

SPECIAL "TO PRINT" DOVETAIL FORM TOOLS NOW AVAILABLE! CONTACT US FOR A PROMPT QUOTE.

- LOW COST
- AVAILABILITY
- NO WASTE
- SAVE SKILLED LABOR
- REDUCE STEEL INVENTORY
- ELIMINATE MILLING CUTTER COSTS

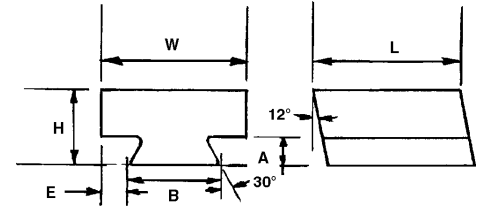
● Semi-standard blanks to your specifications in any material or quantity quoted upon request. Send for a supply of blank order forms.

H.S.S. DOVETAIL FORM TOOL BLANKS HARDENED AND GROUND

ALSO AVAILABLE SOFT - PRICES ON REQUEST



ASK FOR QUANTITY DISCOUNT PRICES FOR GREATER SAVINGS



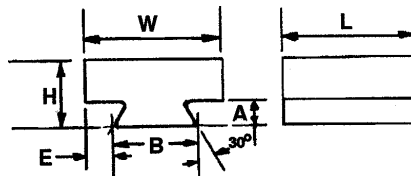
BLANKS SHOWN IN GRAY SHADED AREA ARE SEMI-STANDARD DELIVERY: 2-3 WEEKS

* SEE PAGES 64 & 65 FOR THESE HOLDERS.

Fits Dovetail Form Tool Holder	H	W	L	A	B	E	G	M-2 HSS	M-42 HSS	T15PM H.S.S.	76PM H.S.S.	FOR CARBIDE TIPPING	
												ALLOY TOOL STEEL FOR CARBIDE TIPPED SOFT GROUND DOVETAIL	4140 STEEL HARDENED TO R/C35-45 GROUND DOVETAIL
												Cat. No.	Cat. No.
3/8	3/4	1"	1-1/2	19/64	.700	1/4	-	3/8DTF-1	3/8DTF-1H	3/8DTF-1P	3/8DTF-1A	3/8DTF-1-SG	3/8DTF-1-HG
5/8	1"	1"	2-1/4	19/64	.951	1/16	-	5/8DTF-1	5/8DTF-1H	5/8DTF-1P	5/8DTF-1A	5/8DTF-1-SG	5/8DTF-1-HG
5/8	1"	1-1/2	2-1/4	19/64	.951	9/16	-	5/8DTF-2	5/8DTF-2H	5/8DTF-2P	5/8DTF-2A	5/8DTF-2-SG	5/8DTF-2-HG
5/8	1"	2"	2-1/4	19/64	.951	17/32	-	5/8DTF-3	5/8DTF-3H	5/8DTF-3P	5/8DTF-3A	5/8DTF-3-SG	5/8DTF-3-HG
1"	1-1/2	2"	3"	35/64	1.614	3/16	-	1DTF-1	1DTF-1H	1DTF-1P	1DTF-1A	1DTF-1-SG	1DTF-1-HG
1"	1-1/2	2-1/2	3"	35/64	1.614	7/16	-	1DTF-2	1DTF-2H	1DTF-2P	1DTF-2A	1DTF-2-SG	1DTF-2-HG
1"	1-1/2	3"	3"	35/64	1.614	11/16	-	1DTF-3	1DTF-3H	1DTF-3P	1DTF-3A	1DTF-3-SG	1DTF-3-HG
1-1/4	1-1/2	2"	3"	35/64	1.882	1/8	-	1-1/4DTF-1	1-1/4DTF-1H	1-1/4DTF-1P	1-1/4DTF-1A	1-1/4DTF-1-SG	1-1/4DTF-1-HG
1-1/4	1-1/2	2-1/2	3"	35/64	1.882	9/16	-	1-1/4DTF-2	1-1/4DTF-2H	1-1/4DTF-2P	1-1/4DTF-2A	1-1/4DTF-2-SG	1-1/4DTF-2-HG
1-1/4	1-1/2	3"	3"	35/64	1.882	9/16	-	1-1/4DTF-3	1-1/4DTF-3H	1-1/4DTF-3P	1-1/4DTF-3A	1-1/4DTF-3-SG	1-1/4DTF-3-HG
1-1/4	1-1/2	2"	2-1/4	35/64	1.882	1/8	-	1-1/4DTF-4	1-1/4DTF-4H	1-1/4DTF-4P	1-1/4DTF-4A	1-1/4DTF-4-SG	1-1/4DTF-4-HG
1-1/4	1-1/2	2-1/2	2-1/4	35/64	1.882	9/16	-	1-1/4DTF-5	1-1/4DTF-5H	1-1/4DTF-5P	1-1/4DTF-5A	1-1/4DTF-5-SG	1-1/4DTF-5-HG
1-1/4	1-1/2	3"	2-1/4	35/64	1.882	9/16	-	1-1/4DTF-6	1-1/4DTF-6H	1-1/4DTF-6P	1-1/4DTF-6A	1-1/4DTF-6-SG	1-1/4DTF-6-HG
1-5/8	1-1/2	3"	3"	35/64	2.238	3/8	-	1-5/8DTF-1	1-5/8DTF-1H	1-5/8DTF-1P	1-5/8DTF-1A	1-5/8DTF-1-SG	1-5/8DTF-1-HG
2-1/8	1-1/2	3"	3"	43/64	2.883	1/8	-	2-1/8DTF-1	2-1/8DTF-1H	2-1/8DTF-1P	2-1/8DTF-1A	2-1/8DTF-1-SG	2-1/8DTF-1-HG
Davenport DTH-DAV*	1"	1"	1-1/2	19/64	.951	1/16	1/4-28	DAV-DTF-1	DAV-DTF-1H	DAV-DTF-1P	DAV-DTF-1A	DAV-DTF-1-SG	DAV-DTF-1-HG
	1"	1-1/2	1-1/2	19/64	.951	19/64	1/4-28	DAV-DTF	DAV-DTF-H	DAV-DTF-P	DAV-DTF-A	DAV-DTF-SG	DAV-DTF-HG
NEW BRITAIN GRIDLEY	1-1/2	1-1/2	2"	9/16	1.253	1/4	-	NBDTF-1	NBDTF-1H	NBDTF-1P	NBDTF-1A	NBDTF-1-SG	NBDTF-1-HG
	1-1/2	2"	2"	9/16	1.253	3/8	-	NBDTF-2	NBDTF-2H	NBDTF-2P	NBDTF-2A	NBDTF-2-SG	NBDTF-2-HG
	1-1/2	2-1/2	2"	9/16	1.253	5/8	-	NBDTF-3	NBDTF-3H	NBDTF-3P	NBDTF-3A	NBDTF-3-SG	NBDTF-3-HG
	1-1/2	3"	2"	9/16	1.253	7/8	-	NBDTF-4	NBDTF-4H	NBDTF-4P	NBDTF-4A	NBDTF-4-SG	NBDTF-4-HG
DTH00*	3/4	1-1/4	1"	13/64	.714	17/64	10-32	DTH00-9	DTH00-9H	DTH00-9P	DTH00-9A	DTH00-9-SG	DTH00-9-HG
DTH0*	1"	1-1/2	1-5/16	19/64	.951	9/32	1/4-20	DTH0-9	DTH0-9H	DTH0-9P	DTH0-9A	DTH0-9-SG	DTH0-9-HG
DTH2*	1-1/2	2"	1-7/16	7/16	1.250	3/8	1/4-20	DTH2-9	DTH2-9H	DTH2-9P	DTH2-9A	DTH2-9-SG	DTH2-9-HG

H.S.S. DOVETAIL SHAVE TOOL BLANKS HARDENED AND GROUND

ALSO AVAILABLE SOFT - PRICES ON REQUEST



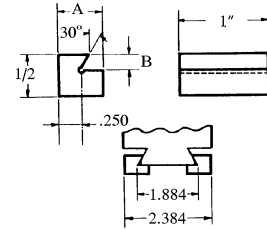
Fits Dovetail Shave Tool Holder	H	W	L	A	B	E	M-2 H.S.S.	M-42 H.S.S.	T15PM H.S.S.	76PM H.S.S.	FOR CARBIDE TIPPING	
											ALLOY TOOL STEEL SOFT GROUND DOVETAIL	4140 STEEL HARDENED GROUND DOVETAIL
											Cat. No.	Cat. No.
1/2	5/8	1-1/4	1-1/8	13/64	.714	3/8	1/2DTS-1	1/2DTS-1H	1/2DTS-1P	1/2DTS-1A	1/2DTS-1-SG	1/2DTS-1-HG
5/8	3/4	1"	1-1/2	17/64	.912	3/32	5/8DTS-1	5/8DTS-1H	5/8DTS-1P	5/8DTS-1A	5/8DTS-1-SG	5/8DTS-1-HG
5/8	3/4	1-1/2	1-1/2	17/64	.912	19/64	5/8DTS-2	5/8DTS-2H	5/8DTS-2P	5/8DTS-2A	5/8DTS-2-SG	5/8DTS-2-HG
5/8	3/4	2"	1-1/2	17/64	.912	35/64	5/8DTS-3	5/8DTS-3H	5/8DTS-3P	5/8DTS-3A	5/8DTS-3-SG	5/8DTS-3-HG
1"	1"	1-1/2	1-3/4	17/64	1.287	7/32	1DTS-1	1DTS-1H	1DTS-1P	1DTS-1A	1DTS-1-SG	1DTS-1-HG
1"	1"	2"	1-3/4	17/64	1.287	23/64	1DTS-2	1DTS-2H	1DTS-2P	1DTS-2A	1DTS-2-SG	1DTS-2-HG
1-1/4	1"	2"	1-3/4	17/64	1.554	11/32	1-1/4DTS-1	1-1/4DTS-1H	1-1/4DTS-1P	1-1/4DTS-1A	1-1/4DTS-1-SG	1-1/4DTS-1-HG
1-1/2	1"	2"	1-7/8	17/64	1.787	7/32	1-1/2DTS-1	1-1/2DTS-1H	1-1/2DTS-1P	1-1/2DTS-1A	1-1/2DTS-1-SG	1-1/2DTS-1-HG
1-5/8	1-1/2	2-1/2	2-9/16	25/64	2.057	11/32	1-5/8DTS-1	1-5/8DTS-1H	1-5/8DTS-1P	1-5/8DTS-1A	1-5/8DTS-1-SG	1-5/8DTS-1-HG

CAT. NO.	A	B
DTG-250	1/2	.185
DTG-250 x 100	13/32	.100

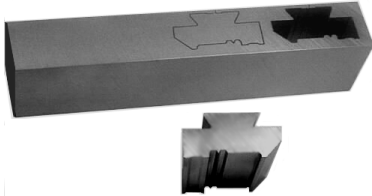
**SOLD AS A SET
2 PIECES**

DOVETAIL CHECKING GAGES

- EASIER THAN CHECKING OVER BALLS OR RODS.
- JUST ADD .500" TO THEORETICAL SHARP CORNER DIMENSION OF DOVETAIL. (SEE DIAGRAM.)



EDM WIRE READY H.S.S. BARS



**ASK FOR QUANTITY
DISCOUNT PRICES FOR
GREATER SAVINGS**

- HEAT TREATED / SURFACE GROUND
- FOR THOSE WHO HAVE WIRE EDM EQUIPMENT
- ECONOMICAL - MINIMUM WASTE
- USE ONLY WHAT YOU NEED FOR EACH JOB
- AVAILABLE IN M2, M42, T15PM AND 76PM HIGH SPEED STEEL

EDM WIRE READY H.S.S. BARS

CAT. NO.	HEIGHT	WIDTH	LENGTH	M42	T15PM	76PM
				CAT. NO.	CAT. NO.	CAT. NO.
EDM4848	1"	2"	12"	EDM4848-H	EDM4848-P	EDM4848-A
EDM6848	1-1/2"	2"	12"	EDM6848-H	EDM6848-P	EDM6848-A
EDM8848	2"	2"	12"	EDM8848-H	EDM8848-P	EDM8848-A
EDM81248	2"	2-1/2"	12"	EDM81248-H	EDM81248-P	EDM81248-A

*CAN ALSO BE SUPPLIED IN
SPECIAL SIZES TO YOUR
SPECIFICATIONS. PRICES ON
APPLICATION - SPECIFY
QUANTITY, HEIGHT, WIDTH
AND LENGTH.*

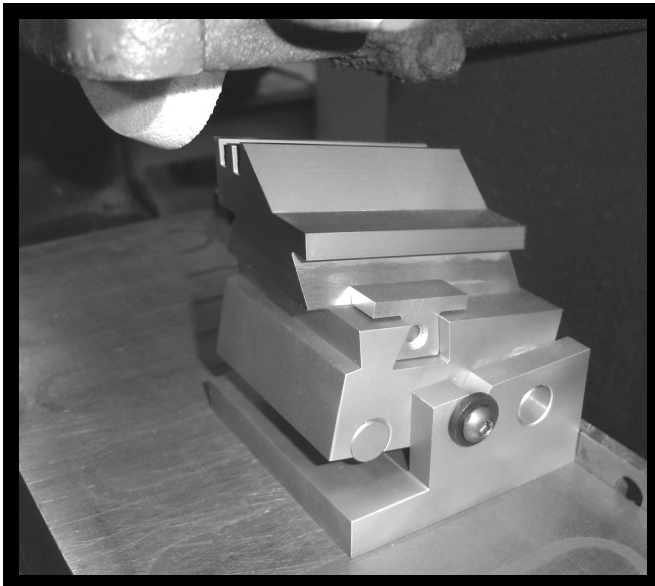
DOVETAIL SHARPENING FIXTURE



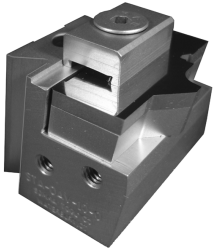
- CAN BE USED IN BOTH VERTICAL AND HORIZONTAL POSITIONS
- FOR DOVETAIL SIZES UP TO 1.882 (1-1/4)
- SUPPLIED WITH SPACERS FOR THE FOLLOWING ANGLES:
0, 2, 12, 17, 19.5 & 22 DEGREES

**Cat. No.
DSF**

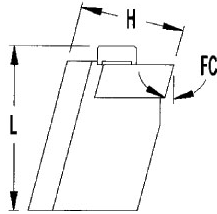
CAN ALSO SUPPLY SPACERS FOR OTHER ANGLES



EQUIP ALL YOUR MACHINES WITH INEXPENSIVE QUICK CHANGE INSERT FORM TOOL HOLDERS!



**STA
Dovetail Holder**



EXCLUSIVE FEATURES:

- Choose from full-width holder for parts up to 1-1/4" long or L-style holders for parts up to 3/4" long that require working close to the spindle or clearance for tools on the turret or tool spindle.
- Same holder can accommodate part forms up to 1/2" depth of cut (3/8" depth of cut for Davenport).
- Uses simple but rugged backup ANVIL (No need for expensive tailor made screwed on anvils).
- Ideal for Datum Point applications.
- Integral insert clamp and screw make it easy to install inserts.
- Dovetail holders available for Davenport, Acme, New Britain and CNC machines.
- Choice of 0° or 5° top rake angles for cutting of ferrous and non-ferrous metals.
- Compact and rigid one-piece body design.
- Pin locating system within +/- .001".
- Keyed inserts make it impossible to mistakenly use a 0° insert on a 5° holder, or a 5° insert on a 0° holder.

