

# Somma

**TOOL COMPANY, INC.**

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**PREMIER TOOLING FOR THE  
MANUFACTURING INDUSTRY**

*since 1939*

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**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

### CAM ROLLERS AND PINS

#### • HEAT TREATED ALLOY STEEL

For hardness and long life.

\*Also used on  
Slotting Attachments



- **PRECISION-MADE**  
Pin O.D., Roll O.D. & I.D.  
ground for accuracy and  
smooth operation.

#### CHECK DIMENSIONAL REQUIREMENTS AND ORDER BY CATALOG NO.

MACHINE USED ON	Cat. No.	Part Name	Used On	B&S Ref. No.	Outside Diameter	Inside Diameter	Length or Width	Cotter Pin or Flat
No. 00 Prior to Serial #128582	*M3963	Pin	Lead Lever & Cross Slides	91-90-83/645	.250	—	1.062	Flat
	M3982	Roller	Lead Lever & Cross Slides	91-215-8	.500	.250	.312	—
	M3965	Pin	Cross & Vertical Slides	91-90-83/700	.250	—	1.062	Cotter Pin
	M3969	Pin	Lead Lever & Cross Slides	91-90-83	.250	—	1.250	Flat
No. 00 Begins with Serial #12852 and #542-00-3300	*M3973	Pin	Lead Lever	91-90-705	.250	—	1.312	Cotter Pin
	M3961	Pin	Cross Slide Some Machines	91-90-645	.250	—	1.000	Flat
	*M3984	Roller	Lead Lever, Cross & Vertical Slides	91-215-211	.500	.250	.375	—
	M3971	Pin	Lead Lever, Cross & Vertical Slides Some Machines	91-90-738	.250	—	1.250	Cotter Pin
No. 0 Prior to Serial #8020	*M3963	Pin	Lead Lever & Cross Slides	91-90-83	.250	—	1.062	Flat
	M3967	Pin	Cross Slide Some Machines	91-90-83	.250	—	1.125	Flat
	*M3986	Roller	Lead Lever & Cross Slides	91-215-9	.562	.250	.375	—
No. 0 Begins with Serial #8020	*M3973	Pin	Lead Lever	91-90-705/738	.250	—	1.312	Cotter Pin
	M3965	Pin	Cross & Vertical Slides	91-90-83/700	.250	—	1.062	Cotter Pin
	*M3988	Roller	Lead Lever, Cross & Vertical Slides	91-215-212	.562	.250	.437	—
	*M3971	Pin	Cross & Vertical Slides Some Machines	91-90-738	.250	—	1.250	Cotter Pin
	*M3986	Roller	Lead Lever, Cross & Vertical Slides Some Machines	91-215-9	.562	.250	.375	—
No. 2 Prior to Serial #7351	*M3975	Pin	Lead Lever & Cross Slides	91-90-82	.312	—	1.187	Flat
	*M3990	Roller	Lead Lever & Cross Slides	91-215-3	.625	.312	.437	—
No. 2 Begins with Serial #7351 and #542-2-3100	*M3977	Pin	Lead Lever*, Cross & Vertical Slides (*Except 542-2-3100)	91-90-752	.312	—	1.312	Cotter Pin
	*M3992	Roller	Lead Lever, Cross & Vertical Slides	91-215-220	.625	.312	.500	—
	M3979	Pin	Lead Lever (Begins Serial 542-2-3100)	42-17185-99	.312	—	1.833	Cotter Pin
No. 2 Ultramatic	M3981	Pin	Lead Lever	42-17185-1	.312	—	2.015	Cotter Pin
	M3994	Roller	Lead Lever	42-21653	.625	.312	.625	—

### STEEL CAM BLANKS

For lead, cross-slide and vertical attachment on automatic screw machines. Blanks are 1020 steel, with finished center hole, locating hole, graduated in hundredths and face ground and blued for easy scribing.

