

# Somma

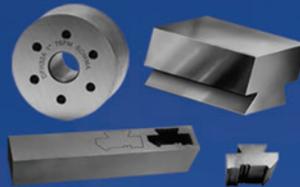
TOOL COMPANY, INC.

PREMIER TOOLING FOR THE MANUFACTURING INDUSTRY

*Rotary Broaching, Form Tooling, Dovetail Blanks,  
Workholding, Toolholding and more*



**BROACHING TOOLS  
& HOLDERS**



**TOOL BLANKS**



**QUICK CHANGE INSERTS  
FORMING & SHAVING**



**CUT OFF TOOLING**



**TAPPING & RETAPPING  
MACHINES**



**SWISS & CNC**

WEB

**SOMMATOOL.COM**

EMAIL

**SALES@SOMMATOOL.COM**

PHONE

**(203) 753-2114**

**109 SCOTT ROAD, WATERBURY, CT 06705**

*And now featuring our Max-Bar division  
of indexable insert tooling  
for CNC and Swiss*



**UNIVERSAL HOLDERS & INSERTS TO TURN,  
CUTOFF, GROOVE, THREAD & MORE**



**PROFILING**



**FACE GROOVING &  
I.D. APPLICATIONS**

# A DIRECTORY OF TOOLING AVAILABLE FROM SOMMA TOOL COMPANY

## Box Turning

Tangi-Square Insert Box Turning  
Triangular Insert Box Turning  
H.S.S. Tool Bit Box Turning

## Broaching, Internal

Swiss Adjustment Free Broach Tool Holders  
Adjustable Broach Tool Holders  
CNC Adjustment Free Broach Tool Holders  
Index Punch Broaching  
Broaches 8mm, 1/2", & 3/4" Dia.  
Gages: Set Up & Go / No Go

## Broaching, External

External Broach Tool Holders & Broaches

## Bushings / Tool Holding

Split Drill & Tap Bushings  
Type B, C, DD, J, L, LB, LBF, & Z Tool  
Holder Bushings  
Boring Bar Sleeves  
Taper Drill Sockets  
B&S Slotting Bushings

## Collets / Tool Holding

ER Drill & Tap Collets  
TG Drill & Tap Collets  
Erickson® "DA" Drill Collets  
Universal® Acura-Flex Drill Collets  
Sandvik® / Balas "C" Series Drill & Tap Collets  
5C Collets & R8 Collets

## Cutting-Off

Indexable Carbide Insert Cut Offs  
For Swiss, CNC, Davenport, & B&S  
Davenport & B&S Circular C/O & C/O  
Blade Holders  
T-Type C/O Blades & Acme C/O Blades  
Johnson Hollow Ground C/O Blades  
Twin Tip, Empire Style C/O Blades  
Davenport Circular Resharpenable Insert  
C/O Holders

## Drilling \*

Davenport & B&S Drill Holders  
Quick Change ER Collet System  
ER Collet, Collet Chucks  
ER Collet Double Ended Collet Chucks  
DA & TG Collet, Collet Chucks  
Automotive Threaded Shank Collet Chucks  
Solid Carbide Drills  
Flat Drill Blanks  
Drill Blanks

## Endmills \*

Solid Carbide

## End Working \*

Davenport Countersink  
Countersinking  
Spot Drilling  
Recess Tool Holders & Tool Blanks  
Tube End Forming Tooling  
Outside Deburring & Chamfering  
Inside Deburring & Chamfering

## Forming & Shaving

RQC Quick Change Resharpenable  
Form & Shave Tool System  
STAI Economical Quick Change  
Form Tool System  
Form Tool Calculation Program  
Spindle Speed/Surface Feet Calculator  
Dovetail Form Tool Holders  
Form Tool Blanks & Shave Tool Blanks  
Dovetail Checking Gages  
Dovetail Sharpening Fixtures  
Rectangular & Square Form Tool Blanks

## Knurling

Davenport Knurling Tools  
Self Centering Straddle Knurl Tools  
Adjustable Straddle Knurl Tools  
Swiss In-Line & T Style Straddle Knurl Tools  
Bump Style Single Knurl Tools  
Knurls

