

Somma

TOOL COMPANY, INC.

**PREMIER TOOLING FOR THE
MANUFACTURING INDUSTRY**

since 1939

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Customer Service

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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

STC-TAP-ER TAPPING MACHINE

TAPS UP TO 5/16-18 THREAD IN 1/2" STEEL!!

HEAVY DUTY TAPERED CONE DRIVE

5/64" to 1/2" capacity chuck
 1/3 H.P., 115V, Single Phase
 1725 RPM, A48 Frame Motor
 Shipping weight: 43 lbs



TAPPING

The STC-TAP-ER has a double disc friction drive that reverses rotation instantly by the application of forward or backward hand pressure on the part being tapped. The friction discs are driven by a Heavy Duty Tapered Cone Drive Collar mounted on the motor shaft. The maximum spindle speed is 300 RPM.

ORDERING NO.	CONFIGURATION
STC-TAP-ER	STANDARD AS SHOWN
STC-TAP-ER(-)	MINUS THE FRONT STAGING
STC-TAP-ER/MAGNETIC	WITH MAGNETIC START
STC-TAP-ER-3/4CAP	WITH 3/4" CAPACITY CHUCK
STC-TAP-ER KEYLESS	WITH KEYLESS CHUCK
STC-TAP-ER-380/3	WITH 380V 50HZ 3 PHASE MOTOR
STC-TAP-ER-VAR/RPM	WITH VARIABLE SPINDLE SPEED CONTROL AND FORWARD-REVERSE SWITCH

FEATURES:

- Push to tap in
- Pull to tap out
- Sliding face plate
- Work table can be reversed when not needed
- Easy to set stop for tap depth control
- Comfortable bench height working area
- Long lasting tapered cone drive
- Pilot light switch warns if motor is left running

ALSO AVAILABLE 220V, 50HZ OR 60HZ, SINGLE OR SPLIT PHASE MOTORS OR AVAILABLE WITHOUT MOTOR
 CALL FOR A QUOTATION ON YOUR SPECIFIC CONFIGURATION

REPLACEMENT PART

CAT. NO.	DESCRIPTION
BB-TAP-6	TAPPERED CONE DRIVE

WARNING!! TO AVOID INJURIES, WORKPIECE SHOULD BE HELD IN AN APPROPRIATE CLAMPING DEVICE WHILE BEING TAPPED AND SHOULD NEVER BE HELD BY HAND WITHOUT ADEQUATE PROTECTION.

BB-SR RE-TAPPING MACHINE

THE FASTEST AND EASIEST WAY TO:

- Retap threaded parts
- Chase threads
- Remove cutoff burrs from threads
- Inspect threads (with thread gage mounted in chuck)
- Countersink holes
- Deburr holes
- Ream holes



5/64" to 1/2" capacity chuck
 1/3 H.P., 115V, Single Phase
 1725 RPM, A48 Frame Motor
 Shipping weight: 32 lbs

The RE-TAP-ER has a double disc friction drive that reverses rotation instantly by the application of forward or backward hand pressure on the part being retapped. The friction discs are driven by a Rubber Drive Ring mounted on the motor shaft.

Since the unit is driven merely by friction, it would be impossible to guarantee any particular R.P.M. because the R.P.M. will vary with the pressure exerted and the operation performed. The maximum spindle speed is 1,000 RPM.

NEW IMPROVED DESIGN

- Solid one piece enclosed housing
- Motor slides back for easy drive ring replacement
- Pilot light switch warns if motor is left running
- Rugged construction yet light weight and portable (only 32lbs)



ORDERING NO.	CONFIGURATION
BB-SR	STANDARD AS SHOWN
BB-SR/MAGNETIC START	WITH MAGNETIC START
BB-SR-3/4CAP	WITH 3/4" CAPACITY CHUCK
BB-SR 3450RPM	WITH 3450 RPM MOTOR
BB-SR-380/3	WITH 380V 50HZ 3 PHASE MOTOR
BB-SR-VAR/RPM	WITH VARIABLE SPINDLE SPEED CONTROL AND FORWARD-REVERSE SWITCH



