

Somma

TOOL COMPANY, INC.

**PREMIER TOOLING FOR THE
MANUFACTURING INDUSTRY**

since 1939

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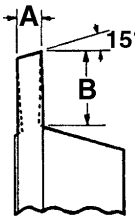
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Customer Service

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(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



- For straight cutting-off
- **Carbide tipped tools** are supplied for right hand cutting, for left hand cutting add -L to the part number listed. All other choices have a "U" shaped gash for cutting in either direction.
- Side clearance ground
- Available with side pinholes
- Available with 23 degree C/O angle for non-ferrous metals
- Available with TIN and other coatings

CIRCULAR PLAIN CUT-OFF TOOLS FOR #0 B&S (1-3/4" DIA., 1/4" WIDE WITH 3/8-16 THREAD)

A	B	M2 PART#	T15PM PART#	3-LIP C2 CARB. TIPPED PART#	C2 SOLID CARBIDE PART#
.030	1/8	00P3	00P3V	00P3-CT	
.040	3/16	00P4	00P4V	00P4-CT	00P4-SC
.050	7/32	00P5	00P5V	00P5-CT	
.060	1/4	00P6	00P6V	00P6-CT	00P6-SC
.070	1/4	00P7	00P7V	00P7-CT	
.080	1/4	00P8	00P8V	00P8-CT	00P8-SC
.100	1/4	00P10	00P10V	00P10-CT	00P10-SC

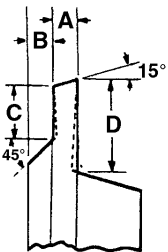
CIRCULAR PLAIN CUT-OFF TOOLS FOR #0 B&S (2-1/4" DIA., 5/16" WIDE WITH 1/2-13 THREAD)

A	B	M2 PART#	T15PM PART#	3-LIP C2 CARB. TIPPED PART#	C2 SOLID CARBIDE PART#
.040	3/16	0P4	0P4V	0P4-CT	
.050	7/32	0P5	0P5V	0P5-CT	
.060	1/4	0P6	0P6V	0P6-CT	0P6-SC
.070	5/16	0P7	0P7V	0P7-CT	
.080	5/16	0P8	0P8V	0P8-CT	0P8-SC
.090	3/8	0P9	0P9V	0P9-CT	
.100	3/8	0P10	0P10V	0P10-CT	0P10-SC
.120	3/8	0P12	0P12V	0P12-CT	0P12-SC

CIRCULAR PLAIN CUT-OFF TOOLS FOR #2 B&S (3" DIA., 3/8" WIDE WITH 5/8-11 THREAD)

A	B	M2 PART#	T15PM PART#	3-LIP C2 CARB. TIPPED PART#	C2 SOLID CARBIDE PART#
.060	5/16	2P6	2P6V	2P6-CT	
.080	7/16	2P8	2P8V	2P8-CT	2P8-SC
.100	9/16	2P10	2P10V	2P10-CT	2P10-SC
.120	5/8	2P12	2P12V	2P12-CT	2P12-SC
.140	11/16	2P14	2P14V	2P14-CT	2P14-SC

CUT OFF



- For cutting-off and chamfering
- **Carbide tipped tools** are supplied for right hand cutting, for left hand cutting add -L to the part number listed. All other choices have a "U" shaped gash for cutting in either direction.
- Side clearance ground
- Available with side pinholes
- Available with 23 degree C/O angle for non-ferrous metals
- Available with TIN and other coatings



CIRCULAR CUT-OFF & CHAMFER TOOLS FOR #0 B&S (1-3/4" DIA., 1/4" WIDE WITH 3/8-16 THREAD)

A	B	C	D	M2 PART#	T15PM PART#	3-LIP C2 CARB. TIPPED PART#
.030	.030	3/64	1/4	00C3	00C3V	00C3-CT
.040	.040	5/64	1/4	00C4	00C4V	00C4-CT
.050	.050	7/64	1/4	00C5	00C5V	00C5-CT
.060	.060	9/64	1/4	00C6	00C6V	00C6-CT
.070	.070	11/64	1/4	00C7	00C7V	00C7-CT
.080	.080	13/64	1/4	00C8	00C8V	00C8-CT

CIRCULAR CUT-OFF & CHAMFER TOOLS FOR #2 B&S (3" DIA., 3/8" WIDE WITH 5/8-11 THREAD)

A	B	C	D	M2 PART#	T15PM PART#	3-LIP C2 CARB. TIPPED PART#
.060	.060	1/8	3/8	2C6	2C6V	2C6-CT
.070	.070	3/16	7/16	2C7	2C7V	2C7-CT
.080	.080	1/4	1/2	2C8	2C8V	2C8-CT
.090	.090	5/16	9/16	2C9	2C9V	2C9-CT
.100	.100	3/8	9/16	2C10	2C10V	2C10-CT
.110	.110	7/16	5/8	2C11	2C11V	2C11-CT
.120	.120	1/2	5/8	2C12	2C12V	2C12-CT
.140	.140	9/16	11/16	2C14	2C14V	2C14-CT

CIRCULAR CUT-OFF & CHAMFER TOOLS FOR #0 B&S (2-1/4" DIA., 5/16" WIDE WITH 1/2-13 THREAD)

A	B	C	D	M2 PART#	T15PM PART#	3-LIP C2 CARB. TIPPED PART#
.040	.040	5/64	5/16	0C4	0C4V	0C4-CT
.050	.050	7/64	5/16	0C5	0C5V	0C5-CT
.060	.060	9/64	5/16	0C6	0C6V	0C6-CT
.070	.070	11/64	3/8	0C7	0C7V	0C7-CT
.080	.080	7/32	3/8	0C8	0C8V	0C8-CT
.090	.090	9/32	3/8	0C9	0C9V	0C9-CT
.100	.100	11/32	3/8	0C10	0C10V	0C10-CT

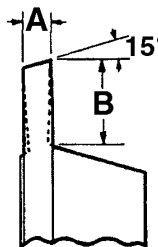
FISHTAIL (TUBING) CUT-OFF TOOLS

Somma can supply any of the above standard tools to "fishtail" shape for cutting tubing. The fishtail shape produces a clean cutoff on both the front and back of the part. It avoids the problem of material being rolled into and closing the front end of the hole.



