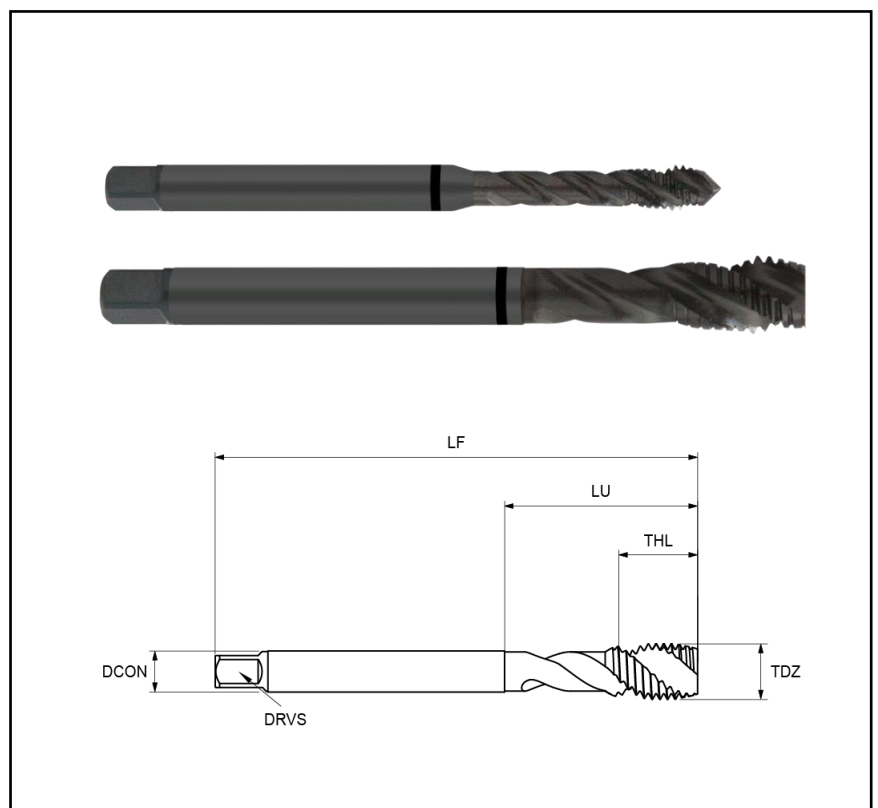


Features

- 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

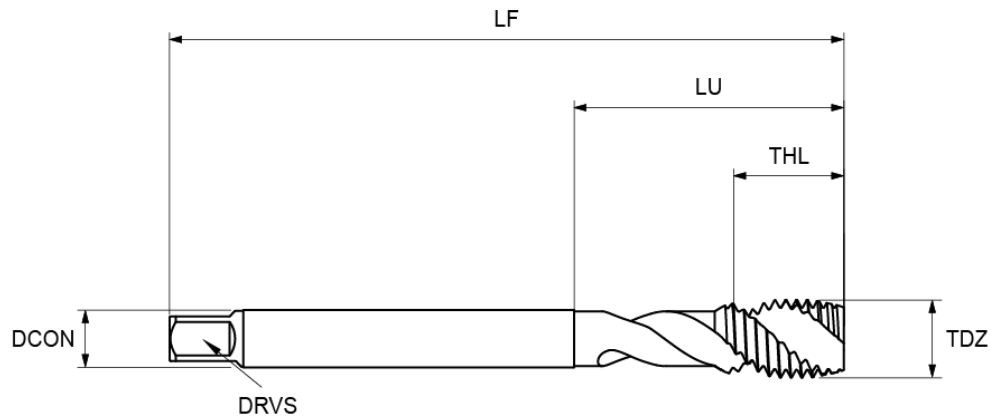
Threading Taps



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 900371	RS PRO	M2	0.4	8	45	13	2.8	2.1	3	1.6
XXX-XXXX 900240	RS PRO	M3	0.5	6	56	18	3.5	2.7	3	2.5
XXX-XXXX 900238	RS PRO	M4	0.7	7	63	21	4.5	3.4	3	3.3
XXX-XXXX 900239	RS PRO	M5	0.8	8	70	25	6.0	4.9	3	4.2
XXX-XXXX 900242	RS PRO	M6	1.0	10	80	30	6.0	4.9	3	5.0
XXX-XXXX 900243	RS PRO	M8	1.25	13	90	35	8.0	6.2	3	6.8
XXX-XXXX 900241	RS 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 900259	RS PRO	M2	0.4	8	45	13	2.8	2.1	3	1.6
XXX-XXXX 900260	RS PRO	M3	0.5	11	56	18	3.5	2.7	3	2.5
XXX-XXXX 900263	RS PRO	M4	0.7	13	63	21	4.5	3.4	3	3.3
XXX-XXXX 900261	RS PRO	M5	0.8	15	70	25	6.0	4.9	3	4.2
XXX-XXXX 900262	RS PRO	M6	1.0	17	80	30	6.0	4.9	3	5.0
XXX-XXXX 900265	RS PRO	M8	1.25	20	90	35	8.0	6.2	3	6.8
XXX-XXXX 900266	RS PRO	M10	1.5	22	100	39	10.0	8.0	3	8.5
XXX-XXXX 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	
P	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
M	12-13 Ferritic / Martensitic Stainless steel		Neat oil	○ 5-10
	14 Austenitic Stainless steel		Neat oil	○ 4-6
K	15-16 Grey Cast iron		Neat oil or Emulsion	● 5-15
	17-20 Nodular & Malleable Cast iron		Neat oil or Emulsion	● 5-15
N	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		-	
S	30 Synthetic Graphite		-	
	31-35 HRSA Fe & Ni/Co Based		Neat oil	○ 8-10
	36-37 Titanium & Titanium alloys		Neat oil	○ 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	