ALSO AVAILABLE 220V, 50HZ OR 60HZ, SINGLE OR SPLIT PHASE MOTORS OR AVAILABLE WITHOUT MOTOR

CALL FOR A QUOTATION ON YOUR SPECIFIC CONFIGURATION

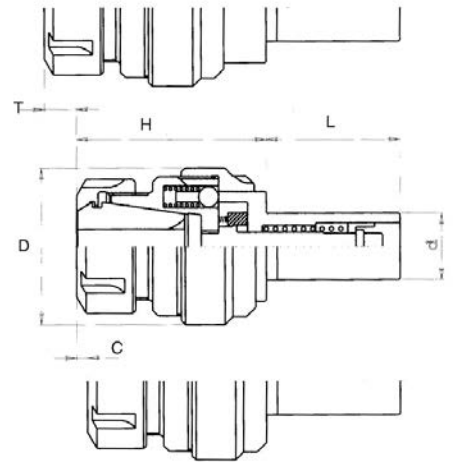
Replacement Parts

CAT. NO.	RE-TAP-ER
BB-7	DRIVE RING BLACK NEOPRENE
BB-7HD	HEAVY DUTY DRIVE RING ORANGE URETHANE
BB-21	PKG. OF 6 FINGER PROTECTORS

TENSION & COMPRESSION ER COLLET FLOATING TAP HOLDERS

- Axial-float/tension/compression for CNC lathes & milling machines with reversing motors and rigid tapping
- Compensates for machine feed and tap pitch variance
- Floating mechanism (.002 per side / .004 total float) compensates for misalignment between tap and work piece
- Compact design for minimal clearance applications
- Uses ER series tap collets

SEE PAGE 107 FOR COLLETS.



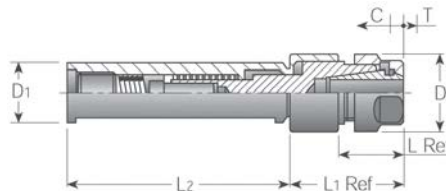
TAP COLLET SERIES	HAND TAP COLLET RANGE
ER11	#0 TO 1/4
ER16	#0 TO 5/16
ER20	#0 TO 1/2
ER25	#0 TO 5/8
ER32	#0 TO 13/16

Shank Dia.	Collet Series	L	H	D	Tension T	Compression C	Part No.	Collet Nut*	Collet Wrench**
5/8	ER11	32	36	29	5.5	2.5	SS062TCIER11	ER11H	ER11HW
5/8	ER16	32	48	29	5.5	2.5	SS062TCIER16	ER16M	ER16MW
3/4	ER11	32	36	29	5.5	2.5	SS075TCIER11	ER11H	ER11HW
3/4	ER16	32	48	29	5.5	2.5	SS075TCIER16	ER16M	ER16MW
3/4	ER20	46	59	44	9	3	SS075TCIER20	ER20H	ER20HW
3/4	ER25	46	73	44	9	3	SS075TCIER25	ER25E	ER25EW
1"	ER20	46	59	44	9	3	SS100TCIER20	ER20H	ER20HW
1"	ER25	50	68	58	12	4	SS100TCIER25	ER25E	ER25EW
1"	ER25	80	68	58	12	4	SS100TCIER25L	ER25E	ER25EW
1"	ER32	50	70	58	12	4	SS100TCIER32	ER32E	ER32EW
1"	ER32	80	70	58	12	4	SS100TCIER32L	ER32E	ER32EW
1-1/4"	ER25	50	68	58	12	4	SS125TCIER25	ER25E	ER25EW
1-1/4"	ER32	50	70	58	12	4	SS125TCIER32	ER32E	ER32EW
16MM	ER11	32	36	29	5.5	2.5	SS16TCIER11	ER11H	ER11HW
16MM	ER16	32	48	29	5.5	2.5	SS16TCIER16	ER16M	ER16MW
20MM	ER11	32	36	29	5.5	2.5	SS20TCIER11	ER11H	ER11HW
20MM	ER16	32	48	29	5.5	2.5	SS20TCIER16	ER16M	ER16MW
20MM	ER20	46	59	44	9	3	SS20TCIER20	ER20H	ER20HW
20MM	ER25	46	73	44	9	3	SS20TCIER25	ER25E	ER25EW
22MM	ER20	46	59	44	9	3	SS22TCIER20	ER20H	ER20HW
22MM	ER25	46	73	44	9	3	SS22TCIER25	ER25E	ER25EW
25MM	ER20	46	59	44	9	3	SS25TCIER20	ER20H	ER20HW
25MM	ER25	50	68	58	12	4	SS25TCIER25	ER25E	ER25EW
25MM	ER25	80	68	58	12	4	SS25TCIER25L	ER25E	ER25EW
25MM	ER32	50	70	58	12	4	SS25TCIER32	ER32E	ER32EW
25MM	ER32	80	70	58	12	4	SS25TCIER32L	ER32E	ER32EW
30MM	ER25	50	68	58	12	4	SS30TCIER25	ER25E	ER25EW
30MM	ER32	50	70	58	12	4	SS30TCIER32	ER32E	ER32EW
32MM	ER25	50	68	58	12	4	SS32TCIER25	ER25E	ER25EW
32MM	ER32	50	70	58	12	4	SS32TCIER32	ER32E	ER32EW
40MM	ER25	85	68	58	12	4	SS40TCIER25	ER25E	ER25EW
40MM	ER32	85	70	58	12	4	SS40TCIER32	ER32E	ER32EW

