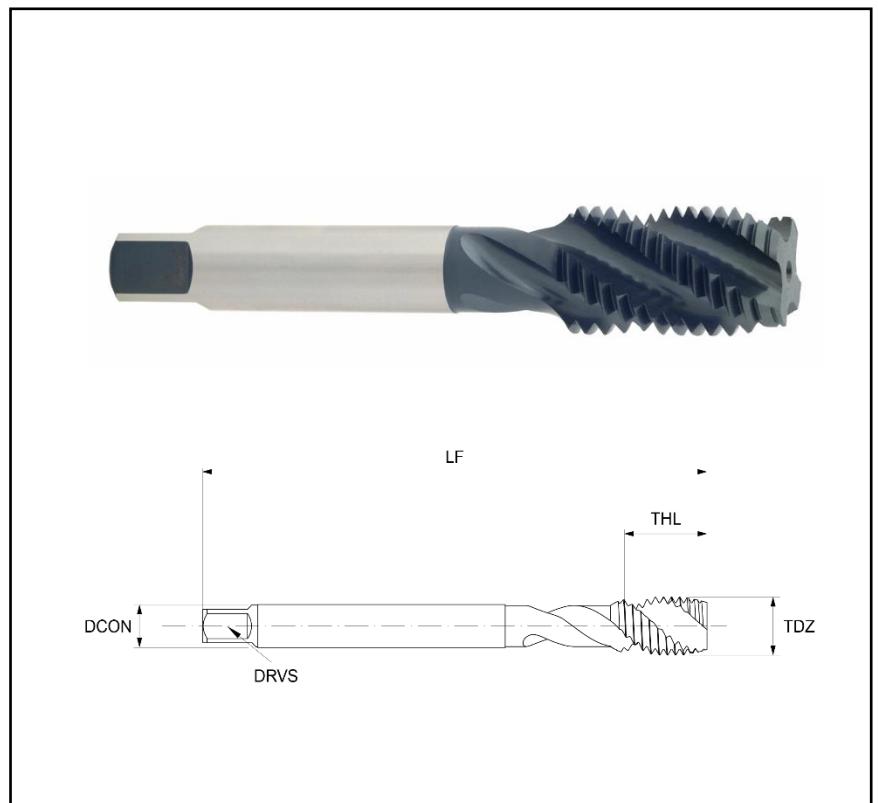


Features

- High-Speed Steel (HSS) Construction
Provides excellent toughness and wear resistance for reliable tapping in a wide range of materials.
- VAP Surface Treatment
Improves lubrication and reduces friction, resulting in smoother cutting, longer tool life, and better thread quality.
- The multi-flute geometry ensures efficient chip evacuation and stable cutting performance, reducing the risk of tap breakage and improving productivity.

RS Pro Metric Blue 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

RS Pro Metric Blue tap is a high performance threading tool designed for accurate and reliable metric thread cutting. Manufactured from premium high-speed steel, it offers excellent strength, wear resistance, and durability for consistent performance in production. The advanced VAP surface treatment reduces friction and improves lubrication, resulting in smoother cutting action, extended tool life, and high quality threads. Conforming to ISO 529 standards, the Blue Merlin tap delivers precise thread geometry and dependable results across a wide range of metric sizes and applications.

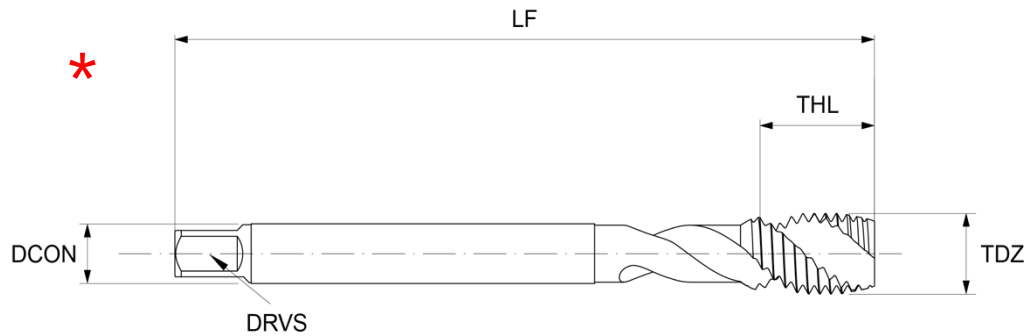
General Specifications

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 900450	RS PRO	M3	0.5	15.0	48	3.15	2.5	2	2.5
XXX-XXXX 900451	RS PRO	M4	0.7	17.0	53	4.0	3.15	2	3.3
XXX-XXXX 900452	RS PRO	M5	0.8	16.0	58	5.0	4.0	3	4.2
XXX-XXXX 900453	RS PRO	M6	1.0	19.0	66	6.3	5.0	3	5.0
XXX-XXXX 900454	RS PRO	M8	1.25	22.0	72	8.0	6.3	3	6.8
XXX-XXXX 900455	RS PRO	M10	1.5	24.0	80	10.0	8.0	3	8.5
XXX-XXXX 900456	RS PRO	M12	1.75	29.0	89	9.0	7.1	3	10.2
XXX-XXXX 900458	RS PRO	M16	2.0	32.0	102	12.5	10.0	3	14.0
XXX-XXXX 900457	RS PRO	M20	2.5	37.0	112	14.0	11.2	3	17.5

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 MERLIN
DIN 371/376	M	Series No. (TSYC)	
ISO 529	M		F015
ISO 529	MF		F025 - F035
APPLICATION TYPE			GP
TREATMENT/COATING			VAP
SPIRAL FLUTE ANGLE			40°
CHAMFER LEAD TO DIN 2197			C
HOLE TYPE			 Max 2.5xD
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