Dovetail-Style Holders										
Fits Holder	Dovetail	Front Clearance Angle (FC)	H	L	Max Depth of Cut	Max Width of Cut	Top Rake Angle	Catalog #	Uses Insert #	Uses Spacer #
5/8"	0.951	12°	1.42	2-1/4"	1/2"	1-1/4"	0°	STA-5/8-0	STAI-128-3	STAS-3/8-2
							5°	STA-5/8-5		
							0°	STA-5/8-0L	STAI-103-2	STAS-3/8-3
							5°	STA-5/8-5L		
1-1/4"	1.882	12°	1.66	2-1/4"	1/2"	1-1/4"	0°	STA-1-1/4-0	STAI-128-3	STAS-3/8-2
							5°	STA-1-1/4-5		
NBG	1.253	12°	1.66	2-1/4"	1/2"	1-1/4"	0°	STA-1.253-0	STAI-128-3	STAS-3/8-2
							5°	STA-1.253-5		
							0°	STA-1.253-0L	STAI-103-2	STAS-3/8-3
							5°	STA-1.253-5L		
NBG	1.827	12°	1.66	2-1/4"	1/2"	1-1/4"	0°	STA-1.827-0	STAI-128-3	STAS-3/8-2
							5°	STA-1.827-5		
DAV	0.951	10°	1.215	1-1/2"	3/8"	1-1/4"	0°	STA-DAV-10-0	STAI-128-1	STAS-1/4-1
							5°	STA-DAV-10-5		
						0°	STA-DAV-10-0L	STAI-103-1	STAS-1/4-4	
						5°	STA-DAV-10-5L			
DAV	0.951	12°	1.215	1-1/2"	3/8"	1-1/4"	0°	STA-DAV-12-0	STAI-128-1	STAS-1/4-1
							5°	STA-DAV-12-5		
						0°	STA-DAV-12-0L	STAI-103-1	STAS-1/4-4	
						5°	STA-DAV-12-5L			

Circular-Style Holders

Fits Holder	Diameter	Front Clearance Angle (FC)	Center Offset	Max Depth of Cut	Max Width of Cut	Top Rake Angle	Catalog #	Uses Insert #	Uses Spacer #
00	1-3/4"	12°	1/8"	1/4"	1"	0°	STA-00-C-0	STAI-103-3	STAS-1/4-5
						5°	STA-00-C-5		
0	2-1/4"	12°	5/32"	1/2"	1-1/4"	0°	STA-0-C-0	STAI-128-4	STAS-1/4-2
						5°	STA-0-C-5		STAS-1/4-3
2	3"	12°	1/4"	5/8"	1-1/4"	0°	STA-2-C-0	STAI-128-1	STAS-3/8-1
						5°	STA-2-C-5	STAI-128-2	STAS-3/8-2
Dav	2"	12°	1/8"	3/8"	1-1/4"	0°	STA-DAV-C-0	STAI-128-1	STAS-1/4-1
						5°	STA-DAV-C-5	STAI-128-2	

Holders are also available with coolant attachment. Add "-CS" to the holder catalog#.



**STA Circular
Holder**

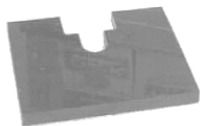
FORMED INSERTS TO YOUR PRINT

Send print for a prompt quote!



FOR THOSE WITH EDM FACILITIES:

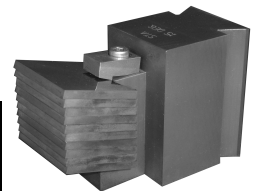
Insert Blanks & Spacers are available for EDMing in your plant. Blanks are available in micrograin carbide, C2, 76PM HSS and MAXAMET.



- EDM your inserts in house - save money - expedite delivery!
- STA-EDM Fixture for EDMing inserts available.
- Fixture can hold 10 inserts

EDM FIXTURES

Catalog Number	Included Angle	Front Clearance Angle	Top Rake Angle
STA-EDM-10	10	10	0
STA-EDM-12	12	12	0
STA-EDM-15	15	10	5
STA-EDM-17	17	12	5





PRO-CALC SPINDLE SPEED/ SURFACE FEET CALCULATOR

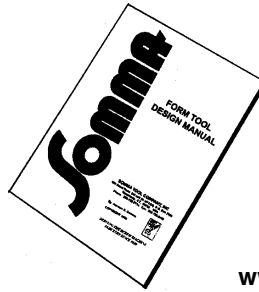
Cat. No.
PRO-CALC.®

- Merely select material:**
Choose from 34 materials
- Select machine operation:**
Cutoff/Form Tool
End mill
Drill/Counterbore
Tapping
Face Mill
- Select Diameter:**
Part Diameter
Tool Diameter

Calculates surface feet, RPM, feed rate for turning, drilling, tapping and milling. Inches or metric.

Hand held - Can be used at machine location.

THE SOMMA FORM TOOL DESIGN MANUAL ANSWERS ALL THE QUESTIONS YOU WANTED TO KNOW ABOUT FORM TOOL DESIGNING.



- CHECKLIST
- DRAWING
- CALCULATING
- DIMENSIONING
- HELPFUL IDEAS
- USEFUL TABLES
- SELECTING TOOL MATERIAL
- FORM TOOL GEOMETRY

Download and print a free copy at www.sommatool.com or contact us to purchase one.

FORM TOOL CALCULATION PROGRAM

SOMMA'S EXCLUSIVE PROGRAM WILL PERFORM ALL YOUR FORM TOOL CALCULATIONS

FEATURES:

- Leads you through problems.
- Eliminates long, complicated manual calculations.
- Eliminates corrected diameter tables, charts, graphs, trig tables, and square root calculations.
- Calculates any Circular Form Tool - regardless of Diameter, Offset or Top Rake.
- Calculates any Flat Type Form Tool - regardless of Front Clearance Angle or Top Rake.
- Can print out answers for a permanent record.

Cat. No.
FTSCW

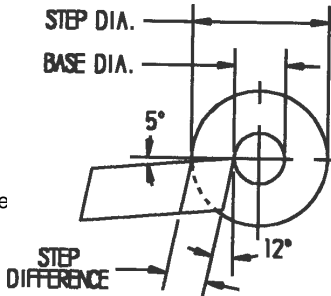
Download a free demo today at www.sommatool.com

FOR RESHARPENABLE QUICK CHANGE CHANGE FORM TOOL INSERTS

All you need to do is enter:

- Front Clearance Angle = 12°
- Top Rake Angle = 5°
- Base Diameter of Part =

Then as you enter each part diameter, the program calculate the corrected step difference.

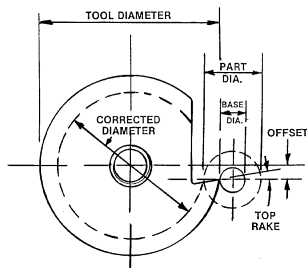
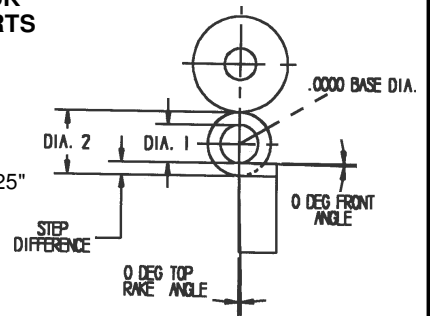


FOR RESHARPENABLE QUICK CHANGE CHANGE SHAVE TOOL INSERTS

All you need to do is enter:

- Front Clearance Angle = 0°
- Top Rake Angle = 0°
- Base Diameter of Part = .000", .125"

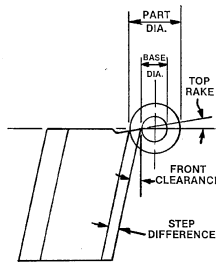
or .500" depending on holder being used. Then as you enter each part diameter, the program calculates the corrected step difference.



FOR CIRCULAR FORM TOOLS

All you need to do is enter:

- Tool Diameter ---
- Tool Offset Distance---
- Top Rake Angle---
- Base Diameter of Part---
- Then as you enter each part diameter, the program calculates tool diameter and step difference.



FOR FLAT TYPE FORM TOOLS

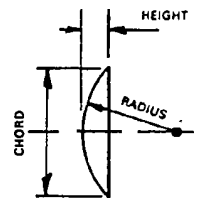
All you need to do is enter:

- Front Clearance Angle---
- Top Rake Angle---
- Base Diameter of Part---
- Then as you enter each part diameter, the program calculates the corrected step difference.

FOR RADIUS PROBLEMS

All you need to do is:

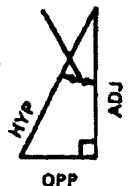
- Enter any two of the three dimensions of a chord.
- The program will calculate the third dimension.



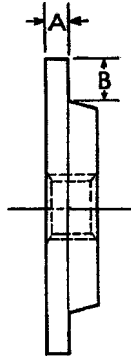
FOR TRIANGLE PROBLEMS

All you need to do is:

- Enter any two of the four dimensions of a right angle triangle---
- The program will calculate the remaining two dimensions.



B&S CIRCULAR FORM TOOL BLANKS



* Flange type (cutaway blanks)
save grinding time on narrow tools.

ALL BLANKS ARE AVAILABLE WITH PIN HOLES TO THE FOLLOWING SPECIFICATIONS				
Mach. Size	No. of Holes	Dia.	Depth	Bolt Circle
#00 B&S	8	5/32	5/16	1-1/16
#00 TRAUB	8	1/8	5/16	.787
#0 B&S	6	3/16	5/16	1-3/8
#2 B&S	6	3/16	3/8	1-1/2

*Specify type when ordering #00 Blanks.
**PRICES ON APPLICATION FOR THRU
HOLES OR ANY VARIATION OF
THESE SPECIFICATIONS.**

- Hardened and Surface ground both sides
- O.D. turned only

CUTTING TOOLS

WIDTH		M2 H.S.S.	M42 H.S.S.	T15PM H.S.S.	76PM H.S.S.	
A	B	CAT. NO.	CAT. NO.	CAT. NO.	CAT. NO.	
#00 B&S 1-3/4" Dia.		3/8-16 Tap Hole				
* FLANGE	.080	7/32	00FLH08	00FLH08H	00FLH08P	00FLH08A
	.120	1/4	00FLH12	00FLH12H	00FLH12P	00FLH12A
	.160	1/4	00FLH16	00FLH16H	00FLH16P	00FLH16A
	.200	1/4	00FLH20	00FLH20H	00FLH20P	00FLH20A
	1/4		00BH8	00BH8H	00BH8P	00BH8A
	5/16		00BH10	00BH10H	00BH10P	00BH10A
	3/8		00BH12	00BH12H	00BH12P	00BH12A
	7/16		00BH14	00BH14H	00BH14P	00BH14A
	1/2		00BH16	00BH16H	00BH16P	00BH16A
	9/16		00BH18	00BH18H	00BH18P	00BH18A
	5/8		00BH20	00BH20H	00BH20P	00BH20A
	3/4		00BH24	00BH24H	00BH24P	00BH24A
	7/8		00BH28	00BH28H	00BH28P	00BH28A
	1"		00BH32	00BH32H	00BH32P	00BH32A
	1-1/8		00BH36	00BH36H	00BH36P	00BH36A
	1-1/4		00BH40	00BH40H	00BH40P	00BH40A
	1-3/8		00BH44	00BH44H	00BH44P	00BH44A
	1-1/2		00BH48	00BH48H	00BH48P	00BH48A
	1-5/8		00BH52	00BH52H	00BH52P	00BH52A
	1-3/4		00BH56	00BH56H	00BH56P	00BH56A

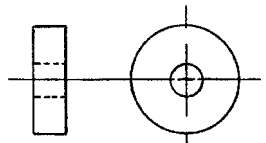
WIDTH		M2 H.S.S.	M42 H.S.S.	T15PM H.S.S.	76PM H.S.S.	
A	B	CAT. NO.	CAT. NO.	CAT. NO.	CAT. NO.	
#0 B&S 2-1/4" Dia.		1/2-13 Tap Hole				
* FLANGE	.100	1/4	0FLH10	0FLH10H	0FLH10P	0FLH10A
	.150	3/8	0FLH15	0FLH15H	0FLH15P	0FLH15A
	.200	3/8	0FLH20	0FLH20H	0FLH20P	0FLH20A
	.250	3/8	0FLH25	0FLH25H	0FLH25P	0FLH25A
	5/16		0BH10	0BH10H	0BH10P	0BH10A
	3/8		0BH12	0BH12H	0BH12P	0BH12A
	7/16		0BH14	0BH14H	0BH14P	0BH14A
	1/2		0BH16	0BH16H	0BH16P	0BH16A
	9/16		0BH18	0BH18H	0BH18P	0BH18A
	5/8		0BH20	0BH20H	0BH20P	0BH20A
	3/4		0BH24	0BH24H	0BH24P	0BH24A
	7/8		0BH28	0BH28H	0BH28P	0BH28A
	1"		0BH32	0BH32H	0BH32P	0BH32A
	1-1/8		0BH36	0BH36H	0BH36P	0BH36A
	1-1/4		0BH40	0BH40H	0BH40P	0BH40A
	1-3/8		0BH44	0BH44H	0BH44P	0BH44A
	1-1/2		0BH48	0BH48H	0BH48P	0BH48A
	1-5/8		0BH52	0BH52H	0BH52P	0BH52A
	1-3/4		0BH56	0BH56H	0BH56P	0BH56A
	1-7/8		0BH60	0BH60H	0BH60P	0BH60A
	2"		0BH64	0BH64H	0BH64P	0BH64A

WIDTH		M2 H.S.S.	M42 H.S.S.	T15PM H.S.S.	76PM H.S.S.	
A	B	CAT. NO.	CAT. NO.	CAT. NO.	CAT. NO.	
#2 B&S 3" Dia.		5/8-11 Tap Hole				
* FLANGE	1/8	3/8	2FLH4	2FLH4H	2FLH4P	2FLH4A
	3/16	1/2	2FLH6	2FLH6H	2FLH6P	2FLH6A
	1/4	1/2	2FLH8	2FLH8H	2FLH8P	2FLH8A
	5/16	1/2	2FLH10	2FLH10H	2FLH10P	2FLH10A
	3/8		2BH12	2BH12H	2BH12P	2BH12A
	7/16		2BH14	2BH14H	2BH14P	2BH14A
	1/2		2BH16	2BH16H	2BH16P	2BH16A
	9/16		2BH18	2BH18H	2BH18P	2BH18A
	5/8		2BH20	2BH20H	2BH20P	2BH20A
	3/4		2BH24	2BH24H	2BH24P	2BH24A
	7/8		2BH28	2BH28H	2BH28P	2BH28A
	1"		2BH32	2BH32H	2BH32P	2BH32A
	1-1/8		2BH36	2BH36H	2BH36P	2BH36A
	1-1/4		2BH40	2BH40H	2BH40P	2BH40A
	1-3/8		2BH44	2BH44H	2BH44P	2BH44A
	1-1/2		2BH48	2BH48H	2BH48P	2BH48A
	1-5/8		2BH52	2BH52H	2BH52P	2BH52A
	1-3/4		2BH56	2BH56H	2BH56P	2BH56A
	1-7/8		2BH60	2BH60H	2BH60P	2BH60A
	2"		2BH64	2BH64H	2BH64P	2BH64A
	2-1/4		2BH72	2BH72H	2BH72P	2BH72A
	2-1/2		2BH80	2BH80H	2BH80P	2BH80A
	2-3/4		2BH88	2BH88H	2BH88P	2BH88A
	3"		2BH96	2BH96H	2BH96P	2BH96A
	3-1/4		2BH104	2BH104H	2BH104P	2BH104A
	3-1/2		2BH112	2BH112H	2BH112P	2BH112A
	3-3/4		2BH120	2BH120H	2BH120P	2BH120A
	4"		2BH128	2BH128H	2BH128P	2BH128A

**BLANKS SHOWN IN GRAY SHADED AREA ARE SEMI-STANDARD
DELIVERY: 1-2 WEEKS**

BLANKS FOR B&S CIRCULAR POINTING TOOLS

- M2 H.S.S. - Hardened
- I.D. and Both Sides Ground
- O.D. Turned



MACH. SIZE	O.D.	WIDTH	I.D.	CAT. NO.
#00 B&S	1-1/8	1/4	3/8	00PTBL
#0 B&S	1-3/8	3/8	3/8	0PTBL
#2 B&S	1-3/4	1/2	1/2	2PTBL

DAVENPORT FORM TOOL BLANKS

also used on the 7/16" National Acme
and the 9/16" Conomatic.



2" Diameter
9/16" Center Hole,
(6) 9/64 Dia. Pin Holes
Thru On 1-1/4 B.C.

Hardened and surface
ground both sides O.D. turned only.

