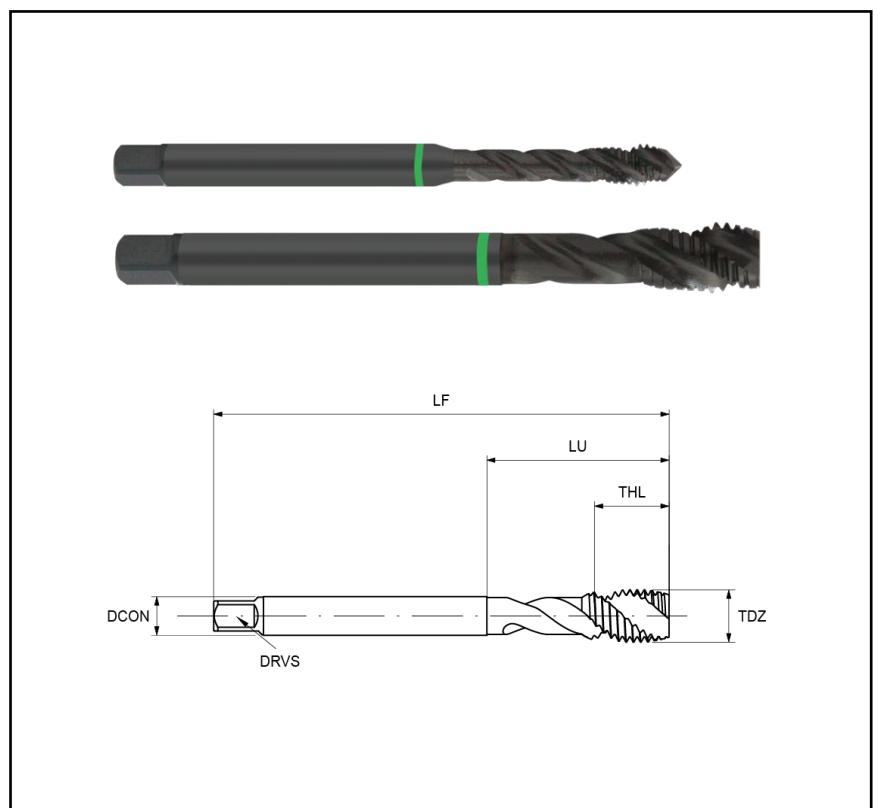


## Features

- HSS-E PM construction manufactured from powder-metallurgy cobalt high-speed steel, providing high wear resistance, excellent toughness, and consistent performance in demanding tapping applications.
- Spiral flute geometry designed to efficiently evacuate chips upwards, making it ideal for blind-hole tapping while reducing the risk of chip jamming and improving thread finish.
- VAP surface treatment: Advanced surface treatment reduces friction and heat build-up during cutting, enhancing tool life and enabling smoother, more reliable threading operations.

## RS PRO Metric PM 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 PM Spiral Flute Tap range is designed for accurate and reliable internal threading in blind holes. Manufactured from HSS-E PM (powder-metallurgy high speed steel with cobalt) with a VAP surface treatment, these taps provide excellent wear resistance, reduced friction, and long tool life. The 3 flute spiral design ensures efficient chip evacuation and improved thread quality, while the range of sizes from M3 to M12 offers versatility for general engineering and machining applications, including use in steels and stainless steels.*

## General Specifications

|                  |                |
|------------------|----------------|
| Brand            | RS PRO         |
| Product Type     | Threading Tap  |
| Thread Size      | M3 – M12       |
| Thread Pitch     | 0.5mm – 1.75mm |
| Thread Length    | 6mm – 18mm     |
| Number of Pieces | 1              |
| Overall Length   | 56mm – 110mm   |
| Hand/Machine Tap | Machine Tap    |
| Shank Diameter   | 3.5mm – 10mm   |
| Substrate        | HSS-E-PM       |

## Mechanical Specifications

|                             |                                                 |
|-----------------------------|-------------------------------------------------|
| <b>Thread Diameter Size</b> | TDZ – See table below and detailed image below  |
| <b>Thread Pitch</b>         | TP – See table below and detailed image below   |
| <b>Threading Length</b>     | THL – See table below and detailed image below  |
| <b>Overall Length</b>       | LF – See table below and detailed image below   |
| <b>Usable Length</b>        | LU – See table below and detailed image below   |
| <b>Connection Diameter</b>  | DCON – See table below and detailed image below |
| <b>Drive Square Size</b>    | DRVS – See table below and detailed image below |