CIRCULAR CUT-OFF & CHAMFER TOOLS To Your Specifications

Prices on application, specify "A", "B", "C", and "D" dimensions, quantity, machine size, steel and type tool desired.



CIRCULAR PLAIN CUT-OFF TOOLS FOR DAVENPORT MACHINES (CAN ALSO BE USED ON 7/16" ACME AND 9/16" CONE MACHINES)

A	B	M2 PART#	T15PM PART#	3-LIP C2 CARB. TIPPED PART#	SOLID C2 CARBIDE PART#
.030	3/32	DP030	DP030V	DP030-CT	
.040	1/8	DP040	DP040V	DP040-CT	
.050	3/16	DP050	DP050V	DP050-CT	DP050-SC
.060	7/32	DP060	DP060V	DP060-CT	
.070	1/4	DP070	DP070V	DP070-CT	DP070-SC
.080	9/32	DP080	DP080V	DP080-CT	
.090	9/32	DP090	DP090V	DP090-CT	DP090-SC



- For straight cutting-off
- Side clearance ground
- All with side pinholes
- Available with 23 degree C/O angle for non-ferrous metals
- Available with TIN and other coatings

"T" CUT-OFF BLADE HOLDER FOR DAVENPORT

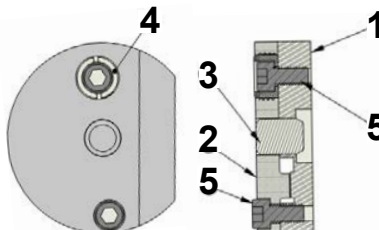
This Cut-Off Blade Holder can be mounted in the circular form tool position on the Davenport Machine and holds standard 1/2" high "T" Type Cut-Off Blades.

Cat. No.
TCOBH-DAV

EXCLUSIVE ADJUSTMENT FEATURE
MAKES COMPENSATION FOR
DIFFERENT BLADE WIDTHS FAST AND
EASY

- * ELIMINATES NEED FOR WASHERS OR SPACERS
- * HOLDS BLADES MORE SECURELY
- * HOLDER LASTS LONGER

(FOR STANDARD BLADES TO FIT THIS HOLDER SEE PAGES 47 & 48).



Part No.	Cat. No.
1. Body	TCOBH-DAV-1
2. Clamp	TCOBH-DAV-2
3. Adjustment Screw	TCOBH-DAV-3
4. Center Stud	TCOBH-DAV-4
5. Clamp Screws	ATTO-16

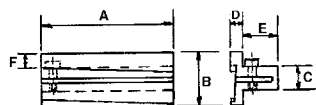
CUT-OFF BLADE HOLDERS

- Fits R & L Universal Tool Post
- Can also be used on turret lathe tool posts
- Forward rotation holder can be used on either front or rear side.
- Reverse rotation holder can be used on either front or rear side
- Entire holder can be removed for tool resharping without losing setting.
- TCOBH-ACCU is rectangular and does not have projection "C" and "E".



HOLDERS FOR T-TYPE BLADES

TOOL NO.	ROTATION	BLADE HEIGHT
TCOBH00-F	FORWARD	1/2
TCOBH00-R	REVERSE	1/2
TCOBH1-F	FORWARD	11/16
TCOBH1-R	REVERSE	11/16
TCOBH2-F	FORWARD	11/16
TCOBH2-R	REVERSE	11/16
TCOBH-ACCU	FORWARD	1/2

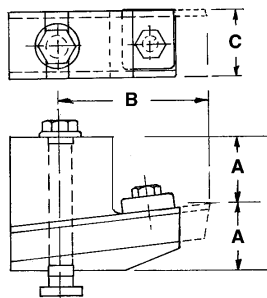


CUT-OFF BLADE HOLDER SPECIFICATIONS

Size	A	B	C	D	E	F
No. 00	2-1/2	1"	3/8	1/4	1/2	5/16
No. 1	2-3/4	1-1/8	1/2	1/4	3/4	9/32
No. 2	3"	1-3/16	5/8	5/16	1"	5/16
ACCU	3-1/2	63/64	0	9/16	0	1/4

(FOR STANDARD CUT-OFF BLADES TO FIT THESE HOLDERS SEE PAGES 48 & 49.)

UNIVERSAL CUT-OFF BLADE TOOL POST FOR B&S MACHINES



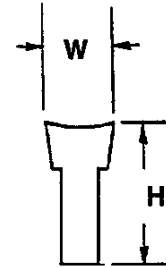
UNIQUE DESIGN:

- ONE TOOL POST TAKES CARE OF ALL POSITIONS BY HOLDING BLADE ON ONE SIDE OR THE OTHER AND BY USING TOOL POST RIGHT SIDE UP OR UPSIDE DOWN
- CAN BE USED ON EITHER FRONT OR REAR SLIDE AND FOR FORWARD OR REVERSE ROTATION
- HOLDS "T" TYPE CUTOFF BLADES (SEE PAGES 6 & 7 FOR BLADES TO FIT THESE HOLDERS)
- RUGGED CONSTRUCTION
- REVERSIBLE CLAMP BLOCK HOLDS BLADE SECURELY ON EITHER SIDE

CAT. NO.	A	B	C	BLADE
BLTP-00	1"	2-3/16	1"	1/2
BLTP-0	1-5/16	2-3/4	1-1/4	11/16
BLTP-2	1-7/16	3-5/8	1-3/8	11/16



- Ground all over
- Concave ground top
- Blade centered



- M2** - GENERAL PURPOSE WITH EXCELLENT TOUGHNESS
COBALT- HIGHEST HEAT RESISTANCE, HIGHER RPM APPLICATIONS
T15PM - EXCELLENT FOR DIFFICULT TO MACHINE MATERIALS WITH GOOD HEAT RESISTANCE

