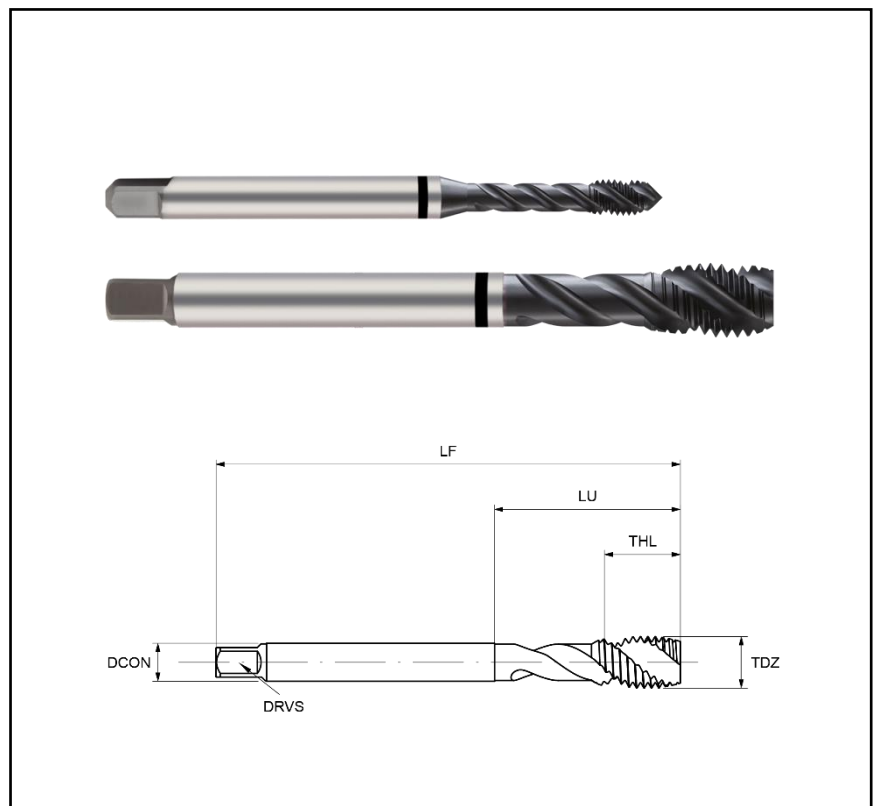


Features

- HSS-E PM construction with 6HX tolerance: Powder-metallurgy high-speed steel delivers a strong, wear-resistant cutting edge with excellent toughness, ensuring precise and consistent threading performance.
- AlCrN / AlCr-based coating: Advanced coating technology provides outstanding heat and wear resistance, enabling higher cutting speeds and extended tool life, even in difficult-to-machine materials.
- Engineered to efficiently evacuate chips upward from blind holes, reducing chip packing, minimising edge chipping, and producing a smooth, high-quality thread finish.

RS PRO Metric 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 Spiral Flute Tap is designed for precise and reliable threading in blind hole applications. Manufactured from HSS-E PM for excellent toughness and wear resistance, it features an advanced AlCrN/AlCr-based coating to improve heat resistance and extend tool life. The 3 flute spiral geometry efficiently evacuated chips from the hole, reducing risk of chip packing and end ensuring a smooth, high-quality thread finish.

General Specifications

Brand	RS PRO
Product Type	Threading Tap
Thread Size	M3 – M12
Thread Pitch	0.5mm – 1.75mm
Thread Length	4mm – 18mm
Number of Pieces	1
Overall Length	56mm – 110mm
Hand/Machine Tap	Machine Tap
Shank Diameter	3.5mm – 9mm
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 & DIN 376 for M12

