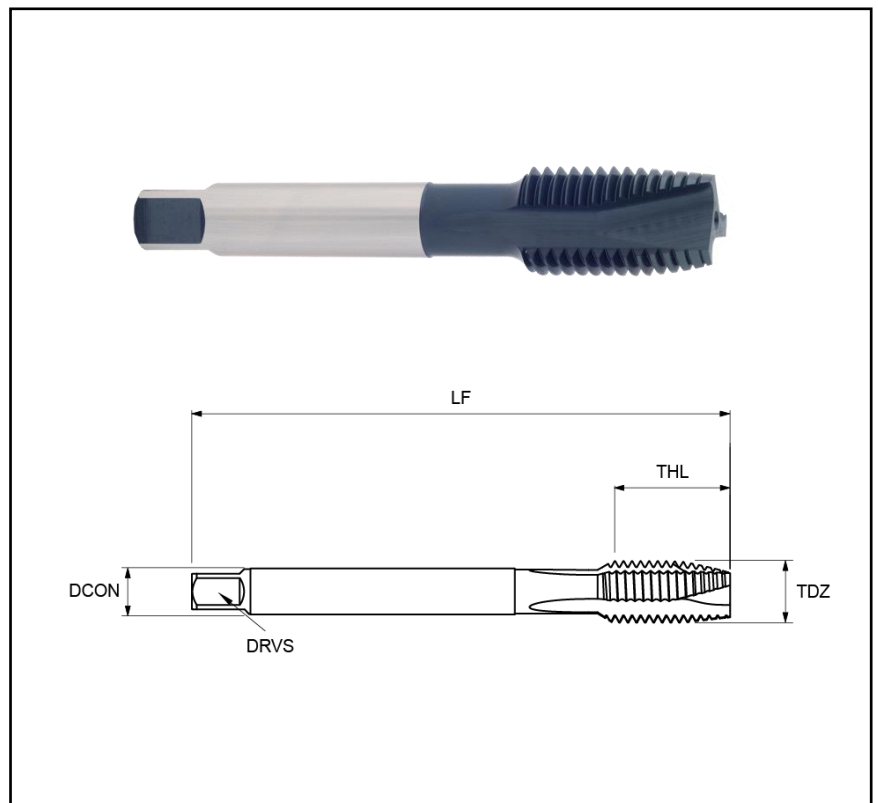


Features

- **Spiral Point Design**
Pushes chips forward for efficient chip evacuation, making it ideal for through-hole tapping and high-speed production.
- **High-Speed Steel (HSS) Construction**
Delivers excellent toughness and wear resistance for consistent performance in a wide range of materials.
- **VAP Surface Treatment**
Reduces friction and improves lubrication, resulting in smoother cutting, longer tool life, and improved thread quality.

RS Pro Metric Blue Tap



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

RS Pro Metric Blue Spiral Point Tap is a high performance threading solution engineered for efficient and accurate metric thread production. Manufactured from premium high-speed steel and conforming to ISO 529 standards, it delivers excellent strength, durability, and dimensional accuracy. The spiral point design effectively pushes chips forward, making it ideal for through hole applications and high speed machining. Enhanced with a VAP surface treatment, the Blue Wizard tap reduces friction and improves lubrication, resulting in smoother cutting action, extended tool life, and consistently high quality threads across a wide range of materials.

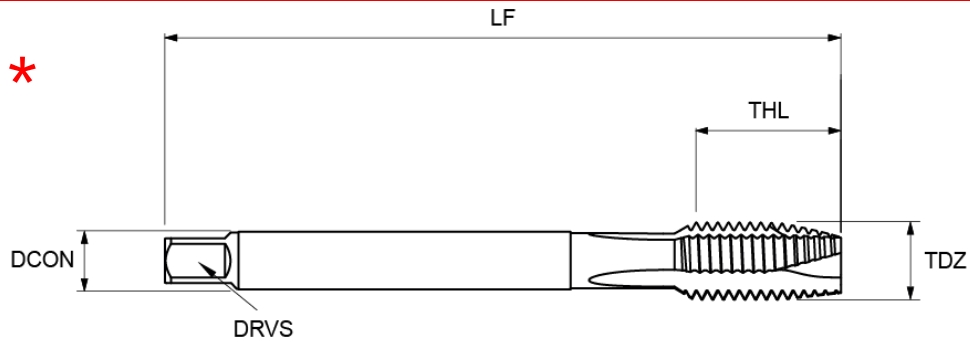
General Specifications

Cutter Diameter	TDZ – See table below and detailed image below*
Cut Length	LU - See table below and detailed image below*
Number of Flutes	2-3
Material	HSS (High Speed Steel)
Overall Length	LF - See table below and detailed image below*
Shank Type	Plain
Shank Diameter	DCON – See table below and detailed image below*
Centre Cutting	-

Stock No.	Brand	Size TDZ	Pitch TP	Thread Length THL	O/ALL Length LF	DCON	DRVS	No. Of Flutes NOF	Tapping Drill PHD
XXX-XXXX 900449	RS PRO	M2	0.4	9.5	41	2.5	2.0	2	1.6
XXX-XXXX 900277	RS PRO	M5	0.8	16.0	58	5.0	4.0	3	4.2
XXX-XXXX 900278	RS PRO	M6	1.0	19.0	66	6.3	5.0	3	5.0
XXX-XXXX 900279	RS PRO	M8	1.25	22.0	72	8.0	6.3	3	6.8
XXX-XXXX 900280	RS PRO	M10	1.5	24.0	80	10.0	8.0	3	8.5
XXX-XXXX 900281	RS PRO	M12	1.75	29.0	89	9.0	7.1	3	10.2
XXX-XXXX 900282	RS PRO	M16	2.0	32.0	102	12.5	10.0	3	14.0

Approvals

Declarations	n/a
Hazardous Area Certification	n/a
Standards Met	ISO 529



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)

TAP TYPE			BLUE WIZARD
DIN 371/376	M	Series No. (TSYC)	
ISO 529	M		F013
ISO 529	MF		F023 - F033
APPLICATION TYPE			GP
TREATMENT/COATING			VAP
SPIRAL FLUTE ANGLE			
CHAMFER LEAD TO DIN 2197			B
HOLE TYPE			 Max 3.0xD
TAP STYLE			

VDI MATERIAL GROUP		HRc	COOLANT TYPE	
P	1-5 Non-alloy Steel	<25	Emulsion	● 10-15
	6-9 Low alloy Steel	25-35	Emulsion	
	10-11 High alloy Steel, Tool Steel	35-45	Neat oil or Emulsion	
M	12-13 Ferritic / Martensitic Stainless steel		Neat oil	
	14 Austenitic Stainless steel		Neat oil	
K	15-16 Grey Cast iron		Neat oil or Emulsion	● 8-10
	17-20 Nodular & Malleable Cast Iron		Neat oil or Emulsion	
N	21-25 Aluminium (HSM)		Emulsion	○ 10-20
	Aluminium			
	26-28 Copper & Copper alloys		Emulsion	
	29.1 Thermosetting Plastics, Acrylics		Dry or emulsion	
	29.2 CFRP/GFRP		-	
	30 Synthetic Graphite		-	
S	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	