

Somma

TOOL COMPANY, INC.

**PREMIER TOOLING FOR THE
MANUFACTURING INDUSTRY**

since 1939

TITLE	PAGE	TITLE	PAGE
Broaching, Internal		Reaming	
Swiss Adjustment Free Broach Tool Holders.....	8	ER Collet Floating Reamer Holder	113
Swiss Broaching Heads for ER Collet Chucks	7	DA Collet Floating Reamer Holder	114
Adjustable Broach Tool Holders	10	Bushing Style Adjustable Offset Holder.....	115
CNC Adj. Free Broach Tool Holders	11	VDI Shank ER Collet Floating Reamer Holder.....	114
Index Punch Broaching	17	Morse Taper Shank ER Collet Holder.....	115
Driven Broach Tool Holder for Multi's	11	Solid Carbide Reamers	116-117
Broaches 8mm Dia x 28mm (#SW).....	9	Swiss Mini Shank Tooling	
Broaches: 8mm Dia. x 1-1/4" (#00)	12-14	Series 6 Holders & Diamond Inserts	57-63
Broaches: 1/2" Dia. x 1-3/4" (#2).....	12-14	Series 8 Holders & Diamond Inserts	65,66,76
Broaches: 3/4" Dia. x 2-3/4" (#HD).....	15 & 16	Series 50 Holders & Diamond Inserts	67-69
Gages; Set Up & Go / No Go	16	Series 10 Holders & Triangular Inserts.....	70-71
Broaching, External		Series 16 Holders & Triangular Inserts.....	72-73
External Broach Tool Holders	18	Series 20 Holders & Triangular Inserts.....	74-75
Driven Broach Tool Holder for Multi's	11	Forming & Shaving	
External Broaches	19	RQC Quick Change Resharpenable	20-29
Drilling		Form & Shave Tool System	
Davenport and B&S Drill Holders	118-119	STAI Economical Quick Change	30
Quick Change ER Collet System	120-123	Form Tool System	
ER Collet, Collet Chucks	124-128	Form Tool Calculation Program.....	31
ER Collet Double Ended Collet Chucks	129	Spindle Speed/Surface Feet Calculator	31
DA & TG Collet, Collet Chucks	130-132	Dovetail Form Tool Holders	32-33
Automotive Threaded Shank Collet Chuck	119	Dovetail Form Tool Blanks.....	34-35
Drill Speeder & Air Speeder	133	Dovetail Shave Tool Blanks	36
Solid Carbide Drills	134-138	Dovetail Checking Gages.....	35
Flat Drill Blanks	139	Dovetail Sharpening Fixtures	35
Drill Blanks	139	Davenport Circ. Tools & Holders	38-39
End Working		B&S Circ. Form Tool Holder	40
Davenport Countersink.....	86	B&S Circ. Blanks and Form Tools	41-44
Countersinking	85-90	B&S Universal Tool Post	45
Spot Drilling	84	Rectangular & Square Form Tool Blanks	45
Recess Tool Holders & Tool Blanks	101	Box Turning	
Tube End Forming Tooling	91-93	Tangi-Square Insert Box Turning.....	78-79
Outside Deburring & Chamfering	94-97	Triangular Insert Box Turning	80-81
Inside Deburring & Chamfering	98-99	H.S.S. Tool Bit Box Turning	80-81
Tapping		Rectangular Insert L.H. Box Turning	80-81
Tapping / Re-Tapping 2nd Operation Mach.....	106-107	Carbide Insert Tool Bit for L.H. Turning	77
Tension / Compression & Tension Only.....	108-109	R&L Turning Tools	82-83
ER Collet Tap Holders		Replacement Rolls & Pins.....	77
Non-Releasing Tap Holders.....	110	Endmills	
Releasing Tap Holders	111-112	Solid Carbide.....	181-185
Releasing Acorn Die Holders	112		

TITLE	PAGE	TITLE	PAGE
Cutting-Off		Collets / Tool Holding	
Davenport & B&S Circ. C/O	46-47	ER8 to ER50 Drill Collets	156-160
C/O Blade Holders	47	ER11 to ER40 Tap Collets	161
T-Type C/O Blades	48-50	Erickson® "DA" Drill Collets	162-163
Acme C/O Blades	50	50TG to 150TG Drill Collets	164-167
Johnson Hollow Ground C/O Blades.....	51	50TG to 150TG Tap Collets.....	168
Twin Tip, Empire Style.....	50	Universal® Acura-Flex Drill Collets	155
Square Shank Holders W/ Indexable Inserts	52-53	Universal® Double Taper Drill Collets	161
Dav. & B&S Circ. Indexable Square Insert C/O.....	55	Sandvik® /Balas "C" Series Drill & Tap Collets	169
Indexable Square C/O Inserts	54	5C Collets	170-171
Dav. Circ. Resharpenable Insert C/O Hldr.....	55	R8 Collets	171
Knurling		Bushings / Tool Holding	
Davenport Knurling Tools	102	Split Drill Bushings	142-144
Self Centering Straddle Knurl Tools.....	102	Split Tap Bushings	145
Adjustable Straddle Knurl Tools.....	103	B&S Slotting Bushings	145
Swiss In-Line & T Style Straddle Knurl Tools	104	Type "B" Tool Holder Bushings.....	146-151
Bump Style Single Knurl Tools	105	Type "C" Tool Holder Bushings.....	151
Knurls	102	Type "DD" & "L" Tool Holder Bushings	152
Taper Shank Tooling		Type "LB" & "LBF" Tool Holder Bushings.....	153
Cat. 40 "TG" Collet Chucks	173	Type "J" & "Z" Tool Holder Bushings.....	154
Cat. 40 "ER" & "DA" Collet Chucks	174	Boring Bar Sleeves.....	141
Cat. 40 Balanced Precision Chuck.....	176	Taper Drill Sockets	141
Cat. 40 Straight Shank Adapter.....	177	Workholding	
Cat. 40 Milling Chuck	178	Bar Pullers.....	186-187
Cat. 40 Endmill Adapter.....	179	Balas Master Collets, Master Pushers	188-191
Cat. 50 "ER" & "DA" Collet Chucks	174	& Pads for Warner & Swasey Machines	
Cat. 50 "TG" Collet Chucks	175	Swiss Machine Spindle Collets	192-193
Cat. 50 Balanced Precision Chuck.....	176	Swiss Carbide Lined Guide Bushings	194
Cat. 50 Straight Shank Adapter.....	177	Miscellaneous B&S	
Cat. 50 Milling Chuck	178	Cam Blanks	140
Cat. 50 Endmill Adapter.....	179	Cam Roller & Pins	140
BT40 & 50 Precision & Milling Chucks	178	Deburring Tool for Slotting Attachments	141

Customer Service

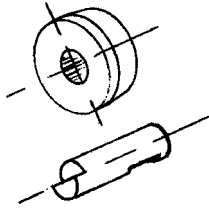
109 Scott Road Waterbury, CT 06705 USA
(203)-753-2114 • Fax (203)-756-5489
Email: sales@sommatool.com

Your local Somma distributor will provide you with prompt service and knowledgeable assistance. We also offer excellent backup support from our factory. Here is a list of people to contact at Somma Tool Company for sales and technical assistance.

