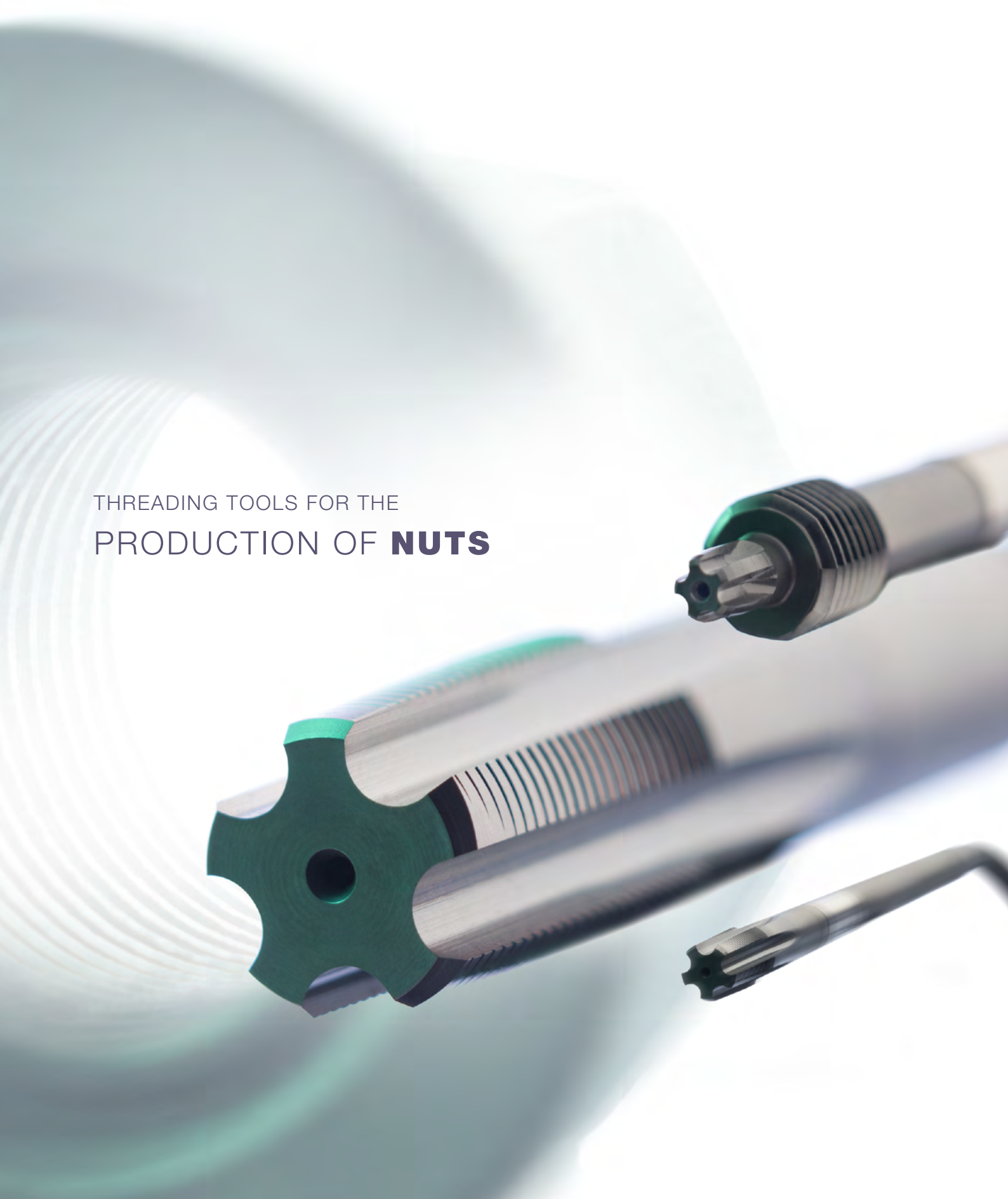


BASS
TECHNIK FÜR GEWINDE

THREADING TOOLS FOR THE
PRODUCTION OF **NUTS**



Application

- for fully automatic tapping of nuts with through hole threads in a run-over tapping process
- for nut height up to max. 1.5xd

Your advantage

- high productivity due to process-reliable chip evacuation and low tool wear
- qualified technical consulting by BASS specialists

AMGB R

for welding



Dimensions	
M	M3 – M12
MF	M4x0.5 – M12x1.5
UNC	UNC No8-32 – UNC7/16"-14
UNF	UNF No8-36 – UNF7/16"-20

AMGB L

for soldering



Dimensions	
M	M8 – M36
MF	M8x1 – M36x1.5
UNC	UNC5/16"-18 – UNC1.1/4"-7
UNF	UNF5/16"-24 – UNF1.1/4"-12

AMGB V

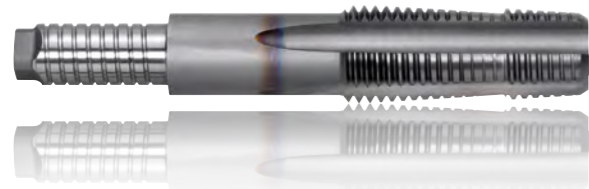
screw system (cartridge)



Dimensions	
M	M10 – M36
MF	M12x1.5 – M36x1.5
UNC	UNC7/16"-14 – UNC1.1/4"-7
UNF	UNF7/16"-20 – UNF1.1/4"-12

AMGB F

screw system (spring)



Dimensions	
M	M12 – M36
MF	M12x1.5 – M36x1.5
UNC	UNC7/16"-14 – UNC1.1/4"-7
UNF	UNF7/16"-20 – UNF1.1/4"-12

Model

tool material	HSSE-PM
thread length	standard 24 thread turns, different thread lengths on request
thread tolerance	customizable
coating	TIN / TiCN
nut material	cold and hot formed steels up to grade 10
shank connection	AMGB R for welding AMGB L for soldering AMGB V with screw system (cartridge) AMGB F with screw system (spring)

Shank

for AMGB V

Model

according to the machine type – or according to customer specifications

Dimensions	
M	M10 – M36
MF	M12x1.5 – M36x1.5
UNC	UNC7/16"-14 – UNC1.1/4"-7
UNF	UNF7/16"-20 – UNF1.1/4"-12



Cartridge

for AMGB V

Application

The cartridge connects the tap nib with the bent shank. If the torque gets too high (tool wear) the cartridge breaks, disconnecting the assembly.