STEEL FULL CAM BLANKS				
MACHINE SIZE	CAT. NO.	DIA.	WIDTH	I.D.
No. 00 B&S	CB00-4.5	4-1/2	1/4	1"
	CB00-5	5	1/4	1"
	CB00-5.5	5-1/2	1/4	1"
No. 0 B&S	CB0-6	6	5/16	1-1/8
	CB0-7	7	5/16	1-1/8
No. 2 B&S	CB2-7	7	3/8	1-1/4
	CB2-8	8	3/8	1-1/4
	CB2-9	9	3/8	1-1/4
	CB2-10	10	3/8	1-1/4

### STEEL ROUGH CAM BLANKS

Blanks are 1020 steel, with finished center hole and locating hole - but without graduations or bluing. Saving for cam makers who do not require these features. Face ground for scribing.

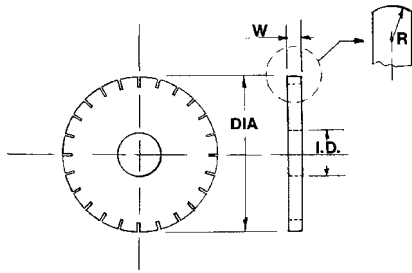
STEEL ROUGH CAM BLANKS				
MACHINE SIZE	CAT. NO.	DIA.	WIDTH	I.D.
No. 00 B&S	RCB00-4.5	4-1/2	1/4	1"
	RCB00-5	5	1/4	1"
	RCB00-5.5	5-1/2	1/4	1"
No. 0 B&S	RCB0-6	6	5/16	1-1/8
	RCB0-7	7	5/16	1-1/8
No. 2 B&S	RCB2-7	7	3/8	1-1/4
	RCB2-8	8	3/8	1-1/4
	RCB2-9	9	3/8	1-1/4
	RCB2-10	10	3/8	1-1/4



GROUND  
BOTH SIDES

CAMS SHOULD BE CARBURIZED AND DEEP CASE HARDENED FOR LONGEST LIFE.

### DEBURRING TOOLS FOR SLOTTING ATTACHMENTS OF B&S AND SWISS MACHINES

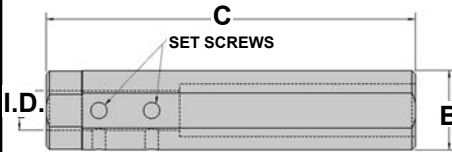


These high speed steel circular deburring tools fit the slotting attachment of B&S Screw Machines and Swiss Machines and remove cut-off burrs from the back end of the part completely, smoothly and uniformly.

The O.D. of the deburring tool is slightly crowned and the teeth are radial (without clearance) so as to only remove the cut-off burr without digging into the part.

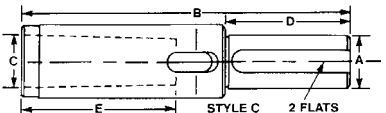
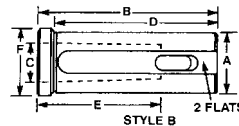
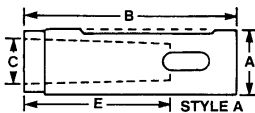
CAT. NO.	MACHINE SIZE	DIA.	I.D.	WIDTH
SBT-00	#00 B&S	1-3/4	5/8	3/16
SBT-0	#0 B&S	2-1/4	5/8	3/16
SBT-2	#2 B&S	2-3/4	3/4	1/4
SBT-SW	SWISS	25MM(1")	8MM(.315)	3/16

### BORING BAR SLEEVES



B O.D.	C Length	I.D. Size / Cat. No.													
		1/4	5/16	3/8	1/2	5/8	3/4	7/8	1"	1-1/4	1-1/2	1-3/4	2"	2-1/2	
3/4	5"	53339	53400	53392	53393										
22MM	5"	53340	53341	53342	53343	53344									
1"	6"			53401	53402										
1-1/2	7"			53411	53412	53413	53414								
1-1/2	8"							53415	53416						
1-3/4	8"				53421	53425	53422	53426	53423						
2"	9"					53431	53432	53433	53434	53435					
2-1/2	10"					53441	53442		53443	53444	53445				
3"	11-1/2"								53450	53451	53452	53453	53454		
4"	14"										53460	53461	53462	53463	

