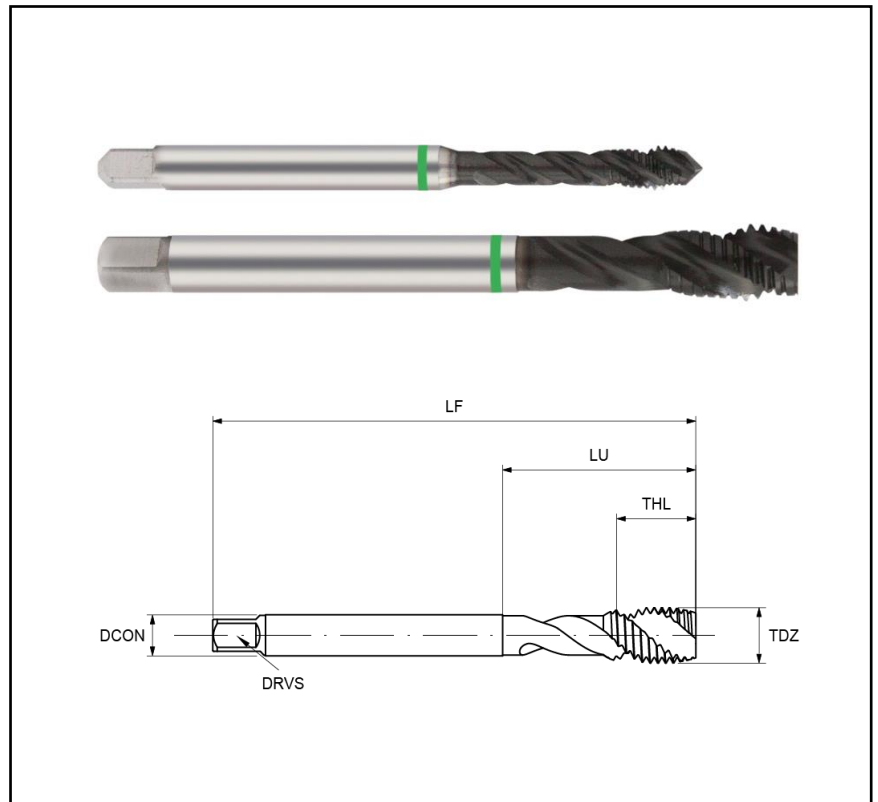


Features

- HSS-E construction with recessed threads: High-speed steel with cobalt for strength and heat resistance, with recessed thread geometry ideal for tapping deep holes and improving chip control.
- Spiral flute design, efficiently evacuates chips out of the hole, reducing jamming and improving performance in blind-hole and deep tapping applications.
- Hardslick coating for advanced surface treatment that reduces friction and wear, providing increased tool life and better performance in stainless steel and other tough materials.

RS PRO Metric Green Ring 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 Green Ring Spiral Flute Tap is designed for high-performance threading in steel, stainless steel and heat-resistance alloys. Manufactured from HSS-E for excellent strength and heat resistance, it features recessed threads that make it particularly suitable for deep-hole tapping. The spiral flute geometry ensures efficient chip evacuation, reducing the risk of chip jamming and improving thread quality. Finished with a Hard slick coating, the tap delivers reduced friction, improved wear resistance, and extended tool life in demanding machining applications.

General Specifications

Brand	RS PRO
Product Type	Threading Tap
Thread Size	M3 – M10
Thread Pitch	0.5mm – 1.5mm
Thread Length	6mm – 15mm
Number of Pieces	1
Overall Length	56mm – 100mm
Hand/Machine Tap	Machine Tap
Shank Diameter	3.5mm – 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

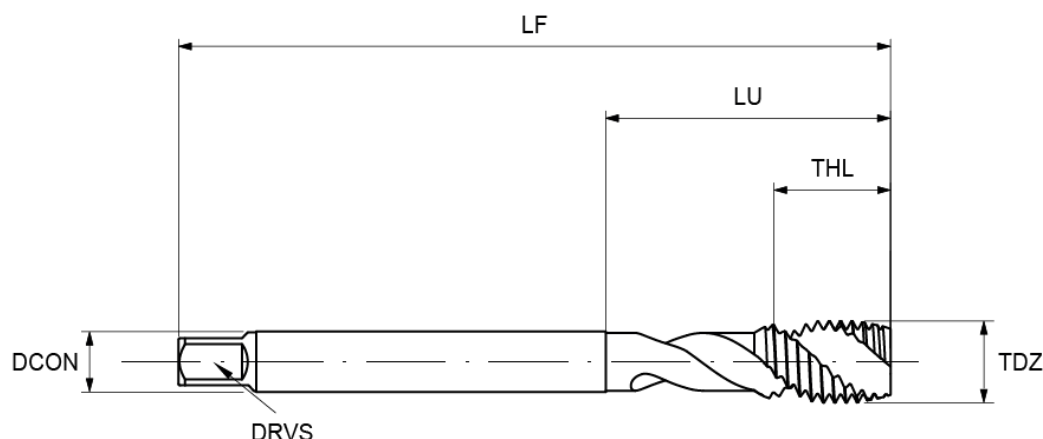
Threading Taps



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 900378	RS PRO	M4	0.7	7	63	21	4.5	3.4	3	3.3
XXX-XXXX 900380	RS PRO	M5	0.8	8	70	25	6.0	4.9	3	4.2
XXX-XXXX 900381	RS PRO	M6	1.0	10	80	30	6.0	4.9	3	5.0
XXX-XXXX 900379	RS PRO	M8	1.25	13	90	35	8.0	6.2	3	6.8
XXX-XXXX 900382	RS PRO	M10	1.5	15	100	39	10.0	8.0	3	8.5

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 900252	RS PRO	M3	0.5	11	56	18	3.5	2.7	3	2.5
XXX-XXXX 900253	RS PRO	M4	0.7	13	63	21	4.5	3.4	3	3.3
XXX-XXXX 900254	RS PRO	M5	0.8	15	70	25	6.0	4.9	3	4.2
XXX-XXXX 900256	RS PRO	M6	1.0	17	80	30	6.0	4.9	3	5.0
XXX-XXXX 900257	RS PRO	M8	1.25	20	90	35	8.0	6.2	3	6.8



Cutting Data

					HOLE TYPE
					Max 2.5xD
					TM8153
VDI MATERIAL GROUP		HRc	COOLANT TYPE	vc (m/min)	
P	1-5	Non-alloy Steel	<25	Emulsion	15-25
	6-9	Low alloy Steel	25-35	Emulsion	15-20
M	12-13	Ferritic / Martensitic Stainless steel		Neat oil	8-13
	14	Austenitic Stainless steel		Neat oil	6-8
S	31-35	HRSA Fe & Ni/Co Based		Neat oil	10-15
	36-37	Titanium & Titanium alloys		Neat oil	10-15

► 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.