Your advantage

The cartridge saves shank and tap from breaking so that both are reusable.

Dimensions	
M	M10 – M36
MF	M12x1.5 – M36x1.5
UNC	UNC7/16"-14 – UNC1.1/4"-7
UNF	UNF7/16"-20 – UNF1.1/4"-12



VARIO K RZ

cutting tap with reamer

Application

- for fully automatic tapping of union nuts in a reversing tapping cycle
- chamfer length min. 1.5 thread turns

Your advantage

Customized high quality cutting taps convince through best performance.



Dimensions	
MF	M8x1 – M36x2
G	G1/4" – G1"
UNF	on request

Model

tool material	HSSE-PM
dimensions	customizable
thread tolerance	customizable
coating	TIN / HL
nut material	cold and hot formed steels up to grade 10

DURAMAX K RZ

roll tap with reamer

Application

for union nuts with chamfer length min. 1 thread turns

Your advantage

Customized high quality roll taps convince through best performance.



Dimensions	
MF	M8x1 – M24x1.5
UNF	on request

Model

tool material	HSSE-PM
dimensions	customizable
thread tolerance	customizable
coating	TIN / TICN / BT
nut material	cold formed steels

VARIANT H

cutting tap with spiral point

Application

for tapping of nuts with through hole threads in a reversing tapping cycle

Your advantage

Constant quality and high availability in different thread tolerances offer planning reliability.

Dimensions	
M	M2 – M24
MF	M8x1 – M30x1.5
UNC	UNC1/4"-20 – UNC1"-8
UNF	UNF1/4"-28 – UNF1"-12



Model

tool material	HSSE-PM
chamfer form	B / 3.5–5.5
thread tolerance	6H / 6G / 7G / 6H+0.1 / on request
coating	TIN / TICN / HL
dimensions	DIN 371 / DIN 376
nut material	cold and hot formed steels up to grade 10

AVANT H25

cutting tap with spiral flute 25°

Application

for tapping of nuts with blind hole threads in a reversing tapping process

Your advantage

- high process reliability due to optimal evacuation of chips
- high tool life

Dimensions	
M	M2 – M24
MF	M8x1 – M30x1.5
UNC	UNC1/4"-20 – UNC1"-8
UNF	UNF1/4"-28 – UNF1"-12
G	G1/8" – G1"



Model

tool material	HSSE-PM
chamfer form	E / 1.5–2
thread tolerance	6HX / 6GX / on request
coating	HL
dimensions	DIN 371 / DIN 376
nut material	cold and hot formed steels up to grade 10

DURAMAX H

roll tap

Application
for chipless threading of nuts with through or blind hole threads in a reversing tapping cycle

- Your advantage**
- high tool life
 - qualified technical consulting by BASS specialists



Dimensions	
M	M2 – M16
MF	M8×1 – M24×1.5
UNC	UNC1/4"-20 – UNC5/8"-11
UNF	UNF1/4"-28 – UNF3/4"-16

Model	
tool material	HSSE-PM
chamfer form	C / 2-3 / E / 1.5-2
thread tolerance	6HX / 6GX / on request
coating	TIN / TICN / BT
internal coolant	axial (KA), radial (KR)
dimensions	DIN 371 / DIN 376
nut material	cold formed steels

**Streicher Tapping Machines
Partner of BASS**



RUN-OVER TAPPING PROCESS

Thread	dimension	tolerance	cutting direction RH LH	nut height
	bore depth [mm]	thread depth [mm]	bore hole diameter	process thread cutting thread roll forming
Nut material	material	cold formed hot formed	resistance [N/mm²]	hardness
	chamfer form	flute form / design	number of flutes	coating
	l1 [mm]	l2 [mm]		
	l4 [mm]	d2 [mm]		
Tool data	a [mm]	d3 [mm]	shank connection screw system (cartridge) screw system (spring)	for soldering for welding
	further tool data (dimensions,...)		gauge dimension go: gauge dimension no-go:	
	manufacturer	machine type	nut type	processing horizontal vertical
Machine	tool clamping	number of spindles	coolant lubrication	rotation speed rpm [1/min]
	cutting speed v _c [m/min]	rotation speed rpm [1/min]		

REVERSING TAPPING PROCESS

Thread	dimension	tolerance	cutting direction RH LH	bore hole through hole blind hole
	material	cold formed hot formed	resistance [N/mm²]	hardness
Nut material	chamfer form	flute form / design	number of flutes	coating
	l1 [mm]	l2 [mm]		
	l4 [mm]	d2 [mm]		
	a [mm]	d3 [mm]	gauge dimension go: gauge dimension no-go:	
Tool data	manufacturer	machine type	workpiece clamping	processing horizontal vertical
	tool clamping	number of spindles	coolant lubrication	rotation speed rpm [1/min]
	cutting speed v _c [m/min]	rotation speed rpm [1/min]		

BASS

TECHNIK FÜR GEWINDE



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