* F L A N G E	WIDTH		M2 H.S.S.	M42 H.S.S.	T15PM H.S.S.	76PM H.S.S.
	A	B	CAT. NO.	CAT. NO.	CAT. NO.	CAT. NO.
	1/8	1/4	DFLH4	DFLH4H	DFLH4P	DFLH4A
	3/16	1/4	DFLH6	DFLH6H	DFLH6P	DFLH6A
	1/4		DFH8	DFH8H	DFH8P	DFH8A
	5/16		DFH10	DFH10H	DFH10P	DFH10A
	3/8		DFH12	DFH12H	DFH12P	DFH12A
	7/16		DFH14	DFH14H	DFH14P	DFH14A
	1/2		DFH16	DFH16H	DFH16P	DFH16A
	9/16		DFH18	DFH18H	DFH18P	DFH18A
	5/8		DFH20	DFH20H	DFH20P	DFH20A
	3/4		DFH24	DFH24H	DFH24P	DFH24A
	7/8		DFH28	DFH28H	DFH28P	DFH28A
	1"		DFH32	DFH32H	DFH32P	DFH32A
	1-1/8		DFH36	DFH36H	DFH36P	DFH36A
	1-1/4		DFH40	DFH40H	DFH40P	DFH40A
	1-3/8		DFH44	DFH44H	DFH44P	DFH44A
	1-1/2		DFH48	DFH48H	DFH48P	DFH48A
	1-5/8		DFH52	DFH52H	DFH52P	DFH52A
	1-3/4		DFH56	DFH56H	DFH56P	DFH56A
	1-7/8		DFH60	DFH60H	DFH60P	DFH60A
	2"		DFH64	DFH64H	DFH64P	DFH64A

DAVENPORT SIZE TOOL BLANKS



1-5/16" Diameter
7/16-20 L.H. Thread

Hardened and surface
ground both sides O.D. turned only.

WIDTH	M2 H.S.S.	M42 H.S.S.	T15PM H.S.S.	76PM H.S.S.
	CAT. NO.	CAT. NO.	CAT. NO.	CAT. NO.
1/4	DSH8	DSH8H	DSH8P	DSH8A
5/16	DSH10	DSH10H	DSH10P	DSH10A
3/8	DSH12	DSH12H	DSH12P	DSH12A
7/16	DSH14	DSH14H	DSH14P	DSH14A
1/2	DSH16	DSH16H	DSH16P	DSH16A
9/16	DSH18	DSH18H	DSH18P	DSH18A
5/8	DSH20	DSH20H	DSH20P	DSH20A
3/4	DSH24	DSH24H	DSH24P	DSH24A
7/8	DSH28	DSH28H	DSH28P	DSH28A
1"	DSH32	DSH32H	DSH32P	DSH32A
1-1/8	DSH36	DSH36H	DSH36P	DSH36A
1-1/4	DSH40	DSH40H	DSH40P	DSH40A
1-3/8	DSH44	DSH44H	DSH44P	DSH44A
1-1/2**	DSH48	DSH48H	DSH48P	DSH48A

** NOTE: 1-1/2" WIDE BLANKS COUNTERBORED .501 DIA X 1-1/16" DEEP

DAVENPORT ROLL BLANKS

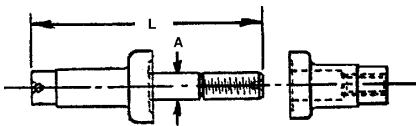


Hardened 52100 steel
(RC/55) Surface ground both sides
O.D. rough ground only
15/16 O.D.
.3125/.313 HONED I.D.

WIDTH	CAT. NO.
1/4	DR8
5/16	DR10
3/8	DR12
7/16	DR14
1/2	DR16

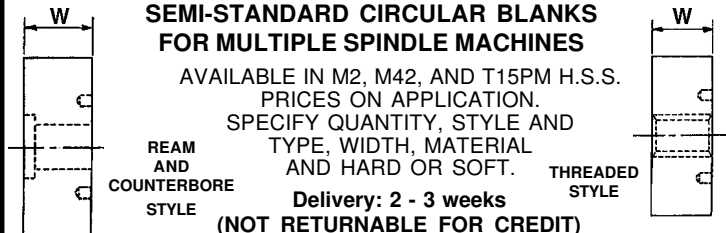
WIDTH	CAT. NO.
9/16	DR18
5/8	DR20
3/4	DR24
7/8	DR28
1"	DR32

GRINDING ARBORS FOR CIRCULAR FORM TOOLS



- TOOL MOUNTED ON TAP DRILL HOLE SIZE ("A" DIM.)
- ELIMINATES TRUING UP TOOLS
- ELIMINATES JAMMING ON ARBOR
- DRIVE DOG CAN BE PLACED ON EITHER END
- SUPPLIED IN SETS OF ARBOR AND THREE DIFFERENT LENGTH NUTS

DESCRIPTION	CAT. NO.	A	L
Set of #00 B&S Grinding Arbor and 3 clamping nuts for form tools with 3/8"-16 thread.	GA00	.312	4-5/8
Set of #0 B&S Grinding Arbor and 3 clamping nuts for form tools with 1/2"-13 or 1/2"-14 thread.	GA0	.421	4-5/8
Set of #2 B&S Grinding Arbor and 3 clamping nuts for form tools with 5/8"-11 or 5/8"-12 thread.	GA2	.531	4-5/8
Set of Davenport Grinding Arbor and 3 clamping nuts for form tools with 9/16" Dia. Center hole.	GADF	.562	4-5/8
Set of Davenport Grinding Arbor and 3 clamping nuts for size tools with 7/16"-20 L.H. thread.	GADS	.386	4-5/8
Set of Grinding Arbor and 3 clamp nuts for tools with 5/8 Dia. center hole.	GA5/8	.624	4-5/8
Set of Grinding Arbor and 3 clamp nuts for tools with 3/4 Dia. center hole.	GA3/4	.749	4-5/8



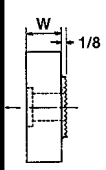
SEMI-STANDARD CIRCULAR BLANKS FOR MULTIPLE SPINDLE MACHINES

AVAILABLE IN M2, M42, AND T15PM H.S.S. PRICES ON APPLICATION. SPECIFY QUANTITY, STYLE AND TYPE, WIDTH, MATERIAL AND HARD OR SOFT.

Delivery: 2 - 3 weeks
(NOT RETURNABLE FOR CREDIT)

Available:

NBH Style	2-1/4" Dia. for New Britain
GH Style	2-3/8" Dia. for Greenlee
CH Style	3" Dia. for Cleveland
4H Style	3-1/2" Dia. for NBG, B&S & Cleveland
6H Style	4" Dia. for Brown & Sharpe



SEMI-STANDARD CIRCULAR BLANKS WITH SIDE TEETH

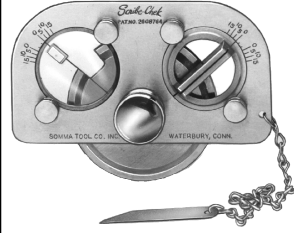
AVAILABLE IN M2, M42, AND T15PM H.S.S. PRICES ON APPLICATION. SPECIFY QUANTITY, STYLE, WIDTH, MATERIAL AND HARD OR SOFT.

Delivery 2 weeks.
(NOT RETURNABLE FOR CREDIT)

Available:

R1H Style	1-7/8" Dia. for Acme
R2H Style	2-3/8" Dia. for Acme
R3H Style	3" Dia. for Acme
R4H Style	3-3/8" Dia. for Acme

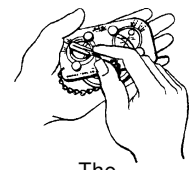
SCRIBE-CHEK CUTTING EDGE GAGE



Enjoy these Advantages:

- No tool life lost in grinding. Tool can be properly sharpened the first time.
- More correct pieces per grind.
- No more costly "cut and try" tool sharpening.
- Saves machine down time and operators' time.

Even inexperienced operators can sharpen tools correctly. Just brush tool surface with steel blue, screw tool on gage, scribe through slotted ring (which can be set to any rake desired), and then grind to this line. Sharpened edge can then be checked visually through the adjustable hair-line lens.

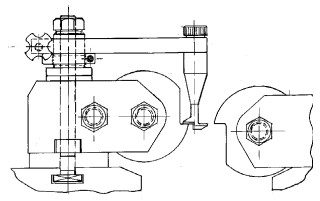


The Simple, Accurate Method for Sharpening Circular Form Tools

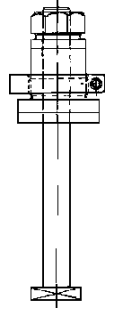
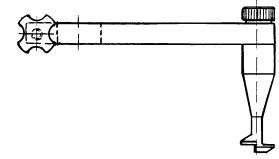
MACH. SIZE	CAT. NO.
#00 B&S	SCK00
#0 B&S	SCK0
#2 B&S	SCK2
DAVENPORT	SCKDAV

Part No.	ITEM
SCK00-1	Plate for SCK00
SCK0-1	Plate for SCK0
SCK2-1	Plate for SCK2
SCKDAV-1	Plate for SCKDAV
SCK00-2	Stud for SCK00
SCK0-2	Stud for SCK0
SCK2-2	Stud for SCK2
SCKDAV-2	Stud for SCKDAV
SCK00-3	Knob w/Set Screw for SCK00
SCK0-3	Knob w/Set Screw for SCK0
SCK2-3	Knob w/Set Screw for SCK2
SCK2-3	Knob w/Set Screw for SCKDAV
SCK-4	Hairline Lens-All Sizes
SCK-5	Slotted Ring-All Sizes
SCK-6	Blade-All Sizes
SCK-7	Clamp Screw & Washer-All Sizes
SCK-8	Chain and Rings-All Sizes

CENTER SETTING GAGE FOR B&S FORM TOOLS



- Easy to set tools to center
- No more cut and try
- Save operator time
- For front or rear slide
- For forward or reverse rotation
- For circular or dovetail tools



Once adjustable collar and bolt assembly is installed on tool post and set to center height, all that is necessary to set tool to center is to place the swing arm onto the adjustable collar and set cutting tool against setting gage. Swing arm setting gage can be moved from machine to machine.

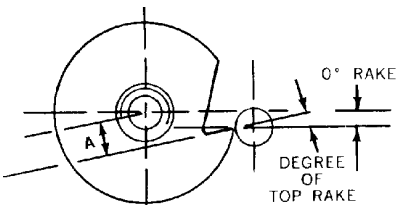
SWING ARM SETTING GAGE
(ONLY ONE REQUIRED FOR SEVERAL MACHINES)

ADJUSTABLE COLLAR POST ASSEMBLY
(ONE REQUIRED FOR EACH TOOL POST)

MACH. SIZE	CAT. NO.
NO. 00	CSG-00
NO. 2	CSG-2

MACH. SIZE	CAT. NO.
NO. 00	CGP-00
NO. 2	CGP-2

TABLE OF BELOW-CENTER GASHING DISTANCE FOR VARIOUS TOP RAKES ON CIRCULAR FORM TOOLS

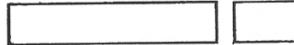


Degree of Top Rake	No. 00 B&S 1-3/4" Dia. "A"	No. 0 B&S 2-1/4" Dia. "A"	No. 2 B&S 3" Dia. "A"	Davenport 2" Dia. "A"
0	.125	.156	.250	.125
3	.170	.214	.327	.177
5	.200	.252	.378	.211
7	.230	.291	.428	.245
10	.273	.347	.503	.295
12	.302	.384	.552	.328
15	.345	.439	.624	.378

To simplify tool sharpening, use our Scribe-Check Cutting Edge Gage

T15PM H.S.S. FLAT FORM TOOL BLANKS

1/16 X 1/2 X 6-P	3/8 X 1.25 X 10-P
3/32 X 1/2 X 6-P	3/8 X 1.5 X 6-P
3/32 X 1 X 6-P	1/2 X 5/8 X 4.5-P
1/8 X 1/2 X 6-P	1/2 X 3/4 X 5-P
1/8 X 3/4 X 6-P	1/2 X 3/4 X 6-P
1/8 X 1 X 6-P	1/2 X 1 X 5-P
5/32 X 5/8 X 6-P	1/2 X 1 X 6-P
5/32 X 1 X 6-P	1/2 X 1 X 7-P
3/16 X 1 X 6-P	1/2 X 1.25 X 9-P
1/4 X 3/8 X 6-P	1/2 X 1.5 X 5-P
1/4 X 1/2 X 4-P	1/2 X 1.5 X 7-P
1/4 X 1/2 X 6-P	5/8 X 3/4 X 4-P
1/4 X 3/4 X 6-P	5/8 X 1 X 7-P
1/4 X 1 X 6-P	5/8 X 1.25 X 7-P
5/16 X 5/8 X 6-P	3/4 X 1 X 5-P
5/16 X 3/4 X 5-P	3/4 X 1 X 6-P
5/16 X 7/8 X 10-P	3/4 X 1 X 7-P
5/16 X 1 X 7-P	3/4 X 1.25 X 7-P
3/8 X 1/2 X 4-P	3/4 X 1.5 X 5-P
3/8 X 1/2 X 6-P	3/4 X 1.5 X 7-P
3/8 X 5/8 X 4.5-P	3/4 X 2 X 8-P
3/8 X 5/8 X 6-P	7/8 X 1.125 X 7-P
3/8 X 3/4 X 6-P	1 X 1.25 X 7-P
3/8 X 1 X 7-P	1 X 1.5 X 7.5-P



These hardened and ground blanks are ideal for grinding into flat form tools, skive tools, punches, spacers, gages and many other applications.

T15PM is a tungsten type high speed steel containing high carbon and vanadium for very high hardness and maximum wear resistance, and cobalt for good red hardness. Manufactured powder - metallurgically for improved quality and grindability.

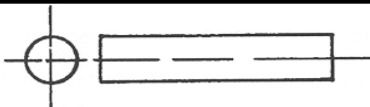
T15PM / WKE45 H.S.S. SQUARE TOOL BITS & FLAT FORM TOOL BLANKS

T15PM	WKE45
1/4 SQ X 2.5-P	--
1/4 SQ X 6-P	--
5/16 SQ X 2.5-P	--
5/16 SQ X 4-P	--
5/16 SQ X 6-P	5/16 SQ X 6
3/8 SQ X 3-P	3/8 SQ X 3
--	3/8 SQ X 4
3/8 SQ X 6-P	--
3/8 SQ X 8-P	--
7/16 SQ X 3.5-P	--
1/2 SQ X 4-P	--
1/2 SQ X 6-P	1/2 SQ X 6
1/2 SQ X 8-P	--
5/8 SQ X 4.5-P	5/8 SQ X 4.5
5/8 SQ X 6-P	--
3/4 SQ X 5-P	--
3/4 SQ X 6-P	--
1 SQ X 5.5-P	--
1 SQ X 7-P	--
1 SQ X 8-P	--



WKE 45 with 11% cobalt content, fine grain structure and unique chemical composition, meets requirements for maximum performance in most cutting tool applications.

WKE45
7MM SQ X 200MM
8MM SQ X 160MM
8MM SQ X 200MM
10MM SQ X 160MM
10MM SQ X 200MM
12MM SQ X 160MM
12MM SQ X 200MM
14MM SQ X 200MM



TOLERANCE +.0000/- .0002
(ALSO AVAILABLE +.0002/- .0000)

M2, M42, ASP30 & T15PM CYLINDRICAL BLANKS

LIMITED AVAILABILITY IN M4PM, ASP23, ASP60 AND CPM10V

These cylindrical blanks are hardened and ground on the O.D. They are ideal for grinding into step drills, counterbores, and other end cutting tools. They can be also used for punches, roll pins, step pins and many other tool room applications.