SALES / SALES ENGINEERS				BROACHING/ TECHNICAL SUPPORT		QC INSERT TOOLING/ TECHNICAL SUPPORT	
NAME	Ext.#	NAME	Ext.#	NAME	Ext.#	NAME	Ext.#
Matt Ciullo	105	Gina Somma	104	Dick Noti	108	Rob Somma	111
Jerry Somma	106	Raphael Santiago	107	Abel Rodrigues	110	Rick Grante	115

ROLLERS AND PINS FOR BOYAR-SCHULTZ TURNING TOOLS

* Fit all Boyar-Schultz RT, LT, RTC Turning Tools * Made of 52100 Heat Treated Steel * Precision ground all over



TAPERED ROLLS

CAT. NO.	USED ON	O.D.	I.D.	WIDTH
	00RT			
BSR-5020	00LT/00C	5/16	5/32	3/16
BSR-5120	0RT/0LT/0C	1/2	1/4	1/4
BSR-5220	2RT-2LT-2C	5/8	1/4	1/4
BSR-5720	000RT	9/32	1/8	3/16

PINS

CAT. NO.	USED ON	DIA.	LENGTH
	00RT		
BSP-5025	00LT/00C	5/32	17/32
BSP-5125	0RT/0LT/0C	1/4	23/32
BSP-5225	2RT/2LT/2C	1/4	27/32
BSP-5725	000RT	1/8	17/32

ROLLS FOR DOVETAIL SHAVE TOOL HOLDERS

HARDENED 52100 STEEL
- GROUND ALL OVER

Cat. No.	O.D.	I.D.	Width	C'Bore
62-5-5-RL	1"	3/8	11/16	--
62-5-4-RL	1-1/4"	3/8	11/16	--
62-5-5A-RL	1"	1/2	11/16	1/8 x 3/4
62-4-4A-RL	1-1/8"	1/2	11/16	1/8 x 3/4
62-5-4A-RL	1-1/4"	1/2	11/16	1/8 x 3/4



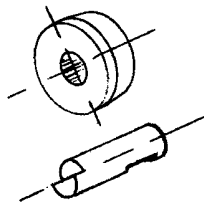
ROLLS FOR SOMMA BOX TOOLS

Cat. No.	O.D.	I.D.	Width
ATT00-6	.250	.125	.156
ATT0-6	.432	.188	.250
ATT2-6	.500	.250	.375

ROLLS FOR SOMMA SHAVE TOOL HOLDERS

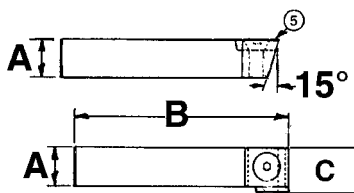
Cat. No.	O.D.	I.D.	Width
QCDS-3A	.875	.312	.375
QCDS-3A-1/2	.875	.312	.500

ROLLER & PIN SETS FOR SOMMA TURNING TOOLS



Cat. No.	O.D.	I.D.	C'Bore	Width	Pin Length
TT00RBR-1	.556	.284	.050 X .375	.250	15/32
TT1RBR-1	.615	.315	.062 X .375	.312	19/32
TT2RBR-1	.740	.378	.067 X .450	.375	23/32
TT3RBR-1	.865	.440	.067 X .560	.375	23/32

RECTANGULAR CARBIDE INSERT HOLDERS FOR LEFT HAND TURNING



- Cut tangentially-not radially
- Ideal 10° front clearance angle - instead of 5° of triangular inserts
- Shave turned diameter for better size control and finish

CAT. NO.		A	B
CIH00-L	Left Hand	5/16	1-7/16
CIH1-L	Left Hand	3/8	2-1/8
CIH2-L	Left Hand	7/16	2-7/16
CIH2A-L	Left Hand	1/2	2-7/16
CIH3-L	Left Hand	5/8	3-1/2

Holders do not include insert

Part No.	TOOL SIZE				
	CIH00 Cat. No.	CIH1 Cat. No.	CIH2 Cat. No.	CIH2A Cat. No.	CIH3 Cat. No.
5. Carbide Insert Grade C-2	CIH00-5-C2	CIH1-5-C2	CIH2-5-C2	CIH2A-5-C2	CIH3-5-C2
5. Carbide Insert Grade C-7	CIH00-5-C7	CIH1-5-C7	CIH2-5-C7	CIH2A-5-C7	CIH3-5-C7
TITANIUM NITRIDE (TIN) COATED INSERTS					
5. Carbide Insert Grade C-2 Titanium Coated	CIH00-5-C2TIN	CIH1-5-C2TIN	CIH2-5-C2TIN	CIH2A-5-C2TIN	CIH3-5-C2TIN
5. Carbide Insert Grade C-7 Titanium Coated	CIH00-5-C7TIN	CIH1-5-C7TIN	CIH2-5-C7TIN	CIH2A-5-C7TIN	CIH3-5-C7TIN

* Carbide inserts available from stock in: GRADE C-2 For brass, aluminum, and light cuts on steel. GRADE C-7 For heavy cuts on steel.

Right Hand holders discontinued.

• Replaced with TSQ style holders - Page 5.

• Inserts available with .015 or .031 corner radius for special applications.