** Collet Wrench and Tap Collets sold separately

AXIAL-FLOAT TENSION COMPRESSION TAPHOLDERS

Cat. No.	Collet Series	Tap Capacity	D1	L2	L1	L	D	T	C
SS062FTCER11	ER11	#3-1/4"	5/8	6.00		.75	.63	.24	.12
SS075FTCER16	ER16	#6-3/8"	3/4	3.15	1.61	.95	1.10	.32	.12
SS075FTCER20	ER20	#8-1/2"	3/4	3.15	1.89	1.06	1.34	.32	.12
SS100FTCER25	ER25	#10-5/8"	1	3.15	2.01	1.18	1.66	.36	.16
SS100FTCER32	ER32	1/4-3/4"	1	3.15	2.91	1.18	1.97	.36	.16
SS125FTCER40	ER40	5/16-1-3/8"	1-1/4	3.15	3.54	1.81	2.36	.36	.16



SEE PAGE 107 FOR COLLETS.

ER Axial - Float Tension/Compression Tapholders

Application:

Axial-float/tension/compression type for C.N.C. milling machines and lathes with reversing motors and rigid tapping.

Features:

- Compensates for machine feed and tap pitch variance.
- Floating mechanism compensates for misalignment between tap and workpiece. (-.004/side .008 Total Float)
- Right-and left-hand tapping.

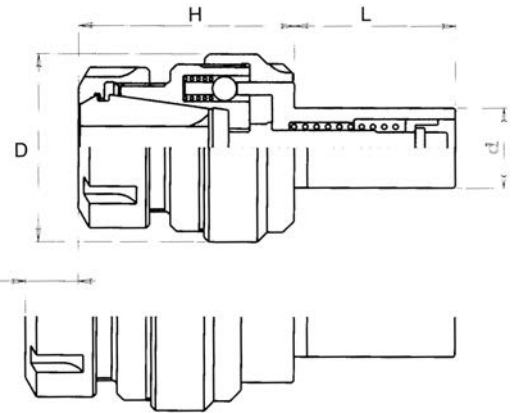
Advantages:

- Practical and efficient tap holding by the ER spring collet without using jaw drive.
- Compact design for minimal clearance applications.
- Heavy Duty design for high torque drive ensures the same accuracy as the tap itself.

TENSION ONLY FLOATING ER COLLET TAP HOLDERS

- Tension Feature Eliminates Tap Breakage During Machine Reversal
- For use on CNC machining centers and lathes, screw machines, automatic lathes, chuckers, and milling machines.
- Can be used on rigid or reversing spindles
- Floating mechanism (.002 per side / .004 total float) compensates for misalignment between tap and work piece.

SEE PAGE 107
FOR COLLETS.