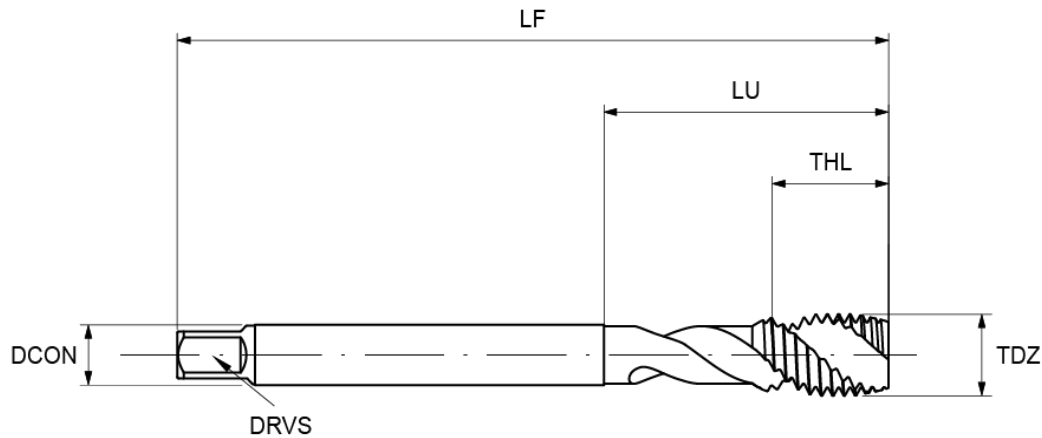
## Approvals

|                                     |         |
|-------------------------------------|---------|
| <b>Declarations</b>                 | N/A     |
| <b>Hazardous Area Certification</b> | N/A     |
| <b>Standards Met</b>                | DIN 371 |

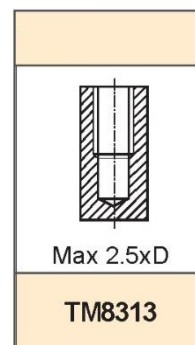
# Threading Taps



| 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<br>900385 | RS<br>PRO | M3       | 0.5      | 6                 | 56              | 18             | 3.5  | 2.7  | 3                 | 2.5               |
| XXX-XXXX<br>900383 | RS<br>PRO | M4       | 0.7      | 7                 | 63              | 21             | 4.5  | 3.4  | 3                 | 3.3               |
| XXX-XXXX<br>900384 | RS<br>PRO | M5       | 0.8      | 8                 | 70              | 25             | 6.0  | 4.9  | 3                 | 4.2               |
| XXX-XXXX<br>900387 | RS<br>PRO | M6       | 1.0      | 10                | 80              | 30             | 6.0  | 4.9  | 3                 | 5.0               |
| XXX-XXXX<br>900388 | RS<br>PRO | M8       | 1.25     | 13                | 90              | 35             | 8.0  | 6.2  | 3                 | 6.8               |
| XXX-XXXX<br>900386 | RS<br>PRO | M10      | 1.5      | 15                | 100             | 39             | 10.0 | 8.0  | 3                 | 8.5               |



## Cutting Data



| VDI MATERIAL GROUP |       |                                        | HRc   | COOLANT TYPE |             |
|--------------------|-------|----------------------------------------|-------|--------------|-------------|
| <b>P</b>           | 1-5   | Non-alloy Steel                        | <25   | Emulsion     | 15-20       |
|                    | 6-9   | Low alloy Steel                        | 25-35 | Emulsion     | 10-15       |
| <b>M</b>           | 12-13 | Ferritic / Martensitic Stainless steel |       | Neat oil     | <b>5-10</b> |
|                    | 14    | Austenitic Stainless steel             |       | Neat oil     | <b>4-6</b>  |
| <b>N</b>           | 26-28 | Copper & Copper alloys                 |       | Emulsion     | 15-20       |

► 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.