CAT. NO.	M2	M42	ASP30	T15PM
SUFFIX	-M	-H	-A30	-P
1/64 DIA X 1.5	-M			
1/32 DIA X 1.5	-M	-H		
3/64 DIA X 1.75	-M	-H		
1/16 DIA X 1.875	-M	-H		
1/16 DIA X 2.5			-A30	
5/64 DIA X 2	-M	-H		
3/32 DIA X 2.25	-M	-H		
3/32 DIA X 2.5			-A30	
7/64 DIA 2.75	-M	-H		
1/8 DIA X 2.5	-M		-A30	
1/8 DIA X 2.75	-M	-H		
1/8 DIA X 4	-M		-A30	
1/8 DIA X 6	-M		-A30	-P
9/64 DIA X 3	-M	-H		
5/32 DIA 3.25	-M	-H		
11/64 DIA X 3.25	-M	-H		
3/16 DIA X 2.5	-M		-A30	
3/16 DIA X 3.5	-M	-H		
3/16 DIA X 4	-M		-A30	-P
3/16 DIA X 6	-M		-A30	-P
13/64 DIA X 3.625	-M	-H		
7/32 DIA X 3.75	-M	-H		
15/64 DIA X 3.875	-M	-H		
1/4 DIA X 2.5	-M		-A30	-P
1/4 DIA X 4	-M	-H	-A30	-P
1/4 DIA X 6	-M		-A30	-P
17/64 DIA X 4.125	-M	-H		
9/32 DIA X 4.25	-M	-H		
19/64 DIA X 4.375	-M	-H		
5/16 DIA X 4	-M		-A30	-P
5/16 DIA X 4.5	-M	-H		
5/16 DIA X 6	-M		-A30	-P
21/64 DIA X 4.625	-M	-H		
11/32 DIA X 4.75	-M	-H		
23/64 DIA X 4.875	-M	-H		
3/8 DIA X 4	-M		-A30	-P
3/8 DIA X 5	-M	-H		
3/8 DIA X 6	-M		-A30	-P

CAT. NO.	M2	M42	ASP30	T15PM
SUFFIX	-M	-H	-A30	-P
25/64 DIA X 5.125	-M	-H		
13/32 DIA X 5.25	-M	-H		
27/64 DIA X 5.375	-M	-H		
7/16 DIA X 5.5	-M	-H		
7/16 DIA X 6	-M		-A30	-P
29/64 DIA X 5.625	-M	-H		
15/32 DIA X 5.75	-M	-H		
31/64 DIA X 5.875	-M	-H		
1/2 DIA X 4	-M		-A30	-P
1/2 DIA X 6	-M	-H	-A30	-P
33/64 DIA X 6	-M	-H		
33/64 DIA X 9	-M	-H		
33/64 DIA X 12	-M	-H		
17/32 DIA X 6	-M	-H		
17/32 DIA X 9	-M	-H		
17/32 DIA X 12	-M	-H		
35/64 DIA X 6	-M	-H		
35/64 DIA X 9	-M	-H		
35/64 DIA X 12	-M	-H		
9/16 DIA X 6	-M	-H		-P
9/16 DIA X 9	-M	-H		
9/16 DIA X 12	-M	-H		
37/64 DIA X 6	-M	-H		
37/64 DIA X 9	-M	-H		
37/64 DIA X 12	-M	-H		
19/32 DIA X 6	-M	-H		
19/32 DIA X 9	-M	-H		
19/32 DIA X 12	-M	-H		
39/64 DIA X 6	-M	-H		
39/64 DIA X 9	-M	-H		
39/64 DIA X 12	-M	-H		
5/8 DIA X 4	-M		-A30	-P
5/8 DIA X 6	-M	-H	-A30	-P
5/8 DIA X 9	-M	-H		
5/8 DIA X 12	-M	-H		
41/64 DIA X 6	-M	-H		
41/64 DIA X 9	-M	-H		
41/64 DIA X 12	-M	-H		

CAT. NO.	M2	M42	ASP30	T15PM
SUFFIX	-M	-H	-A30	-P
21/32 DIA X 6	-M	-H		
21/32 DIA X 9	-M	-H		
21/32 DIA X 12	-M	-H		
43/64 DIA X 6	-M	-H		
43/64 DIA X 9	-M	-H		
43/64 DIA X 12	-M	-H		
11/16 DIA X 6	-M	-H		
11/16 DIA X 9	-M	-H		
11/16 DIA X 12	-M	-H		
45/64 DIA X 6	-M	-H		
45/64 DIA X 9	-M	-H		
45/64 DIA X 12	-M	-H		
23/32 DIA X 6	-M	-H		
23/32 DIA X 9	-M	-H		
23/32 DIA X 12	-M	-H		
47/64 DIA X 6	-M	-H		
47/64 DIA X 9	-M	-H		
47/64 DIA X 12	-M	-H		
3/4 DIA X 4	-M		-A30	-P
3/4 DIA X 6	-M	-H	-A30	-P
3/4 DIA X 9	-M	-H		
3/4 DIA X 12	-M	-H		
49/64 DIA X 6	-M	-H		
49/64 DIA X 9	-M	-H		
49/64 DIA X 12	-M	-H		
25/32 DIA X 6	-M	-H		
25/32 DIA X 9	-M	-H		
25/32 DIA X 12	-M	-H		
51/64 DIA X 6	-M	-H		
51/64 DIA X 9	-M	-H		
51/64 DIA X 12	-M	-H		
13/16 DIA X 6	-M	-H		
13/16 DIA X 9	-M	-H		
13/16 DIA X 12	-M	-H		
53/64 DIA X 6	-M	-H		
53/64 DIA X 9	-M	-H		
53/64 DIA X 12	-M	-H		

CAT. NO.	M2	M42	ASP30	T15PM
SUFFIX	-M	-H	-A30	-P
27/32 DIA X 6	-M	-H		
27/32 DIA X 9	-M	-H		
27/32 DIA X 12	-M	-H		
55/64 DIA X 6	-M	-H		
55/64 DIA X 9	-M	-H		
55/64 DIA X 12	-M	-H		
7/8 DIA X 6	-M	-H	-A30	-P
7/8 DIA X 9	-M	-H		
7/8 DIA X 12	-M	-H		
57/64 DIA X 6	-M	-H		
57/64 DIA X 9	-M	-H		
57/64 DIA X 12	-M	-H		
29/32 DIA X 6	-M	-H		
29/32 DIA X 9	-M	-H		
29/32 DIA X 12	-M	-H		
59/64 DIA X 6	-M	-H		
59/64 DIA X 9	-M	-H		
59/64 DIA X 12	-M	-H		
15/16 DIA X 6	-M	-H		
15/16 DIA X 9	-M	-H		
15/16 DIA X 12	-M	-H		
61/64 DIA X 6	-M	-H		
61/64 DIA X 9	-M	-H		
61/64 DIA X 12	-M	-H		
31/32 DIA X 6	-M	-H		
31/32 DIA X 9	-M	-H		
31/32 DIA X 12	-M	-H		
63/64 DIA X 6	-M	-H		
63/64 DIA X 9	-M	-H		
63/64 DIA X 12	-M	-H		
1" DIA X 6	-M	-H	-A30	-P
1" DIA X 9	-M	-H		
1" DIA X 12	-M	-H		

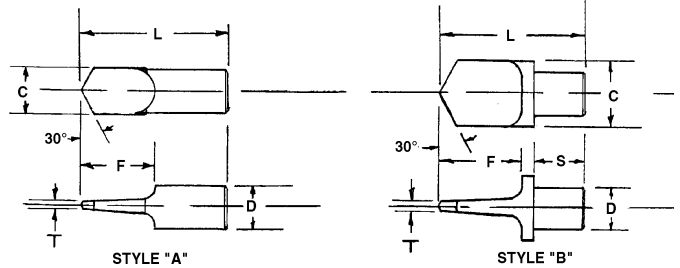
Metric Drill Blanks also available. Call with requests.

M2 H.S.S. HARDENED AND GROUND FLAT DRILL BLANKS



- Ready for step grinding to suit your job
- Eliminate flute grinding or milling
- Can be sharpened for right or left hand operation
- Short lengths for screw machine use
- No need to cut off length

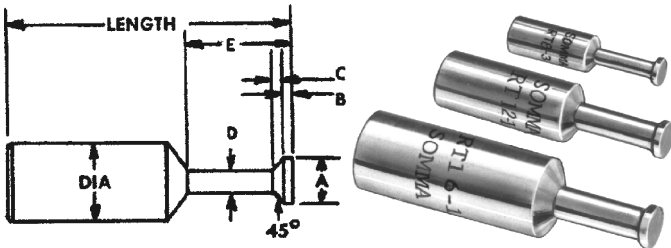
CAT. NO.	STYLE	D-.001	L	F	C+.010	S	T
FLDR-8	A	1/4	2"	3/4	1/4	--	.050
FLDR-12	A	3/8	2-1/4	1"	3/8	--	.060
FLDR-16	A	1/2	2-1/2	1-1/8	1/2	--	.070
FLDR-20	A	5/8	2-3/4	1-1/4	5/8	--	.090
FLDR-24	A	3/4	3"	1-3/8	3/4	--	.100
FLDR-32	A	1"	3-1/2	1-3/4	1"	--	.110
FLDR-40	B	1"	3-1/2	1-3/4	1-1/4	1-1/4	.188
FLDR-48	B	1"	3-1/2	2"	1-1/2	1-1/4	.218



AVAILABLE IN T15PM H.S.S. - P.O.A.

CUTTING TOOLS

HIGH SPEED STEEL CIRCULAR RECESS TOOL BLANKS



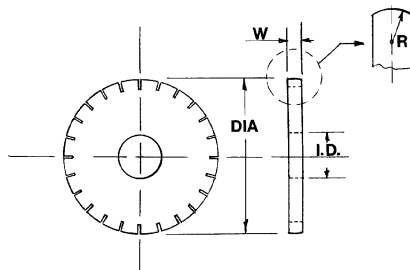
Available in a wide variety of shank sizes, head diameters and lengths to fit all recessing tools and for all types of jobs.

These tool blanks are made from hardened M2 high speed steel.

Also see our Recess Tool Holders on Page 51.

CAT. NO.	DIA.	LENGTH	A +/- .005	B +/- .003	C +/- .003	D +/- .005	E
RT8-1	1/4	7/8	.140	.030	.030	.080	5/16
RT8-2	1/4	1"	.190	.030	.040	.110	7/16
RT8-3	1/4	1-1/8	.240	.030	.045	.150	9/16
RT10-81	5/16	2"	.140	.030	.030	.080	5/16
RT10-1	5/16	1-1/4	.220	.040	.035	.150	1/2
RT10-101	5/16	2"	.220	.040	.035	.150	1/2
RT10-2	5/16	1-3/8	.260	.040	.040	.180	5/8
RT10-3	5/16	1-1/2	.300	.040	.045	.210	3/4
RT12-1	3/8	1-1/2	.240	.045	.030	.180	9/16
RT12-121	3/8	2"	.240	.045	.030	.180	9/16
RT12-2	3/8	1-5/8	.300	.045	.050	.200	11/16
RT12-122	3/8	2"	.300	.045	.050	.200	11/16
RT12-3	3/8	1-3/4	.360	.045	.055	.250	13/16
RT16-1	1/2	1-7/8	.270	.050	.035	.200	5/8
RT16-2	1/2	2"	.330	.050	.040	.250	3/4
RT16-3	1/2	2-1/4	.400	.050	.050	.300	1"

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



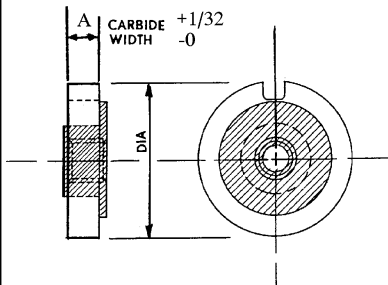
These high speed steel circular deburring tools fit the slotting attachment of B&S Screw Machines and Swiss Machines and remove cut-off burrs from the back end of the part completely, smoothly and uniformly.

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

SOLID CARBIDE CIRCULAR BLANKS GRADE C2 CARBIDE - UNGROUND

- Solid carbide circular form tool blanks brazed to threaded steel hubs
- Gashed "U" shape for right or left hand cutting.
- Lower cost than brazed insert type blanks.

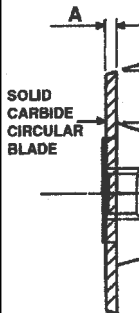


* (6) 9/64 dia. pinholes thru 3/16 steel hub only

Also available in H.S.S.
(See page 20 & 21)

A CARBIDE WIDTH	#00 B&S 1-3/4" DIA., 3/8-16 THD. CAT. NO.	#0 B&S 2-1/4" DIA., 1/2-13 THD. CAT. NO.	#2 B&S 3" DIA., 5/8-11 THD. CAT. NO.	DAVENPORT 2" DIA., 9/16 I.D.* CAT. NO.
1/8	00SCB-4	0SCB-4	2SCB-4	DSCB-4
3/16	00SCB-6	0SCB-6	2SCB-6	DSCB-6
1/4	00SCB-8	0SCB-8	2SCB-8	DSCB-8
5/16	00SCB-10	0SCB-10	2SCB-10	DSCB-10
3/8	00SCB-12	0SCB-12	2SCB-12	DSCB-12
1/2	00SCB-16	0SCB-16	2SCB-16	DSCB-16

SOLID CARBIDE CIRCULAR CUT-OFF TOOLS GRADE C2 CARBIDE



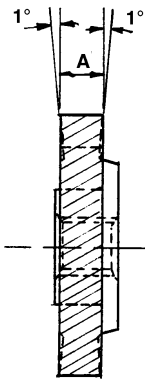
- Finish ground all over
- For straight cutting-off of bar stock.
- Clearance provided on both sides for free cutting.
- "U" shape gash, sharpened for right or left hand cutting.
- Carbide cutting edge brazed to threaded steel center hub
- Up to 10 times resharpenable life of carbide tipped tools.

Also available in H.S.S.
(See page 26)

A	B	CAT. NO.	A	B	CAT. NO.
No. 00 B&S 1-3/4" Dia. 3/8-16 thd.			No. 2 B&S 3" Dia. 5/8-11 thd.		
.040	5/32	00P4-SC	.080	7/16	2P8-SC
.060	7/32	00P6-SC	.100	9/16	2P10-SC
.080	1/4	00P8-SC	.120	5/8	2P12-SC
.100	1/4	00P10-SC	.140	5/8	2P14-SC
No. 0 B&S 2-1/4" Dia. 1/2-13 thd.			DAV. TOOLS 2" Dia. 9/16" Center Hole* (also fit 7/16" National Acme and 9/16" Conomatic)		
.060	1/4	0P6-SC	.050	3/16	DP050-SC
.080	5/16	0P8-SC	.070	1/4	DP070-SC
.100	3/8	0P10-SC	.090	1/4	DP090-SC
.120	3/8	0P12-SC			

*NOTE: Davenport tools have (6) 9/64 dia. pinholes thru steel hub only. Steel hub is on spindle side of tool, not as shown in diagram of B&S tools

SOLID CARBIDE STRAIGHT TOOLS GRADE C2 CARBIDE



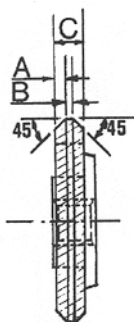
- Finish ground all over
- "U" shape gashed and sharpened for right or left hand cutting.
- Clearance on both sides for free cutting.
- The construction of these tools is the same as our Solid Carbide Circular Blanks with a steel center hub for clamping to tool post.

Also available in H.S.S. (See page 27)

WIDTH (A)	NO. 00 B&S 1-3/4 DIA. CAT. NO.	NO. 0 B&S 2-1/4 DIA. CAT. NO.	NO. 2 B&S 3" DIA. CAT. NO.	DAVENPORT 2" DIA. CAT. NO.
1/8	00S4-SC	0S4-SC	2S4-SC	DS4-SC
3/16	00S6-SC	0S6-SC	2S6-SC	DS6-SC
1/4	00S8-SC	0S8-SC	2S8-SC	DS8-SC
5/16	00S10-SC	0S10-SC	2S10-SC	DS10-SC
3/8	00S12-SC	0S12-SC	2S12-SC	DS12-SC
1/2	00S16-SC	0S16-SC	2S16-SC	DS16-SC

*(6) 9/64 dia. pinholes thru 3/16 steel hub only

SOLID CARBIDE 45° CHAMFER TOOLS GRADE C2 CARBIDE



- Finish ground all over
- "U" shape gashed and sharpened for right or left hand cutting.
- The construction of these tools is the same as our Solid Carbide Circular Blanks with a steel center hub for clamping to the tool post.