ACCU-SET Turning Tools

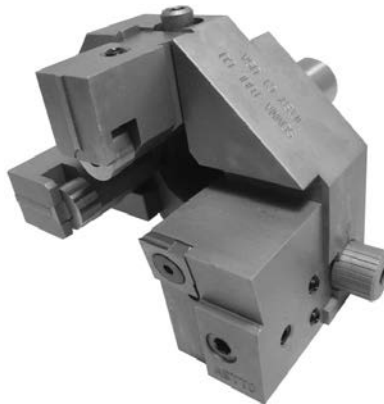
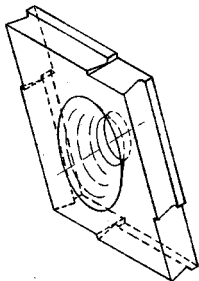
with exclusive TANGI-SQUARE
QUICK CHANGE

Micro-Grain Carbide Inserts

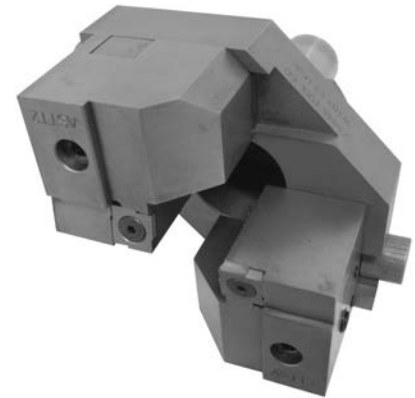
TANGI-SQUARE CARBIDE
INSERTS OUTPERFORM ALL
OTHER INSERTS BECAUSE:

- Quick change - only one easy-to-get-at screw
- Cut tangentially-not radially
- Ideal 10° front clearance angle - instead of 5° of triangular inserts
- Shave turned diameter for better size control and finish
- Built in chip breaker
- Produce square, sharp corners
- Repeatability within .001"
- No need for slide retraction because freer cutting action eliminates scroll lines on most applications.
- 4 right hand cutting edges
- MICRO-GRAIN carbide for longest tool life

The only insert ever designed specifically for screw machine turning tools!



ROLLER BACKREST STYLE
TANGI SQUARE
TURNING TOOLS



BALANCE STYLE
TANGI-SQUARE
TURNING TOOLS



Cat. No. Roller Style	ASTT00	ASTT0	ASTT2
Cat. No. Balance Style	BASTT00	BASTT0	BASTT2
Shank Size	5/8" Dia. x 1-9/32"	3/4" Dia. x 1-1/2"	1" Dia. x 1-15/16"
Insert Series*	TSQ00-.....	TSQ2-....	TSQ2-....
Insert Max. Depth of Cut	3/16"	17/64"	17/64"
Turning Capacities	5/64" to 3/8" Dia. will pass thru shank 25/64" to 1/2" Dia x 1-3/8" Length	5/32" to 1/2" Dia. will pass thru shank 33/64" to 7/8" Dia. x 1-7/8" Length	3/16" to 5/8" Dia. will pass thru shank 41/64" to 1-1/4" Dia. x 2-3/4" Length
Replacement Rolls	ATT00-6	ATT0-6	ATT2-6
Replacement Carbide Pin	ATT00-7	ATT0-7	ATT2-7

*See following page for Insert options

Convert your present Somma Turning Tools to a Tangi-Square Turning Tool with the purchase of the insert slide/s listed below

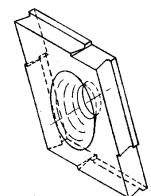
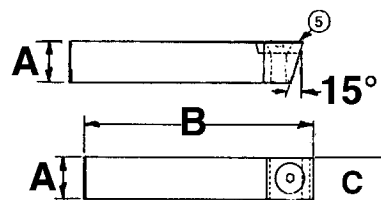
Tangi-Square Slide Cat. No.	ATT00-SCS	ATT0-SCS	ATT2-SCS
Conversion slide for these Somma Cat No's—>	ATT00, ACTT00 AVTT00, BATT00 BACTT00 BAVTT00	ATT0, ACTT0 AVTT0, BATT0 BACTT0 BAVTT0	ATT2, ACTT2 AVTT2, BATT2 BACTT2 BAVTT2

**CONVERT YOUR PRESENT TOOLBIT TURNING TOOLS TO INDEXABLE CARBIDE INSERTS
WITH TANGI-SQUARE CARBIDE INSERT TOOL BIT TYPE HOLDERS.**
THEY WILL REPLACE HIGH SPEED STEEL TOOL BITS IN MOST TURNING TOOLS.

TANGI-SQUARE CARBIDE INSERT HOLDERS FOR RIGHT HAND TURNING

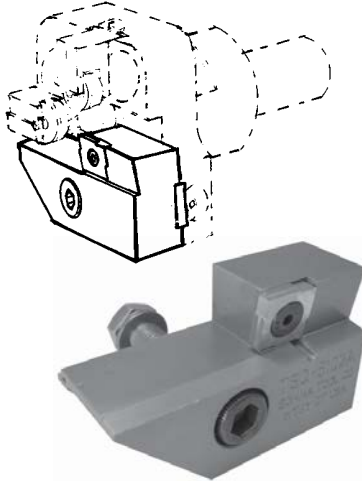
Cat. No.	A	B	C	Insert Series
TSQ000-R	1/4	1-5/16	1/4	TSQ000
TSQ00-R	5/16	1-1/2	3/8	TSQ00
TSQ1-R	3/8	2-1/8	3/8	TSQ00
TSQ2-R	7/16	2-1/2	1/2	TSQ2
TSQ2A-R	1/2	2-1/2	1/2	TSQ2
TSQ3-R	5/8	3-1/2	1/2	TSQ2

Inserts Not Included



The only insert ever designed specifically for screw machine turning tools!

**CONVERT YOUR BOYAR-SCHULTZ RT H.S. TOOLBIT STYLE OR
RTC TRIANGULAR INSERT TURNING TOOLS TO TANGI-SQUARE INSERTS
AND IMPROVE YOUR CUTTING PERFORMANCE BECAUSE:**



- Cut tangentially-not radially
- Freer cutting 10° front clearance angle - instead of 5° of triangular inserts
- No need for slide retraction because freer cutting action eliminates scroll line on most applications.
- Shaves turned diameter for better size control and finish
- 4 right hand cutting edges
- Built in chip breaker
- MICRO-GRAIN carbide for longest life
- Produces square sharp corners
- Repeatability within .001"
- Quick change-only one easy-to-get-at screw

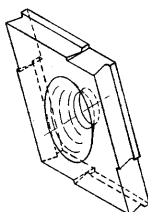
TANGI-SQUARE CARBIDE INSERT CUTTING TOOL SLIDES (INCLUDES INSERT)					
BOYAR-SCHULTZ TOOL SIZE	00RTC	00RT	0RTC	0RT	2RTC/2RT
TANGI-SQUARE COMPLETE CARBIDE INSERT SLIDE	TSQ-51204	TSQ-5002A	TSQ-51304	TSQ-5102A	TSQ-51404
USES INSERT SERIES	TSQ00	TSQ00	TSQ2	TSQ2	TSQ2