REF#	SIZE			M2 STEEL ORDERING#	COBALT STEEL ORDERING#	T15PM STEEL ORDERING#
	W	H	L			
P1N	.040	1/2	3-1/2	TBL332	TBL332C	TBL332V
P1	1/16	1/2	4-1/2	TBL432	TBL432C	TBL432V
P2N	5/64	1/2	4-1/2	TBL532	TBL532C	TBL532V
P2	3/32	1/2	4-1/2	TBL632	TBL632C	TBL632V
P3S	1/8	1/2	4-1/2	TBL832	TBL832C	TBL832V
P3N-866	1/16	11/16	5	TBL444	TBL444C	TBL444V
	5/64	11/16	5	TBL544	TBL544C	TBL544V
P3N	3/32	11/16	5	TBL644	TBL644C	TBL644V
P3	1/8	11/16	5	TBL844	TBL844C	TBL844V
P4	5/32	11/16	5	TBL1044	TBL1044C	TBL1044V
P5S	3/16	11/16	5	TBL1244	TBL1244C	TBL1244V
P3W	1/8	3/4	5	TBL848	TBL848C	TBL848V
P4W	5/32	3/4	5	TBL1048	TBL1048C	TBL1048V
P5W	3/16	3/4	5	TBL1248	TBL1248C	TBL1248V
P5X-931	3/32	7/8	6	-	TBL656C	TBL656V
P5X	1/8	7/8	6	TBL856	TBL856C	TBL856V
P5N	5/32	7/8	6	TBL1056	TBL1056C	TBL1056V
P5	3/16	7/8	6	TBL1256	TBL1256C	TBL1256V
P6	1/4	7/8	6	TBL1656	TBL1656C	TBL1656V
P8X	1/8	1-1/8	6-1/2	TBL872	TBL872C	TBL872V
P8N	5/32	1-1/8	6-1/2	TBL1072	TBL1072C	TBL1072V
P8	3/16	1-1/8	6-1/2	TBL1272	TBL1272C	TBL1272V
P9	1/4	1-1/8	6-1/2	TBL1672	TBL1672C	TBL1672V
P10	5/16	1-1/8	6-1/2	TBL2072	TBL2072C	TBL2072V

H.S.S. CUT-OFF BLADE GRINDING OPTIONS:

(FOR THE OPTIONS LISTED, ADD THE SUFFIX LISTED BELOW TO THE ORDERING NUMBER)

- CB = CHIP BREAKER GROOVE GROUND ALONG THE TOP LENGTH OF THE BLADE
- TAPER = SIDE TAPER GROUND FRONT TO BACK ALONG T PORTION OF BLADE

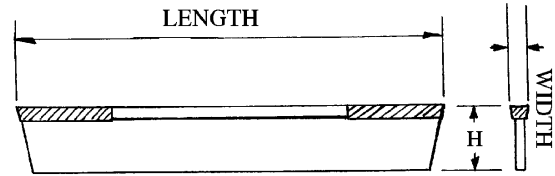
CUT-OFF BLADE COATING OPTIONS:

(FOR THE OPTIONS LISTED, ADD THE SUFFIX LISTED BELOW TO THE ORDERING NUMBER)

- TIN A GOOD GENERAL PURPOSE COATING FOR METAL CUTTING
- TICN THIS COATING IS RECOMMENDED FOR MACHINING 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

*****MANY MORE SPECIALIZED COATINGS AVAILABLE*****

SOLID CARBIDE T-TYPE C/O BLADES ON PAGE 50



MICROGRAIN - INCREASED FEEDS, SHOCK RESISTANT FOR INTERRUPTED CUTS.
C2 CARBIDE - HEAT AND WEAR RESISTANT. FOR CAST IRON & NON-FERROUS METALS AND PLASTICS.
C6 CARBIDE - FOR CARBON AND ALLOY STEELS AT MEDIUM SPEEDS. CAN BE USED AT HIGHER FEED RATES THAN C2.

REF#	W	SIZE H	L	DOUBLE END MICROGRAIN ORDERING#	SINGLE END C2 ORDERING#	DOUBLE END C6 ORDERING#	SINGLE END C6 ORDERING#
P1N	.040	1/2	3-1/2	CTBL332-MIC	CTBL332-C2-SE	CTBL332-C6	CTBL332-C6-SE
P1	1/16	1/2	4-1/2	CTBL432-MIC	CTBL432-C2-SE	CTBL432-C6	CTBL432-C6-SE
P2N	5/64	1/2	4-1/2	CTBL532-MIC	CTBL532-C2-SE	CTBL532-C6	CTBL532-C6-SE
P2	3/32	1/2	4-1/2	CTBL632-MIC	CTBL632-C2-SE	CTBL632-C6	CTBL632-C6-SE
P3S	1/8	1/2	4-1/2	CTBL832-MIC	CTBL832-C2-SE	CTBL832-C6	CTBL832-C6-SE
P3N-866	1/16	11/16	5	CTBL444-MIC	CTBL444-C2-SE	CTBL444-C6	CTBL444-C6-SE
	5/64	11/16	5	CTBL544-MIC	CTBL544-C2-SE	CTBL544-C6	CTBL544-C6-SE
P3N	3/32	11/16	5	CTBL644-MIC	CTBL644-C2-SE	CTBL644-C6	CTBL644-C6-SE
P3	1/8	11/16	5	CTBL844-MIC	CTBL844-C2-SE	CTBL844-C6	CTBL844-C6-SE
P4	5/32	11/16	5	CTBL1044-MIC	CTBL1044-C2-SE	CTBL1044-C6	CTBL1044-C6-SE
P5S	3/16	11/16	5	CTBL1244-MIC	CTBL1244-C2-SE	CTBL1244-C6	CTBL1244-C6-SE
P3W	1/8	3/4	5	CTBL848-MIC	CTBL848-C2-SE	CTBL848-C6	CTBL848-C6-SE
P4W	5/32	3/4	5	CTBL1048-MIC	CTBL1048-C2-SE	CTBL1048-C6	CTBL1048-C6-SE
P5W	3/16	3/4	5	CTBL1248-MIC	CTBL1248-C2-SE	CTBL1248-C6	CTBL1248-C6-SE
P5X-931	3/32	7/8	6	CTBL656-MIC	-	-	-
P5X	1/8	7/8	6	CTBL856-MIC	CTBL856-C2-SE	CTBL856-C6	CTBL856-C6-SE
P5N	5/32	7/8	6	CTBL1056-MIC	CTBL1056-C2-SE	CTBL1056-C6	CTBL1056-C6-SE
P5	3/16	7/8	6	CTBL1256-MIC	CTBL1256-C2-SE	CTBL1256-C6	CTBL1256-C6-SE
P6	1/4	7/8	6	CTBL1656-MIC	CTBL1656-C2-SE	CTBL1656-C6	CTBL1656-C6-SE
P8X	1/8	1-1/8	6-1/2	CTBL872-MIC	CTBL872-C2-SE	CTBL872-C6	CTBL872-C6-SE
P8N	5/32	1-1/8	6-1/2	CTBL1072-MIC	CTBL1072-C2-SE	CTBL1072-C6	CTBL1072-C6-SE
P8	3/16	1-1/8	6-1/2	CTBL1272-MIC	CTBL1272-C2-SE	CTBL1272-C6	CTBL1272-C6-SE
P9	1/4	1-1/8	6-1/2	CTBL1672-MIC	CTBL1672-C2-SE	CTBL1672-C6	CTBL1672-C6-SE
P10	5/16	1-1/8	6-1/2	CTBL2072-MIC	CTBL2072-C2-SE	CTBL2072-C6	CTBL2072-C6-SE