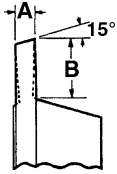
Also available in H.S.S. (See page 26)

CAT. NO.	MACHINE SIZE	A	B	C	DIA.	CENTER HOLE
0045C2-SC	#00 B&S	7/64	.025	1/4	1-3/4	3/8-16 THD.
045C2-SC	#0 B&S	1/8	.040	5/16	2-1/4	1/2-13 THD.
245C2-SC	#2 B&S	5/32	.050	3/8	3"	5/8-11 THD.
D45C1-SC	DAV.	7/64	.025	1/4	2"	9/16 REAM*

*(6) 9/64 dia. pinholes thru 3/16 steel hub only

CIRCULAR PLAIN CUT-OFF TOOLS

- For straight cutting-off
- Clearance ground both sides
- Gashed "U" shape for right or left hand cutting
- Available with pinholes
- Available in Solid Carbide



Also available in carbide. See page 25.

A	B	M2 CAT. NO.	T15PM CAT. NO.
No. 00 B&S 1-3/4" Dia., 1/4" Width, 3/8-16 thd.			
.030	1/8	00P3	00P3V
.040	3/16	00P4	00P4V
.050	7/32	00P5	00P5V
.060	1/4	00P6	00P6V
.070	1/4	00P7	00P7V
.080	1/4	00P8	00P8V
.100	1/4	00P10	00P10V

A	B	M2 CAT. NO.	T15PM CAT. NO.
No. 0 B&S 2-1/4" Dia., 5/16" Width, 1/2-13 thd.			
.040	3/16	0P4	0P4V
.050	7/32	0P5	0P5V
.060	1/4	0P6	0P6V
.070	5/16	0P7	0P7V
.080	5/16	0P8	0P8V
.090	3/8	0P9	0P9V
.100	3/8	0P10	0P10V
.120	3/8	0P12	0P12V

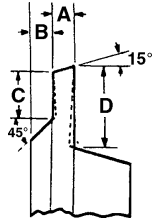
A	B	M2 CAT. NO.	T15PM CAT. NO.
No. 2 B&S 3" Dia., 3/8" Width, 5/8-11 thd.			
.060	5/16	2P6	2P6V
.080	7/16	2P8	2P8V
.100	9/16	2P10	2P10V
.120	5/8	2P12	2P12V
.140	11/16	2P14	2P14V

**DAVENPORT (Also 7/16" National
Acme and 9/16" Conomatic)
2" Dia., 1/4" Width,
9/16 I.D., 6-9/64 holes thru.**

A	B	M2 CAT. NO.	T15PM CAT. NO.
.030	3/32	DP030	DP030V
.040	1/8	DP040	DP040V
.050	3/16	DP050	DP050V
.060	7/32	DP060	DP060V
.070	1/4	DP070	DP070V
.080	9/32	DP080	DP080V
.090	9/32	DP090	DP090V

CIRCULAR CUT-OFF & CHAMFER TOOLS

- For straight cutting-off of the finished part and chamfering the front of the part held in the collet.
- Clearance ground both sides
- Gashed "U" shape for right or left hand cutting
- Available with pinholes



A	B	C	D	M2 CAT. NO.	T15PM CAT. NO.
No. 00 B&S 1-3/4" Dia., 1/4" Width, 3/8-16 thd.					
.030	.030	3/64	1/4	00C3	00C3V
.040	.040	5/64	1/4	00C4	00C4V
.050	.050	7/64	1/4	00C5	00C5V
.060	.060	9/64	1/4	00C6	00C6V
.070	.070	11/64	1/4	00C7	00C7V
.080	.080	13/64	1/4	00C8	00C8V
No. 0 B&S 2-1/4" Dia. 5/16" Width, 1/2-13 thd.					
.040	.040	5/64	5/16	0C4	0C4V
.050	.050	7/64	5/16	0C5	0C5V
.060	.060	9/64	5/16	0C6	0C6V
.070	.070	11/64	3/8	0C7	0C7V
.080	.080	7/32	3/8	0C8	0C8V
.090	.090	9/32	3/8	0C9	0C9V
.100	.100	11/32	3/8	0C10	0C10V
No. 2 B&S 3" Dia., 3/8" Width, 5/8-11 thd.					
.060	.060	1/8	3/8	2C6	2C6V
.070	.070	3/16	7/16	2C7	2C7V
.080	.080	1/4	1/2	2C8	2C8V
.090	.090	5/16	9/16	2C9	2C9V
.100	.100	3/8	9/16	2C10	2C10V
.110	.110	7/16	5/8	2C11	2C11V
.120	.120	1/2	5/8	2C12	2C12V
.140	.140	9/16	11/16	2C14	2C14V

CIRCULAR CHAMFER & FACE-OFF TOOLS

DOUBLE CHAMFER TOOLS are designed for chamfering the back end of the completed part and the front end of the following part prior to cutting off in between.

45°, 30°, and 60° CHAMFER TOOLS are available with the flat in the center of the tool, our offset type which has the flat closer to the spindle side of the tool to allow working close to the collet.

45° FACE-OFF TOOLS are intended for facing the end of the bar, necking, or forming large 45° chamfers.

Available with pinholes

Also available in carbide. See page 25.

45° CHAMFER TOOLS

Machine	A	B	C	M2 Cat. No.	T15PM Cat. No.
No. 00	1/16	.025	1/4	0045C1	0045C1V
	7/64	.025	1/4	0045C2	0045C2V
No. 0	3/32	.040	5/16	045C1	045C1V
	1/8	.040	5/16	045C2	045C2V
No. 2	7/64	.050	3/8	245C1	245C1V
	5/32	.050	3/8	245C2	245C2V
DAV.	7/64	.025	1/4	D45C1	D45C1V

30° CHAMFER TOOLS

Machine	A	B	C	M2 Cat. No.	T15PM Cat. No.
No. 00	1/16	.025	1/4	0030C1	0030C1V
	7/64	.025	1/4	0030C2	0030C2V
No. 0	3/32	.040	5/16	030C1	030C1V
	1/8	.040	5/16	030C2	030C2V
No. 2	7/64	.050	3/8	230C1	230C1V
	5/32	.050	3/8	230C2	230C2V
DAV.	7/64	.025	1/4	D30C1	D30C1V

30° + 45° CHAMFER TOOLS

Machine	A	B	C	M2 Cat. No.	T15PM Cat. No.
No. 00	5/64	.025	1/4	00C3045	00C3045V
No. 0	3/32	.040	5/16	0C3045	0C3045V
No. 2	7/64	.050	3/8	2C3045	2C3045V

60° CHAMFER TOOLS

Machine	A	B	C	M2 Cat. No.	T15PM Cat. No.
No. 00	1/16	.025	1/4	0060C1	0060C1V
	7/64	.025	1/4	0060C2	0060C2V
No. 0	3/32	.040	5/16	060C1	060C1V
	1/8	.040	5/16	060C2	060C2V
No. 2	7/64	.050	3/8	260C1	260C1V
	5/32	.050	3/8	260C2	260C2V

FACE-OFF TOOLS

Machine	A	B	M2 Cat. No.	T15PM Cat. No.
No. 00	.025	1/4	00F45	00F45V
No. 0	.040	5/16	0F45	0F45V
No. 2	.050	3/8	2F45	2F45V

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.

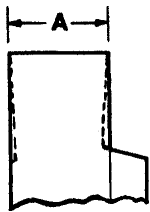


CIRCULAR CUT-OFF & CHAMFER TOOLS To Your Specifications

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

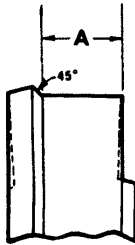
The following Circular Tools are available in M2 and T15PM H.S.S. (Add -V to part# for T15PM)
Delivery is 1-3 weeks, call us for prices.
Also available with pinholes upon request.

CIRCULAR STRAIGHT TOOLS



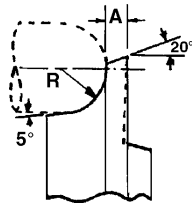
A	CAT. NO.
for 00 B&S	
1/8	00S4
3/16	00S6
1/4	00S8
5/16	00S10
3/8	00S12
7/16	00S14
1/2	00S16
for 0 B&S	
1/8	0S4
3/16	0S6
1/4	0S8
5/16	0S10
3/8	0S12
7/16	0S14
1/2	0S16
5/8	0S20
for 2 B&S	
1/8	2S4
3/16	2S6
1/4	2S8
5/16	2S10
3/8	2S12
7/16	2S14
1/2	2S16
5/8	2S20
3/4	2S24
for DAVENPORT	
1/8	DS4
3/16	DS6
1/4	DS8
5/16	DS10
3/8	DS12
7/16	DS14
1/2	DS16
9/16	DS18
5/8	DS20

CIRCULAR HUB TOOLS



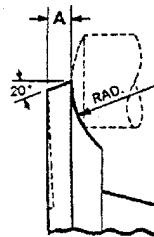
A	CAT. NO.
for 00 B&S	
.060	00H060
.090	00H090
.122	00H122
.153	00H153
.184	00H184
.215	00H215
.246	00H246
.308	00H308
.370	00H370
.432	00H432
.495	00H495
for 0 B&S	
.090	0H090
.122	0H122
.153	0H153
.184	0H184
.215	0H215
.246	0H246
.308	0H308
.370	0H370
.432	0H432
.495	0H495
.557	0H557
for 2 B&S	
.122	2H122
.153	2H153
.184	2H184
.215	2H215
.246	2H246
.308	2H308
.370	2H370
.432	2H432
.495	2H495
.557	2H557
.620	2H620

CIRCULAR RADIUS CUT-OFF TOOLS



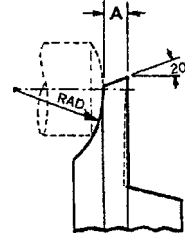
RADIUS	A	CAT. NO.
for 00 B&S		
1/32	.030	00R1
3/64	.030	00R15
1/16	.030	00R2
3/32	.035	00R3
1/8	.040	00R4
5/32	.045	00R5
3/16	.050	00R6
7/32	.055	00R7
1/4	.060	00R8
for 0 B&S		
3/32	.040	0R3
1/8	.040	0R4
5/32	.045	0R5
3/16	.050	0R6
7/32	.055	0R7
1/4	.060	0R8
5/16	.070	0R10
11/32	.075	0R11
3/8	.075	0R12
for 2 B&S		
1/8	.050	2R4
5/32	.055	2R5
3/16	.060	2R6
7/32	.065	2R7
1/4	.070	2R8
9/32	.080	2R9
5/16	.090	2R10
11/32	.100	2R11
3/8	.110	2R12

CIRCULAR REAR CROWN CUT-OFF TOOLS



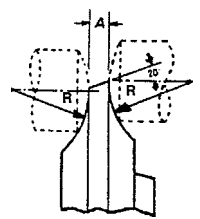
RADIUS	A	CAT. NO.
for 00 B&S		
1/16	.030	00RR2
3/32	.030	00RR3
1/8	.030	00RR4
5/32	.035	00RR5
3/16	.035	00RR6
7/32	.040	00RR7
1/4	.040	00RR8
9/32	.045	00RR9
5/16	.045	00RR10
11/32	.050	00RR11
3/8	.050	00RR12
13/32	.055	00RR13
7/16	.055	00RR14
15/32	.060	00RR15
1/2	.060	00RR16
for 0 B&S		
1/8	.040	0RR4
5/32	.040	0RR5
3/16	.040	0RR6
7/32	.040	0RR7
1/4	.040	0RR8
9/32	.045	0RR9
5/16	.045	0RR10
11/32	.050	0RR11
3/8	.050	0RR12
13/32	.055	0RR13
7/16	.055	0RR14
15/32	.060	0RR15
1/2	.060	0RR16
9/16	.065	0RR18
5/8	.070	0RR20
11/16	.075	0RR22
3/4	.075	0RR24
for 2 B&S		
1/4	.060	2RR8
5/16	.070	2RR10
3/8	.080	2RR12
7/16	.085	2RR14
1/2	.090	2RR16
9/16	.095	2RR18
5/8	.100	2RR20
11/16	.105	2RR22
3/4	.110	2RR24

CIRCULAR FRONT CROWN CUT-OFF TOOLS



RADIUS	A	CAT. NO.
for 00 B&S		
1/16	.030	00RF2
3/32	.030	00RF3
1/8	.030	00RF4
5/32	.035	00RF5
3/16	.035	00RF6
7/32	.040	00RF7
1/4	.040	00RF8
9/32	.045	00RF9
5/16	.045	00RF10
11/32	.050	00RF11
3/8	.050	00RF12
13/32	.055	00RF13
7/16	.055	00RF14
15/32	.060	00RF15
1/2	.060	00RF16
for 0 B&S		
1/8	.040	0RF4
5/32	.040	0RF6
3/16	.040	0RF6
7/32	.040	0RF8
1/4	.040	0RF8
9/32	.045	0RF10
5/16	.045	0RF10
11/32	.050	0RF12
3/8	.050	0RF12
13/32	.055	0RF14
7/16	.055	0RF14
15/32	.060	0RF16
1/2	.060	0RF16
9/16	.065	0RF18
5/8	.070	0RF20
11/16	.075	0RF22
3/4	.075	0RF24
for 2 B&S		
1/4	.060	2RF8
5/16	.070	2RF10
3/8	.080	2RF12
7/16	.085	2RF14
1/2	.090	2RF16
9/16	.095	2RF18
5/8	.100	2RF20
11/16	.105	2RF22
3/4	.110	2RF24

CIRCULAR DOUBLE CROWN CUT-OFF TOOLS



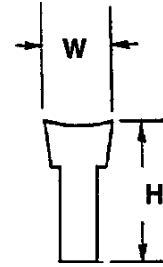
RADIUS	A	CAT. NO.
for 00 B&S		
1/16	.030	00RD2
3/32	.030	00RD3
1/8	.030	00RD4
5/32	.035	00RD5
3/16	.035	00RD6
7/32	.040	00RD7
1/4	.040	00RD8
9/32	.045	00RD9
5/16	.045	00RD10
11/32	.050	00RD11
3/8	.050	00RD12
13/32	.055	00RD13
7/16	.055	00RD14
15/32	.060	00RD15
1/2	.060	00RD16
for 0 B&S		
1/8	.040	0RD4
5/32	.040	0RD6
3/16	.040	0RD6
7/32	.040	0RD8
1/4	.040	0RD8
9/32	.045	0RD10
5/16	.045	0RD10
11/32	.050	0RD12
3/8	.050	0RD12
13/32	.055	0RD14
7/16	.055	0RD14
15/32	.060	0RD16
1/2	.060	0RD16
9/16	.065	0RD18
5/8	.070	0RD20
11/16	.075	0RD22
3/4	.075	0RD24
for 2 B&S		
1/4	.060	2RD8
5/16	.070	2RD10
3/8	.080	2RD12
7/16	.085	2RD14
1/2	.090	2RD16
9/16	.095	2RD18
5/8	.100	2RD20
11/16	.105	2RD22
3/4	.110	2RD24

CUTTING TOOLS

ALL TOOLS GASHED "U" SHAPED FOR RIGHT OR LEFT HAND CUTTING.