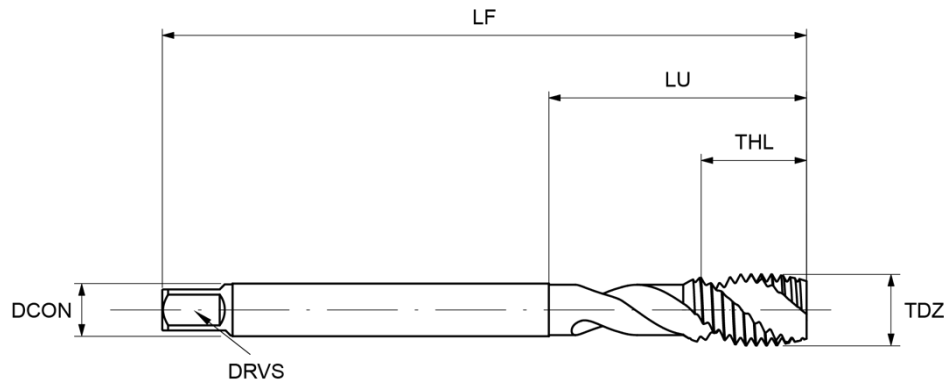
Threading Taps



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 900290	RS PRO	M3	0.5	4.0	56	18	3.5	2.7	3	2.5
XXX-XXXX 900291	RS PRO	M4	0.7	5.6	63	21	4.5	3.4	3	3.3
XXX-XXXX 900292	RS PRO	M5	0.8	6.4	70	25	6.0	4.9	3	4.2
XXX-XXXX 900293	RS PRO	M6	1.0	8.0	80	30	6.0	4.9	3	5.0
XXX-XXXX 900296	RS PRO	M8	1.25	13.0	90	35	8.0	6.2	3	6.8
XXX-XXXX 900294	RS PRO	M12	1.75	18.0	110	44	9.0	7.0	3	10.3

Similar Products

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 900297	RS PRO	M3	0.5	11.0	56	18	3.5	2.7	3	2.5
XXX-XXXX 900298	RS PRO	M4	0.7	13.0	63	21	4.5	3.4	3	3.3
XXX-XXXX 900425	RS PRO	M5	0.8	15.0	70	25	6.0	4.9	3	4.2
XXX-XXXX 900423	RS PRO	M6	1.0	17.0	80	30	6.0	4.9	3	5.0
XXX-XXXX 900424	RS PRO	M8	1.25	20.0	90	35	8.0	6.2	3	6.8
XXX-XXXX 900426	RS PRO	M10	1.5	22.0	100	39	10.0	8.0	3	8.5
XXX-XXXX 900427	RS PRO	M12	1.75	24.0	110	44	9.0	7.0	3	10.3



Cutting Data

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.

• Primary Application ◦ Secondary Application
vc (m/min)

APPLICATION TYPE	UV
TREATMENT/COATING	AlCr Base
SPIRAL FLUTE ANGLE	45°
CHAMFER LEAD TO DIN 2197	C
HOLE TYPE	 Max 2.5xD
TAP STYLE	

VDI MATERIAL GROUP		HRc	COOLANT TYPE	• Primary A
P	1-5 Non-alloy Steel	<25	Emulsion	• 10-40
	6-9 Low alloy Steel	25-35	Emulsion	• 8-30
	10-11 High alloy Steel, Tool Steel	35-45	Neat oil or Emulsion	◦ 8-30
M	12-13 Ferritic / Martensitic Stainless steel		Neat oil	• 5-15
	14 Austenitic Stainless steel		Neat oil	• 5-15
K	15-16 Grey Cast iron		Neat oil or Emulsion	◦ 15-30
	17-20 Nodular & Malleable Cast iron		Neat oil or Emulsion	• 15-30
N	21-25 Aluminium (HSM)		Emulsion	• 15-35
	Aluminium			
	26-28 Copper & Copper alloys		Emulsion	• 15-35
	29.1 Thermosetting Plastics, Acrylics		Dry or emulsion	
	29.2 CFRP/GFRP	-		
S	30 Synthetic Graphite	-		
	31-35 HRSA Fe & Ni/Co Based		Neat oil	
	36-37 Titanium & Titanium alloys		Neat oil	
H	38 Hardened Steel	40-55	Neat oil	
	39 Hardened Steel	55-60	Neat oil	
	40-41 Chilled & Hardened Cast Iron	42-55	Neat oil	