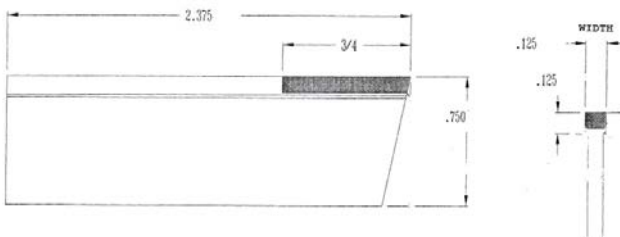
CUT-OFF BLADE COATING OPTIONS:

(FOR THE OPTIONS LISTED, ADD THE SUFFIX LISTED BELOW TO THE ORDERING NUMBER)

- 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 MACHING CAST IRON, HIGH NICKEL AND TITANIUM ALLOYS, HARDENED STEELS AND STAINLESS STEELS. GOOD CHOICE FOR INTERRUPTED APPLICATIONS

*****MANY MORE SPECIALIZED COATINGS AVAILABLE*****

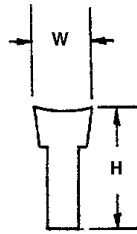
MICRO-GRAIN CARBIDE TIPPED / SHORT LENGTH T-TYPE CUT-OFF BLADES



CAT. NO.	WIDTH	HEIGHT	LENGTH	"A"
CTBL848-MIC-2-3/8	1/8	3/4	2-3/8"	3/4
CTBL1048-MIC-2-3/8	5/32	3/4	2-3/8"	3/4
CTBL1248-MIC-2-3/8	3/16	3/4	2-3/8"	3/4

SOLID CARBIDE T-TYPE C/O BLADES ON NEXT PAGE

SOLID CARBIDE T-TYPE CUT-OFF BLADES



Tools are supplied ready for use with cut-off angles sharpened on both ends so that tools can be used on front or rear slide and for either right or left hand operations.

CAT NO.	W	H	LENGTH	REF. NO.
SCBL332	3/64	1/2	4"	P-1-N
SCBL432	1/16	1/2	4"	P-1
SCBL532	5/64	1/2	4"	P-2-N
SCBL632	3/32	1/2	4"	P-2
SCBL832	1/8	1/2	4"	P-3-S
SCBL444	1/16	11/16	4"	P-3N-866
SCBL644	3/32	11/16	4"	P-3-N
SCBL844	1/8	11/16	4"	P-3
SCBL1244	3/16	11/16	4"	P-5-S

LOW COST!
MORE PIECES PER BLADE!
 Longer wear, less galling, better finish,
 higher speeds than high-speed steels.
PLUS greater rigidity and up to 10 times the
 resharpenable tool life of carbide tipped tools.

CUT-OFF BLADE COATING OPTIONS:

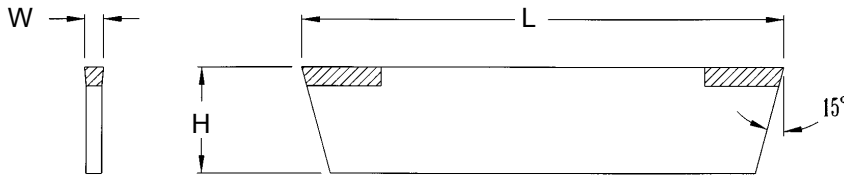
(FOR THE OPTIONS LISTED, ADD THE SUFFIX LISTED BELOW TO THE ORDERING NUMBER)

- TIN A GOOD GENERAL PURPOSE COATING FOR METAL CUTTING
- TICN THIS COATING IS RECOMMENDED FOR MACHINING 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

CUT OFF

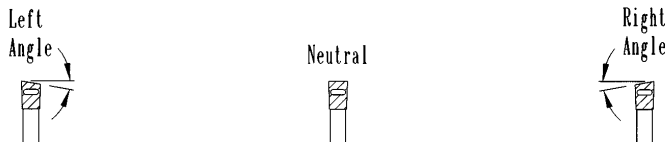
EMPIRE® TWIN-TIP® STYLE CUT-OFF BLADES

Call Somma Tool for a quote!



Specify either the complete Empire® part number or the following:

- 1) Height, Width, and Length
- 2) Front C/O Angle (Ex. 4° left angle)
- 3) Carbide Grade (Ex. C2)
- 4) Coating Type (if applicable)

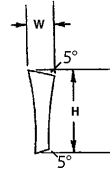


ACME "B" TYPE CUT-OFF BLADES 7° BEVELED



W	H	L	REF. NO	T15PM H.S.S CAT. NO.	MICRO-GRAIN CARBIDE TIPPED CAT. NO.
.040	1/2	5-3/4	B-17	ABL332V	ABL332-MIC
1/16	1/2	5-3/4	B-1	ABL432V	ABL432-MIC
3/32	1/2	5-3/4	B-2	ABL632V	ABL632-MIC
1/8	1/2	5-3/4	B-5	ABL832V	ABL832-MIC
3/32	13/16	7-3/16	B-3	ABL652V	ABL652-MIC
1/8	13/16	7-3/16	B-6	ABL852V	ABL852-MIC
5/32	13/16	7-3/16	B-8	ABL1052V	ABL1052-MIC
3/16	13/16	7-3/16	B-9	ABL1252V	ABL1252-MIC
1/4	13/16	7-3/16	B-11	ABL1652V	ABL1652-MIC
1/8	1"	8-1/4	B-7	ABL864V	ABL864-MIC
3/16	1"	8-1/4	B-10	ABL1264V	ABL1264-MIC
1/4	1"	8-1/4	B-12	ABL1664V	ABL1664-MIC
1/4	1-1/4	9"	B-13	ABL1680V	ABL1680-MIC

JCO (JOHNSON STYLE) HOLLOW GROUND CUT-OFF BLADES - H.S.S.



