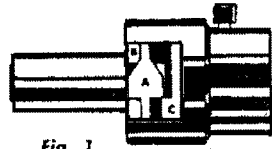


Fig. 1

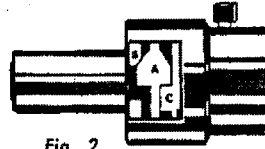


Fig. 2

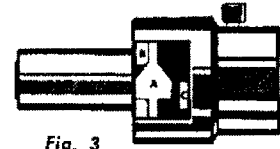


Fig. 3

PATENTED

Ready to start threading operation, clutch slightly engaged (A) and (C).

When tap contacts work, clutch ring (A) slides forward to fully engage spindle (C) for positive driving power.

When end of pullout is reached clutch ring (A) springs back instantly, leaving ample clearance between contact points of clutch ring and spindle, preventing re-engagement or hammering of clutch points in case turret advances slightly after release.

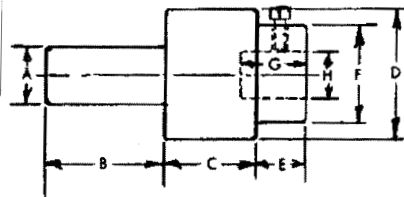
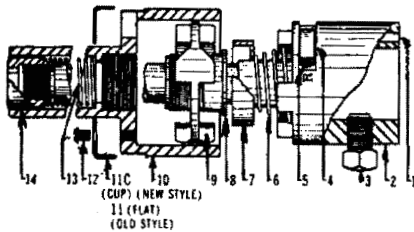
NOTE: TH2-NBG, TH3-NBG AND TH4-NBG have special shank diameter and length for use on New Britain Gridley automatics.

SEE PAGE 112 FOR TAP HOLDER BUSHINGS FOR THESE TAP HOLDERS

SIZE	A	B	C	D	E	F	G	H	TAP CAPACITY		PULLOUT FOR RELEASING			
									HAND TAP	PIPE TAP	CAT. NO.	STD. CLUTCH NUT	CAT. NO.	SHORT CLUTCH NUT
TH000	5/8	1-3/16	7/8	1-1/32	3/8	13/16	1/2	1/2	1/4	1/16	TH000	1/8	TH000-S	.100
TH00	5/8	1-1/4	7/8	1-11/32	13/32	1-1/8	19/32	1/2	7/16	1/8	TH00	1/8	TH00-S	.100
TH1	3/4	1-3/4	1-1/16	1-19/32	1/2	1-5/16	3/4	5/8	11/16	1/4	TH1	5/32	TH1-S	.115
TH2	1"	2"	1-3/8	2-7/32	13/16	1-3/4	1-5/32	1"	1-1/8	3/4	TH2	7/32	TH2-S	.156
TH2-NBG	1"	2"	1-3/8	2-7/32	13/16	1-3/4	1-5/32	1"	1-1/8	3/4			TH2-NBG	.156
TH3	1-1/4	2-9/16*	2"	2-13/16	7/8	2-1/4	1-1/2	1-1/4	1-1/4	1"	TH3	1/4	TH3-S	.167
TH3-NBG	1-1/2	1-11/16	2"	2-13/16	7/8	2-1/4	1-1/2	1-1/4	1-1/4	1"			TH3-NBG	.167
TH4	1-1/2	3-3/16	2-9/16	3-5/8	1-1/8	3"	1-5/8	1-1/2	1-1/2	1"	TH4	5/16	TH4-S	.203
TH4-NBG	1-1/2	1-11/16	2-9/16	3-5/8	1-1/8	3"	1-5/8	1-1/2	1-1/2	1"			TH4-NBG	.203

* PLUS 31/32 DIA. x 15/16 LONG PROJECTION

RELEASING TAP HOLDER PARTS



Part No.	TH000 Cat. No.	TH00 Cat. No.	TH1 Cat. No.	TH2 Cat. No.	TH2-NBG Cat. No.	TH3 Cat. No.	TH3-NBG Cat. No.	TH4 Cat. No.	TH4-NBG Cat. No.
1. Pawl Pin	TH000-1	TH00-1	TH1-1	TH2-1	TH2-1	TH3-1	TH3-1	TH4-1	TH4-1
2. Spindle	TH000-2	TH00-2	TH1-2	TH2-2	TH2-2	TH3-2	TH3-2	TH4-2	TH4-2NBG
3. Set Screw	TH000-3	TH00-13	TH1-6	TH2-13	TH2-13	TH3-13	NR3-3	TH4-3	NR4-3
4. Pawl	TH000-4	TH00-4	TH1-4	TH2-4	TH2-4	TH3-4	TH3-4	TH4-4	TH4-4
5. Pawl Spring	TH000-5	TH1-5	TH1-5	TH1-5	TH1-5	TH3-5	TH3-5	TH3-5	TH3-5
6. Clutch Spring	TH000-6	TH00-6	TH1-6	TH2-6	TH2-6	TH3-6	TH3-6	TH4-6	TH4-6
7. Clutch Washer	TH000-7	TH00-7	TH1-7	TH2-7	TH2-7	TH3-7	TH3-7	TH4-7	TH4-7
8. Clutch Nut	TH000-8	TH00-8	TH1-8	TH2-8	--	TH3-8	--	TH4-8	--
8-S Short Clutch Nut	TH000-8S	TH00-8S	TH1-8S	TH2-8S	TH2-8S	TH3-8S	TH3-8S	TH4-8S	TH4-8S
9. Clutch Ring	TH000-9	TH00-9	TH1-9	TH2-9	TH2-9	TH3-9	TH3-9	TH4-9	TH4-9
10. Body	TH000-10	TH00-10	TH1-10	TH2-10	TH2-10NBG	TH3-10	TH3-10NBG	TH4-10	TH4-10NBG
11. Cover Plate (Old Style)	TH000-11	TH00-11	TH1-11	TH2-11	TH2-11	TH3-11	TH3-11NBG	TH4-11	TH4-11
11C. Cup Style	TH000-11C	TH00-11C	TH1-11C	TH2-11C	TH2-11C	TH3-11C	TH3-11NBG	TH4-11C	TH4-11C
12. Cover Plate Screw	TH000-12	TH00-12	TH00-12	TH00-12	TH00-12	TH00-12	TH00-12	TH00-12	TH00-12
13. Shank Spring	TH000-13	TH00-13	TH1-13	TH2-13	TH2-13	TH3-13	TH3-13	TH4-13	TH4-13NBG
13-2 Retainer	--	TH00-13-2	--	--	--	--	--	--	--
14. Spindle Nut	TH000-14	TH00-14	TH1-14	TH2-14	TH2-14	TH2-14	TH2-14	TH4-14	TH4-14NBG