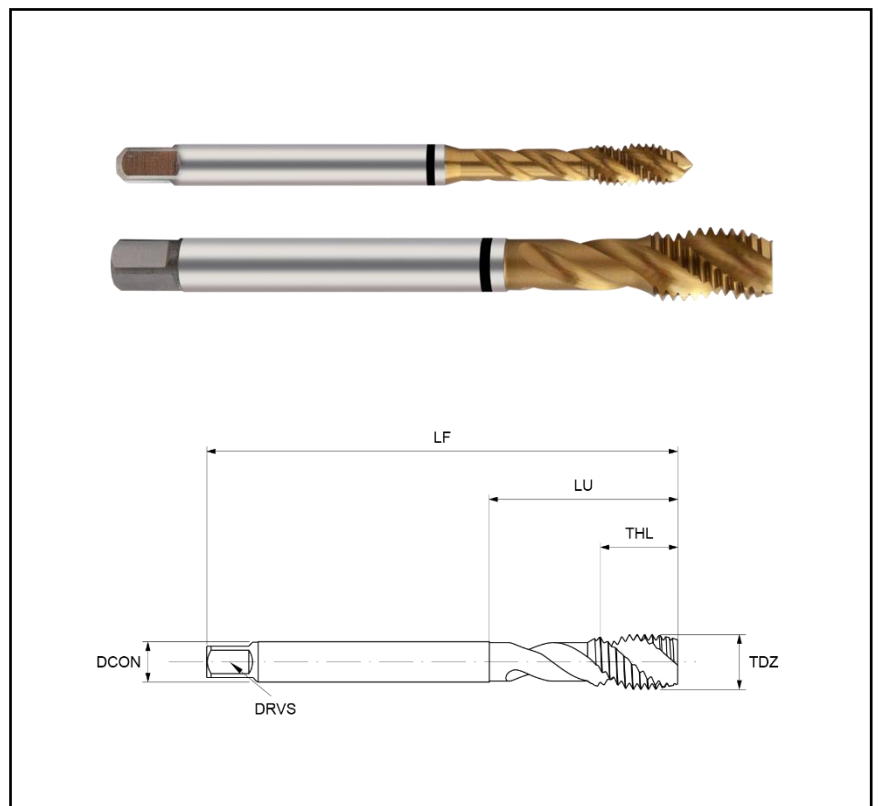


## Features

- 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 |

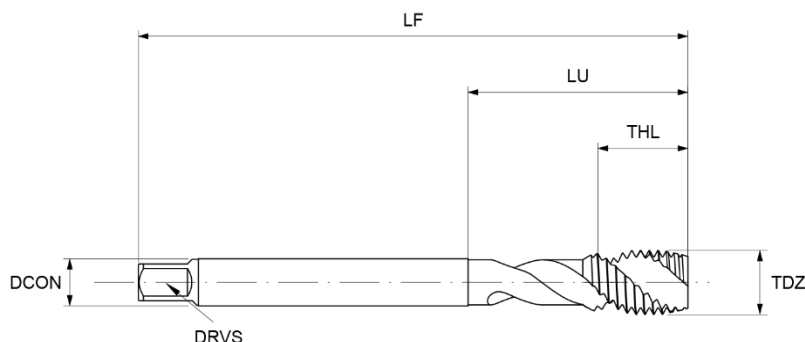
## Approvals

|                              |                           |
|------------------------------|---------------------------|
| 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<br>900364 | RS PRO | M2       | 0.4      | 8                 | 45              | 13             | 2.8  | 2.1  | 3                 | 1.6               |
| XXX-XXXX<br>900363 | RS PRO | M3       | 0.5      | 6                 | 56              | 18             | 3.5  | 2.7  | 3                 | 2.5               |
| XXX-XXXX<br>900366 | RS PRO | M4       | 0.7      | 7                 | 63              | 21             | 4.5  | 3.4  | 3                 | 3.3               |
| XXX-XXXX<br>900365 | RS PRO | M5       | 0.8      | 8                 | 70              | 25             | 6.0  | 4.9  | 3                 | 4.2               |
| XXX-XXXX<br>900367 | RS PRO | M6       | 1.0      | 10                | 80              | 30             | 6.0  | 4.9  | 3                 | 5.0               |
| XXX-XXXX<br>900368 | RS PRO | M8       | 1.25     | 13                | 90              | 35             | 8.0  | 6.2  | 3                 | 6.8               |
| XXX-XXXX<br>900370 | RS PRO | M10      | 1.5      | 15                | 100             | 39             | 10.0 | 8.0  | 3                 | 8.5               |
| XXX-XXXX<br>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<br>No.<br>(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               |         |
|--------------------|----------------------------------------------|----------------------------|---------|
| <b>P</b>           | 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   |
| <b>M</b>           | 12-13 Ferritic / Martensitic Stainless steel | Neat oil                   | ○ 8-15  |
|                    | 14 Austenitic Stainless steel                | Neat oil                   | ○ 6-8   |
| <b>K</b>           | 15-16 Grey Cast iron                         | Neat oil or Emulsion       | ● 8-20  |
|                    | 17-20 Nodular & Malleable Cast iron          | Neat oil or Emulsion       | ● 8-20  |
| <b>N</b>           | 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                        | -                          |         |
| <b>S</b>           | 31-35 HRSA Fe & Ni/Co Based                  | Neat oil                   | ○ 12-15 |
|                    | 36-37 Titanium & Titanium alloys             | Neat oil                   | ○ 12-15 |
| <b>H</b>           | 38 Hardened Steel                            | 40-55 Neat oil             |         |
|                    | 39 Hardened Steel                            | 55-60 Neat oil             |         |
|                    | 40-41 Chilled & Hardened Cast Iron           | 42-55 Neat oil             |         |