TANGI-SQUARE MICROGRAIN CARBIDE INSERTS



**TANGI-SQUARE INSERTS ARE
AVAILABLE IN FOUR STYLES**

- 35° HIGH TOP RAKE FOR LONGEST TOOL LIFE ON STAINLESS AND OTHER DIFFICULT-TO-MACHINE MATERIALS.
 - * SQUARE CORNER
 - * .015 OR .031 CORNER RADIUS
- 5° TOP RAKE FOR MILD MATERIALS
 - * SQUARE CORNER
 - * .015 OR .031 CORNER RADIUS



INSERT STYLE	TSQ00 Series Cat. No.'s	TSQ2 Series Cat. No.'s	TSQ000 Series Cat. No.'s
35° HIGH TOP RAKE SQUARE CORNER	TSQ00-45-MIC	TSQ2-45-MIC	TSQ000-45-MIC
	TSQ00-45-MICTIN	TSQ2-45-MICTIN	TSQ000-45-MICTIN
	TSQ00-45-MICTICN	TSQ2-45-MICTICN	-
	TSQ00-45-MICTIALN	TSQ2-45-MICTIALN	-
35° HIGH TOP RAKE .015 CORNER RADIUS OR .031 CORNER RADIUS	TSQ00-45-015	TSQ2-45-015	TSQ000-45-015
	TSQ00-45-015TIN	TSQ2-45-015TIN	TSQ000-45-015TIN
	TSQ00-45-015TICN	TSQ2-45-015TICN	-
	TSQ00-45-015TIALN	TSQ2-45-015TIALN	-
	TSQ00-45-031	TSQ2-45-031	TSQ000-45-031
	TSQ00-45-031TIN	TSQ2-45-031TIN	TSQ000-45-031TIN
5° TOP RAKE SQUARE CORNER	TSQ00-5-MIC	TSQ2-5-MIC	TSQ000-5-MIC
	TSQ00-5-MICTIN	TSQ2-5-MICTIN	TSQ000-5-MICTIN
	TSQ00-5-MICTICN	TSQ2-5-MICTICN	-
	TSQ00-5-MICTIALN	TSQ2-5-MICTIALN	-
5° TOP RAKE .015 CORNER RADIUS OR .031 CORNER RADIUS	TSQ00-5-015	TSQ2-5-015	TSQ000-5-015
	TSQ00-5-015-TIN	TSQ2-5-015-TIN	TSQ000-5-015TIN
	TSQ00-5-015-TICN	TSQ2-5-015-TICN	-
	TSQ00-5-015-TIALN	TSQ2-5-015-TIALN	-
	TSQ00-5-031	TSQ2-5-031	TSQ000-5-031
	TSQ00-5-031-TIN	TSQ2-5-031-TIN	TSQ000-5-031TIN
TSQ00-5-031-TICN	TSQ2-5-031-TICN	-	
TSQ00-5-031-TIALN	TSQ2-5-031-TIALN	-	
INSERT SCREW	ATT00-17	ATT2-17	TSQ000-2
MAX DEPTH OF CUT PER SIDE	3/16"	17/64"	7/64"

- TIN A GOOD GENERAL PURPOSE COATING FOR METAL CUTTING
- TICN THIS COATING IS RECOMMENDED FOR MACHING HIGH CARBON STEEL, HIGH SILICON ALUMINUMS AND TOOL STEELS
- TIALN FOR MACHINING CAST IRON, HIGH NICKEL AND TITANIUM ALLOYS, HARDENED STEELS AND STAINLESS STEELS. GOOD CHOICE FOR INTERRUPTED APPLICATIONS

ACCU-SET Roller Backrest Turning Tool

FEATURES

- All cutting tool slides are interchangeable.
- All cutting tool slides are adjustable to center to compensate for machine misalignment.
- Screw adjustment of roller backrest slides assure easy, positive setting.
- Extended roller blocks available for supporting on stock O.D. (positioned ahead of the cutting tool)
- Available for left hand operation.
- Micrometer adjustment of cutting tool slide- each graduation = .004" (1MM) on diameter (easily set in between for .001 or less movement.)
- Available for left hand operation.

Shown in 3 styles below - See page 5 for improved Tangi-Square design!

ATT STYLE With H.S.S. Cutting Tool Slide



- Cuts tangentially.

AVTT STYLE With Triangular Carbide Insert Slide

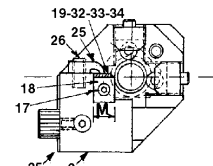
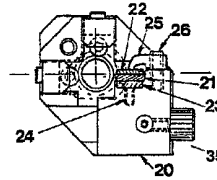
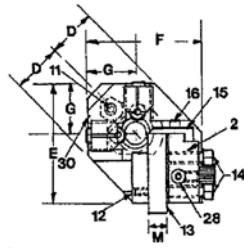
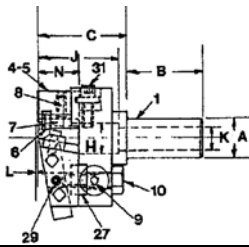


- Triangular carbide insert cuts radially.

ACTT STYLE With Rectangular Carbide Insert Slide



- Only available left hand, right hand tools have been replaced with TANGI-SQUARE ASTT style holder shown on Pg. 5.



Roller Turning Tool	Cat. No.	Cat. No.	Cat. No.
With H.S.S. Cutting Tool Slide	ATT00	ATT0	ATT2
With H.S.S. Cutting Tool Slide LH	ATT00-L	ATT0-L	ATT2-L
With Rectangular Carbide Insert Tool Slide LH	ACTT00-L	ACTT0-L	ACTT2-L
With Triangular Carbide Insert Tool Slide	AVTT00	AVTT0	AVTT2
With Triangular Carbide Insert Tool Slide LH	AVTT00-L	AVTT0-L	AVTT2-L
A	5/8	3/4	1"
B	1-9/32	1-1/2	1-15/16
C	1-17/32	2-3/16	3"
D	13/16	1-3/16	1-3/8
E	1-15/16	2-3/4	3-7/16
F	1-15/16	2-7/8	3-9/16
G	13/16	1-3/8	1-11/16
H	1/2	7/8	1-1/4
J	1-3/8	1-7/8	2-3/4
K	3/8	1/2	5/8
L	3/64	3/32	3/32
M	5/16	3/8	7/16
N	11/16	1-1/16	1-1/2
Turning Capacity	5/64 to 3/8 Dia. x Mach. Cap. 25/64 to 1/2 Dia. x 1-3/8 Lg	5/32 to 1/2 Dia. x Mach. Cap. 33/64 to 7/8 Dia. x 1-7/8 Lg	3/16 to 5/8 Dia. x Mach. Cap. 41/64 to 1-1/4 Dia. x 2-3/4 Lg

