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

**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

<table>
<thead>
<tr>
<th>SIZE</th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
<th>E</th>
<th>F</th>
<th>G</th>
<th>H</th>
<th>PIPE TAP</th>
<th>CAT. CLUTCH</th>
<th>SHORT CLUTCH</th>
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**RELEASING TAP HOLDER PARTS**

- Pawl Pin
- Spindle
- Set Screw
- Pawl
- Pawl Spring
- Clutch
- Clutch Spring
- Clutch Washer
- Clutch Nut
- Clutch Nut
- Shank Spring
- Clutch Nut
- Clutch Ring
- Body
- Cover Plate (Old Style)
- Cup Style
- Cover Plate Screw
- Shank Nut
- Retainer
- Spindle Nut

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