## Max-Bar Swiss Mini Shank Tooling

Full Range of Swiss Turning Holders  
& Inserts in Six Different I.C. Sizes for:

- Front & Back Turning
- Cutting Off
- Grooving
- Threading
- Plunge & Turn
- Face Grooving
- as well as I.D. Grooving, Threading & Boring

## Reaming

ER Collet Floating Reamer Holder  
DA Collet Floating Reamer Holder  
VDI Shank ER Collet Floating Reamer Holders  
Morse Taper Shank ER Collet Holder  
Solid Carbide Reamers

## Taper Shank Tooling

CAT40 & CAT50 Tool Holders  
BT40 & 50 Tool Holders

## Tapping

Tapping / Re-Tapping Second Operation  
Tension / Compression & Tension Only  
ER Collet Tap Holders  
Non-Releasing Tap Holders  
Releasing Tap Holders

## Workholding

Bar Pullers

\* See Our Website for Further Details

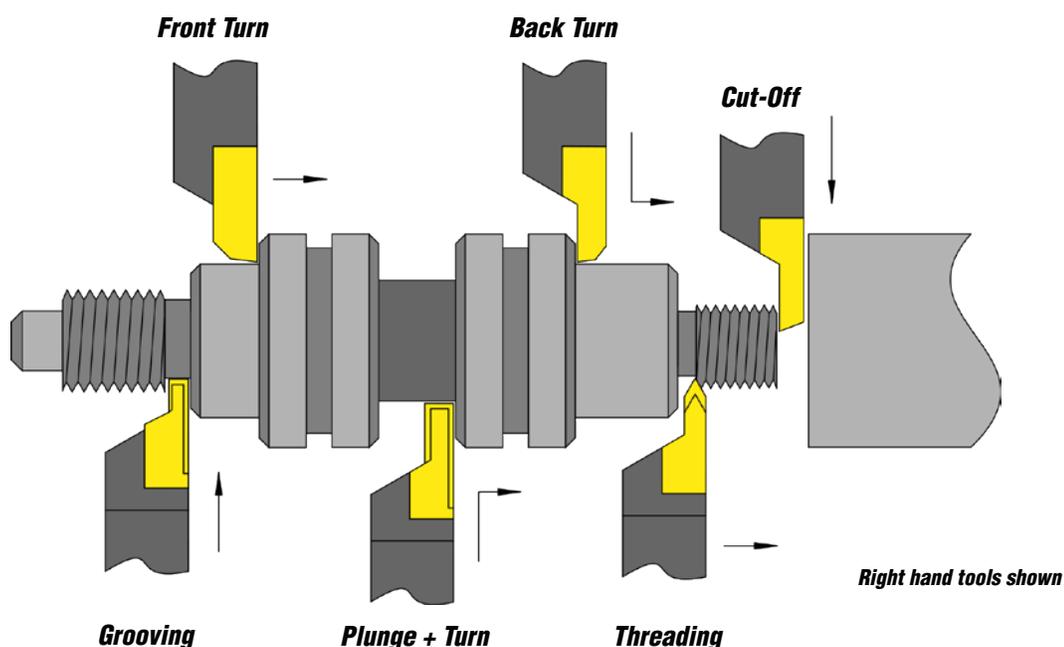
***Please visit our website [www.sommatool.com](http://www.sommatool.com) for a complete listing of our products.***

Somma Tool Company is the leading manufacturer in the United States to offer a full line of tooling for screw machines. We offer preset and quick change tooling in addition to cutting tools, tool holders, work holders and accessories for screw machines, turret lathes and CNC lathes. Our goal is to provide superior value and innovation in our products and services, and to conduct all of our business activities with our customers, distributors, employees and vendors with integrity and respect. Our products are sold through a nationwide and worldwide network of distributors. Contact us today.

# SOMMA / MAX-BAR MINI SHANK TOOLING

Designed to fit your Swiss type CNC screw machine without the need of modification or large offsets.