Tool Slide Only Replacement	For ATT00 Cat. No.	For ATT0 Cat. No.	For ATT2 Cat. No.
Complete H.S.S. Cutting Tool Slide	ATT00-CTS	ATT0-CTS	ATT2-CTS
Complete H.S.S. Cutting Tool Slide LH	ATT00-CTS-L	ATT0-CTS-L	ATT2-CTS-L
Complete Rectangular Carbide Insert Slide	ATT00-RCS	ATT0-RCS	ATT2-RCS
Complete Rectangular Carbide Insert Slide LH	ATT00-RCS-L	ATT0-RCS-L	ATT2-RCS-L
Complete Triangular Carbide Insert Slide	ATT00-VCS	ATT0-VCS	ATT2-VCS
Complete Triangular Carbide Insert Slide LH	ATT00-VCS-L	ATT0-VCS-L	ATT2-VCS-L
Complete Roller Backrest Slide (Rolls on turned diameter)	ATT00-RBS	ATT0-RBS	ATT2-RBS
Complete Extended Roller Backrest Slide (Rolls on bar stock)	ATT00-ERB	ATT0-ERB	ATT2-ERB

Parts for Tool Numbers	ATT00 AVTT00 ACTT00-L	ATT00-L AVTT00-L ACTT00-L	ATT0 AVTT0 ACTT0-L	ATT0-L AVTT0-L ACTT0-L	ATT2 AVTT2 ACTT2-L	ATT2-L AVTT2-L ACTT2-L
Part No.	Cat. No.	Cat. No.	Cat. No.	Cat. No.	Cat. No.	Cat. No.
1. Body	ATT00-1	ATT00-1L	ATT0-1	ATT0-1L	ATT2-1	ATT2-1L
1. Body LH	ATT00-1L	ATT00-1L	ATT0-1L	ATT0-1L	ATT2-1L	ATT2-1L
2. H.S.S. Tool Slide	ATT00-2	ATT00-2	ATT0-2	ATT0-2	ATT2-2	ATT2-2
2. H.S.S. Tool Slide LH	ATT00-2L	ATT00-2L	ATT0-2L	ATT0-2L	ATT2-2L	ATT2-2L
3. Rectangular Insert Tool Slide LH	ATT00-3L	ATT00-3L	ATT0-3L	ATT0-3L	ATT2-3L	ATT2-3L
4. Roller Block	ATT00-4	ATT00-4	ATT0-4	ATT0-4	ATT2-4	ATT2-4
5. Extended Roller Block	ATT00-5	ATT00-5	ATT0-5	ATT0-5	ATT2-5	ATT2-5
6. Roll	ATT00-6	ATT00-6	ATT0-6	ATT0-6	ATT2-6	ATT2-6
7. Carbide Roll Pin	ATT00-7	ATT00-7	ATT0-7	ATT0-7	ATT2-7	ATT2-7
8. Pin Screw	ATT00-8	ATT00-8	ATT0-8	ATT0-8	ATT2-8	ATT2-8
9. Micrometer Screw	ATT00-9	ATT00-9	ATT0-9	ATT0-9	ATT2-9	ATT2-9
10. H.S.S. Tool Slide Lock Screw	ATT00-10	ATT00-10	ATT0-10	ATT0-10	ATT2-10	ATT2-10
11. Roller Slide Clamp Lock Screw	ATT00-10	ATT00-10	ATT0-10	ATT0-10	ATT2-10	ATT2-10
12. Rocker Screw	ATT00-12	ATT00-12	ATT0-12	ATT0-12	ATT2-12	ATT2-12
13. H.S.S. Cutting Tool	TT00-8	TT00-8	TT0-8	TT0-8	TT2-8	TT2-8
14. Tool Lock Screw	ATT00-14	ATT00-14	ATT0-14	ATT0-14	ATT2-14	ATT2-14
15. H.S.S. Chip Breaker	ATT00-15	ATT00-15	ATT0-15	ATT0-15	ATT2-15	ATT2-15
16. Chip Breaker Screw	ATT00-16	ATT00-16	ATT0-16	ATT0-16	ATT2-16	ATT2-16
17. Rectangular Insert Screw	ATT00-17	ATT00-17	ATT0-17	ATT0-17	ATT2-17	ATT2-17
18. Rectangular Inserts Grade C-2 Carbide	CIH00-5-C2	CIH00-5-C2	CIH1-5-C2	CIH1-5-C2	CIH2-5-C2	CIH2-5-C2
18. Rectangular Inserts Grade C-7 Carbide	CIH00-5-C7	CIH00-5-C7	CIH1-5-C7	CIH1-5-C7	CIH2-5-C7	CIH2-5-C7
19. Rectangular Carbide Chip Breaker	ATT00-19	ATT00-19	ATT0-19	ATT0-19	ATT2-19	ATT2-19
20. Triangular Insert Tool Slide	ATT00-20	ATT00-20	ATT0-20	ATT0-20	ATT2-20	ATT2-20
20. Triangular Insert Tool Slide LH	ATT00-20L	ATT00-20L	ATT0-20L	ATT0-20L	ATT2-20L	ATT2-20L
21. Triangular Inserts Grade C-2 Carbide	ATT00-21-C2	ATT00-21-C2	ATT0-21-C2	ATT0-21-C2	ATT2-21-C2	ATT2-21-C2
21. Triangular Inserts Grade C-7 Carbide	ATT00-21-C7	ATT00-21-C7	ATT0-21-C7	ATT0-21-C7	ATT2-21-C7	ATT2-21-C7
22. Triangular Carbide Chip Breaker	ATT00-22	ATT00-22	ATT0-22	ATT0-22	ATT2-22	ATT2-22
23. Triangular Anvil	ATT00-23	ATT00-23	ATT0-23	ATT0-23	ATT2-23	ATT2-23
24. Triangular Anvil Screw	ATT00-24	ATT00-24	ATT0-24	ATT0-24	ATT2-24	ATT2-24
25. Carbide Insert Clamp	ATT00-25	ATT00-25	ATT0-25	ATT0-25	ATT2-25	ATT2-25
26. Carbide Insert Clamp Screw	ATT00-26	ATT00-26	ATT0-26	ATT0-26	ATT2-26	ATT2-26
27. Slide Plate	ATT00-27	ATT00-27	ATT0-27	ATT0-27	ATT2-27	ATT2-27
27. Slide Plate LH	ATT00-27L	ATT00-27L	ATT0-27L	ATT0-27L	ATT2-27L	ATT2-27L
28. Adjusting Stud	ATT00-28	ATT00-28	ATT0-28	ATT0-28	ATT2-28	ATT2-28
29. Adj. Stud Lock Screw	ATT00-12	ATT00-12	ATT0-12	ATT0-12	ATT2-12	ATT2-12
30. Roller Block Clamp	ATT00-30	ATT00-30	ATT0-30	ATT0-30	ATT2-30	ATT2-30
31. Roller Block Adj. Screw	ATT00-31	ATT00-31	ATT0-31	ATT0-31	ATT2-31	ATT2-31
32. Backup Plate & Screw	ATT00-32	ATT00-32	ATT0-32	ATT0-32	ATT2-32	ATT2-32
33. Triangular Chip Breaker Adjuster	ATT00-33	ATT00-33	ATT0-33	ATT0-33	ATT2-33	ATT2-33
34. Breaker Adj Screw	ATT00-34	ATT00-34	ATT0-34	ATT0-34	ATT2-34	ATT2-34
35. Slide Clamp Screw	ATT00-35	ATT00-35	ATT0-35	ATT0-35	ATT2-35	ATT2-35