- Ground all over
- Concave ground top
- Blade centered



- M2** - GENERAL PURPOSE WITH EXCELLENT TOUGHNESS
COBALT - HIGHEST HEAT RESISTANCE, HIGHER RPM APPLICATIONS
M4PM - MAXIMUM PERFORMANCE ON ABRASIVE MATERIALS WHERE HEAT IS NOT A FACTOR
T15PM - EXCELLENT FOR DIFFICULT TO MACHINE MATERIALS WITH GOOD HEAT RESISTANCE

REF#	SIZE			M2 STEEL	COBALT STEEL	M4PM STEEL	T15PM STEEL
	W	H	L	ORDERING#	ORDERING#	ORDERING#	ORDERING#
P-1-N	.040	1/2	4-1/2	TBL332	TBL332C	TBL332C-K	TBL332V
P-1	1/16	1/2	4-1/2	TBL432	TBL432C	TBL432C-K	TBL432V
P-2-N	5/64	1/2	4-1/2	TBL532	TBL532C	TBL532C-K	TBL532V
P-2	3/32	1/2	4-1/2	TBL632	TBL632C	TBL632C-K	TBL632V
P-3-S	1/8	1/2	4-1/2	TBL832	TBL832C	TBL832C-K	TBL832V
P3N-866	1/16	11/16	5	TBL444	TBL444C	TBL444C-K	TBL444V
P-3-N	3/32	11/16	5	TBL644	TBL644C	---	TBL644V
P-3	1/8	11/16	5	TBL844	TBL844C	TBL844C-K	TBL844V
P-4	5/32	11/16	5	TBL1044	TBL1044C	---	TBL1044V
P-5-S	3/16	11/16	5	TBL1244	TBL1244C	---	TBL1244V
P-3-W	1/8	3/4	5	TBL848	TBL848C	---	TBL848V
P-4-W	5/32	3/4	5	TBL1048	TBL1048C	---	TBL1048V
P-5-W	3/16	3/4	5	TBL1248	TBL1248C	---	TBL1248V
P-5-X	1/8	7/8	6	TBL856	TBL856C	TBL856C-K	TBL856V
P-5-N	5/32	7/8	6	TBL1056	TBL1056C	TBL1056C-K	TBL1056V
P-5	3/16	7/8	6	TBL1256	TBL1256C	---	TBL1256V
P-6	1/4	7/8	6	TBL1656	TBL1656C	---	TBL1656V
P-8-X	1/8	1-1/8	6-1/2	TBL872	TBL872C	---	TBL872V
P-8-N	5/32	1-1/8	6-1/2	TBL1072	TBL1072C	---	TBL1072V
P-8	3/16	1-1/8	6-1/2	TBL1272	TBL1272C	---	TBL1272V
P-9	1/4	1-1/8	6-1/2	TBL1672	TBL1672C	---	TBL1672V
P-10	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

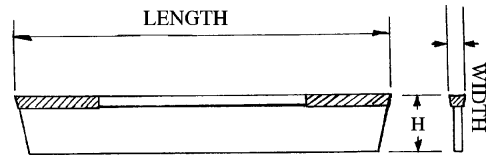
CUT-OFF BLADE COATING OPTIONS:

(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 30



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#	SIZE			DOUBLE END	SINGLE END C2	DOUBLE END C6	SINGLE END C6
	W	H	L	MICROGRAIN ORDERING#	ORDERING#	ORDERING#	ORDERING#
P-1	1/16	1/2	4-1/2	CTBL432-MIC	CTBL432-C2-SE	CTBL432-C6	CTBL432-C6-SE
P-2-N	5/64	1/2	4-1/2	CTBL532-MIC	CTBL532-C2-SE	CTBL532-C6	CTBL532-C6-SE
P-2	3/32	1/2	4-1/2	CTBL632-MIC	CTBL632-C2-SE	CTBL632-C6	CTBL632-C6-SE
P-3-S	1/8	1/2	4-1/2	CTBL832-MIC	CTBL832-C2-SE	CTBL832-C6	CTBL832-C6-SE
P-3-N	3/32	11/16	5	CTBL644-MIC	CTBL644-C2-SE	CTBL644-C6	CTBL644-C6-SE
P-3	1/8	11/16	5	CTBL844-MIC	CTBL844-C2-SE	CTBL844-C6	CTBL844-C6-SE
P-4	5/32	11/16	5	CTBL1044-MIC	CTBL1044-C2-SE	CTBL1044-C6	CTBL1044-C6-SE
P-5-S	3/16	11/16	5	CTBL1244-MIC	CTBL1244-C2-SE	CTBL1244-C6	CTBL1244-C6-SE
P-3-W	1/8	3/4	5	CTBL848-MIC	CTBL848-C2-SE	CTBL848-C6	CTBL848-C6-SE
P-4-W	5/32	3/4	5	CTBL1048-MIC	CTBL1048-C2-SE	CTBL1048-C6	CTBL1048-C6-SE
P-5-W	3/16	3/4	5	CTBL1248-MIC	CTBL1248-C2-SE	CTBL1248-C6	CTBL1248-C6-SE
P-5-X	1/8	7/8	6	CTBL856-MIC	CTBL856-C2-SE	CTBL856-C6	CTBL856-C6-SE
P-5-N	5/32	7/8	6	CTBL1056-MIC	CTBL1056-C2-SE	CTBL1056-C6	CTBL1056-C6-SE
P-5	3/16	7/8	6	CTBL1256-MIC	CTBL1256-C2-SE	CTBL1256-C6	CTBL1256-C6-SE
P-6	1/4	7/8	6	CTBL1656-MIC	CTBL1656-C2-SE	CTBL1656-C6	CTBL1656-C6-SE
P-8-X	1/8	1-1/8	6-1/2	CTBL872-MIC	CTBL872-C2-SE	CTBL872-C6	CTBL872-C6-SE
P-8-N	5/32	1-1/8	6-1/2	CTBL1072-MIC	CTBL1072-C2-SE	CTBL1072-C6	CTBL1072-C6-SE
P-8	3/16	1-1/8	6-1/2	CTBL1272-MIC	CTBL1272-C2-SE	CTBL1272-C6	CTBL1272-C6-SE
P-9	1/4	1-1/8	6-1/2	CTBL1672-MIC	CTBL1672-C2-SE	CTBL1672-C6	CTBL1672-C6-SE
P-10	5/16	1-1/8	6-1/2	CTBL2072-MIC	CTBL2072-C2-SE	CTBL2072-C6	CTBL2072-C6-SE

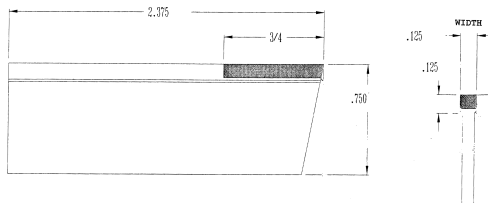
CUT-OFF BLADE COATING OPTIONS:

(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 MACHINING CAST IRON, HIGH NICKEL AND TITANIUM ALLOYS, HARDENED STEELS AND STAIN LESS STEELS. GOOD CHOICE FOR INTERRUPTED APPLICATIONS

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

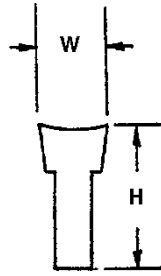
MICRO-GRAIN CARBIDE TIPPED / SHORT LENGTH T-TYPE CUT-OFF BLADES



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.

**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.

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

CUT-OFF BLADE COATING OPTIONS:

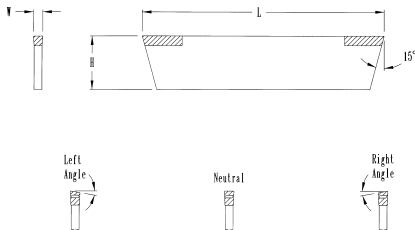
(FOR THE OPTIONS LISTED, ADD THE SUFFIX LISTED BELOW TO THE ORDERING NUMBER)

- 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

NOW AVAILABLE!

EMPIRE® TWIN-TIP® STYLE CUT-OFF BLADES

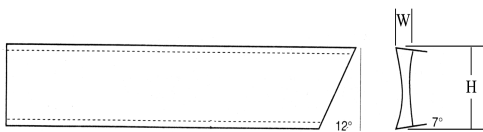
Call Somma Tool for a quote!



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

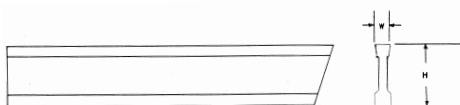
- 1) Empire® tool number (Ex. 1732)
- 2) Front Angle (Ex. 4° left angle)
- 3) Carbide Grade (Ex. C2)
- 4) Coating Type (if applicable)

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



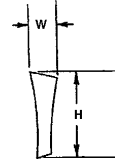
W	H	LENGTH	REF. NO.	M2 H.S.S. CAT. NO.	COBALT H.S.S. CAT. NO.	T15PM H.S.S. CAT. NO.	MICRO-GRAIN CARBIDE TIPPED CAT. NO.
.040	1/2	5-3/4	B-17	ABL332	ABL332C	ABL332V	ABL332-MIC
1/16	1/2	5-3/4	B-1	ABL432	ABL432C	ABL432V	ABL432-MIC
3/32	1/2	5-3/4	B-2	ABL632	ABL632C	ABL632V	ABL632-MIC
1/8	1/2	5-3/4	B-5	ABL832	ABL832C	ABL832V	ABL832-MIC
3/32	13/16	7-3/16	B-3	ABL652	ABL652C	ABL652V	ABL652-MIC
1/8	13/16	7-3/16	B-6	ABL852	ABL852C	ABL852V	ABL852-MIC
5/32	13/16	7-3/16	B-8	ABL1052	ABL1052C	ABL1052V	ABL1052-MIC
3/16	13/16	7-3/16	B-9	ABL1252	ABL1252C	ABL1252V	ABL1252-MIC
1/4	13/16	7-3/16	B-11	ABL1652	ABL1652C	ABL1652V	ABL1652-MIC
1/8	1"	8-1/4	B-7	ABL864	ABL864C	ABL864V	ABL864-MIC
3/16	1"	8-1/4	B-10	ABL1264	ABL1264C	ABL1264V	ABL1264-MIC
1/4	1"	8-1/4	B-12	ABL1664	ABL1664C	ABL1664V	ABL1664-MIC
1/4	1-1/4	9"	B-13	ABL1680	ABL1680C	ABL1680V	ABL1680-MIC

I-BEAM STYLE CUT-OFF BLADES



W	H	LENGTH	REF. NO.	M2 H.S.S. CAT. NO.	REF. NO.	T15PM H.S.S. CAT. NO.
1/8	15/16	5"	ST-589	IBL860	ST-590	IBL860V
3/16	1-7/16	7-1/2"	ST-591	IBL12112	ST-592	IBL12112V

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
- M4PM** - MAXIMUM PERFORMANCE ON ABRASIVE MATERIALS WHERE HEAT IS NOT A FACTOR
- T15PM** - EXCELLENT FOR DIFFICULT TO MACHINE MATERIALS WITH GOOD HEAT RESISTANCE

W	H	L	M2 STEEL ORDERING#	COBALT STEEL ORDERING#	M4PM STEEL ORDERING#	T15PM STEEL ORDERING#
.035	1/2	4-1/2	BL232	--	BL232C-K	BL232V
3/64	1/2	4-1/2	BL332	BL332C	--	BL332V
1/16	1/2	4-1/2	BL432	BL432C	BL432C-K	BL432V
5/54	1/2	4-1/2	BL532	BL532C	BL532C-K	BL532V
3/32	1/2	4-1/2	BL632	BL632C	BL632C-K	BL632V
1/8	1/2	4-1/2	BL832	BL832C	--	BL832V
3/16	1/2	4-1/2	--	BL1232C	BL1232C-K	BL1232V
3/64	11/16	5"	--	--	--	BL344V
1/16	11/16	5"	BL444	BL444C	BL444C-K	BL444V
3/32	11/16	5"	BL644	BL644C	BL644C-K	BL644V
1/8	11/16	5"	BL844	BL844C	BL844C-K	BL844V
5/32	11/16	5"	BL1044	BL1044C	BL1044C-K	BL1044V
3/16	11/16	5"	BL1244	BL1244C	BL1244C-K	BL1244V
1/4	11/16	5"	BL1644	BL1644C	BL1644C-K	BL1644V
1/16	13/16	6"	BL452	BL452C	--	BL452V
3/32	13/16	6"	BL652	BL652C	BL652C-K	BL652V
1/8	13/16	6"	BL852	BL852C	BL852C-K	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

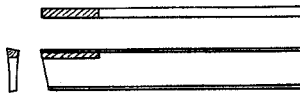
CUT-OFF BLADE COATING OPTIONS:

(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.

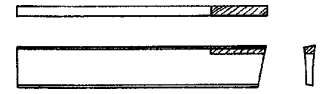


STYLE "Y"

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	5/54	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



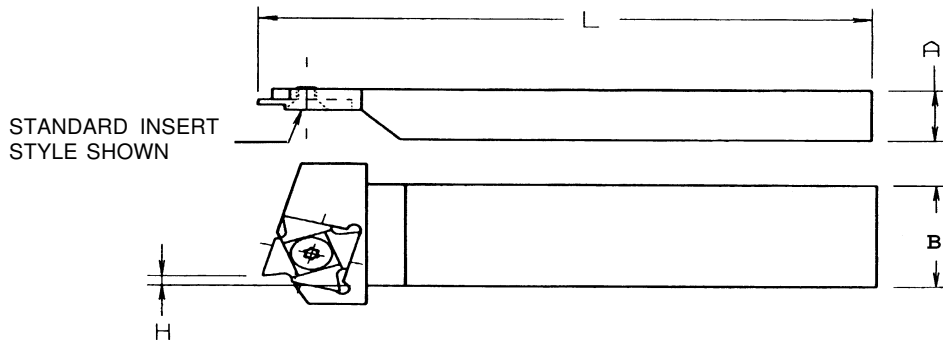
STYLE "X"

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

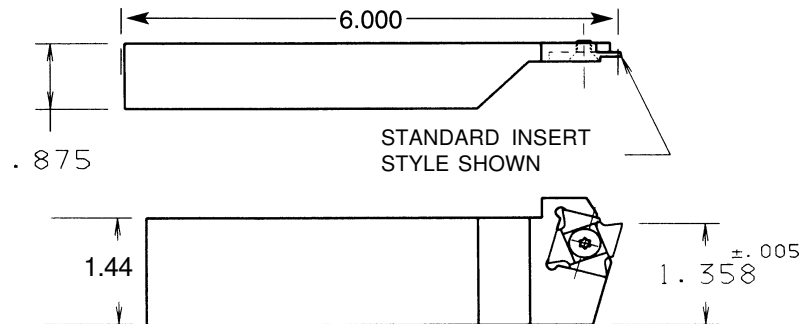
See Page 34 for inserts.



NEW BRITAIN CUT-OFF TOOLHOLDERS

TOOLHOLDERS SHOWN USE .750 SQ INSERT

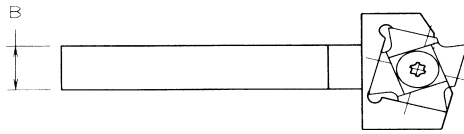
Patent No. D307859



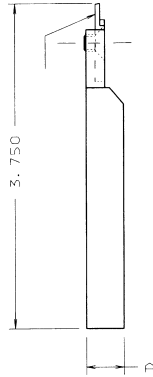
TOOLHOLDER CAT. #	INSERT SIZE	INSERT SCREW	INSERT WRENCH
NB-CIN	3/4"	DAV-CIN-SCR	DAV-CIN-WR
NB-CIN-EX	1"	DAV-CIN-SCR-ISO	DAV-CIN-WR

See Page 34 for inserts.

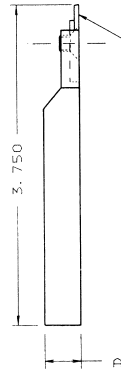
TOOLHOLDERS SHOWN USE **.750 SQ INSERT**
Patent No. D307859



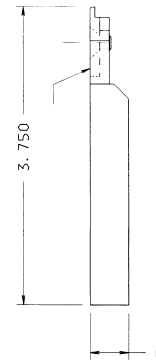
STANDARD STYLE INSERT



STYLE "R" INSERT



STYLE "C" INSERT

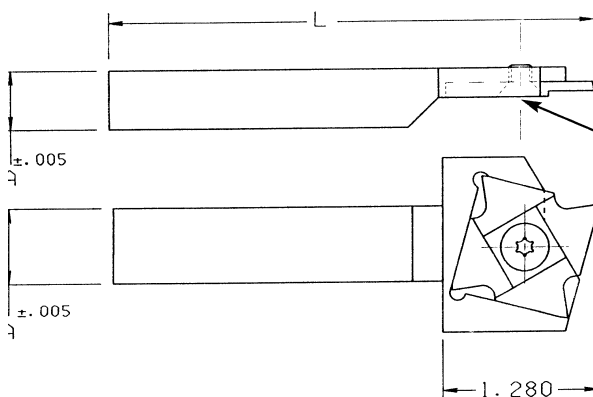


A	B	CAT# FOR STANDARD TOOLHOLDER	CAT# FOR STYLE R TOOLHOLDER	CAT# FOR STYLE C TOOLHOLDER
0.312	0.312	STCC-2117	STCC-2117R	STCC-2117C
0.375	0.375	STCC-2333	STCC-2333R	STCC-2333C
0.500	0.500	STCC-2237	STCC-2237R	STCC-2237C
0.500	0.625	STCC-1099	STCC-1099R	STCC-1099C
0.750	0.750	STCC-2218	STCC-2218R	STCC-2218C
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 34 for inserts.

