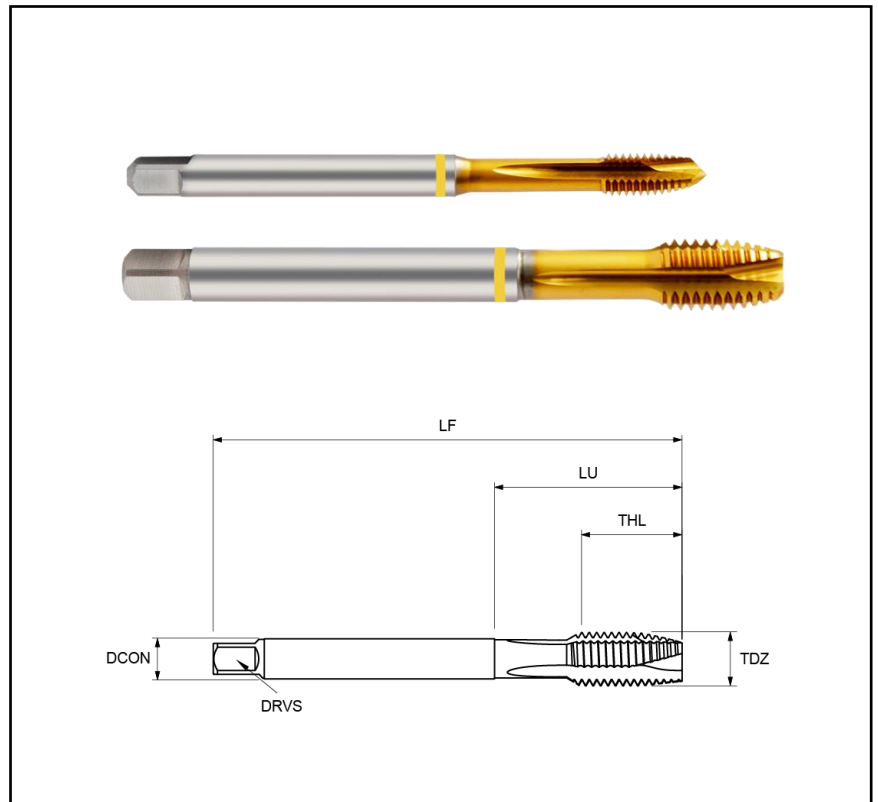


Features

- **HSS-E Construction:** Manufactured from high-speed steel with cobalt (HSS-E) for improved hardness, heat resistance, and long service life..
- **TiN Coating:** Titanium nitride coating reduces friction and wear, enhances cutting performance, and extends tool life.
- **Spiral Point Design (DIN 371):** Optimised for through-hole tapping, pushing chips forward for clean, accurate threads and reliable performance in production environments.

RS PRO Metric High Speed Tap, Spiral Point



RS Professionally Approved Products bring to you professional quality parts across all product categories. Our product range has been tested by engineers and provides a comparable quality to the leading brands without paying a premium price.

Product Description

The Metric High Speed Spiral Point Tap is designed for efficient and accurate through hole threading. Manufactured from HSS-E (cobalt alloy high speed steel), it offers excellent strength, heat resistance, and durability. The TiN coating reduces friction and wear, improves cutting performance, and extends tool life. The spiral point design, pushes chips forward, this tap ensures smooth operation and clean thread formation. Compliant with DIN 371, ensuring reliable dimensional accuracy and performance.

General Specifications

Brand	RS PRO
Product Type	Threading Tap
Thread Size	M3 – M12
Thread Pitch	0.5mm – 1.75mm
Thread Length	5mm – 18mm
Number of Pieces	1
Overall Length	56mm – 110mm
Hand/Machine Tap	Machine Tap
Shank Diameter	3.5mm – 10mm
Substrate	HSS-E

Mechanical Specifications

Thread Diameter Size	TDZ – See table below and detailed image below
Thread Pitch	TP – See table below and detailed image below
Threading Length	THL – See table below and detailed image below
Overall Length	LF – See table below and detailed image below
Usable Length	LU – See table below and detailed image below
Connection Diameter	DCON – See table below and detailed image below
Drive Square Size	DRVS – See table below and detailed image below