BOX TURN

ACCU-SET Balance Turning Tool

Shown in 3 styles below - See page 5 for improved Tangi-Square design!

FEATURES

- All cutting tool slides are interchangeable. (see parts list). Converts from H.S.S. to carbide in seconds.
- All cutting tool slides are adjustable to center to compensate for machine misalignment.
- Micrometer adjustment of cutting tool slides- each graduation = .004" (1MM) on diameter (easily set in between for .001 or less move ment.)
- Fine adjustment of H.S.S. cutting tool provided by rocker screw.
- Available for left hand operation.



BATT STYLE
With H.S.S. Cutting Tool Slides



BAVTT STYLE
With Triangular Carbide Insert Slides

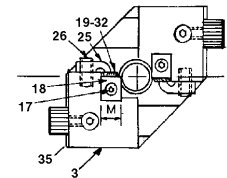
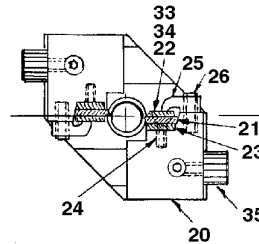
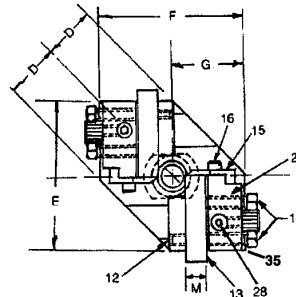
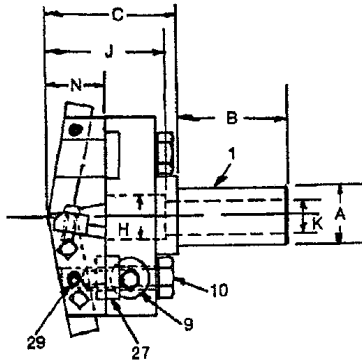


BACTT STYLE
With Rectangular Carbide Insert Slides



- Triangular carbide Inserts cut radially.

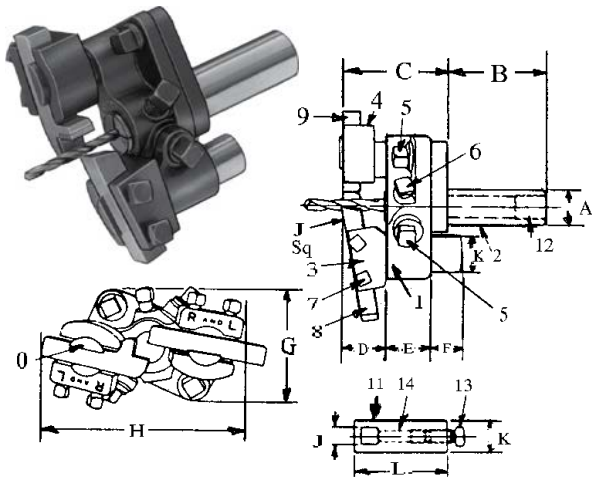
- Only available left hand, right hand tools have been replaced with TANGI-SQUARE BASTT style holder. Page 5.



Balance Turning Tool	Cat. No.	Cat. No.	Cat. No.
With H.S.S. Cutting Tool Slide	BATT00	BATT0	BATT2
With H.S.S. Cutting Tool Slide LH	BATT00-L	BATT0-L	BATT2-L
With Rectangular Carbide Insert Tool Slide LH	BACTT00-L	BACTT0-L	BACTT2-L
With Triangular Carbide Insert Tool Slide	BAVTT00	BAVTT0	BAVTT2
With Triangular Carbide Insert Tool Slide LH	BAVTT00-L	BAVTT0-L	BAVTT2-L
A	5/8	3/4	1"
B	1-9/32	1-1/2	1-15/16
C	1-17/32	2-3/16	3"
D	13/16	1-3/16	1-3/8
E	2-1/4	2-3/4	3-1/2
F	2-3/8	3"	3-3/4
G	1-3/16	1-1/2	1-7/8
H	5/8	7/8	1-1/4
J	1-7/16	1-7/8	2-3/4
K	3/8	1/2	5/8
M	5/16	3/8	7/16
N	11/16	1-1/16	1-1/2
Turning Capacity	Up to 3/8 Dia. x Mach. Cap.	Up to 1/2 Dia. x Mach. Cap.	Up to 5/8 Dia. x Mach. Cap.
	25/64 to 5/8 Dia. x 1-3/8 Lg	33/64 to 7/8 Dia. x 1-7/8 Lg	41/64 to 1-1/4 Dia. x 2-3/4 Lg