- Inserts are precision ground for repeatability
- Widest choice of inserts per holder
- Zero radius as standard



**Inserts are also available for Face Grooving, I.D. Grooving, I.D. Threading, and I.D. Boring**



**Diamond insert style, offered in 3 series sizes:**

**Series 6** (6mm I.C.)

**Series 8** (8mm I.C.)

**Series 50** (1/2" I.C.)



**Triangular insert style, offered in 3 series sizes:**

**Series 10** (3/8" Dia. Cap.)

**Series 16** (5/8" Dia. Cap.)

**Series 20** (3/4" Dia. Cap.)



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# ROTARY BROACHING

from **Somma**  
featuring our **FORTE** material



**The Toughest Broaching  
Material Available**

**Improved Wear Resistance  
for Better Tool Life**

**Industry Leading  
Depth of Cut**

**Industry-Wide  
Compatibility**

**Largest Stock of ANSI Hex  
& Squares Available for  
Same Day Shipping**

**Special Hex & Square  
Sizes Available  
in 1-2 Days**

**Internal adjustment-free holders available  
for Swiss and CNC lathes and mills.**

**Internal & External adjustable holders  
available for Davenport, Brown & Sharpe  
and multi-spindle screw machines.**

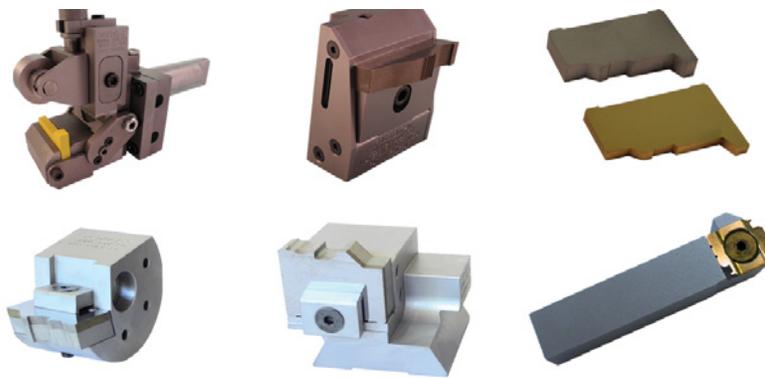
**Made to print Internal & External  
broaches are promptly quoted and  
manufactured!**



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# FORM TOOL FREEDOM

The freedom to choose the holders and inserts  
that best suit your product requirements.



*Learn more at*  
**FormToolFreedom.com**

## RQC

**RESHARPENABLE  
QUICK CHANGE**

**Economical inserts  
20-30 uses from 1 Insert**

**Always on center after  
resharpening**

**Great for part families**

**Can also accept  
single-use inserts**

## STA

**SINGLE-USE  
THROW-AWAY**

**Economical  
holders**

**Compact yet  
rigid design**

**0° or 5° top rakes**

## DIY

**MAKE YOUR  
OWN INSERTS**

**Have control over your  
design and deliveries!  
We provide the insert  
blanks and EDM fixtures  
so you can make your  
own inserts in-house.**

## SES

**SOMMA ENGINEERING  
SERVICES**

**Our tool design  
engineers will design  
the inserts from the part  
prints you send us. We'll  
provide you with a PDF  
print and DXF file so you  
can start cutting your  
inserts immediately.**

We also offer a full line of dovetail and circular tool blanks. We can even supply them finished to your part print.

See next page for details.

***Please visit our website [www.sommatool.com](http://www.sommatool.com) for a complete listing of our products.***

# FORMING & SHAVING

**Somma Tool Company has been the leader in circular and dovetail tool blanks since 1939.**

- Blanks are stocked in M42, T15PM, 76PM. We can also quote M2 upon request.
- Dovetails are also available Carbide Tipped.
- Semi-standard blanks and cutting tools engineered to your print can also be quoted.

