BASS **EINSATZEMPFEHLUNG** GEWINDE**BOHRER/-FURCHER** DIN 2174

BASS RECOMMENDATION TAPS/ROLL TAPS DIN 2174

ANWENDUNGSGEBIET	HÄRTE / HARDNESS (HB)	ZUG-FESTIGKEIT / TENSILE STRENGTH N/mm²	Best.-Nr.	VARIANT N 1311 TIN Vc m/min	DOMINANT N 1141 TIN Vc m/min	VARIANT N 1.1311 VAP Vc m/min	DOMINANT N 1.1141 VAP Vc m/min	VARIANT H 2311 TIN Vc m/min	DOMINANT Z 6141 TIN Vc m/min	VARIANT H 2311 TICN Vc m/min	AVANT H 2131 TICN Vc m/min	DOMINANT H 2141 TICN Vc m/min	VARIANT TiH 25.2311 TICN Vc m/min	AVANT TiH 25.2131 TICN Vc m/min	VARIANT Ni 22.2311 Vc m/min	VARIANT VA 14.2311 TIN Vc m/min	DOMINANT VA 14.6141 TIN Vc m/min	VARIANT HST 20.7311 TIN syncro Vc m/min	DOMINANT HST 20.7141 TIN syncro Vc m/min	VARIO GG 1191 TICN Vc m/min	VARIO GG 20.8191 KA-TICN Vc m/min	AVANT GAL 1931 TICN Vc m/min	DOMINANT W 3.1151 Vc m/min	DURAMAX 1531 TIN Vc m/min	DURAMAX P 20.1531 TIN Vc m/min	Order No.	APPLICATION
1. STAHLWERKSTOFF																											**STEEL MATERIAL**
1.1 Magnetweicheisen	< 120	> 200 < 400		20-30	20-30	10-15	10-15											20-60	20-60					30-40	30-40	1.1	Magnetic soft steel
1.2 Baustahl / Einsatzstahl	> 105 < 210	> 350 < 710		20-30	20-30	10-15	10-15											20-60	20-60					30-40	30-40	1.2	Construction steel / case hardening steel
1.3 Kohlenstoffstahl	> 105 < 255	> 350 < 850		20-30	20-30	10-15	10-15											20-60	20-60					30-40	30-40	1.3	Carbon steel
1.4 Legierter Stahl / Vergütungsstahl	> 150 < 255	> 500 < 850						15-25	15-25		15-35							15-45	15-45					30-40	30-40	1.4	Alloyed / tempered steel
1.5 Legierter Stahl	> 250 < 355	> 850 < 1200								10-15	10-15	10-15						10-20	10-20						15-20	1.5	Alloyed steel
1.6 Legierter Stahl	> 355 < 410	> 1200 < 1400											2-4	2-4												1.6	Alloyed steel
2. ROSTFREIER STAHL																											**STAINLESS STEEL**
2.1 Ferritischer / martensitischer Stahl	> 135 < 325	> 450 < 1100														6-12	6-12	8-12	8-12					8-12	8-12	2.1	Ferritic / martensitic steel
2.2 Austenitischer Stahl	> 135 < 255	> 450 < 850														6-12	6-12	8-12	8-12					8-12	8-12	2.2	Austenitic steel
3. GUSSEISEN																											**CAST IRON**
3.1 Grauguss	> 100 < 300	> 150 < 1000																		20-30	20-30	20-30				3.1	Grey cast iron
3.2 Kugelgraphitguss	> 100 < 300	> 350 < 1000								15-25	15-25							15-25	15-25	15-30		20-30				3.2	Nodular graphite iron
3.3 Temperguss	> 100 < 210	> 350 < 700								15-25	15-25							15-25	15-25							3.3	Malleable cast iron
4. KUPFER																											**COPPER**
4.1 Reinkupfer / Elektrolytkupfer	> 80 < 100	> 250 < 350														15-20	15-20	20-30	20-30					15-25	15-25	4.1	Pure copper
4.2 Kupfer-Legierungen (kurzspanend)	> 100 < 200	> 350 < 700																		10-20						4.2	Brass (short chipping)
4.3 Kupfer-Legierungen (langspanend)	> 100 < 200	> 350 < 700														25-35	25-35	20-60	20-60					25-35	25-35	4.3	Brass (long chipping)
4.4 Cu-Al-Ni-Legierungen (kurzspanend)	> 120 < 250	> 400 < 850																		2-4						4.4	Cu-Al-Ni alloy (short chipping)
5. ALUMINIUM / MAGNESIUM																											**ALUMINIUM / MAGNESIUM**
5.1 Alu unlegiert / Alu-Knetlegierungen Si < 0,5%	> 50 < 150	> 100 < 500																					15-25			5.1	Alu wrought alloy Si < 0,5%
5.2 Alu legiert Si < 6%	> 50 < 100	> 160 < 300			25-35													25-35	25-35					20-40	30-40	5.2	Alu alloyed Si < 6%
5.3 Alu legiert Si > 6%	> 90 < 180	> 300 < 600		20-30	20-30													20-30	20-30			20-30				5.3	Alu alloyed Si > 6%
5.4 Magnesium-Knetlegierung	< 100	> 120 < 300									25-35									30-40						5.4	Magnesium wrought alloy
6. TITAN																											**TITANIUM**
6.2 Titan legiert	> 200 < 265	> 700 < 900											4-8	4-8												6.2	Titanium alloyed
6.3 Titan legiert	> 270 < 410	> 900 < 1400											2-4	2-4												6.3	Titanium alloyed
7. NICKEL																											**NICKEL**
7.1 Nickel unlegiert	> 120 < 170	> 400 < 600														15-20	15-20							15-25	15-25	7.1	Nickel unalloyed
7.3 Nickel legiert	> 355 < 470	> 1200 < 1600													2-3											7.3	Nickel alloyed
8. KUNSTSTOFF																											**PLASTIC**
8.1 Thermoplaste (langspanend)	< 100	< 80																					15-25			8.1	Thermoplastic (long chipping)
8.2 Duroplaste (kurzspanend)	< 100	< 110																		10-15						8.2	Thermosetting plastic (short chipping)
8.3 Faserverstärkte Kunststoffe	< 440	> 80 < 1500																		5-10						8.3	Reinforced plastic material
Weitere Informationen BASS-Katalogseite				4	26	6	28	8	32	8	16	36	14	22	14	12	38	6	30	42	42	20	38	48	50		For further information see BASS catalog page.

Durchgangsloch

Grundloch

Synchronbearbeitung
synchron spindle

through hole

blind hole