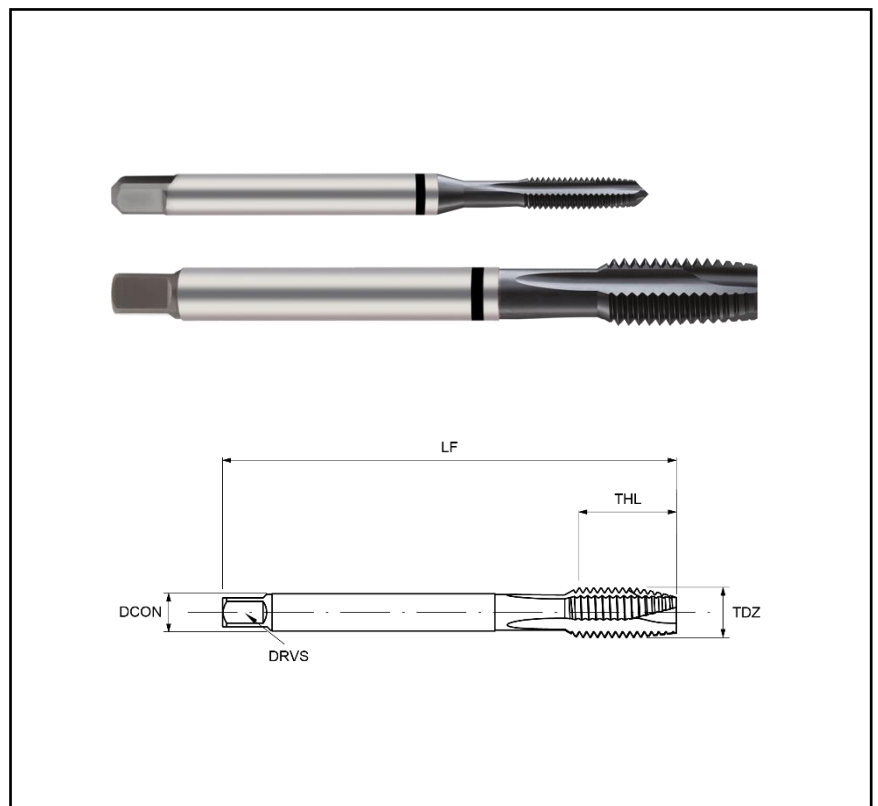


Features

- HSS-E PM construction with 6HX tolerance: High-quality powder-metallurgy high-speed steel provides a stronger cutting edge and excellent toughness, ensuring precise and reliable threading in demanding applications.
- AlCrN / AlCr-based coating for advanced coating offers superior heat and wear resistance, allowing high-speed tapping and extended tool life, even in tough or hard to machine materials.
- Optimised flute and point design, carefully engineered geometry reduces bird nesting and chipping, improves thread finish, and ensures efficient chip evacuation for smoother, high quality threads.

RS PRO Metric 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 Tap is engineered for high performance, precision threading in a wide range of materials. Manufactured from HSS-E PM (powder-metallurgy high speed steel) with a 6HX tolerance, it provides a strong, durable cutting edge for consistent and reliable results. The AlCrN / AlCr base coating delivers excellent heat and wear resistance, enabling high speed tapping and extended tool life. Its optimised flute and point design minimises bird nesting and chipping, improves thread finishes and ensures smooth chip evacuation, making it the first choice for demanding machining and in production environments.

General Specifications

Brand	RS PRO
Product Type	Threading Tap
Thread Size	M3 – M12
Thread Pitch	0.5mm – 1.75mm
Thread Length	11mm – 24mm
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 & DIN 376 for M12

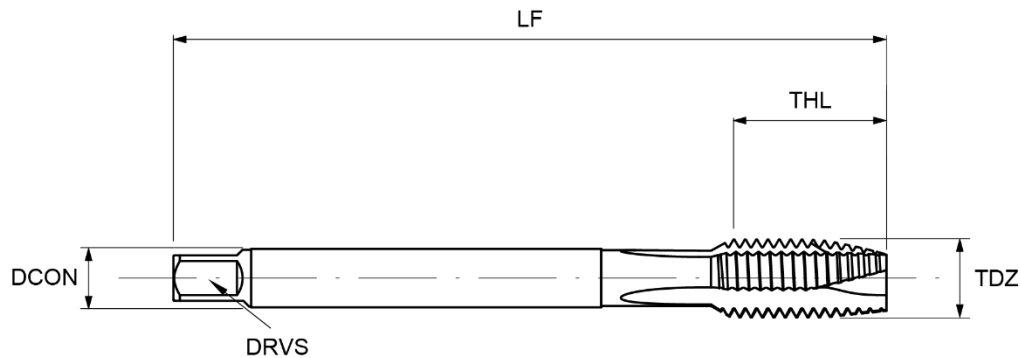
Threading Taps



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 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

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 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



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)	TM9515
DIN 374	MF		TM9516
DIN 371/376	UNC		TM9517
DIN 371/374	UNF		TM9518
APPLICATION TYPE			UV
TREATMENT/COATING			AlCr Base
SPIRAL FLUTE ANGLE			
CHAMFER LEAD TO DIN 2197			B
HOLE TYPE			 Max 3.0xD
TAP STYLE			

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

VDI MATERIAL GROUP		HRc	COOLANT TYPE	
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	-	
	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