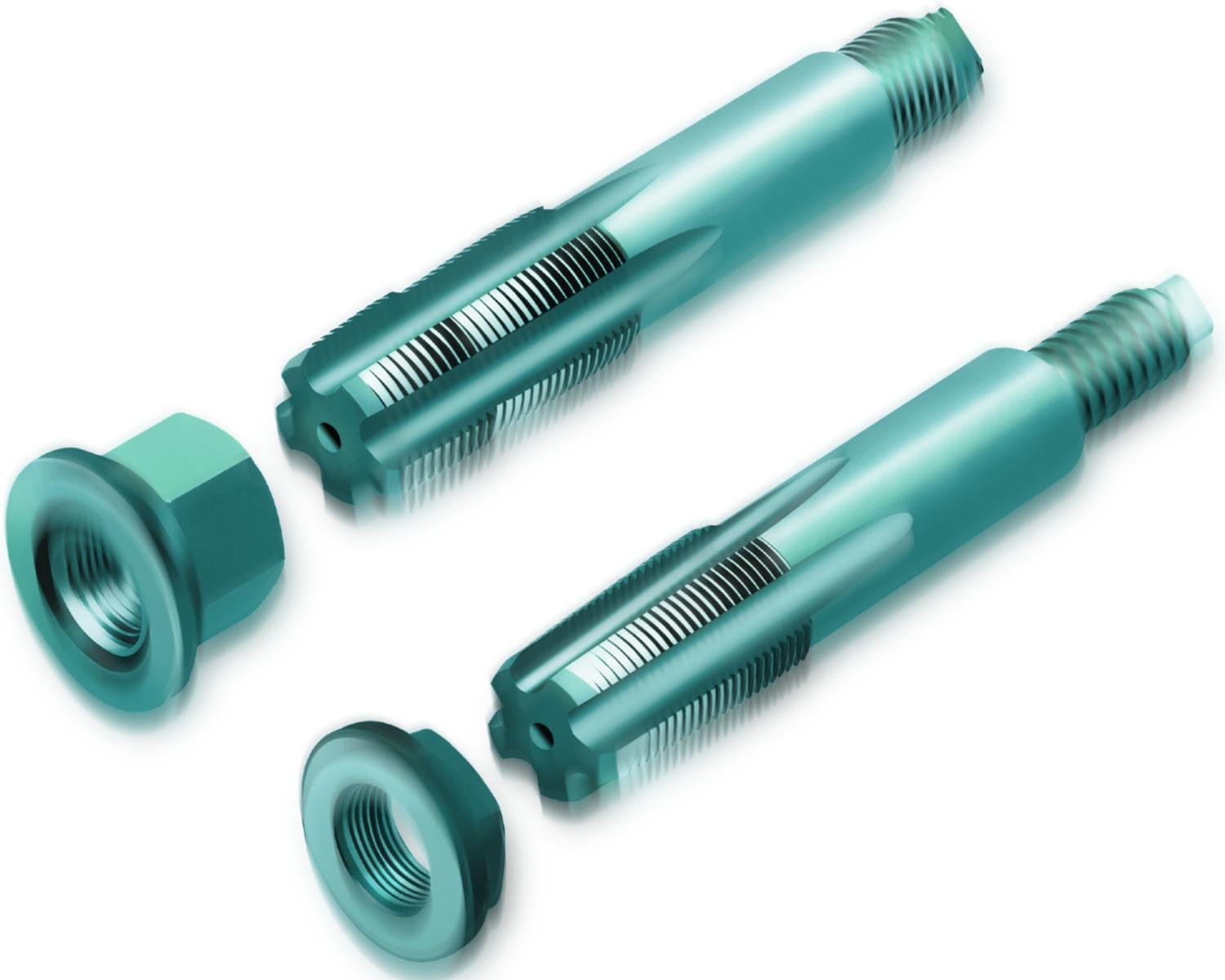




**THREADING TOOLS FOR
THE PRODUCTION OF NUTS**



Application

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

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	M4×0.5 – M12×1.5
UNC	UNC No8-32 – UNC7/16"-14
UNF	UNF No8-36 – UNF7/16"-20

AMGB L

for soldering



Dimensions

M	M8 – M36
MF	M8×1 – M36×1.5
UNC	UNC5/16"-18 – UNC1.1/4"-7
UNF	UNF5/16"-24 – UNF1.1/4"-12

AMGB V

screw system (cartridge)



Dimensions

M	M12 – M36
MF	M12×1.5 – M36×1.5
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	M12×1.5 – M36×1.5
UNC	UNC7/16"-14 – UNC1.1/4"-7
UNF	UNF7/16"-20 – UNF1.1/4"-12

NUT TAPS

Model

tool material	HSSE
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	M12 – M36
MF	M12×1.5 – M36×1.5
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	M12 – M36
MF	M12×1.5 – M36×1.5
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
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
nut material	cold formed steels

CUTTING TAPS

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
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
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 N

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	M8x1 – M24x1.5
UNC	UNC1/4"-20 – UNC5/8"-11
UNF	UNF1/4"-28 – UNF3/4"-16

Model

tool material	HSSE / HSSE-PM
chamfer form	C / 2-3 / E / 1.5-2
thread tolerance	6HX / 6GX / on request
coating	TIN / TICN
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 <input type="checkbox"/> RH <input type="checkbox"/> LH	nut height
	bore depth [mm]	thread depth [mm]	bore hole diameter	process <input type="checkbox"/> thread cutting <input type="checkbox"/> thread roll forming
Nut material	material	<input type="checkbox"/> cold formed <input type="checkbox"/> hot formed	resistance [N/mm ²]	hardness
Tool data	chamfer form	flute form / design	number of flutes	coating
	l1 [mm]	l2 [mm]		
	l4 [mm]	d2 [mm]		
	a [mm]	d3 [mm]		
further tool data (dimensions,...)		gauge dimension go: gauge dimension no-go:		
Machine	manufacturer	machine type	nut type	processing <input type="checkbox"/> horizontal <input type="checkbox"/> vertical
	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 <input type="checkbox"/> RH <input type="checkbox"/> LH	bore hole <input type="checkbox"/> through hole <input type="checkbox"/> blind hole
	material	<input type="checkbox"/> cold formed <input type="checkbox"/> hot formed	resistance [N/mm ²]	hardness
Tool data	l1 [mm]	l2 [mm]		
	l4 [mm]	d2 [mm]		
	a [mm]	d3 [mm]		
	further tool data (dimensions,...)		gauge dimension go: gauge dimension no-go:	
Machine	manufacturer	machine type	workpiece clamping	processing <input type="checkbox"/> horizontal <input type="checkbox"/> 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

TAPPING TECHNOLOGY



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