CUT-OFF ANGLE HAS TO BE SHARPENED BEFORE USING TO SUIT INDIVIDUAL APPLICATION.

- Ground all over

- M2** - GENERAL PURPOSE WITH EXCELLENT TOUGHNESS
- COBALT-** HIGHEST HEAT RESISTANCE, HIGHER RPM APPLICATIONS
- T15PM** - EXCELLENT FOR DIFFICULT TO MACHINE MATERIALS WITH GOOD HEAT RESISTANCE

W	H	L	M2 STEEL ORDERING#	COBALT STEEL ORDERING#	T15PM STEEL ORDERING#
.035	1/2	4-1/2	BL232	--	--
3/64	1/2	4-1/2	BL332	BL332C	BL332V
1/16	1/2	4-1/2	BL432	BL432C	BL432V
5/64	1/2	4-1/2	BL532	BL532C	BL532V
3/32	1/2	4-1/2	BL632	BL632C	BL632V
1/8	1/2	4-1/2	BL832	BL832C	BL832V
3/64	11/16	5"	--	--	BL344V
1/16	11/16	5"	BL444	BL444C	BL444V
3/32	11/16	5"	BL644	BL644C	BL644V
1/8	11/16	5"	BL844	BL844C	BL844V
5/32	11/16	5"	BL1044	BL1044C	BL1044V
3/16	11/16	5"	BL1244	BL1244C	BL1244V
1/4	11/16	5"	BL1644	BL1644C	BL1644V
1/16	13/16	6"	BL452	BL452C	BL452V
3/32	13/16	6"	BL652	BL652C	BL652V
1/8	13/16	6"	BL852	BL852C	BL852V
5/32	13/16	6"	BL1052	BL1052C	BL1052V
3/16	13/16	6"	BL1252	BL1252C	BL1252V
1/4	13/16	6"	BL1652	BL1652C	BL1652V

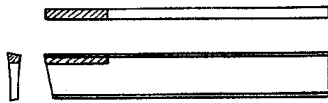
CUT-OFF BLADE COATING OPTIONS:

(FOR THE OPTIONS LISTED, ADD THE SUFFIX LISTED BELOW TO THE ORDERING NUMBER)

- TIN** A GOOD GENERAL PURPOSE COATING FOR METAL CUTTING
- TICN** THIS COATING IS RECOMMENDED FOR MACHINING 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

JCO (JOHNSON STYLE) HOLLOW GROUND CUT-OFF BLADES - CARBIDE TIPPED

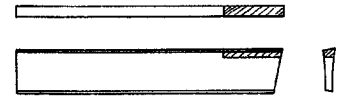
MICROGRAIN CARBIDE- INCREASED FEEDS, SHOCK RESISTANT FOR INTERRUPTED CUTS.



STYLE "Y"
FOR USE ON: FRONT SLIDE
R.H. / REAR SLIDE R.H. OR
VERTICAL SLIDE L.H.

CUT-OFF ANGLE HAS TO BE SHARPENED BEFORE USING TO SUIT INDIVIDUAL APPLICATION.

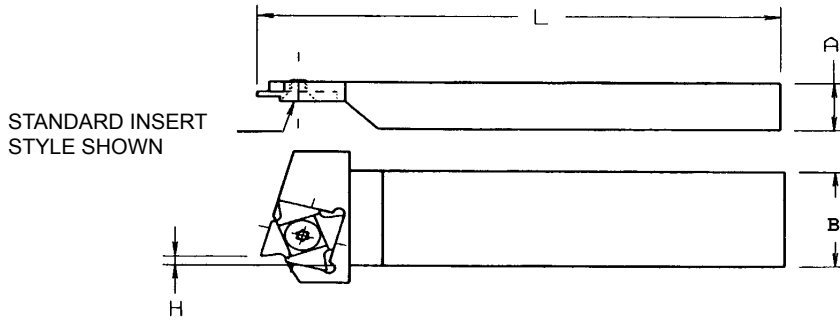
STYLE "Y" ORDERING#	W	H	L	STYLE "X" ORDERING#
CHBL432-Y-MIC	1/16	1/2	4-1/2	CHBL432-X-MIC
CHBL532-Y-MIC	5/64	1/2	4-1/2	CHBL532-X-MIC
CHBL632-Y-MIC	3/32	1/2	4-1/2	CHBL632-X-MIC
CHBL832-Y-MIC	1/8	1/2	4-1/2	CHBL832-X-MIC
CHBL444-Y-MIC	1/16	11/16	5"	CHBL444-X-MIC
CHBL644-Y-MIC	3/32	11/16	5"	CHBL644-X-MIC
CHBL844-Y-MIC	1/8	11/16	5"	CHBL844-X-MIC
CHBL1044-Y-MIC	5/32	11/16	5"	CHBL1044-X-MIC
CHBL1244-Y-MIC	3/16	11/16	5"	CHBL1244-X-MIC
CHBL452-Y-MIC	1/16	13/16	6"	CHBL452-X-MIC
CHBL652-Y-MIC	3/32	13/16	6"	CHBL652-X-MIC
CHBL852-Y-MIC	1/8	13/16	6"	CHBL852-X-MIC
CHBL1052-Y-MIC	5/32	13/16	6"	CHBL1052-X-MIC
CHBL1252-Y-MIC	3/16	13/16	6"	CHBL1252-X-MIC
CHBL1652-Y-MIC	1/4	13/16	6"	CHBL1652-X-MIC



STYLE "X"
FOR USE ON: FRONT SLIDE
L.H. / REAR SLIDE L.H. OR
VERTICAL SLIDE R.H.