Parts for Tool Numbers	BATT00 BAVTT00 BATT00-L BACTT00-L BAVTT00-L	BATT0 BAVTT0 BACTT0-L BAVTT0-L	BATT2 BAVTT2 BACTT2-L BAVTT2-L
Part No.	Cat. No.	Cat. No.	Cat. No.
1. Body	BATT00-1	BATT0-1	BATT2-1
1. Body LH	BATT00-1L	BATT0-1L	BATT2-1L
2. HSS Tool Slide	ATT00-2	ATT0-2	ATT2-2
2. HSS Tool Slide LH	ATT00-2L	ATT0-2L	ATT2-2L
3. Rectangular Insert Tool Slide LH	ATT00-3L	ATT0-3L	ATT2-3L
9. Micrometer Screw	ATT00-9	ATT0-9	ATT2-9
10. H.S.S. Tool Slide Lock Screw	ATT00-10	ATT0-10	ATT2-10
12. Rocker Screw	ATT00-12	TH000-3	1ANR-6
13. HSS Cutting Tool	TT00-8	TT1-8	TT2-8
14. Tool Lock Screw	ATT00-14	ATT0-14	ATT2-14
15. HSS Chip Breaker	ATT00-15	ATT0-15	ATT2-15
16. Chip Breaker Screw	ATT00-16	ATT0-16	TCOBH00-SCR
17. Rectangular Insert Screw	ATT00-17	ATT0-17	ATT2-17
18. Rectangular Inserts Grade C-2 Carbide	See Page 4 for Specifications	See Page 4 for Specifications	See Page 4 for Specifications
18. Rectangular Inserts Grade C-7 Carbide	See Page 4 for Specifications	See Page 4 for Specifications	See Page 4 for Specifications
19. Rectangular Carbide Chip Breaker	ATT00-19	ATT00-19	ATT2-19
20. Triangular Insert Tool Slide	ATT00-20	ATT0-20	ATT2-20
20. Triangular Insert Tool Slide LH	ATT00-20L	ATT0-20L	ATT2-20L
21. Triangular Inserts Grade C-2 Carbide	ATT00-21-C2	ATT00-21-C2	ATT2-21-C2
21. Triangular Inserts Grade C-7 Carbide	ATT00-21-C7	ATT00-21-C7	ATT2-21-C7
22. Triangular Carbide Chip Breaker	ATT00-22	ATT00-22	ATT2-22
23. Triangular Anvil	ATT00-23	ATT00-23	ATT2-23
24. Triangular Anvil Screw	ATT00-24	ATT00-24	ATT2-24
25. Carbide Insert Clamp	ATT00-25	ATT00-25	ATT2-25
26. Carbide Insert Clamp Screw	ATT00-26	ATT00-26	ATT2-26
27. Slide Plate	ATT00-27	ATT0-27	ATT2-27
27. Slide Plate LH	ATT00-27L	ATT0-27L	ATT2-27L
28. Adjusting Stud	ATT00-28	ATT0-28	ATT2-28
29. Adj Stud Lock Screw	ATT00-12	ATT00-12	1ANR-6
32. Backup Plate & Screw	ATT00-32	ATT0-32	ATT2-32
33. Triangular Chip Breaker Adjuster	ATT00-33	ATT00-33	ATT00-33
34. Breaker Adj Screw	ATT00-34	ATT00-34	ATT00-34
35. Slide Clamp Screw	ATT00-35	ATT0-35	ATT00-12

Tool Slide Only Replacement	For BATT00 Cat. No.	For BATT0 Cat. No.	For BATT2 Cat. No.
Complete H.S.S. Cutting Tool Slide	ATT00-CTS	ATT0-CTS	ATT2-CTS
Complete H.S.S. Cutting Tool Slide LH	ATT00-CTS-L	ATT0-CTS-L	ATT2-CTS-L
Complete Rectangular Carbide Insert Slide LH	ATT00-RCS-L	ATT0-RCS-L	ATT2-RCS-L
Complete Triangular Carbide Insert Slide	ATT00-VCS	ATT0-VCS	ATT2-VCS
Complete Triangular Carbide Insert Slide LH	ATT00-VCS-L	ATT0-VCS-L	ATT2-VCS-L



The most **VERSATILE** tool on the market!...
 Saves many times its cost in tool investment...
 Can be used for either **RIGHT** or **LEFT** hand operations as...

- Carbide backrest box tool
- Balance turning tool
- Drilling & Chamfering tool
- Drilling & turning tool
- Roller backrest support for turret
- Pointing tool
- Knee tool
- Roller Backrest box tool
- Carbide backrest support for turret
- Centering & facing tool
- Floating drill holder
- Two diameter turning tool
- Carbide Insert Tool

FEATURES:

- FULLY ADJUSTABLE (FLOATS)
- EASY TO SET
- REQUIRES LESS CROSS SLIDE CLEARANCE
- NO DRILL PUSHBACK
- RUGGED CONSTRUCTION FOR BOTH ROUGHING AND FINISHING CUTS
- MORE VERSATILE
- ADJUSTABLE DRILL STOP SCREW IN SHANK
- ATTACHMENTS CAN BE MOVED FORWARD OR BACK IN HOLDER TO WORK ON ANY AREA OF PART.



TURNING TOOL SPECIFICATIONS

Size	A Shank	B	C	D		E	F		G	H	J Square	K	L	Hole Dia. for Bushing	Hole Dia. In Shank	Turning Capacity	
				Max.	Min.		Max.	Min.								Diameter	Length
No. 00	5/8	1-1/2	1-3/4	1-1/16	5/8	11/16	7/16	0	1-9/16	3"	5/16	1/2	1-17/32	1/2	3/8	Up to 3/8 3/8 to 1/2	Mach. Cap. 1-3/4
No. 1	3/4	2"	2-3/8	1-1/2	7/8	7/8	5/8	0	2-7/16	4-1/4	3/8	3/4	2"	5/8	1/2	Up to 1/2 1/2 to 3/4	Mach. Cap. 2-1/4
No. 2	1"	2"	3-1/16	1-15/16	1-1/16	1-1/8	7/8	0	3"	5-3/8	7/16	1"	3"	1"	11/16	Up to 11/16 11/16 to 1" over 1"	Mach. Cap. 3-1/16 1-15/16

