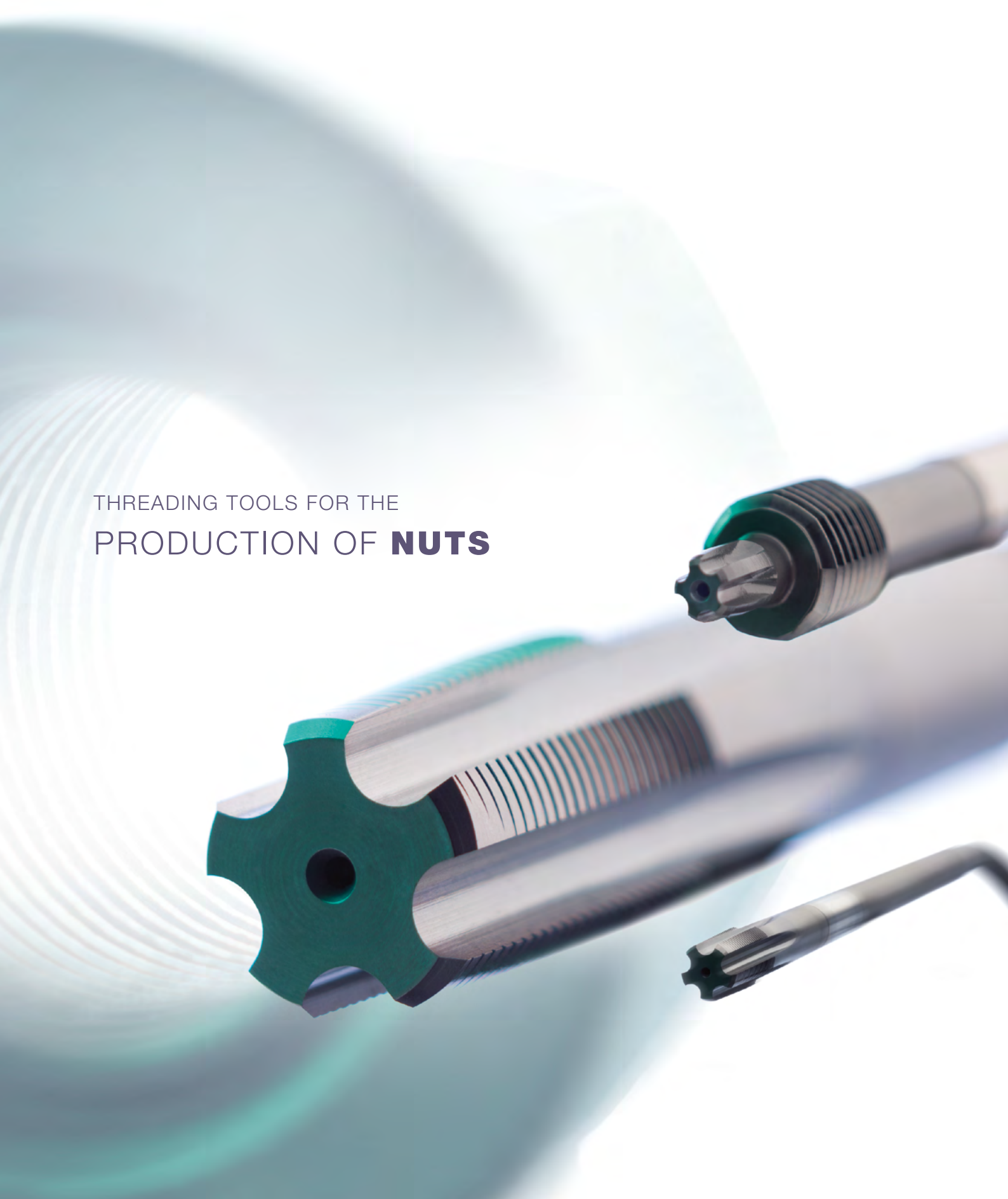


**BASS**  
TECHNIK FÜR GEWINDE

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. 1.5x d

**Your advantage**

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

**AMGB V**

screw system (cartridge)

**dimensions**

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



**Shank**

for AMGB V, according to the machine type or customer specifications

**dimensions**

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



**Cartridge**

for AMGB V

**dimensions**

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



**Application**

The cartridge connects the tap with the bent shank. If the torque gets too high the cartridge breaks, disconnecting the assembly.

