Features

- Complete Tap & Drill Set: Includes HSS jobber drills matched to tapping sizes, ensuring accurate hole preparation and consistent thread quality.
- Patented Geometry: Features a unique patented tap geometry designed for optimum chip evacuation and enhanced thread production.
- Delivers excellent performance across all ISO material groups, making the set suitable for a wide range of materials and applications.

RS PRO Tap & Drill Set



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 Tap & Drill Set is designed for efficient and reliable thread creation across a wide range of applications. Each set includes RS PRO HSS Jobber Drills matched to correct tapping sizes, ensuring accurate hole preparation and consistent results. Featuring a unique patented tap geometry, the set provides optimum chip evacuation and enhanced thread quality. Available in both spiral point (for through holes) and Spiral Flute (for blind holes) configurations, it delivers excellent performance across all ISO material groups, making it a versatile solution for professional and industrial use.

General Specifications

Brand	RS PRO
Material	High Speed Steel (HSS)
Drill Bit Size	Drills: 2.5mm – 10.2mm Taps: M3 – M12
Product Type	Threading Taps
Overall Length	Drills: 57mm – 133mm Taps: 56mm – 110mm
Diameter	Drills: 2.5mm – 10.2mm Taps: 3.5mm – 9mm
Cut Length	Drills: 30mm – 87mm Taps: 18mm – 44mm
Number of Pieces	14
Drill Bit Type	Tap & Drill Set
Drill Application	General application Alloy steels Cast irons Stainless steel Titanium & titanium Alloys Aluminium Non-ferrous materials (brass, bronze, copper)

Mechanical Specifications

Cutter Diameter	DC– See table below and detailed image below
Cut Length	LU – See table below and detailed image below
Number of Flutes	2
Overall Length	OAL – See table below and detailed image below
Shank Type	Plain / Straight
Shank Diameter	DDM – See table below and detailed image below
Centre Cutting	Yes

Approvals

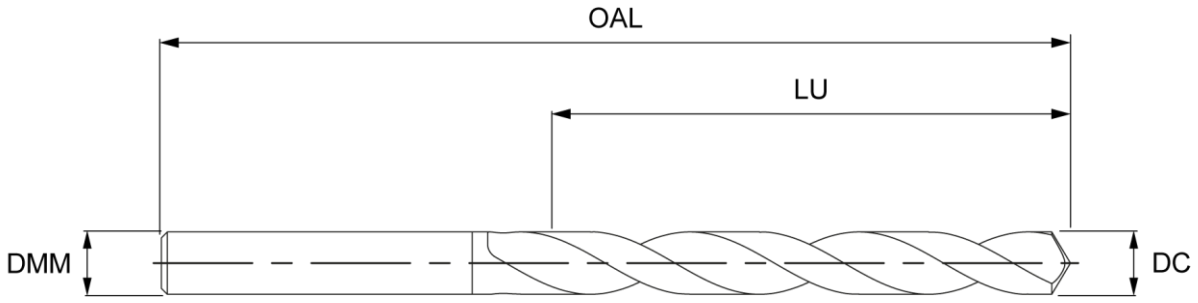
Declarations	N/A
Hazardous Area Certification	N/A
Standards Met	DIN 338

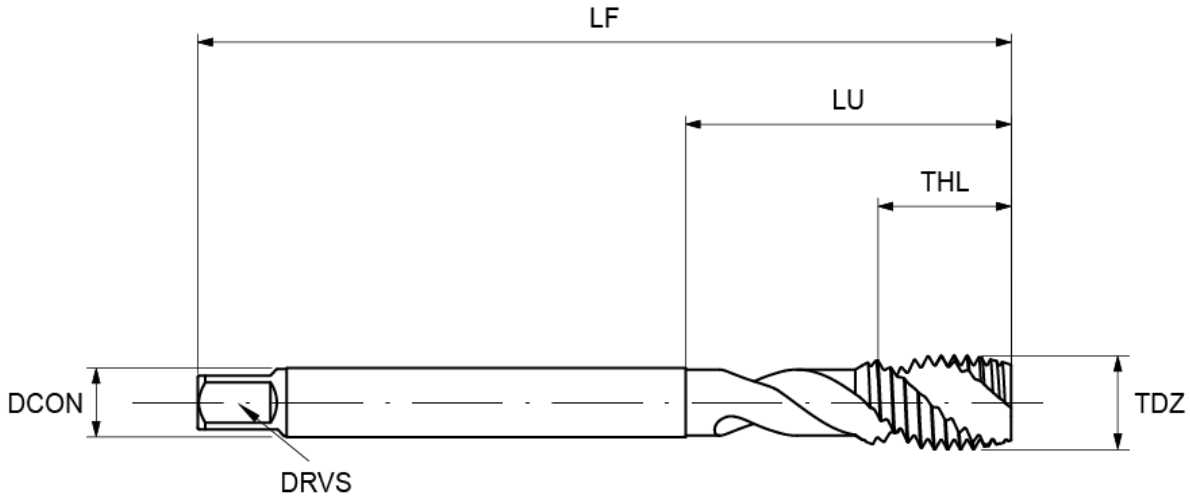
Stock No.	Brand	Tap Type	Size Range	Tapping Drills	No. of Items
900244	RS PRO	Spiral Flute	M3, M4, M5, M6, M8, M10, M12	2.5, 3.3, 4.2, 5.0, 6.8, 8.5, 10.2	14
900267	RS PRO	Spiral Point	M3, M4, M5, M6, M8, M10, M12	2.5, 3.3, 4.2, 5.0, 6.8, 8.5, 10.2	14

