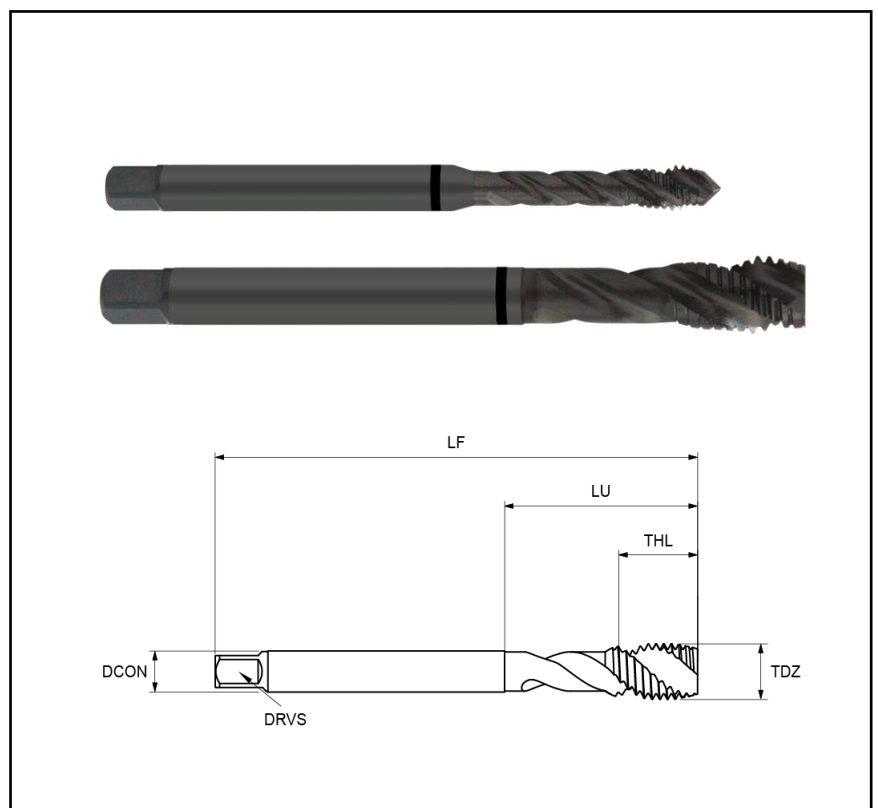


## Features

- High-performance HSS-E construction with VAP coating to deliver excellent wear resistance, heat tolerance, and long tool life when tapping a wide range of steels and difficult-to-machine materials.
- Patented universal cutting geometry ensures smooth cutting action, high thread accuracy, and versatility across multiple material groups, making it ideal for general-purpose and production use.
- Spiral flute design to DIN 371 with 40° helix (FHA) that efficiently evacuates chips from blind holes, reducing clogging and improving thread quality and process reliability.

## 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

*The RS Pro Metric Blue Spiral Flute Tap is a high performance threading solution designed for blind hole applications, manufactured from HSS-E with a VAP surface treatment for enhanced wear resistance and extended tool life. Featuring a 40° spiral flute geometry to DIN 371 standards efficient chip evacuation and consistent thread quality while the patented universal cutting geometry delivers smooth cutting action and reliable performance across a wide range of materials.*

## General Specifications

|                  |               |
|------------------|---------------|
| Brand            | RS PRO        |
| Product Type     | Threading Tap |
| Thread Size      | M2 – M10      |
| Thread Pitch     | 0.4mm – 1.5mm |
| Thread Length    | 8mm – 15mm    |
| Number of Pieces | 1             |
| Overall Length   | 45mm – 100mm  |
| 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 |

