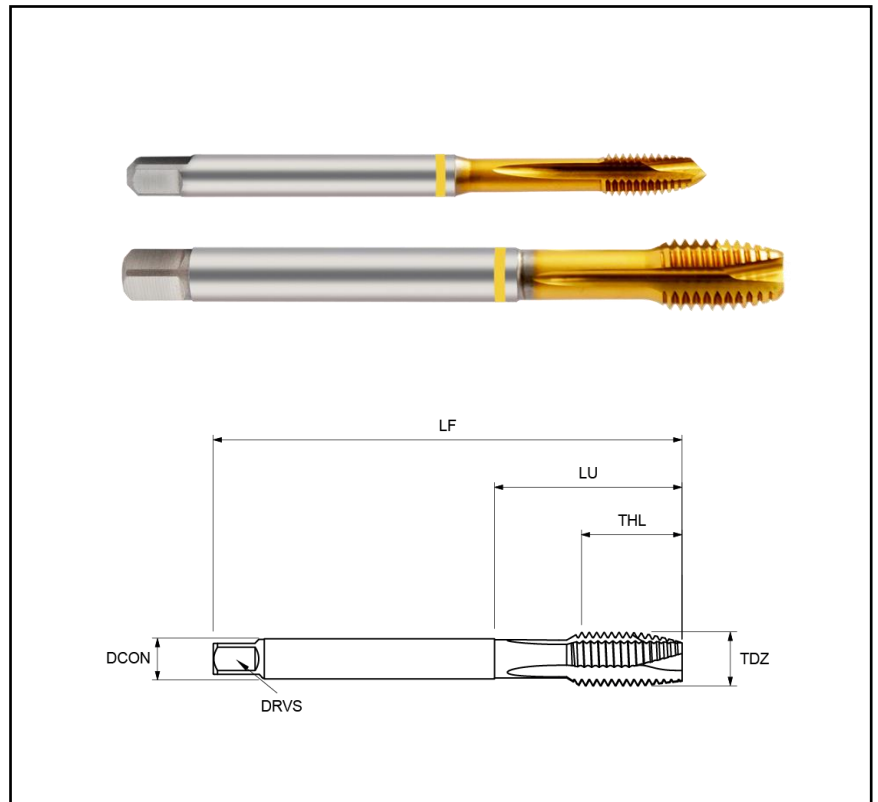


## Features

- **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

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

## Approvals

|                                     |         |
|-------------------------------------|---------|
| <b>Declarations</b>                 | N/A     |
| <b>Hazardous Area Certification</b> | N/A     |
| <b>Standards Met</b>                | DIN 371 |

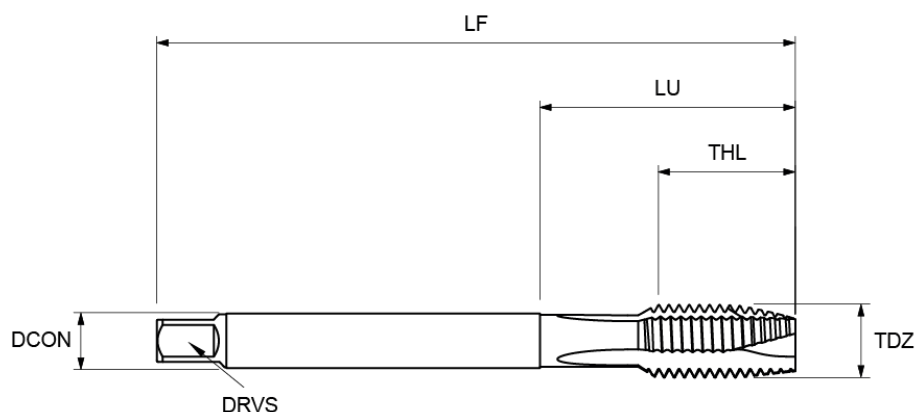
# Threading Taps



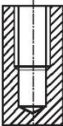
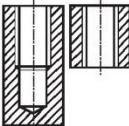
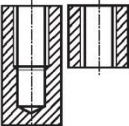
| Stock No.          | Brand     | Size TDZ | Pitch TP | Thread Length THL | O/ALL Length LF | Neck Length LU | DCON | DRVS | No. Of Flutes NOF | Tapping Drill PHD |
|--------------------|-----------|----------|----------|-------------------|-----------------|----------------|------|------|-------------------|-------------------|
| XXX-XXXX<br>900390 | RS<br>PRO | M3       | 0.5      | 5                 | 56              | 18             | 3.5  | 2.7  | 3                 | 2.5               |
| XXX-XXXX<br>900392 | RS<br>PRO | M4       | 0.7      | 7                 | 63              | 21             | 4.5  | 3.4  | 3                 | 3.3               |
| XXX-XXXX<br>900391 | RS<br>PRO | M5       | 0.8      | 8                 | 70              | 25             | 6.0  | 4.9  | 3                 | 4.2               |
| XXX-XXXX<br>900393 | RS<br>PRO | M6       | 1.0      | 10                | 80              | 30             | 6.0  | 4.9  | 3                 | 5.0               |
| XXX-XXXX<br>900394 | RS<br>PRO | M8       | 1.25     | 13                | 90              | 35             | 8.0  | 6.2  | 3                 | 6.8               |
| XXX-XXXX<br>900283 | RS<br>PRO | M10      | 1.5      | 15                | 100             | 39             | 10.0 | 8.0  | 3                 | 8.5               |
| XXX-XXXX<br>900284 | RS<br>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<br>900287 | RS<br>PRO | M3       | 0.5      | 5                 | 56              | 18             | 3.5  | 2.7  | 2.8               |
| XXX-XXXX<br>900285 | RS<br>PRO | M4       | 0.7      | 7                 | 63              | 21             | 4.5  | 3.4  | 3.7               |
| XXX-XXXX<br>900286 | RS<br>PRO | M5       | 0.8      | 8                 | 70              | 25             | 6.0  | 4.9  | 4.7               |
| XXX-XXXX<br>900288 | RS<br>PRO | M6       | 1.0      | 10                | 80              | 30             | 6.0  | 4.9  | 5.6               |
| XXX-XXXX<br>900289 | RS<br>PRO | M8       | 1.25     | 13                | 90              | 35             | 8.0  | 6.2  | 7.4               |
| XXX-XXXX<br>900287 | RS<br>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         | vc (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.