TAP COLLET SERIES	HAND TAP COLLET RANGE
ER11	#0 TO 1/4
ER16	#0 TO 5/16
ER20	#0 TO 1/2
ER25	#0 TO 5/8
ER32	#0 TO 13/16

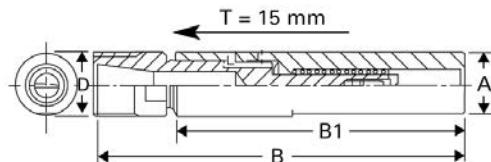
Shank Dia.	Collet Series	L	H	D	Tension (mm)		Part No.	Collet Nut*	Collet Wrench**
					T				
5/8	ER11	32	36	29	8		SS062TIER11	ER11H	ER11HW
5/8	ER16	32	48	29	8		SS062TIER16	ER16M	ER16MW
3/4	ER11	32	36	29	8		SS075TIER11	ER11H	ER11HW
3/4	ER16	32	48	29	8		SS075TIER16	ER16M	ER16MW
3/4	ER20	46	56	44	12		SS075TIER20	ER20H	ER20HW
3/4	ER25	46	70	44	12		SS075TIER25	ER25E	ER25EW
1"	ER20	46	56	44	12		SS100TIER20	ER20H	ER20HW
1"	ER25	50	64	58	16		SS100TIER25	ER25E	ER25EW
1"	ER25	80	64	58	16		SS100TIER25L	ER25E	ER25EW
1"	ER32	50	66	58	16		SS100TIER32	ER32E	ER32EW
1"	ER32	80	66	58	16		SS100TIER32L	ER32E	ER32EW
1-1/4"	ER25	50	64	58	16		SS125TIER25	ER25E	ER25EW
1-1/4"	ER32	50	66	58	16		SS125TIER32	ER32E	ER32EW
16MM	ER11	32	36	29	8		SS16TIER11	ER11H	ER11HW
16MM	ER16	32	48	29	8		SS16TIER16	ER16M	ER16MW
20MM	ER11	32	36	29	8		SS20TIER11	ER11H	ER11HW
20MM	ER16	32	48	29	8		SS20TIER16	ER16M	ER16MW
20MM	ER20	46	56	44	12		SS20TIER20	ER20H	ER20HW
20MM	ER25	46	70	44	12		SS20TIER25	ER25E	ER25EW
22MM	ER20	46	56	44	12		SS22TIER20	ER20H	ER20HW
22MM	ER25	46	70	44	12		SS22TIER25	ER25E	ER25EW
25MM	ER20	46	56	44	12		SS25TIER20	ER20H	ER20HW
25MM	ER25	50	64	58	16		SS25TIER25	ER25E	ER25EW
25MM	ER25	80	64	58	16		SS25TIER25L	ER25E	ER25EW
25MM	ER32	50	66	58	16		SS25TIER32	ER32E	ER32EW
25MM	ER32	80	66	58	16		SS25TIER32L	ER32E	ER32EW
30MM	ER25	50	64	58	16		SS30TIER25	ER25E	ER25EW
30MM	ER32	50	66	58	16		SS30TIER32	ER32E	ER32EW
32MM	ER25	50	64	58	16		SS32TIER25	ER25E	ER25EW
32MM	ER32	50	64	58	16		SS32TIER32	ER32E	ER32EW
40MM	ER25	85	64	58	16		SS40TIER25	ER25E	ER25EW
40MM	ER32	85	64	58	16		SS40TIER32	ER32E	ER32EW

** Collet Wrench and Tap Collets sold separately

ER16 TENSION ONLY TAP HOLDERS

Part No.	A	B	B1	D	Tension	Nut
SS20ERT693	20	6.93	3.94	1.10	0.59	ER16H
SS22ERT531	22	5.31	3.94	1.10	0.59	ER16H
SS075ERT535	3/4	5.35	2.36	1.10	0.59	ER16H
SS075ERT394	3/4	3.94	2.56	.87	0.59	ER16M

- PERMITS TAPPING USING ER16 COLLET SYSTEM #0-5/16 HAND TAP CAPACITY.
- IDEALLY SUITED FOR THROUGH HOLE APPLICATIONS ON SWISS AND JAPANESE AUTOMATICS AND LATHES.