Approvals

Declarations	N/A
Hazardous Area Certification	N/A
Standards Met	DIN 371

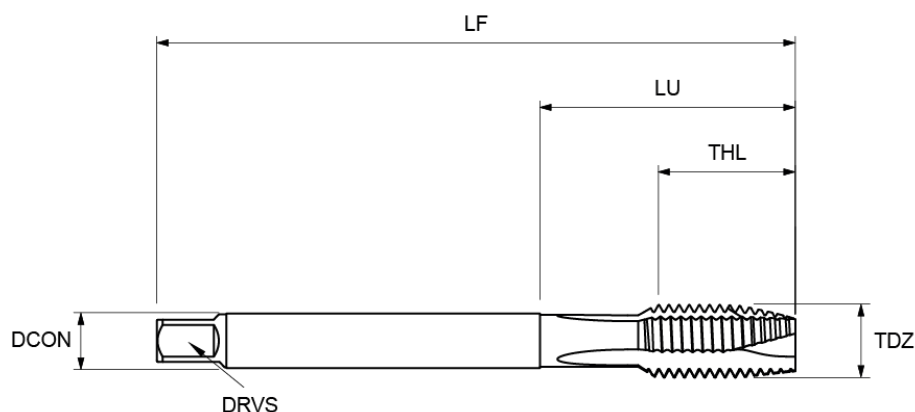
Threading Taps



Stock No.	Brand	Size TDZ	Pitch TP	Thread Length THL	O/ALL Length LF	Neck Length LU	DCON	DRVS	No. Of Flutes NOF	Tapping Drill PHD
XXX-XXXX 900390	RS PRO	M3	0.5	5	56	18	3.5	2.7	3	2.5
XXX-XXXX 900392	RS PRO	M4	0.7	7	63	21	4.5	3.4	3	3.3
XXX-XXXX 900391	RS PRO	M5	0.8	8	70	25	6.0	4.9	3	4.2
XXX-XXXX 900393	RS PRO	M6	1.0	10	80	30	6.0	4.9	3	5.0
XXX-XXXX 900394	RS PRO	M8	1.25	13	90	35	8.0	6.2	3	6.8
XXX-XXXX 900283	RS PRO	M10	1.5	15	100	39	10.0	8.0	3	8.5
XXX-XXXX 900284	RS PRO	M12	1.75	18	110	44	9.0	7.0	4	10.2

Similar Products

Stock No.	Brand	Size TDZ	Pitch TP	Thread Length THL	O/ALL Length LF	Neck Length LU	DCON	DRVS	Tapping Drill PHD
XXX-XXXX 900287	RS PRO	M3	0.5	5	56	18	3.5	2.7	2.8
XXX-XXXX 900285	RS PRO	M4	0.7	7	63	21	4.5	3.4	3.7
XXX-XXXX 900286	RS PRO	M5	0.8	8	70	25	6.0	4.9	4.7
XXX-XXXX 900288	RS PRO	M6	1.0	10	80	30	6.0	4.9	5.6
XXX-XXXX 900289	RS PRO	M8	1.25	13	90	35	8.0	6.2	7.4
XXX-XXXX 900287	RS PRO	M3	0.5	5	56	18	3.5	2.7	2.8



Cutting Data

					HOLE TYPE			
					Max 2.5xD	Max 3.0xD	Max 2.0xD	Max 3.0xD
					TM9031	TM9133	TM9235	TM9337
VDI MATERIAL GROUP		HRc	COOLANT TYPE	v _c (m/min)				
P	1-5	Non-alloy Steel	<25	Emulsion	28-46	28-46	28-46	28-46
	6-9	Low alloy Steel	25-35	Emulsion	28-33	28-33	28-33	28-33
M	12-13	Ferritic / Martensitic Stainless steel		Neat oil	13-23	13-23		13-23
	14	Austenitic Stainless steel		Neat oil	10-14	10-14		10-14
K	15-16	Grey Cast iron		Neat oil or Emulsion	28-33	28-33	28-33	
	17-20	Nodular & Malleable Cast iron		Neat oil or Emulsion	28-33	28-33	28-33	
N	21-25	Aluminium (HSM)		Emulsion	30-46	30-46	30-46	28-46
	26-28	Copper & Copper alloys		Emulsion	25-50	25-50		25-50

► Lighter text denotes secondary application

All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up.

The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.