Similar Products

Stock No.	Brand	Diameter DC / DMM	FL.LTH LU	O/ALL OAL
908124	RS PRO	1.0	12	34
908096	RS PRO	4.0	43	75
908100	RS PRO	4.1	43	75
908097	RS PRO	4.2	43	75
908098	RS PRO	4.3	47	80
908102	RS PRO	4.5	47	80
908103	RS PRO	4.6	47	80
908101	RS PRO	4.7	47	80
908104	RS PRO	4.8	52	86
908105	RS PRO	4.9	52	86
908107	RS PRO	5.0	52	86
908109	RS PRO	5.1	52	86
908110	RS PRO	5.2	52	86
908108	RS PRO	5.3	52	86
908111	RS PRO	5.4	57	93
908113	RS PRO	5.5	57	93
908114	RS PRO	5.6	57	93
908117	RS PRO	5.8	57	93
908115	RS PRO	5.9	57	93
908116	RS PRO	6.0	57	93
908119	RS PRO	6.1	63	101
908120	RS PRO	6.2	63	101
908118	RS PRO	6.3	63	101
908121	RS PRO	6.4	63	101
908122	RS PRO	6.5	63	101
908123	RS PRO	6.8	69	109

Connection Diagrams / Assembly Diagrams / Illustrations / Accessories





Cutting Data

VDI MATERIAL GROUP			HRc	v_c (m/min)	f_n (mm/rev)									
					ø1.0 -1.9	ø2.0 -2.9	ø3.0 -3.9	ø4.0 -4.9	ø5.0 -5.9	ø6.0 -6.9	ø7.0 -7.9	ø8.0 -9.9	ø10.0 -11.9	ø12.0 -13.5
P	1-5	Non-alloy Steel	<25	**40 (35-45)**	0.02	0.06	0.08	0.11	0.11	0.13	0.15	0.18	0.22	0.22
	6-9	Low alloy Steel	25-35	**23 (20-25)**	0.02	0.06	0.08	0.10	0.10	0.12	0.14	0.15	0.18	0.20
M	12-13	Stainless Steel		**23 (20-25)**	0.02	0.06	0.08	0.10	0.10	0.12	0.14	0.15	0.18	0.20
S	36-37	Titanium & Titanium Alloys		**23 (20-25)**	0.02	0.06	0.08	0.09	0.10	0.12	0.14	0.15	0.18	0.20
N	21-24	Aluminium Si<12%		**90 (85-95)**	0.02	0.06	0.10	0.11	0.12	0.14	0.16	0.18	0.23	0.23

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.

v_c - cutting speed (m/min)
n - RPM (rev/min)
f_n - feed rate (mm/rev)
ø - drill diameter (mm)

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 No. (TSYC)	TM8040	TM8140
DIN 374	MF			
DIN 371/376	UNC		TM8240	TM8340
DIN 371/374	UNF		TM8640	TM8740
APPLICATION TYPE			UV	UV
TREATMENT/COATING			Bright	Bright
SPIRAL FLUTE ANGLE			40°	
CHAMFER LEAD TO DIN 2197			C	B
HOLE TYPE			 Max 2.5xD	 Max 3.0xD
TAP STYLE				

● Primary Application ○ Secondary Application

VDI MATERIAL GROUP			HRc	COOLANT TYPE	v_c (m/min)	
P	1-5	Non-alloy Steel	<25	Emulsion	● 6-20	● 6-20
	6-9	Low alloy Steel	25-35	Emulsion	● 3-15	● 3-15
	10-11	High alloy Steel, Tool Steel	35-45	Neat oil or Emulsion	● 3-5	● 3-5
M	12-13	Ferritic / Martensitic Stainless steel		Neat oil	○ 5-10	○ 5-10
	14	Austenitic Stainless steel		Neat oil	○ 4-6	○ 4-6
K	15-16	Grey Cast iron		Neat oil or Emulsion	● 5-15	● 5-15
	17-20	Nodular & Malleable Cast iron		Neat oil or Emulsion	● 5-15	● 5-15
N	21-25	Aluminium (HSM)		Emulsion		
		Aluminium			○ 15-20	○ 15-20
	26-28	Copper & Copper alloys		Emulsion	○ 15-35	○ 15-35
	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	○ 8-10	○ 8-10
	36-37	Titanium & Titanium alloys		Neat oil	○ 8-10	○ 8-10
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		