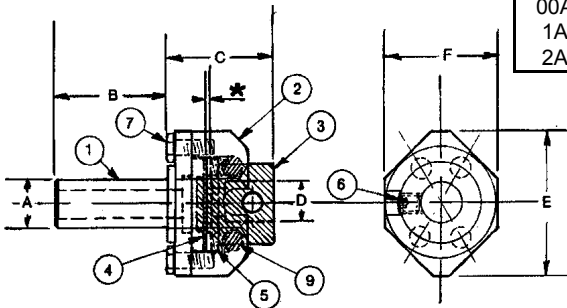
SEE PAGE 107
FOR COLLETS.



ADJUSTABLE NON-RELEASING TAP HOLDER

- Fits all standard machines.
- Adjustable (floating). Easy-to-get-at back end adjustment screws to compensate for machine misalignment.
- Has thru-hole, eliminates cutting down tap shanks. Makes it easier to remove taps from holder.
- Bumper action for better threads - but bumper action can be eliminated by use of two, part No. 4 Retaining Washers to fill gap. *
- Easy to service, simple 2 spring balanced pull-out mechanism.
- Rugged enough for heavy taps and yet sensitive enough for small taps.
- Minimum overhang for maximum machine clearance (Eliminates shortening of taps).

CAT. NO.	A	B	C	D	E	F	PULLOUT	TAP CAPACITY	
								HAND	PIPE
00ANR	5/8	1-3/16	31/32	1/2	1-3/4	1-5/16	3/32	7/16	1/8
1ANR	3/4	1-3/4	1-13/32	5/8	2-1/4	1-3/4	1/4	11/16	1/4
2ANR	1"	2-3/8	1-57/64	1"	3-1/8	2-3/8	9/32	1-1/8	3/4



SEE PAGE 112 FOR TAP HOLDER BUSHINGS FOR THESE TAP HOLDERS.

ADJUSTABLE NON-RELEASING TAP HOLDER PARTS

Part No.	00ANR Cat. No.	1ANR Cat. No.	2ANR Cat. No.
1. Shank	00ANR-1	1ANR-1	2ANR-1
2. Body	00ANR-2N	1ANR-2N	2ANR-2N
3. Spindle	00ANR-3N	1ANR-3N	2ANR-3N
4. Retaining Washer	00ANR-4N	1ANR-4N	2ANR-4N
5. Springs (Std)	00ANR-5	1ANR-5	2ANR-5
5. Springs (Light Duty)	00ANR-5LD	1ANR-5LD	2ANR-5LD
6. Set Screw	ORB2-5	1ANR-6	2ANR-6
7. Clamp Screw & Washer	ARTH00-18 RSA00-5	ARTH1-18 RSA2-5	2ANR-7 2ANR-9
9. Ball			

NON-RELEASING TAP HOLDER



* Excellent for operations where release is not required.

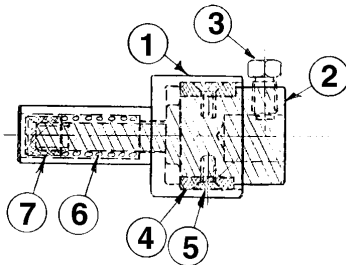
* Smooth, extra long pullout.

CAT. NO.	SHANK DIA.	SHANK LENGTH	TAP CAPACITY		PULLOUT
			HAND	PIPE	
NR000	5/8	1-3/16	1/4	1/16	7/16
NR00	5/8	1-1/4	7/16	1/8	1/2
NR1	3/4	1-3/4	11/16	1/4	17/32
NR2	1"	2"	1-1/8	3/4	5/8
NR2-NBG	1"	2"	1-1/8	3/4	5/8
NR3	1-1/4	2-9/16	1-1/4	1"	7/8
NR3-NBG	1-1/2	1-3/4	1-1/4	1"	7/8
NR4	1-1/2	3-3/16	1-1/2	1"	1"
NR4-NBG	1-1/2	1-11/16	1-1/2	1"	1"

All other dimensions same as releasing tap holders (see pg. 69) Tools with "NBG" Cat. Nos. have special shank dimensions for use on New Britain Gridley Automatics.