ACME CUT-OFF TOOLHOLDERS

Patent No. D307859



MACHINE SIZE	A	B	H	L	CAT# FOR TOOL HOLDER W/ POCKET FOR 3/4" SQ STANDARD INSERT	CAT# FOR TOOL HOLDER W/ POCKET FOR 1" SQ STANDARD INSERT
7/16" R/A	1.215	0.988	0.251	6.00"	7/16AC-CIN	7/16AC-CIN-EX
9/16" R/A	0.595	1.188	0.251	5.00"	9/16AC-CIN	9/16AC-CIN-EX
1-1/4" R/A	0.845	1.781	0.453	5.00"	1-1/4AC-CIN	1-1/4AC-CIN-EX
1-5/8" R/A	1.235	1.875	0.485	6.00"	1-5/8AC-CIN	1-5/8AC-CIN-EX
2" R/A	1.235	2.250	0.407	6.00"	2AC-CIN	2AC-CIN-EX
3" R/A	1.484	2.500	0.219	6.00"	3AC-CIN	3AC-CIN-EX

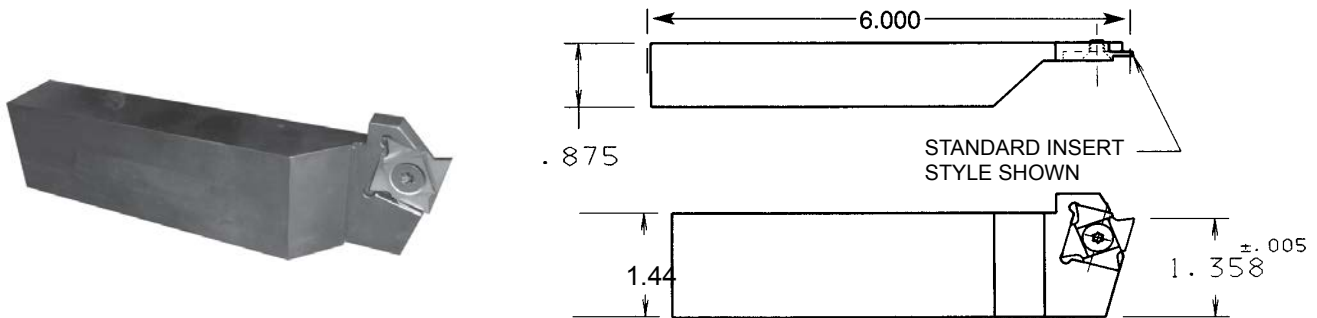
INSERT SIZE	INSERT SCREW#	INSERT WRENCH#
3/4" SQ	DAV-CIN-SCR	DAV-CIN-WR
1" SQ	DAV-CIN-SCR-ISO	DAV-CIN-WR

See Page 54 for inserts.

NEW BRITAIN CUT-OFF TOOLHOLDERS

TOOLHOLDERS SHOWN USE .750 SQ INSERT

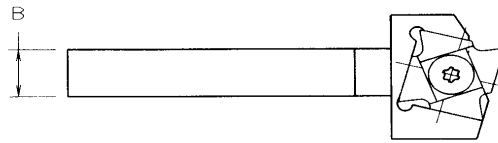
Patent No. D307859



TOOLHOLDER CAT. #	INSERT SIZE	INSERT SCREW	INSERT WRENCH
NB-CIN	3/4"	DAV-CIN-SCR	DAV-CIN-WR
NB-CIN-EX	1"	DAV-CIN-SCR-ISO	DAV-CIN-WR

See Page 54 for inserts.

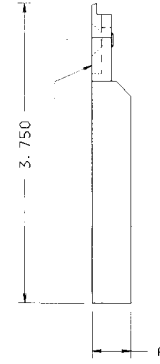
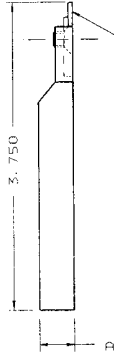
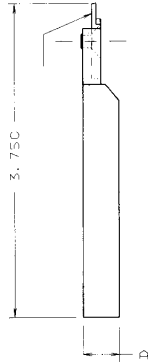
TOOLHOLDERS SHOWN USE .750 SQ INSERT
Patent No. D307859



STANDARD STYLE INSERT

STYLE "R" INSERT

STYLE "C" INSERT

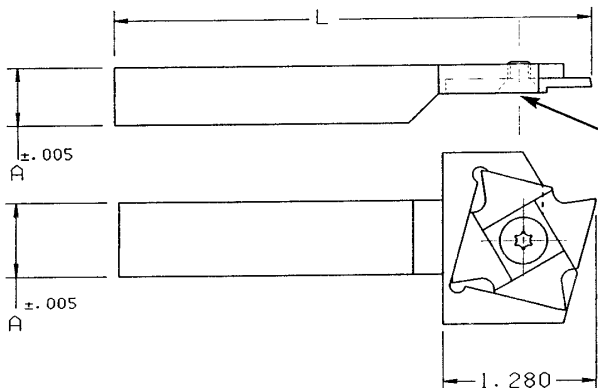


A	B	CAT# FOR STANDARD TOOLHOLDER	CAT# FOR STYLE R TOOLHOLDER	CAT# FOR STYLE C TOOLHOLDER
0.312	0.312	STCC-2117	STCC-2117R	STCC-2117C
0.375	0.375	STCC-2333	STCC-2333R	STCC-2333C
0.500	0.500	STCC-2237	STCC-2237R	STCC-2237C
0.500	0.625	STCC-1099	STCC-1099R	STCC-1099C
0.750	0.750	STCC-2218	STCC-2218R	STCC-2218C
0.750	1.000	STCC-2220	STCC-2220R	STCC-2220C
8MM	8MM	STCC-1915	STCC-4005R	STCC-4005C
10MM	10MM	STCC-4006	STCC-4006R	STCC-4006C
12MM	12MM	STCC-4007	STCC-4007R	STCC-4007C

See Page 54 for inserts.