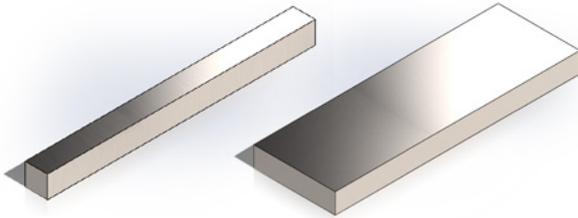
**Dovetail Form & Shave Tool Blanks**



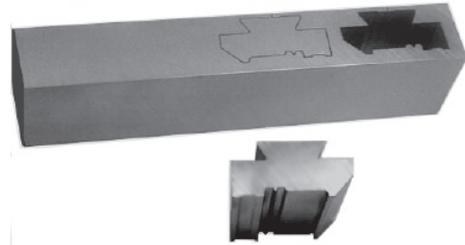
**Circular Form & Shave Tool Blanks**



**Flat Form Tool Blanks**

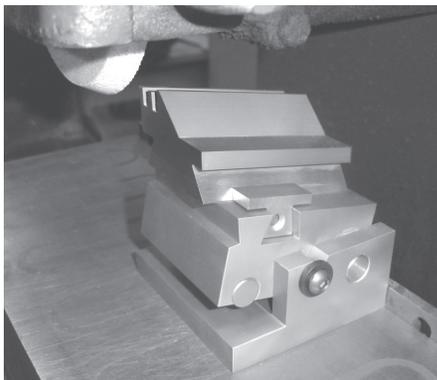


**EDM Wire Ready HSS Bars**



# SHARPENING FIXTURES

**Adjustable Dovetail  
Sharpening Fixtures**



**Dovetail Sharpening Fixtures  
For 12° and 17° Angles**



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# CUT OFF BLADES



## T Type Style

- Ground all over
- Concave ground top
- Blade centered

## JCO (Johnson Style) Hollow ground style

- Ground all over

**HIGH SPEED STEEL (HSS) BLADES ARE STOCKED IN M2, COBALT, AND T15PM.**



## Carbide Tipped T Type & Hollow Ground

- Micro-grain carbide for increased feeds

## Solid Carbide T Type Style

- Longer wearing, less galling, better finish, higher speeds than high speed steels, greater rigidity & up to 10x the resharpenable tool life of carbide tipped blades.

### Other cut off blades are also available including:

Carbide Tipped / Short Length T Type, Empire® Twin-Tip, and Acme “B” Type 7 Degree Beveled Style

### H.S.S. Cut-Off Blade *Grinding* Options

- CB = Chip Breaker groove ground along the top length of the blade
- TAPER = Side taper ground front to back along T portion of the blade

### H.S.S. Cut-Off Blade *Coating* Options

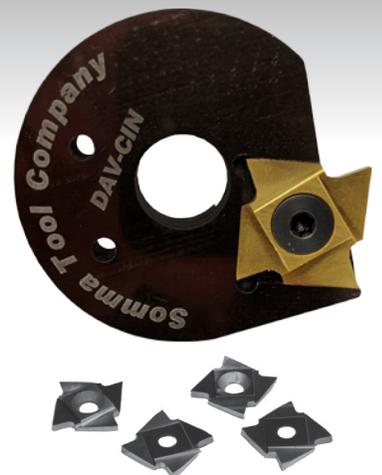
- TIN = A good general purpose coating for metal cutting
- TICN = This coating is recommended for machining high carbon steel, high silicon aluminums and tool steels
- TIALN = For machining cast iron, high nickel and titanium alloys, hardened steels and stainless steels. Good choice for interrupted applications
- NF = For non-ferrous materials like brass, copper, bronze & some aluminums

**\*\* Many more specialized coatings are also available. \*\***

# QUICK CHANGE CARBIDE INSERTED CIRCULAR CUTOFF HOLDERS

## For Davenport 5th Position, B&S Machines, and CNC Machines

- 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



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# RE-TAPPING AND TAPPING MACHINES



## BB-SR Retapping Machine

Deburr holes, countersink holes, chase threads, retap threaded parts

- 5/64" - 1/2" capacity chuck
- Retap threaded parts
- Chase threads
- Remove cut off burrs from threads
- Inspect threads
- Countersink holes
- Deburr holes
- Ream holes



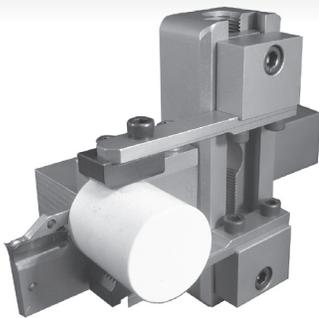
## STC-TAP-ER Tapping Machine

Heavy duty tapered cone drive taps up to 5/16-18 thread in 1/2" steel!