**Your advantage**

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

## NUT TAPS

### Model

tool material	HSSE-PM
thread length	standard 24 thread turns, other thread lengths upon request
thread tolerance	customizable
coating	TIN / TICN
nut material	cold and hot formed steels up to grade 10

### AMGB R

for self-welding

#### dimensions

<b>M</b>	M3 – M12
<b>MF</b>	M4×0.5 – M12×1.5
<b>UNC</b>	UNC No8-32 – UNC7/16"-14
<b>UNF</b>	UNF No8-36 – UNF7/16"-20

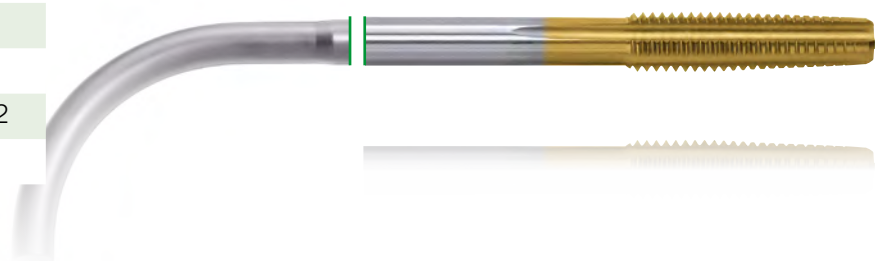


### AMGB RM

with welded shank, curved or straight

#### dimensions

<b>M</b>	M2 – M14
<b>MF</b>	M2×0.35 – M14×1
<b>UNC</b>	UNC No2-56 – UNC9/16"-12
<b>UNF</b>	UNF No2-64 – UNF9/16"-18



### AMGB L

for soldering

#### dimensions

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



### AMGB F

screw system (spring)

#### dimensions

<b>M</b>	M12 – M36
<b>MF</b>	M12×1.5 – M36×1.5
<b>UNC</b>	UNC7/16"-14 – UNC1.1/4"-7
<b>UNF</b>	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**

<b>MF</b>	M8x1 – M36x2
<b>G</b>	G1/4" – G1"
<b>UNF</b>	UNF5/16"-24 – UNF1.1/2"-12

**Model**

<b>tool material</b>	HSSE-PM
<b>dimensions</b>	customizable
<b>thread tolerance</b>	customizable
<b>coating</b>	TIN / HL / BT
<b>nut material</b>	cold and hot formed steels up to grade 10, stainless steels

**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**

<b>MF</b>	M8x1 – M36x2
<b>G</b>	G1/4" – G1"
<b>UNF</b>	UNF5/16"-24 – UNF1.1/2"-12

**Model**

<b>tool material</b>	HSSE-PM
<b>dimensions</b>	customizable
<b>thread tolerance</b>	customizable
<b>coating</b>	TIN / TICN / BT
<b>nut material</b>	cold formed steels, stainless 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

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



#### Model

<b>tool material</b>	HSSE-PM
<b>chamfer form</b>	B / 3.5–5.5
<b>thread tolerance</b>	6H / 6G / 7G / 6H+0.1 / on request
<b>coating</b>	TIN / TiCN / HL
<b>dimensions</b>	DIN 371 / DIN 376
<b>nut material</b>	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

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



#### Model

<b>tool material</b>	HSSE-PM
<b>chamfer form</b>	E / 1.5–2
<b>thread tolerance</b>	6HX / 6GX / on request
<b>coating</b>	HL
<b>dimensions</b>	DIN 371 / DIN 376
<b>nut material</b>	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**


<b>M</b>	M2 – M16
<b>MF</b>	M8x1 – M30x1.5
<b>G</b>	G1/4" – G1"
<b>UNC</b>	UNC1/4"-20 – UNC5/8"-11
<b>UNF</b>	UNF1/4"-28 – UNF3/4"-16

**Model**

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



We also provide tools for  
special and multi-start threads.



**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 <sup>2</sup> ]	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 <sub>c</sub> [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 <sup>2</sup> ]	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 <sub>c</sub> [m/min]		rotation speed rpm [1/min]		



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