CATALOG NUMBER	DESCRIPTION
DAV-CIN-SCR	INSERT SCREW
DAV-CIN-WR	INSERT WRENCH

TOOLHOLDER SHOWN USES 1" SQ INSERT
Patent No. D307859

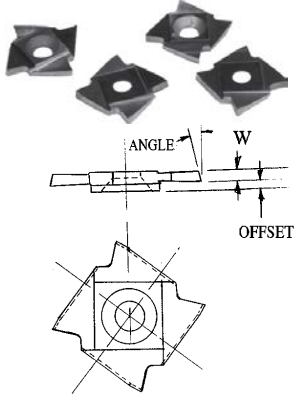


STANDARD INSERT STYLE SHOWN

A	L	CAT# FOR STANDARD TOOLHOLDER
0.500	4"	STCC-4784
0.625	6"	STCC-4785
0.750	6"	STCC-4786
1.000	6"	STCC-4656
12MM	100MM	STCC-4783
16MM	150MM	STCC-4105
20MM	150MM	STCC-6106

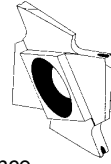
See Page 12 for inserts.

CAT#	DESCRIPTION
DAV-CIN-SCR-ISO	INSERT SCREW
DAV-CIN-WR	INSERT WRENCH



- QUICK CHANGE - JUST ROTATE INSERT WITHOUT REMOVING HOLDER FROM MACHINE (4 USABLE EDGES)
- NEVER LOSES CENTER SETTING - EVEN WHEN CHANGING FROM ONE SIZE CUT-OFF INSERT TO ANOTHER
- FREE CUTTING - INSERTS GROUND WITH BOTH FRONT TO BACK AND TOP TO BOTTOM CLEARANCE - ELIMINATES SIDE RUBBING AND DRAGGING
- LONGER LIFE - MICRO-GRAIN CARBIDE OUTPERFORMS CONVENTIONAL CARBIDE GRADES

CHIP BREAKER TYPE "-CB"



BENEFITS:

- Chip Control
- Ground in chip control for superior performance
- Longer Tool Life
- Minimum Down Time
- Consistent Quality
- Indexes within .001 Inches
- Four Cutting Edges

3/4" SQUARE 8° CUTOFF INSERTS

3/4" SQUARE 0° GROOVING INSERTS

WIDTH C/O	MAX DIA C/O	OFFSET	STD MICRO CARBIDE INSERT CAT. NO	MICRO CARBIDE INSERT W/ CHIP BREAKER CAT#
1/32"	0.187	3/32"	DAV-CIN-2	DAV-CIN-2-CB
1/32"	0.187	0	DAV-CIN-2R	DAV-CIN-2R-CB
3/64"	0.312	5/64"	DAV-CIN-3	DAV-CIN-3-CB
3/64"	0.312	0	DAV-CIN-3R	DAV-CIN-3R-CB
1/16"	0.500	1/16"	DAV-CIN-4	DAV-CIN-4-CB
1/16"	0.500	0	DAV-CIN-4R	DAV-CIN-4R-CB
5/64"	0.562	3/64"	DAV-CIN-5	DAV-CIN-5-CB
5/64"	0.562	0	DAV-CIN-5R	DAV-CIN-5R-CB
3/32"	0.562	1/32"	DAV-CIN-6	DAV-CIN-6-CB
3/32"	0.562	0	DAV-CIN-6R	DAV-CIN-6R-CB
1/8"	0.562	0	DAV-CIN-8	DAV-CIN-8-CB

WIDTH C/O	MAX DIA C/O	OFFSET	STD MICRO CARBIDE INSERT CAT. NO	MICRO CARBIDE INSERT W/ CHIP BREAKER CAT#
1/32"	0.187	3/32"	DAV-CIN-2-0	DAV-CIN-2-0-CB
1/32"	0.187	0	DAV-CIN-2R-0	DAV-CIN-2R-0-CB
3/64"	0.312	5/64"	DAV-CIN-3-0	DAV-CIN-3-0-CB
3/64"	0.312	0	DAV-CIN-3R-0	DAV-CIN-3R-0-CB
1/16"	0.500	1/16"	DAV-CIN-4-0	DAV-CIN-4-0-CB
1/16"	0.500	0	DAV-CIN-4R-0	DAV-CIN-4R-0-CB
5/64"	0.562	3/64"	DAV-CIN-5-0	DAV-CIN-5-0-CB
5/64"	0.562	0	DAV-CIN-5R-0	DAV-CIN-5R-0-CB
3/32"	0.562	1/32"	DAV-CIN-6-0	DAV-CIN-6-0-CB
3/32"	0.562	0	DAV-CIN-6R-0	DAV-CIN-6R-0-CB
1/8"	0.562	0	DAV-CIN-8-0	DAV-CIN-8-0-CB

1" SQUARE 8° CUTOFF INSERTS

WIDTH C/O	MAX DIA C/O	OFFSET	STD MICRO CARBIDE INSERT CAT. NO	MICRO CARBIDE INSERT W/ CHIP BREAKER CAT#
1/16"	0.844	1/16"	2EX-CIN-4	2EX-CIN-4-CB
1/16"	0.844	0	2EX-CIN-4R	2EX-CIN-4R-CB
5/64"	0.844	3/64"	2EX-CIN-5	2EX-CIN-5-CB
5/64"	0.844	0	2EX-CIN-5R	2EX-CIN-5R-CB
3/32"	0.844	1/32"	2EX-CIN-6	2EX-CIN-6-CB
3/32"	0.844	0	2EX-CIN-6R	2EX-CIN-6R-CB
1/8"	0.844	0	2EX-CIN-8	2EX-CIN-8-CB

FOR COATED INSERTS ADD THE FOLLOWING SUFFIXES TO THE PART NUMBERS LISTED:

TIN FOR TITANIUM NITRIDE COATED

TIALN FOR TITANIUM ALUMINUM NITRIDE COATED

TICN FOR TITANIUM CARBO-NITRIDE COATED

PART# DAV-CIN-SCR FOR SCREWS FOR 3/4" SQ INSERTS

PART# DAV-CIN-SCR-ISO FOR SCREWS FOR 1" SQ INSERTS

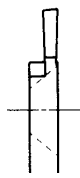
PART# DAV-CIN-WR FOR INSERT WRENCH

AVAILABLE INSERT STYLES

ADD THE SUFFIX LISTED BELOW TO THE ABOVE CATALOG NUMBERS

COUNTERCLOCKWISE SPINDLE

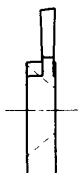
CLOCKWISE SPINDLE



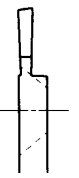
R
(Listed Above)