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

TOOLHOLDER SHOWN USES **1" SQ INSERT**
Patent No. D307859

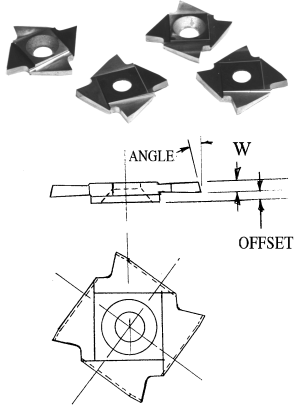


STANDARD INSERT STYLE SHOWN

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

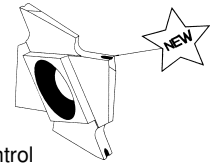
See Page 34 for inserts.

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:

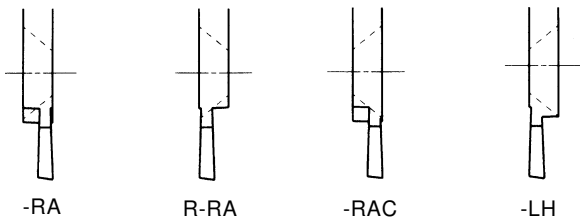
- TIN** FOR TITANIUM NITRIDE COATED
- TIALN** FOR TITANIUM ALUMINUM NITRIDE COATED
- TICN** FOR TITANIUM CARBO-NITRIDE COATED

- 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

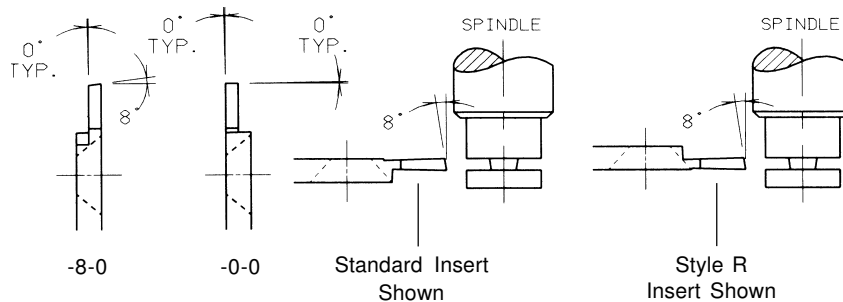
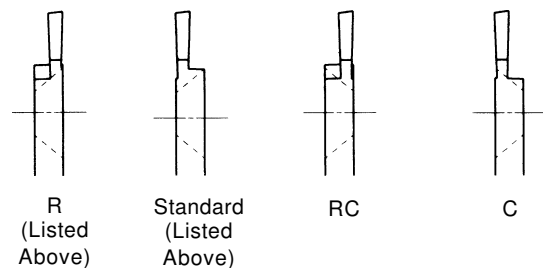
AVAILABLE INSERT STYLES

ADD THE SUFFIX LISTED BELOW TO THE ABOVE CATALOG NUMBERS

CLOCKWISE SPINDLE



COUNTERCLOCKWISE SPINDLE





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

**NEW HOLDERS AVAILABLE!
FOR LEFT HAND TURNING
AND THREADING ON BROWN
& SHARPE #00,#0, AND #2
ADD "-LH" TO THE CAT. NO**

See Page 34 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**

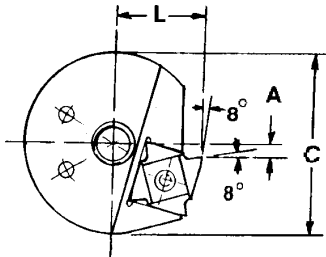
CAT. NO	INSERT SIZE	A	L
DAV-CIN	3/4" SQ	1/8"	1-1/8"
DAV-CIN-EX	1" SQ	1/8"	1-1/8"

**#00 B&S & TRAUB W/ TWO 5/32" DIA
PINHOLES ON 1-1/6" B.C. AND
ONE 1/8" DIA PINHOLE ON .787 B.C.**

CAT. NO	INSERT SIZE	A	L
OO-CIN	3/4" SQ	1/8"	1"

**#2 B&S W/ TWO 3/16" DIA PINHOLES
ON 1-1/2" B.C.**

CAT. NO	INSERT SIZE	A	L
2-CIN	3/4" SQ	1/4"	1-1/2"
2-CIN-EX	1" SQ	1/4"	1-1/2"

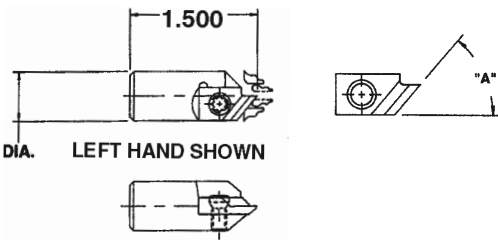


**#0 B&S W/ TWO 3/16" DIA PINHOLES
ON 1-3/8" B.C.**

CAT. NO	INSERT SIZE	A	L
O-CIN	3/4" SQ	5/32"	1-1/8"

CUTTING TOOLS

COUNTERSINK HOLDERS WITH MICRO-GRAIN CARBIDE AND T15PM INSERTS (PATENT NO. D396,865 / 5,827,019)



- COUNTERSINK RANGE .035 TO .325 DIA.
- LARGER RANGES AVAILABLE
- R.H. AND L.H. STOCKED
- BACKWORKING LEFT HAND CUT
- USED TO CHAMFER BACKEND OF PART I.D.
- REPEATABILITY WITHIN .001
- MINIMUM DOWN TIME

HOLDER PARTS

CAT. NO.	ITEM
DAV-CSK-SCR	TORX SCREW
DAV-CSK-WR	TORX WRENCH

USE T15PM INSERTS FOR SLOW SURFACE FEET PER MINUTE OR MACHINES THAT LACK RIGIDITY.

Note: Also available in 1", 2" and 2-1/2" lengths.

LEFT HAND

SHANK DIA.	INCL'D. ANGLE	HOLDER CAT. NO.	CARBIDE INSERT CAT. NO.	"A"	T15PM INSERT CAT. NO.
3/8	82 DEG.	DAV-CSK-3/8	DAV-CSI-LH41	41 DEG.	DAV-CSI-LH41-P
3/8	90 DEG.	DAV-CSK-3/8	DAV-CSI-LH45	45 DEG.	DAV-CSI-LH45-P
3/8	100 DEG.	DAV-CSK-3/8	DAV-CSI-LH50	50 DEG.	DAV-CSI-LH50-P
3/8	120 DEG.	DAV-CSK-3/8-120	DAV-CSI-LH60	60 DEG.	DAV-CSI-LH60-P
10MM	90 DEG.	DAV-CSK-10MM	DAV-CSI-LH45	45 DEG.	DAV-CSI-LH45-P
7/16	90 DEG.	DAV-CSK-7/16	DAV-CSI-LH45	45 DEG.	DAV-CSI-LH45-P
1/2	82 DEG.	DAV-CSK-1/2	DAV-CSI-LH41	41 DEG.	DAV-CSI-LH41-P
1/2	90 DEG.	DAV-CSK-1/2	DAV-CSI-LH45	45 DEG.	DAV-CSI-LH45-P
1/2	100 DEG.	DAV-CSK-1/2	DAV-CSI-LH50	50 DEG.	DAV-CSI-LH50-P
1/2	120 DEG.	DAV-CSK-1/2-120	DAV-CSI-LH60	60 DEG.	DAV-CSI-LH60-P
5/8"	90 DEG.	DAV-CSK-5/8	DAV-CSI-LH45	45 DEG.	DAV-CSI-LH45-P
3/4"	90 DEG.	DAV-CSK-3/4	DAV-CSI-LH45	45 DEG.	DAV-CSI-LH450-P

RIGHT HAND

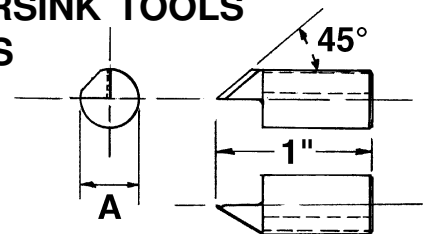
SHANK DIA.	INCL'D. ANGLE	HOLDER CAT. NO.	CARBIDE INSERT CAT. NO.	"A"	T15PM INSERT CAT. NO.
3/8	82 DEG.	DAV-CSK-3/8-R	DAV-CSI-RH41	41 DEG.	DAV-CSI-RH41-P
3/8	90 DEG.	DAV-CSK-3/8-R	DAV-CSI-RH45	45 DEG.	DAV-CSI-RH45-P
3/8	100 DEG.	DAV-CSK-3/8-R	DAV-CSI-RH50	50 DEG.	DAV-CSI-RH50-P
3/8	120 DEG.	DAV-CSK-3/8-120-R	DAV-CSI-RH60	60 DEG.	DAV-CSI-RH60-P
10MM	90 DEG.	DAV-CSK-10MMR	DAV-CSI-RH45	45 DEG.	DAV-CSI-RH45-P
7/16	90 DEG.	DAV-CSK-7/16R	DAV-CSI-RH45	45 DEG.	DAV-CSI-RH45-P
1/2	82 DEG.	DAV-CSK-1/2-R	DAV-CSI-RH41	41 DEG.	DAV-CSI-RH41-P
1/2	90 DEG.	DAV-CSK-1/2-R	DAV-CSI-RH45	45 DEG.	DAV-CSI-RH45-P
1/2	100 DEG.	DAV-CSK-1/2-R	DAV-CSI-RH50	50 DEG.	DAV-CSI-RH50-P
1/2	120 DEG.	DAV-CSK-1/2-120-R	DAV-CSI-RH60	60 DEG.	DAV-CSI-RH60-P
5/8"	90 DEG.	DAV-CSK-5/8-R	DAV-CSI-RH45	45 DEG.	DAV-CSI-RH45-P
3/4"	90 DEG.	DAV-CSK-3/4-R	DAV-CSI-RH45	45 DEG.	DAV-CSI-RH45-P

Also available tin coated - Add TIN to Insert Part #

SOLID MICRO-GRAIN CARBIDE COUNTERSINK TOOLS FOR DAVENPORT MACHINES

CAT. NO.	"A" DIA.
DAV-CSK-LH	3/8

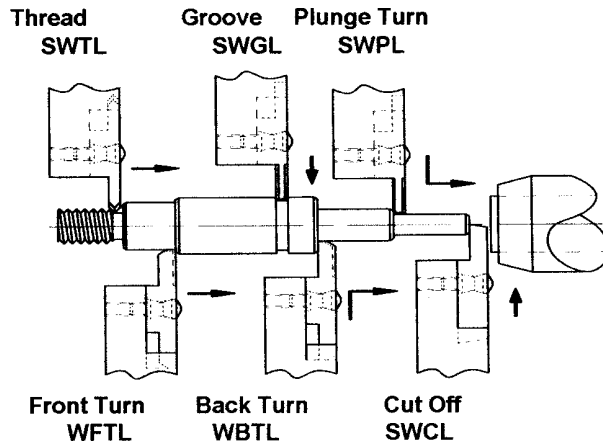
• FOR LEFT HAND CUT



TOOL HOLDERS

Holder No.	Dimensions	
	A	B
SWSL-10	.312	.312
SWSL-12	.375	.375
SWSL-14	.437	.437
SWSL-16	.500	.500
SWSL-20	.625	.625
SWSL-24	.750	.750
SWSL-8MM	8MM	8MM
SWSL-10MM	10MM	10MM
SWSL-12MM	12MM	12MM

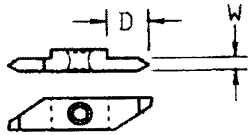
LEFT HAND TURNING



Cat. No.	Description
SW-3126	SCREW
SW-3344	WRENCH

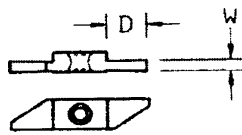
INSERTS

THREADING (SWTL)



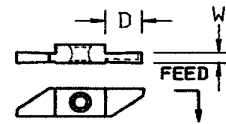
Insert Catalog No.	DIMENSIONS	
	W	D
SWTL-1250	.1250	.320
SWTL-0940	.0940	.300
SWTL-0780	.0780	.275
SWTL-0630	.0630	.250
SWTL-0470	.0470	.125
SWTL-0310	.0310	.093

GROOVE (SWGL)



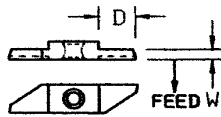
Insert Catalog No.	DIMENSIONS	
	W	D
SWGL-1250	.1250	.320
SWGL-0940	.0940	.300
SWGL-0780	.0780	.275
SWGL-0630	.0630	.250
SWGL-0470	.0470	.125
SWGL-0310	.0310	.093

PLUNGE & TURN (SWPL)



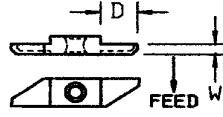
Insert Catalog No.	DIMENSIONS	
	W	D
SWPL-1250	.1250	.320
SWPL-0940	.0940	.300
SWPL-0780	.0780	.275
SWPL-0630	.0630	.250
SWPL-0470	.0470	.125
SWPL-0310	.0310	.093

FRONT TURN (WFTL)



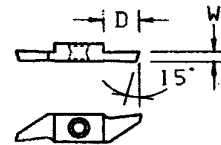
Insert Catalog No.	DIMENSIONS	
	W	D
WFTL-1250	.1250	.320
WFTL-0940	.0940	.300
WFTL-0780	.0780	.275
WFTL-0630	.0630	.250
WFTL-0470	.0470	.125
WFTL-0310	.0310	.093

BACK TURN (WBTL)



Insert L.H.	DIMENSIONS	
	W	D
WBTL-1250	.1250	.320
WBTL-0940	.0940	.300
WBTL-0780	.0780	.275
WBTL-0630	.0630	.250
WBTL-0470	.0470	.125
WBTL-0310	.0310	.093

CUT-OFF (SWCL)

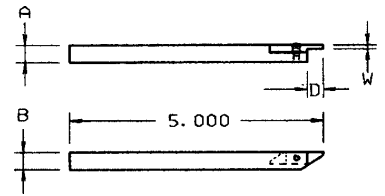
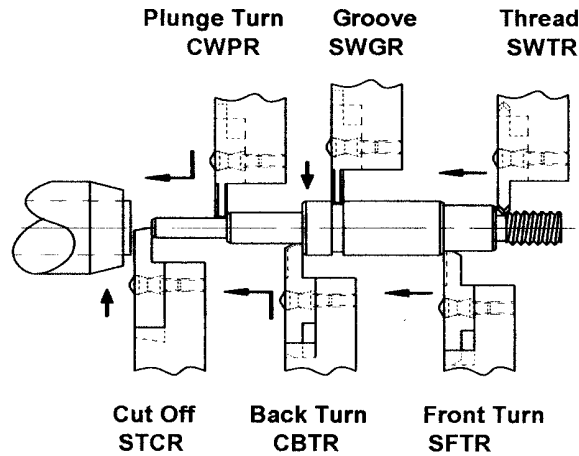


Insert L.H.	DIMENSIONS	
	W	D
SWCL-1250	.1250	.320
SWCL-0940	.0940	.300
SWCL-0780	.0780	.275
SWCL-0630	.0630	.250
SWCL-0470	.0470	.125
SWCL-0310	.0310	.093

TOOL HOLDERS

Holder No.	Dimensions	
	A	B
SWSR-10	.312	.312
SWSR-12	.375	.375
SWSR-14	.437	.437
SWSR-16	.500	.500
SWSR-20	.625	.625
SWSR-24	.750	.750
SWSR-8MM	8MM	8MM
SWSR-10MM	10MM	10MM
SWSR-12MM	12MM	12MM

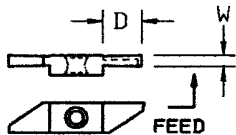
RIGHT HAND TURNING



Cat. No.	Description
SW-3126	SCREW
SW-3344	WRENCH

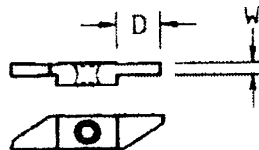
INSERTS

PLUNGE & TURN (CWPR)



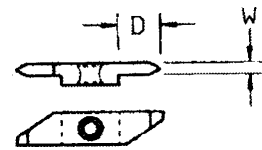
Insert Catalog No.	DIMENSIONS	
	W	D
CWPR-1250	.1250	.320
CWPR-0940	.0940	.300
CWPR-0780	.0780	.275
CWPR-0630	.0630	.250
CWPR-0470	.0470	.125
CWPR-0310	.0310	.093