### TAPER DRILL SOCKETS SUPERIOR DESIGN/PREMIUM QUALITY



These taper drill sockets are hardened, precision ground, and concentric within .0002 of an inch. They fit directly into tool holders and turrets to positively drive all morse taper shank tools, drills, reamers, and counterbores.

The straight shank style "A" taper drill sockets are manufactured in limited quantities and sizes. Please contact our courteous sales staff for availability and pricing information. Select the O.D. size that fits your machine and order from the chart below.

CAT. NO.	STYLE	SHANK DIA. A	B	MORSE TAPER C	D	E	F
MT1-0075	A	3/4	3-1/4	No. 1	2.313	2-3/16	1
*MT1-1000	B	1	3-3/4	No. 1	3.125	2-3/16	1-1/4
*MT2-1000	B	1	3-3/4	No. 2	3.125	2-5/8	1-1/4
*MT1-1250	B	1-1/4	4	No. 1	3.375	2-3/16	1-1/2
*MT2-1250	B	1-1/4	4	No. 2	3.375	2-5/8	1-1/2
*MT3-1250	B	1-1/4	4	No. 3	4.000	3-1/4	1-1/2
*MT1-1500	B	1-1/2	5	No. 1	4.375	2-3/16	1-3/4
*MT2-1500	B	1-1/2	5	No. 2	4.375	2-5/8	1-3/4
*MT3-1500	B	1-1/2	5	No. 3	4.375	3-1/4	1-3/4
*MT4-1500	B	1-1/2	5-3/4	No. 4	4.375	4-1/8	1-3/4
*MT1-1750	B	1-3/4	5-3/4	No. 1	5.125	2-3/16	2
*MT2-1750	B	1-3/4	5-3/4	No. 2	5.125	2-5/8	2
*MT3-1750	B	1-3/4	5-3/4	No. 3	5.125	3-1/4	2
*MT4-1750	B	1-3/4	5-3/4	No. 4	4.375	4-1/8	2

\* Item available in style "A". Call for price and availability.

CAT. NO.	STYLE	SHANK DIA. A	B	MORSE TAPER C	D	E	F
MT5-1750	C	1-3/4	11-1/8	No. 5	4-1/4	5-1/4	2-3/8
MT2-2000	B	2	6-1/8	No. 2	5-1/2	2-5/8	2-1/4
MT3-2000	B	2	6-1/8	No. 3	5-1/2	3-1/4	2-1/4
MT4-2000	B	2	6-1/8	No. 4	5-1/2	4-1/8	2-1/4
MT5-2000	C	2	11-1/8	No. 5	4-1/4	5-1/4	2-3/8
MT2-2500	B	2-1/2	5-3/4	No. 2	5-1/8	2-5/8	2-3/4
MT3-2500	B	2-1/2	6-5/8	No. 3	6	3-1/4	2-3/4
MT4-2500	B	2-1/2	6-5/8	No. 4	6	4-1/8	2-3/4
MT5-2500	B	2-1/2	7-5/8	No. 5	7	5-1/4	2-3/4
MT4-3000	B	3	6-5/8	No. 4	6	4-1/8	3-3/8
MT5-3000	B	3	7-5/8	No. 5	7	5-1/4	3-3/8
MT4-2250	B	2-1/4	6-5/8	No. 4	6	4-1/8	2-1/2
MT5-2250	B	2-1/4	7-5/8	No. 5	7	5-1/4	2-1/2
MT4-2750	B	2-3/4	6-5/8	No. 4	6	4-1/8	3
MT5-2750	B	2-3/4	7-5/8	No. 5	7	5-1/4	3



# 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**  
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