THESE TOOLS ARE AVAILABLE AS UNIVERSAL TURNING TOOLS WITH ALL ACCESSORIES AS SHOWN:			THESE TOOLS ARE ALSO AVAILABLE AS SPECIAL PURPOSE WITH ONLY THE ACCESSORIES AS SHOWN:			
	1-Carbide Backrest 2-Angular Cutter Holders 1-Straight Cutter Holders	1-Roller Backrest 2-Angular Cutter Holders 1-Straight Cutter Holder	1-Carbide Backrest 1-Angular Cutter Holder	1-Roller Backrest 1-Angular Cutter Holder	2-Angular Cutter Holder for Balance Turning	1-Straight Cutter Holder (Knee Tool)
TOOL SIZE	CAT. NO.	CAT. NO.	CAT. NO.	CAT. NO.	CAT. NO.	CAT. NO.
No. 00	TT00-C	TT00-R	TT00-CA	TT00-RA	TT00-AA	TT00-S
No. 1	TT1-C	TT1-R	TT1-CA	TT1-RA	TT1-AA	TT1-S
No. 2	TT2-C	TT2-R	TT2-CA	TT2-RA	TT2-AA	TT2-S

TURNING TOOL PARTS

Part. No.	Cat. No.	No. 00	Cat. No.	No. 1	Cat. No.	No. 2
1. Body	TT00-1		TT1-1		TT2-1	
2. Shank	TT00-2		TT1-2		TT2-2	
3. Angular cutter holder	TT00-3		TT1-3		TT2-3	
4. Backrest holder	TT00-4		TT1-4		TT2-4	
5. Clamp screw (ea)	TT00-5		TT1-5		TT2-5	
6. Drill holder screws (ea)	TT00-13		TT1-6		TT2-13	
7. Tool adjusting screws(ea)	TT00-7		TT00-13		TT1-6	
8. Cutting tool (ea)	TT00-8		TT1-8		TT2-8	
9. Carbide backrest	TT00-9		TT1-9		TT2-9	
10. Rocker shoes (ea)	TT00-10		TT1-10		TT2-10	
11. Straight cutter holder	TT00-11		TT1-11		TT2-11	
12. Shank screw	TT00-12		TT1-12		TT2-12	
13. Set screw for straight cutter holders	TT00-13		TT1-6		TT2-13	
14. Binder pin for straight cutter holders	TT00-14		TT1-14		TT2-14	
15. Double end wrench	TT00-15		TT00-15		TT2-15	

BOX TURN

COMPLETE ROLLER BACKRESTS

Roller backrests can be used advantageously for many support applications where carbide backrests are not satisfactory. Precision rollers and pins rotate freely and give sturdy support on even the heaviest cuts.



SHANK DIA	FITS	CAT. NO.	MIN. DIA. THAT CAN BE TURNED
1/2"	00	TT00-RBR	1/8"
3/4"	1	TT1-RBR	1/8"
1"	2	TT2-RBR	3/16"

ROLLER BACKREST PARTS

Size	TT00-RBR	TT1-RBR	TT2-RBR
Part No.	Cat. No.	Cat. No.	Cat. No.
1. Roller and Pin Sets*	TT00RBR-1	TT1RBR-1	TT2RBR-1
2. Roller Shank	TT00RBR-2	TT1RBR-2	TT2RBR-2
3. Roller Clamp	TT00RBR-3	TT1RBR-3	TT2RBR-3
4. Clamp Screw	TT00-5	TT1-5	TT2-5

*Roller and pin sets consist of 2 rolls and 2 pins

COMPLETE CARBIDE BACKRESTS



The extremely hard surface of the carbide backrests will not pick up metal or mar the surface of the work with scratches or blisters.

SHANK DIA	FITS	CAT. NO.	MIN. DIA. THAT CAN BE TURNED
1/2"	00	TT00-CBR	1/16"
3/4"	1	TT1-CBR	1/16"
1"	2	TT2-CBR	1/16"

The completed carbide backrest consists of the following assembly of parts as listed on page 9.

- | | |
|-------------------------------|--------------------------|
| 1 No. 4 Backrest holder | 1 No. 9 Carbide backrest |
| 2 No. 7 Tool adjusting screws | 1 No. 10 Rocker shoe |

COMPLETE ANGULAR CUTTER HOLDERS



SHANK DIA	FITS	CAT. NO.
1/2"	00	TT00-ACH
3/4"	1	TT1-ACH
1"	2	TT2-ACH

The complete angular cutter holder consists of the following assembly of parts as listed on page 9.

- | | |
|-------------------------------|----------------------|
| 1 No. 3 Angular cutter holder | 1 No. 8 Cutting tool |
| 2 No. 7 Tool adjust screws | 1 No. 10 Rocker shoe |

OFFSET TOOL HOLDER



May be used for either right or left hand operations as:

- Carbide Backrest for Turret
- Roller Backrest for Turret
- Knee Tool
- Drill and Chamfer Tool
- Drill and Turn Tool
- Center and Face Tool

When used in conjunction with standard Somma R & L turning tool attachments as shown below.



With Roller Backrest*



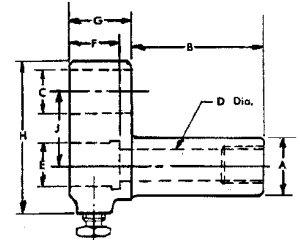
With Carbide Backrest*



With Angular Cutter Holder*



With Straight Cutter Holder*



TOOL NO.	OTH00	OTH1	OTH2
A	5/8	3/4	1"
B	1-1/2	2"	2"
C	1/2	3/4	1"
D	3/8	1/2	11/16
E	1/2	5/8	1"
F	9/16	3/4	7/8
G	11/16	7/8	1-1/8
H	1-11/16	2-3/16	3"
J	13/16	1"	1-5/16

COMPLETE STRAIGHT CUTTER HOLDERS



SHANK DIA	FITS	CAT. NO.
1/2"	00	TT00-SCH
3/4"	1	TT1-SCH
1"	2	TT2-SCH

Complete straight cutter holder consists of the following assembly of parts as listed on page 9.

- | | |
|---------------------------------|---|
| 1 No. 11 Straight cutter holder | 1 No. 13 Set Screw for straight holder |
| 1 No. 8 Cutting tool | 1 No. 14 Binder pin for straight holder |

Somma

Broaching

Form & Shave

Dovetail Blanks

Cut Off

Swiss Turn

Box Turn

End Working

Knurling

Tapping

Reaming

Drilling

Tool Bushings

Tool Collets

V-Flange Collet Chucks

Endmills

Workholding

and More

Somma
TOOL CO., INC.

109 Scott Road

Waterbury, CT 06705 USA

(203) 753-2114 ■ FAX (203) 756-5489

www.sommatool.com ■ EMAIL sales@sommatool.com

COPYRIGHT © 2017

MADE IN U.S.A.