NON-RELEASING TAP HOLDERS PARTS

Part No.	NR000 Cat. No.	NR00 Cat. No.	NR1 Cat. No.	NR2 Cat. No.	NR3 Cat. No.	NR4 Cat. No.
1. Body	NR000-1	NR00-1	NR1-1	NR2-1	NR3-1	NR4-1
2. Spindle	NR000-2	NR00-2	NR1-2	NR2-2	NR3-2	NR4-2
3. Set Screw	ATT00-12	TH000-3	FARH2-10	2ANR-6	NR3-3	NR4-3
4. Key (Ea.)	NR00-4	NR00-4	NR1-4	NR2-4	NR3-4	NR4-4
5. Keys Screws (Ea.)	NR000-5	NR000-5	NR000-5	NR2-5	NR2-5	NR2-5
6. Shank Spring	TH000-13	TH00-13	TH1-13	TH2-13	TH3-13	TH4-13
7. Spindle Nut	TH000-14	TH00-14	TH1-14	TH2-14	TH2-14	TH4-14
8. Retainer	---	TH00-13-2	---	---	---	---



SEE PAGE 112 FOR TAP HOLDER BUSHINGS FOR THESE TAP HOLDERS

All parts for NBG Tap Holders same as standard except as shown below.

Part No.	NR2-NBG Cat. No.	NR3-NBG Cat. No.	NR4-NBG Cat. No.
1. Body	NR2-1NBG	NR3-1NBG	NR4-1NBG
2. Spindle	---	---	NR4-2NBG



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)

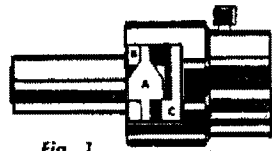


Fig. 1

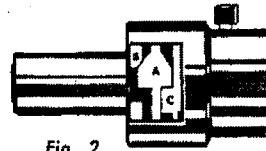


Fig. 2



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.

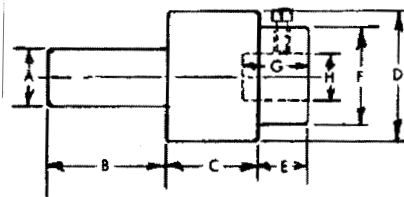
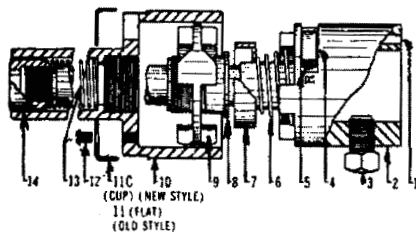
NOTE: TH2-NBG, TH3-NBG AND TH4-NBG have special shank diameter and length for use on New Britain Gridley automatics.

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

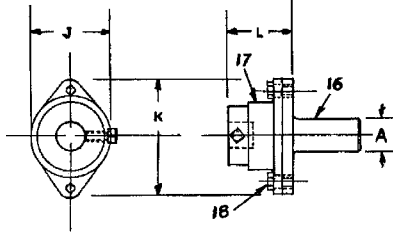
RELEASING TAP HOLDER PARTS



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

ADJUSTABLE (FLOATING) RELEASING TAP HOLDERS

Now the exclusive principal of the Somma clutch type Releasing Tap Holder is available in the adjustable (floating) type. This tool has all the advantages of the Somma Releasing Tap Holder and can also be used on screw machines and turret lathes that are out of alignment.



CAT. NO.	A	J	K	L	TAP CAPACITY	
					HAND	PIPE
ARTH00	5/8	1-3/8	2-1/8	1-11/32	7/16	1/8
ARTH1	3/4	1-19/32	2-3/4	1-11/16	11/16	1/4
ARTH2	1"	2-7/32	3-1/2	2-3/8	1-1/8	3/4

All other dimensions and parts are the same as Releasing Tap Holder (Pg. 9).

ADJUSTABLE RELEASING TAP HOLDER PARTS

Part No.	ARTH00 Cat. No.	ARTH1 Cat. No.	ARTH2 Cat. No.
16. Shank	ARTH00-16	ARTH1-16	ARTH2-16
17. Head	ARTH00-17	ARTH1-17	ARTH2-17
18. Clamp Screw & Washer	ARTH00-18	ARTH1-18	FDH1-4

SEE BELOW FOR TAP HOLDER BUSHINGS FOR THESE TAP HOLDERS.

