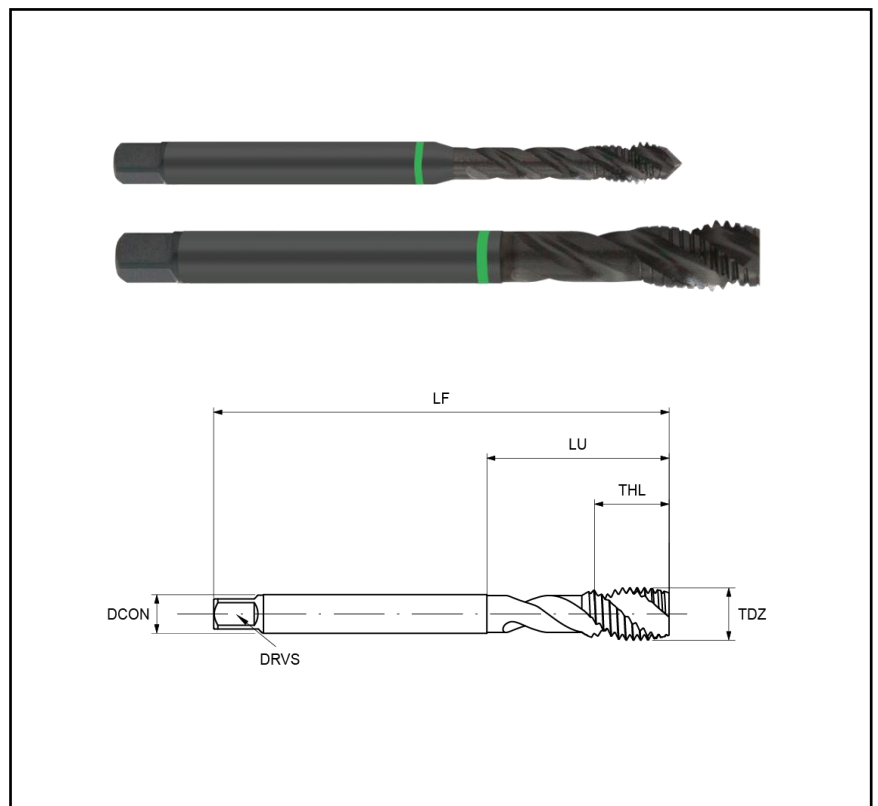


Features

- HSS-E PM construction manufactured from powder-metallurgy cobalt high-speed steel, providing high wear resistance, excellent toughness, and consistent performance in demanding tapping applications.
- Spiral flute geometry designed to efficiently evacuate chips upwards, making it ideal for blind-hole tapping while reducing the risk of chip jamming and improving thread finish.
- VAP surface treatment: Advanced surface treatment reduces friction and heat build-up during cutting, enhancing tool life and enabling smoother, more reliable threading operations.

RS PRO Metric PM Tap, Spiral Flute



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 RS Pro Metric PM Spiral Flute Tap range is designed for accurate and reliable internal threading in blind holes. Manufactured from HSS-E PM (powder-metallurgy high speed steel with cobalt) with a VAP surface treatment, these taps provide excellent wear resistance, reduced friction, and long tool life. The 3 flute spiral design ensures efficient chip evacuation and improved thread quality, while the range of sizes from M3 to M12 offers versatility for general engineering and machining applications, including use in steels and stainless steels.

General Specifications

Brand	RS PRO
Product Type	Threading Tap
Thread Size	M3 – M12
Thread Pitch	0.5mm – 1.75mm
Thread Length	6mm – 18mm
Number of Pieces	1
Overall Length	56mm – 110mm
Hand/Machine Tap	Machine Tap
Shank Diameter	3.5mm – 10mm
Substrate	HSS-E-PM

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

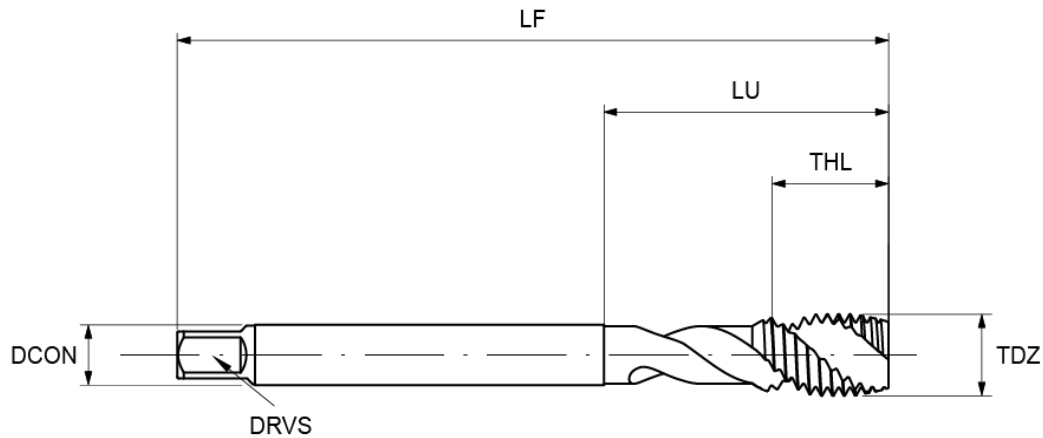
Approvals

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

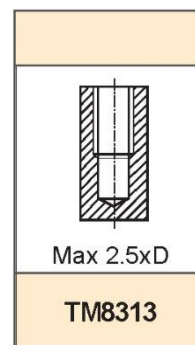
Threading Taps



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 900385	RS PRO	M3	0.5	6	56	18	3.5	2.7	3	2.5
XXX-XXXX 900383	RS PRO	M4	0.7	7	63	21	4.5	3.4	3	3.3
XXX-XXXX 900384	RS PRO	M5	0.8	8	70	25	6.0	4.9	3	4.2
XXX-XXXX 900387	RS PRO	M6	1.0	10	80	30	6.0	4.9	3	5.0
XXX-XXXX 900388	RS PRO	M8	1.25	13	90	35	8.0	6.2	3	6.8
XXX-XXXX 900386	RS PRO	M10	1.5	15	100	39	10.0	8.0	3	8.5



Cutting Data



VDI MATERIAL GROUP			HRc	COOLANT TYPE	
P	1-5	Non-alloy Steel	<25	Emulsion	15-20
	6-9	Low alloy Steel	25-35	Emulsion	10-15
M	12-13	Ferritic / Martensitic Stainless steel		Neat oil	5-10
	14	Austenitic Stainless steel		Neat oil	4-6
N	26-28	Copper & Copper alloys		Emulsion	15-20

► 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.