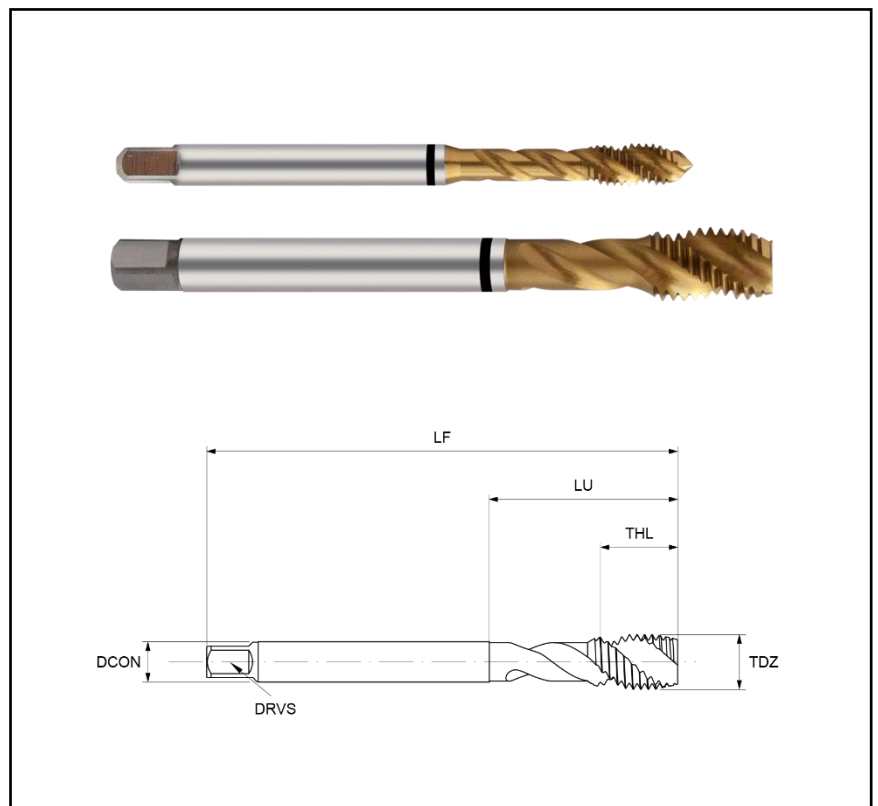


Features

- Made from HSS-E (High-Speed Steel, Enhanced) for enhanced hardness, wear resistance, and durability.
- Tin-coated surface: Reduces friction, improves chip evacuation, prevents wear, and extends tool life for consistent, high-quality threading.
- Spiral flute design for efficient chip evacuation; conforms to DIN 371 standard with FHA 40° thread profile for reliable and accurate threading.

RS PRO Metric Gold 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

Metric Gold in Spiral Flute is designed for versatile threading applications, this high-performance tap is made from HSS-E for superior hardness and durability. Its TiN coated spiral flutes reduce friction, improve chip evacuation, and extended tool life. Compliant with DIN 371 it delivers accurate, clean threads, suitable for Steel, Stainless Steel, Cast Iron and Non-Ferrous metals.

General Specifications

Brand	RS PRO
Product Type	Threading Tap
Thread Size	M2 – M12
Thread Pitch	0.4mm – 1.75mm
Thread Length	8mm – 18mm
Number of Pieces	1
Overall Length	45mm – 110mm
Hand/Machine Tap	Machine Tap
Shank Diameter	2.8mm – 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

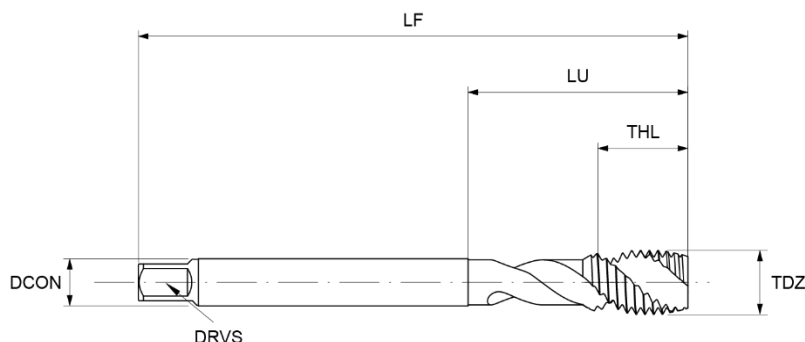
Approvals

Declarations	N/A
Hazardous Area Certification	N/A
Standards Met	DIN 371 & 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 900364	RS PRO	M2	0.4	8	45	13	2.8	2.1	3	1.6
XXX-XXXX 900363	RS PRO	M3	0.5	6	56	18	3.5	2.7	3	2.5
XXX-XXXX 900366	RS PRO	M4	0.7	7	63	21	4.5	3.4	3	3.3
XXX-XXXX 900365	RS PRO	M5	0.8	8	70	25	6.0	4.9	3	4.2
XXX-XXXX 900367	RS PRO	M6	1.0	10	80	30	6.0	4.9	3	5.0
XXX-XXXX 900368	RS PRO	M8	1.25	13	90	35	8.0	6.2	3	6.8
XXX-XXXX 900370	RS PRO	M10	1.5	15	100	39	10.0	8.0	3	8.5
XXX-XXXX 900369	RS PRO	M12	1.75	18	110	44	9.0	7.0	3	10.2



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.

TAP TYPE		
DIN 371/376	M	Series No. (TSYC)
DIN 374	MF	
DIN 371/376	UNC	
DIN 371/374	UNF	
APPLICATION TYPE		
UV		
TREATMENT/COATING		
TIN		
SPIRAL FLUTE ANGLE		
40°		
CHAMFER LEAD TO DIN 2197		
C		
HOLE TYPE		
		Max 2.5xD
TAP STYLE		

● Primary Application ○ Secondary Application
vc (m/min)

VDI MATERIAL GROUP	HRc	COOLANT TYPE	
P	1-5 Non-alloy Steel	<25 Emulsion	● 10-25
	6-9 Low alloy Steel	25-35 Emulsion	● 5-20
	10-11 High alloy Steel, Tool Steel	35-45 Neat oil or Emulsion	● 5-7
M	12-13 Ferritic / Martensitic Stainless steel	Neat oil	○ 8-15
	14 Austenitic Stainless steel	Neat oil	○ 6-8
K	15-16 Grey Cast iron	Neat oil or Emulsion	● 8-20
	17-20 Nodular & Malleable Cast iron	Neat oil or Emulsion	● 8-20
N	21-25 Aluminium (HSM)	Emulsion	● 20-25
	Aluminium		
	26-28 Copper & Copper alloys	Emulsion	● 20-40
	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	○ 12-15
	36-37 Titanium & Titanium alloys	Neat oil	○ 12-15
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	