- 5/64" - 1/2" capacity chuck
- Push to tap in / pull to tap out
- Sliding face plate
- Easy to set stop for tap depth
- Comfortable bench height working area
- Long lasting tapered cone drive
- Pilot light switch

Both machines are also available with a variable speed motor

# BAR PULLERS FOR CNC



## Combination Bar Puller Cut-Off Tool

Gripping Range 1/8" - 3-1/4"

- Single wrench turn adjusts both gripping jaws
- Infinite size adjustment within the gripping range
- Quick change over adjustment to the next job
- Allows easy mounting and removal in any wedge lock turret
- Also allows mounting of the shank in any position in the tool holder pocket



## Bar Puller

- 1-1/16" Dia min to up to 2-1/2" Dia max adjustable pulling range for BP00 up to BP4
- 1-1/16" Dia min to up to 3" Dia max adjustable pulling range for BP5
- No springs, tension built into jaws for up to 250 lbs. of gripping pressure
- Jaws are easily replaced

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# ACCU-SET TURNING TOOLS

## With Exclusive TANGI-SQUARE QUICK CHANGE Micro-Grain Carbide Inserts

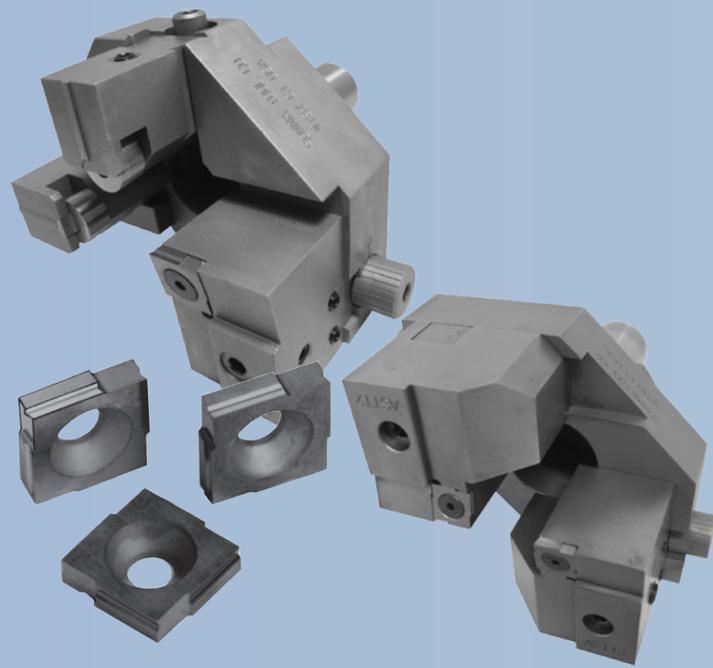
TANGI-SQUARE Carbide Inserts outperform all other inserts:

- Cut tangentially - not radially, Repeatability within .001"
- Shave turned diameter for better size control and finish
- Freer cutting action eliminates scroll lines on most applications
- 4 right hand cutting edges, produce square, sharp corners
- MICRO-GRAIN carbide for longest tool life
- Ideal 10° front clearance angle instead of 5° of triangular inserts
- For jobs on CNC lathes which do not have a tailstock
- For jobs that have a high diameter to

length ratio

- **Available:** 35° high top rake, and 5° top rake Square corner, .015 and .031 corner radius