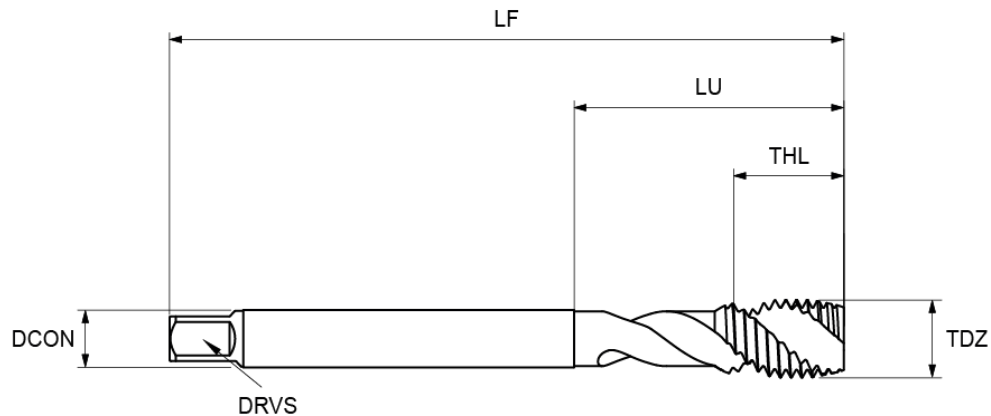
# Threading Taps



| 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>900371 | RS<br>PRO | M2       | 0.4      | 8                 | 45              | 13             | 2.8  | 2.1  | 3                 | 1.6               |
| XXX-XXXX<br>900240 | RS<br>PRO | M3       | 0.5      | 6                 | 56              | 18             | 3.5  | 2.7  | 3                 | 2.5               |
| XXX-XXXX<br>900238 | RS<br>PRO | M4       | 0.7      | 7                 | 63              | 21             | 4.5  | 3.4  | 3                 | 3.3               |
| XXX-XXXX<br>900239 | RS<br>PRO | M5       | 0.8      | 8                 | 70              | 25             | 6.0  | 4.9  | 3                 | 4.2               |
| XXX-XXXX<br>900242 | RS<br>PRO | M6       | 1.0      | 10                | 80              | 30             | 6.0  | 4.9  | 3                 | 5.0               |
| XXX-XXXX<br>900243 | RS<br>PRO | M8       | 1.25     | 13                | 90              | 35             | 8.0  | 6.2  | 3                 | 6.8               |
| XXX-XXXX<br>900241 | RS<br>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<br>900259 | RS PRO | M2       | 0.4      | 8                 | 45              | 13             | 2.8  | 2.1  | 3                 | 1.6               |
| XXX-XXXX<br>900260 | RS PRO | M3       | 0.5      | 11                | 56              | 18             | 3.5  | 2.7  | 3                 | 2.5               |
| XXX-XXXX<br>900263 | RS PRO | M4       | 0.7      | 13                | 63              | 21             | 4.5  | 3.4  | 3                 | 3.3               |
| XXX-XXXX<br>900261 | RS PRO | M5       | 0.8      | 15                | 70              | 25             | 6.0  | 4.9  | 3                 | 4.2               |
| XXX-XXXX<br>900262 | RS PRO | M6       | 1.0      | 17                | 80              | 30             | 6.0  | 4.9  | 3                 | 5.0               |
| XXX-XXXX<br>900265 | RS PRO | M8       | 1.25     | 20                | 90              | 35             | 8.0  | 6.2  | 3                 | 6.8               |
| XXX-XXXX<br>900266 | RS PRO | M10      | 1.5      | 22                | 100             | 39             | 10.0 | 8.0  | 3                 | 8.5               |
| XXX-XXXX<br>900264 | RS PRO | M12      | 1.75     | 24                | 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.

|                          |     |                   |        |
|--------------------------|-----|-------------------|--------|
| DIN 371/376              | M   |                   | TM8030 |
| DIN 374                  | MF  | Series No. (TSYC) |        |
| DIN 371/376              | UNC |                   |        |
| DIN 371/374              | UNF |                   |        |
| APPLICATION TYPE         |     |                   | UV     |
| TREATMENT/COATING        |     |                   | Vap    |
| 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             | ● 6-20  |
|                    | 6-9 Low alloy Steel                          | 25-35 | Emulsion             | ● 3-15  |
|                    | 10-11 High alloy Steel, Tool Steel           | 35-45 | Neat oil or Emulsion | ● 3-5   |
| <b>M</b>           | 12-13 Ferritic / Martensitic Stainless steel |       | Neat oil             | ○ 5-10  |
|                    | 14 Austenitic Stainless steel                |       | Neat oil             | ○ 4-6   |
| <b>K</b>           | 15-16 Grey Cast iron                         |       | Neat oil or Emulsion | ● 5-15  |
|                    | 17-20 Nodular & Malleable Cast iron          |       | Neat oil or Emulsion | ● 5-15  |
| <b>N</b>           | 21-25 Aluminium (HSM)                        |       | Emulsion             |         |
|                    | Aluminium                                    |       |                      | ○ 15-20 |
|                    | 26-28 Copper & Copper alloys                 |       | Emulsion             | ○ 15-35 |
|                    | 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             | ○ 8-10  |
|                    | 36-37 Titanium & Titanium alloys             |       | Neat oil             | ○ 8-10  |
| <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             |         |