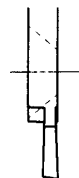
Standard
(Listed Above)



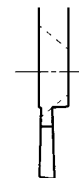
RC



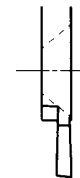
C



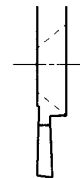
-RA



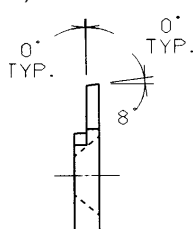
R-RA



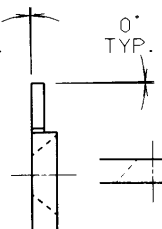
-RAC



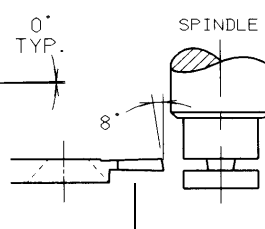
-LH



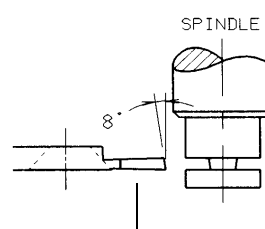
-8-0



-0-0



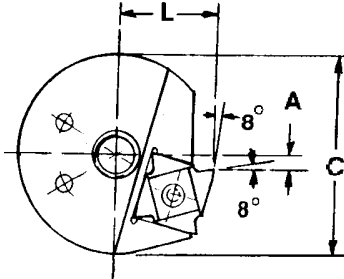
Standard Insert Shown



Style R Insert Shown



QUICK CHANGE CARBIDE INSERTED CIRCULAR CUTOFF HOLDERS FOR DAVENPORT 5TH POSITION & B&S MACHINES



See Page 54 for inserts.

DAVENPORT* W/ TWO 9/64" DIA PINHOLES ON 1-1/4" B.C. & 9/16 REAMED HOLE *ALSO FITS 9/16" CONE & 7/16" ACME				
CAT. NO	INSERT SIZE	A	L	C
DAV-CIN	3/4" SQ	1/8"	1-1/8"	2"
DAV-CIN-EX	1" SQ	1/8"	1-1/8"	2"

#00 B&S & TRAUB W/ TWO 5/32" DIA PINHOLES ON 1-1/16" B.C. AND ONE 1/8" DIA PINHOLE ON .787 B.C.				
CAT. NO	INSERT SIZE	A	L	C
OO-CIN	3/4" SQ	1/8"	1"	1-3/4"

#0 B&S W/ TWO 3/16" DIA PINHOLES ON 1-3/8" B.C.				
CAT. NO	INSERT SIZE	A	L	C
O-CIN	3/4" SQ	5/32"	1-1/8"	2-1/4"

#2 B&S W/ TWO 3/16" DIA PINHOLES ON 1-1/2" B.C.				
CAT. NO	INSERT SIZE	A	L	C
2-CIN	3/4" SQ	1/4"	1-1/2"	3"
2-CIN-EX	1" SQ	1/4"	1-1/2"	3"

For B&S Left Hand holders add **-LH** to the part numbers shown

RESHARPENABLE QUICK CHANGE INSERT CIRCULAR CUTOFF TOOLS FOR 5TH POSITION DAVENPORT

(Patent No. 5,345,846)



Cat. No. RQCDAV-CO

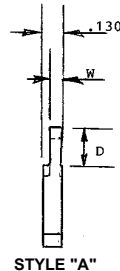
- MOUNTS ON SWING ARM - SAME AS CIRCULAR TOOL.
- ONCE HOLDER IS SET ON CENTER NEVER NEEDS TO BE RESET.
- INSERTS ARE RESHARPENABLE 10 TO 15 TIMES (1/8")..
- INSERTS ALWAYS RETURN TO ORIGINAL DIAMETER AND LENGTH SETTINGS.
- INSERTS CAN BE CHANGED IN LESS THAN A MINUTE.
- INSERTS AVAILABLE TO FULL DIAMETER CAPACITY OF MACHINE.

INSERT RESHARPENING FIXTURE

- For sharpening top surface of inserts
- Flexible jaw clamps insert securely
- For use on surface grinder with cup or dish wheel

Cat. No. RQCSF-CO

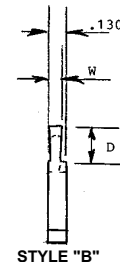
MICRO-GRAIN CARBIDE INSERTS



STYLE "A"

BLADE CLOSE TO PICKOFF COLLET

CAT. NO.	STYLE	W*	D
RQCT-047-0	A	.047	3/16
RQCT-063-0	A	.063	5/16
RQCT-078-0	A	.391	25/64
RQCT-094-0	A	.094	7/16
RQCT-125-0	A	.125	9/16



STYLE "B"

BLADE CLOSE TO SPINDLE

CAT. NO.	STYLE	W*	D
RQCT-047	B	.047	3/16
RQCT-063	B	.063	5/16
RQCT-078	B	.391	25/64
RQCT-094	B	.094	7/16

C/O INSERT BLANKS	
FOR REWORK TO YOUR REQUIREMENTS GROUND ON ALL 6 SIDES, 17° ANGLE	
CAT. NO.	MATERIAL
RQCT-MIC	MICROGRAIN CARBIDE
RQCT-A	76PM H/S/S

- PRICES ON APPLICATION FOR WIDER INSERTS FOR PICKOFF COLLET FORM AND CUTOFF WORK.

• NOTE: CUTOFF WIDTH WILL BE REDUCED UP TO .001" PER SIDE (.002" TOTAL) AS INSERT IS RESHARPENED.

Somma

Broaching

Form & Shave

Dovetail Blanks

Cut Off

Swiss Turn

Box Turn

End Working

Knurling

Tapping

Reaming

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Workholding

and More

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