TAP HOLDER BUSHINGS

SIZE OF TAP USED**	TAP SHANK DIA.	#00	#0	#2
		1/2 OD x 3/4 long CAT. NO.	5/8 OD x 7/8 long CAT. NO.	1" OD x 1-1/4 long CAT. NO.
#0 thru #6	.141	1001	1101	1201
#7-#8-5/32	.168	1002	1102	1202
#9-#10-3/16	.194	1003	1103	1203
#12-7/32	.220	1004	1104	1204
#14-1/4	.255	1005	1105	1205
9/32	.286	1006	1106	1206
5/16	.318	1007	1107	1207
11/32	.349	1008	1108	1208
3/8	.381	1009*	1109	1209
13/32-7/16	.323	1010*	1110	1210
15/32	.354	—	1111	1211
1/2	.367	—	1112	1212
17/32	.398	—	1113	1213
9/16	.429	—	1114	1214
19/32	.460	—	1115*	1215
5/8	.480	—	1116*	1216
21/32	.511	—	1117*	1217
11/16	.542	—	1118*	1218
23/32	.573	—	—	1219
3/4	.590	—	—	1220
25/32	.621	—	—	1221
13/16	.652	—	—	1222
27/32	.684	—	—	1223
7/8	.697	—	—	1224
15/16	.760	—	—	1225*
1"	.800	—	—	1226*
1-1/16-1-1/8	.896	—	—	1227*

PIPE TAP BUSHINGS

1/16	.312	1050	1150	1250
1/8	.437	1051	1151*	1251
1/4	.562	—	1152*	1252
3/8	.701	—	—	1253
1/2	.688	—	—	1254
5/8	.813	—	—	1255
3/4	.907	—	—	1256*

RETAINING SPRINGS

—————	MB00-RS	MB0-RS	MB2-RS
-------	---------	--------	--------

UNIQUE DESIGN -- Bushing grips the tap around three-quarters of its circumference, and fits the hole in the floating holder in the same manner. Result? More accurate fitting and line-up of tap and bushing.

POSITIVE OPERATION -- Entire length of bushing firmly clamps tap shank. Less chance of tap being pushed back. HEAT-TREATED FOR LONG LIFE -- Made of quality carburizing steel and heat-treated.

TAP BUSHING SETS

00TAPSET = 1001 thru 1051
0TAPSET = 1101 thru 1152
2ATAPSET = 1202 thru 1214
2BTAPSET = 1215 thru 1227
2CTAPSET = 1250 thru 1256

- The sets are packaged in a convenient storage case.
- The price for a set is 10% less than when each bushing is ordered separately.

* Note: Thin wall bushings have only 1 split instead of 2 and have no retainer springs

** NOMINAL OD OF THREAD THAT TAP WILL CUT.

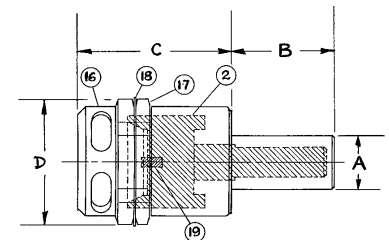
*** FOR TAPS SMALLER THAN #7 USE #0 TAP HOLDER AND TA02 ADAPTER.

RELEASING DIE HOLDERS FOR ACORN DIES

RELEASING ACORN DIE HOLDER SPECIFICATIONS

ACORN DIES ARE AVAILABLE FOR THESE HOLDERS - CALL FOR QUOTATION

CAT. NO.	A	B	C	D	ACORN DIE SIZE
ADH000	5/8	1-3/16	1-5/8	1-3/16	1
ADH00	5/8	1-1/4	1-13/16	1-9/16	2
ADH1	3/4	1-3/4	2-5/16	1-3/4	2
ADH2	1"	2"	2-7/8	2-7/16	3
ADH3	1-1/4	2-9/16	4-1/16	2-13/16	4



* These holders have the same exclusive releasing clutch mechanism as used on our releasing Tap Holder.

* A keyed washer is used between the adjusting cap and the lock nut. Tightening lock nut will not change the adjustment of die.

Somma

Broaching

Form & Shave

Dovetail Blanks

Cut Off

Swiss Turn

Box Turn

End Working

Knurling

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Waterbury, CT 06705 USA

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