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



Cat. No. <b>Rolling Style</b> Cat. No. <b>Balance Style</b>	<b>ASTT00</b> <b>BASTT00</b>	<b>ASTT0</b> <b>BASTT0</b>	<b>ASTT2</b> <b>BASTT2</b>
Shank Size Insert Series* Insert Max. Depth of Cut	5/8" Dia. x 1-9/32" TSQ00-..... 3/16"	3/4" Dia. x 1-1/2" TSQ2-..... 17/64"	1" Dia. x 1-15/16" TSQ2-..... 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

# WIDE SELECTION OF COLLET CHUCKS

## ER, DA, TG, AF, and Flexi Grip Collets



ER Collets



Double Angle Collets



TG Collets



Acura Flex Collets



Flexi Grip  
Collets



Large Nut  
Collet Chucks



Extended Nose  
Collet Chucks



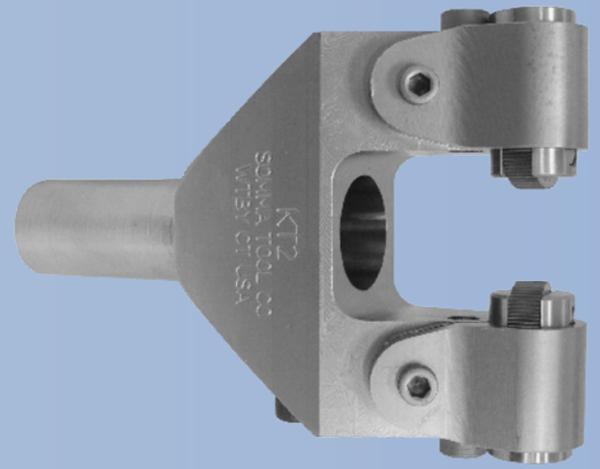
Adjustable Flange  
Collet Chucks

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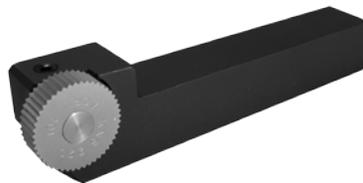
# KNURL TOOL HOLDERS

## Straddle Knurling Tool with Adjustable Knurl Angle

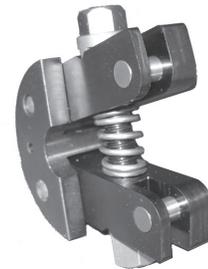
- Knurl can be adjusted to produce straight, diagonal, or diamond knurls by rotating the barrels.
- Holds drills for combined operations
- Standard with carbide knurl pins
- Same tool can be converted to “extra capacity” by changing barrels.



**Swiss Inline  
Straddle Holders**



**Up to the  
Shoulder Bump Holders**



**Straddle Knurl Holder  
for Davenport**

# DRILL & TAP BUSHINGS



## Precision Ground

Inside/Outside Dia. 1/2", 5/8", + 1" O.D.

## Heat Treated

For Longer Life

## Various Inside Diameters

Fractional, Letter, Metric & Tap

## Better Than Ever

Improved Concentricity

## Wedge Split

Grips Entire Length of Shank

# TOOL HOLDER BUSHINGS



Type B



Type C + CS



Type DD



Type J



Type LB



Type LBF



Type L



Type Z

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## ER COLLET FLOATING REAMER HOLDERS

- The free moving ball bearing drive allows reamers to follow the existing drilled hole for high quality work.
- Could be used for synchronized tapping operations on lathes and CNC machining centers.
- Through the shank coolant capability



## 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.



## RELEASING TAP HOLDERS

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.

- For right or left hand threading
- Eases tap into work for better matching of threads
- Simple operation
- No spring plungers to wear or break
- No. 000 size is extremely sensitive for small taps when used on high speed machines



## NON-RELEASING TAP HOLDERS

- Excellent for operations where release is not required.
- Smooth, extra long pullout.



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# Somma

Broaching

Swiss Turn

Form & Shave

Dovetail Blanks

Cut Off

Box Turn

End Working

Knurling

Tapping

Reaming

Drilling

Tool Bushings

Tool Collets

V-Flange Collet Chucks

Endmills

Workholding

and More

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