GROOVE (SWGR)



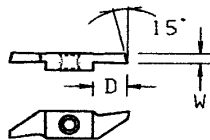
Insert Catalog No.	DIMENSIONS	
	W	D
SWGR-1250	.1250	.320
SWGR-0940	.0940	.300
SWGR-0780	.0780	.275
SWGR-0630	.0630	.250
SWGR-0470	.0470	.125
SWGR-0310	.0310	.093

THREADING (SWTR)



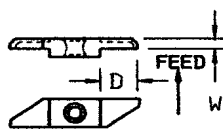
Insert Catalog No.	DIMENSIONS	
	W	D
SWTR-1250	.1250	.320
SWTR-0940	.0940	.300
SWTR-0780	.0780	.275
SWTR-0630	.0630	.250
SWTR-0470	.0470	.125
SWTR-0310	.0310	.093

CUT-OFF (STCR)



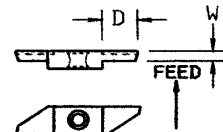
Insert Catalog No.	DIMENSIONS	
	W	D
STCR-1250	.1250	.320
STCR-0940	.0940	.300
STCR-0780	.0780	.275
STCR-0630	.0630	.250
STCR-0470	.0470	.125
STCR-0310	.0310	.093

BACK TURN (CBTR)

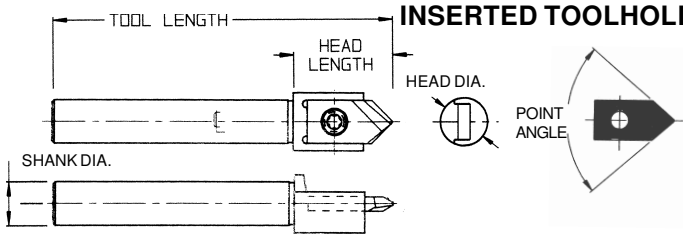


Insert Catalog No.	DIMENSIONS	
	W	D
CBTR-1250	.1250	.320
CBTR-0940	.0940	.300
CBTR-0780	.0780	.275
CBTR-0630	.0630	.250
CBTR-0470	.0470	.125
CBTR-0310	.0310	.093

FRONT TURN (SFTR)



Insert Catalog No.	DIMENSIONS	
	W	D
SFTR-1250	.1250	.320
SFTR-0940	.0940	.300
SFTR-0780	.0780	.275
SFTR-0630	.0630	.250
SFTR-0470	.0470	.125
SFTR-0310	.0310	.093



INSERTED TOOLHOLDERS FOR SPOT DRILLING

- THREE FLAT POINT TYPES AVAILABLE
.005 (FINE) / .015 (MEDIUM) / .034 (HEAVY)
- REPEATABILITY WITHIN +/- .0005
- AVAILABLE IN CARBIDE AND T15PM TIN COATED
- MINIMUM MACHINE DOWN TIME
- LEFT HAND AVAILABLE
- SPECIAL ANGLED INSERTS AVAILABLE (PRICE ON APPLICATION)

SERIES #2 TOOLHOLDER#	TOOL LENGTH	SHANK DIA.	HEAD DIA.	HEAD LENGTH
CDH-2-250-2.0	2.0	.250	.375	.690
CDH-2-375-1.5	1.5	.375	----	----
CDH-2-375-2.5	2.5	.375	----	----
CDH-2-500-2.0	2.0	.500	----	----
CDH-2-500-3.0	3.0	.500	----	----
CDH-2-625-5.0	5.0	.625	----	----
CDH-2-750-5.0	5.0	.750	----	----
CDH-2-1.000-5.0	5.0	1.000	----	----
CDH-2-10MM-1.5	1.5	10MM	----	----
CDH-2-10MM-2.5	2.5	10MM	----	----

SERIES #2 SPOT DRILLING INSERTS - .250 BODY DIAMETER			
POINT ANGLE	POINT FLAT	MICROGRAIN CARBIDE TIN COATED INSERT#	T15PM H.S.S. TIN COATED INSERT#
82°	.005	2-82-005-MICTIN	2-82-005-PTIN
82°	.015	2-82-015-MICTIN	2-82-015-PTIN
90°	.005	2-90-005-MICTIN	2-90-005-PTIN
90°	.015	2-90-015-MICTIN	2-90-015-PTIN
120°	.005	2-120-005-MICTIN	2-120-005-PTIN
120°	.015	2-120-015-MICTIN	2-120-015-PTIN

SCREW# DAV-CSK-SCR / WRENCH# DAV-CSK-WR

SERIES #3 TOOLHOLDER#	TOOL LENGTH	SHANK DIA.	HEAD DIA.	HEAD LENGTH
SDH-3-375-2.0	2.0	.375	.500	1.100
SDH-3-375-3.0	3.0	.375	.500	1.100
SDH-3-500-2.0	2.0	.500	----	----
SDH-3-500-3.0	3.0	.500	----	----
SDH-3-625-3.0	3.0	.625	----	----
SDH-3-625-5.0	5.0	.625	----	----
SDH-3-750-3.5	3.5	.750	----	----
SDH-3-750-5.0	5.0	.750	----	----
SDH-3-1.000-5.0	5.0	1.000	----	----
SDH-3-10MM-2.0	2.0	10MM	.500	1.100
SDH-3-10MM-3.0	3.0	10MM	.500	1.100
SDH-3-16MM-3.0	3.0	16MM	----	----

SERIES #3 SPOT DRILLING INSERTS - .375 BODY DIAMETER			
POINT ANGLE	POINT FLAT	MICROGRAIN CARBIDE TIN COATED INSERT#	T15PM H.S.S. TIN COATED INSERT#
82°	.005	3-82-005-MICTIN	3-82-005-PTIN
82°	.015	3-82-015-MICTIN	3-82-015-PTIN
82°	.034	3-82-034-MICTIN	3-82-034-PTIN
90°	.005	3-90-005-MICTIN	3-90-005-PTIN
90°	.015	3-90-015-MICTIN	3-90-015-PTIN
90°	.034	3-90-034-MICTIN	3-90-034-PTIN
120°	.005	3-120-005-MICTIN	3-120-005-PTIN
120°	.015	3-120-015-MICTIN	3-120-015-PTIN
120°	.034	3-120-034-MICTIN	3-120-034-PTIN

SCREW# STCC-4110 / WRENCH# STCC-4112

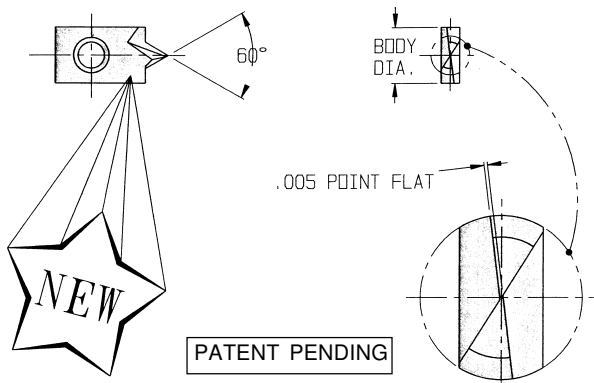
SERIES #4 TOOLHOLDER#	TOOL LENGTH	SHANK DIA.	HEAD DIA.	HEAD LENGTH
CDH-4-375-3.5	3.5	.375	.750	1.100
CDH-4-500-2.5	2.5	.500	.750	1.100
CDH-4-500-3.5	3.5	.500	.750	1.100
CDH-4-625-2.5	2.5	.625	.750	1.100
CDH-4-625-3.5	2.5	.625	.750	1.100
CDH-4-625-5.0	5.0	.625	.750	1.100
CDH-4-750-2.5	2.5	.750	----	----
CDH-4-750-3.5	3.5	.750	----	----
CDH-4-750-5.0	5.0	.750	----	----
CDH-4-1.000-5.0	5.0	1.000	----	----

SERIES #4 SPOT DRILLING INSERTS - .500 BODY DIAMETER			
POINT ANGLE	POINT FLAT	MICROGRAIN CARBIDE TIN COATED INSERT#	T15PM H.S.S. TIN COATED INSERT#
82°	.015	4-82-015-MICTIN	4-82-015-PTIN
82°	.034	4-82-034-MICTIN	4-82-034-PTIN
90°	.015	4-90-015-MICTIN	4-90-015-PTIN
90°	.034	4-90-034-MICTIN	4-90-034-PTIN
120°	.015	4-120-015-MICTIN	4-120-015-PTIN
120°	.034	4-120-034-MICTIN	4-120-034-PTIN

SCREW# STCC-4111 / WRENCH# STCC-4112

Screw is supplied with holder.
Inserts and wrenches are sold separately.

NEW! 60° TWO FLUTE RADIAL RELIEF SPOT DRILL INSERTS FOR ABOVE HOLDERS



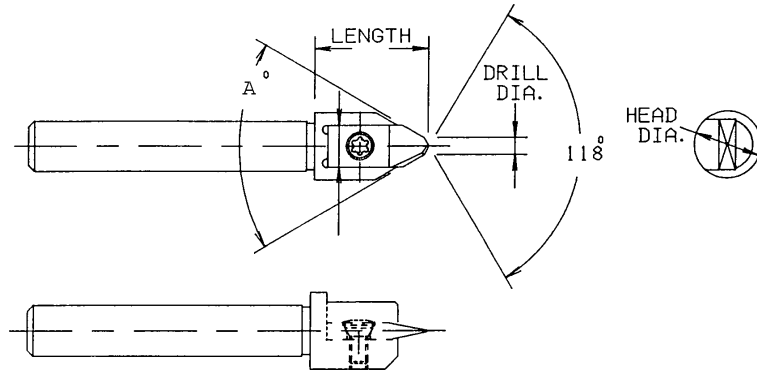
SERIES #2 SPOT DRILLING INSERTS - .250 BODY DIAMETER			
POINT ANGLE	POINT FLAT	MICROGRAIN CARBIDE TIN COATED INSERT#	T15PM H.S.S. TIN COATED INSERT#
60°	.005	2-60-005-MICTIN	2-60-005-PTIN

SERIES #3 SPOT DRILLING INSERTS - .375 BODY DIAMETER			
POINT ANGLE	POINT FLAT	MICROGRAIN CARBIDE TIN COATED INSERT#	T15PM H.S.S. TIN COATED INSERT#
60°	.005	3-60-005-MICTIN	3-60-005-PTIN

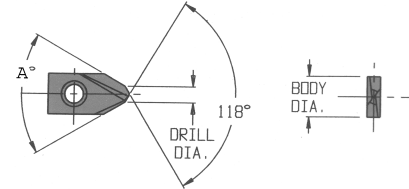
60° INCLUDED RADIAL SPOT DRILL INSERT ADVANTAGES

- The 60° included angle has radial and conical relief that is offset to give the cutting edge maximum strength plus clearance.
- These two spot drill inserts are center cutting with the ability to spot material starting with an outside diameter of .010"

The speed for these two inserts needs to be between 5000 - 8000 R.P.M. and the feed rate should be between .500" - 1.000" per minute.



- REPEATABILITY WITHIN .001
- AVAILABLE IN CARBIDE AND T-15PM
- TIN & TIALN COATED
- MINIMUM MACHINE DOWN TIME
- SHORTER CUTTING CYCLE
- SPECIAL ORDERS WELCOMED



Screw is supplied with holder.
Inserts and wrenches are sold separately.

TWO FLUTE STANDARD RELIEF - R.H. CENTER CUTTING INSERTS

NOTE: INSERTS ALSO AVAILABLE WITHOUT THE FLUTES FOR HEAVY CUTS - ADD "-O" TO PART NUMBERS SHOWN BELOW.

HOLDERS

SERIES #2				
HOLDER NUMBER	SHANK DIA.	HEAD DIA.	HEAD LENGTH	TOTAL LENGTH
CDH2-375-1.5	.375	----	----	1.5
CDH2-375-2.5	.375	----	----	2.5
CDH2-10MM-1.5	10MM	----	----	1.5
CDH2-10MM-2.5	10MM	----	----	2.5
CDH2-500-1.5	.500	----	----	1.5
CDH2-500-2.5	.500	----	----	2.5

INSERTS

SERIES #2 DRILL & COUNTERSINK INSERTS - .250 BODY DIAMETER			
INCLUDED ANGLE "A"	DRILL DIA.	MICROGRAIN CARBIDE TIN COATED INSERT#	T15PM H.S.S TIN COATED INSERT#
60°	.109	CDI2-60-109MICTIN	CDI2-60-109PTIN
82°	.109	CDI2-82-109MICTIN	CDI2-82-109PTIN
90°	.109	CDI2-90-109MICTIN	CDI2-90-109PTIN
SCREW# DAV-CSK-SCR / WRENCH# DAV-CSK-WR			

SERIES #2.5				
HOLDER NUMBER	SHANK DIA.	HEAD DIA.	HEAD LENGTH	TOTAL LENGTH
CDH2.5-375-2.0	.375	.500	.850	2.0
CDH2.5-375-3.0	.375	.500	.850	3.0
CDH2.5-10MM-2.0	10MM	.500	.850	2.0
CDH2.5-10MM-3.0	10MM	.500	.850	3.0
CDH2.5-500-2.0	.500	.500	.850	2.0
CDH2.5-500-3.0	.500	.500	.850	3.0

SERIES #2.5 DRILL & COUNTERSINK INSERTS - .312 BODY DIAMETER			
INCLUDED ANGLE "A"	DRILL DIA.	MICROGRAIN CARBIDE TIN COATED INSERT#	T15PM H.S.S TIN COATED INSERT#
60°	.125	CDI2.5-60-125MICTIN	CDI2.5-60-125PTIN
82°	.125	CDI2.5-82-125MICTIN	CDI2.5-82-125PTIN
90°	.125	CDI2.5-90-125MICTIN	CDI2.5-90-125PTIN
SCREW# STCC-4110 / WRENCH# STCC-4112			

SERIES #3.5				
HOLDER NUMBER	SHANK DIA.	HEAD DIA.	HEAD LENGTH	TOTAL LENGTH
CDH3.5-375-2.0	.375	.750	1.100	2.0
CDH3.5-375-3.0	.375	.750	1.100	3.0
CDH3.5-10MM-2.0	10MM	.750	1.100	2.0
CDH3.5-10MM-3.0	10MM	.750	1.100	3.0
CDH3.5-500-2.0	.500	.750	1.100	2.0
CDH3.5-500-3.0	.500	.750	1.100	3.0

SERIES #3.5 DRILL & COUNTERSINK INSERTS - .437 BODY DIAMETER			
INCLUDED ANGLE "A"	DRILL DIA.	MICROGRAIN CARBIDE TIN COATED INSERT#	T15PM H.S.S TIN COATED INSERT#
60°	.187	CDI3.5-60-187MICTIN	CDI3.5-60-187PTIN
82°	.187	CDI3.5-82-187MICTIN	CDI3.5-82-187PTIN
90°	.187	CDI3.5-90-187MICTIN	CDI3.5-90-187PTIN
SCREW# STCC-4111 / WRENCH# STCC-4112			

SERIES #4				
HOLDER NUMBER	SHANK DIA.	HEAD DIA.	HEAD LENGTH	TOTAL LENGTH
CDH4-500-2.5	.500	.750	1.100	2.5
CDH4-500-3.5	.500	.750	1.100	3.5
CDH4-625-2.5	.625	.750	1.100	2.5
CDH4-625-3.5	.625	.750	1.100	3.5
CDH4-750-2.5	.750	----	----	2.5
CDH4-750-3.5	.750	----	----	3.5

SERIES #4 DRILL & COUNTERSINK INSERTS - .500 BODY DIAMETER			
INCLUDED ANGLE "A"	DRILL DIA.	MICROGRAIN CARBIDE TIN COATED INSERT#	T15PM H.S.S TIN COATED INSERT#
60°	.218	CDI4-60-218MICTIN	CDI4-60-218PTIN
82°	.218	CDI4-82-218MICTIN	CDI4-82-218PTIN
90°	.218	CDI4-90-218MICTIN	CDI4-90-218PTIN
SCREW# STCC-4111 / WRENCH# STCC-4112			