

# E533

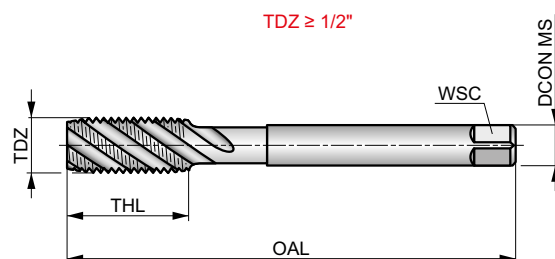
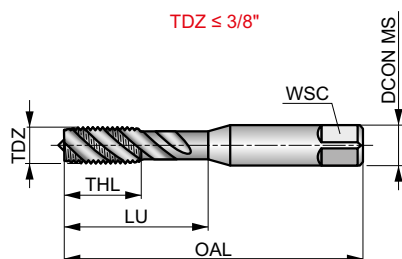
**DORMER**

## HSS Spiral Flute Machine Tap, BSW, ISO Standard

Machine tap with spiral flute suited for blind holes. Available with bright finish to produce more accurate and cleaner threads, preventing the workpiece material from sticking to the cutting edges or BLUE finish with steam tempered surface, which acts to retain cutting fluid and prevent chip to tool welding.



|       |           |        |
|-------|-----------|--------|
|       | ISO 529   | Medium |
|       | 2xD       | HSS    |
| C 2-3 |           | λ 40°  |
|       | Bright ST |        |



Workpiece material group suitability and starting values for cutting speed (m/min).

|              |              |              |             |             |             |             |              |              |             |             |             |             |             |
|--------------|--------------|--------------|-------------|-------------|-------------|-------------|--------------|--------------|-------------|-------------|-------------|-------------|-------------|
| P1.1<br>■ 10 | P1.2<br>■ 11 | P1.3<br>■ 13 | P2.1<br>■ 8 | P2.2<br>■ 7 | P2.3<br>■ 6 | P3.1<br>■ 7 | P3.2<br>■ 5  | P3.3<br>■ 4  | P4.1<br>■ 4 | P4.2<br>■ 3 | M1.1<br>■ 6 | M1.2<br>■ 5 | M2.1<br>■ 4 |
| M2.2<br>■ 5  | M2.3<br>■ 5  | M3.1<br>■ 5  | M3.2<br>■ 4 | M3.3<br>■ 3 | M4.1<br>■ 2 | N1.3<br>■ 5 | N2.1<br>■ 12 | N2.2<br>■ 10 | N2.3<br>■ 8 |             |             |             |             |

| Product                | TDZ  | TPI | TD     | OAL   | THL  | DCON MS | WSC   | NOF | PHD   | LU    |
|------------------------|------|-----|--------|-------|------|---------|-------|-----|-------|-------|
|                        |      |     | [mm]   | [mm]  | [mm] | [mm]    | [mm]  |     | [mm]  | [mm]  |
| E5331/8 <sup>1)</sup>  | 1/8  | 40  | 3.175  | 48.0  | 12.5 | 3.15    | 2.50  | 3   | 2.55  | 12.50 |
| E5331/8BLUE            | 1/8  | 40  | 3.175  | 48.0  | 12.5 | 3.15    | 2.50  | 3   | 2.55  | 12.50 |
| E5333/16 <sup>1)</sup> | 3/16 | 24  | 4.763  | 58.0  | 11   | 5.00    | 4.00  | 3   | 3.70  | 20.00 |
| E5333/16BLUE           | 3/16 | 24  | 4.763  | 58.0  | 11   | 5.00    | 4.00  | 3   | 3.70  | 20.00 |
| E5331/4 <sup>1)</sup>  | 1/4  | 20  | 6.350  | 66.0  | 13   | 6.30    | 5.00  | 3   | 5.10  | 26.00 |
| E5331/4BLUE            | 1/4  | 20  | 6.350  | 66.0  | 13   | 6.30    | 5.00  | 3   | 5.10  | 26.00 |
| E5335/16 <sup>1)</sup> | 5/16 | 18  | 7.938  | 72.0  | 16   | 8.00    | 6.30  | 3   | 6.50  | 31.00 |
| E5335/16BLUE           | 5/16 | 18  | 7.938  | 72.0  | 16   | 8.00    | 6.30  | 3   | 6.50  | 31.00 |
| E5333/8 <sup>1)</sup>  | 3/8  | 16  | 9.525  | 80.0  | 18   | 10.00   | 8.00  | 3   | 7.90  | 34.00 |
| E5333/8BLUE            | 3/8  | 16  | 9.525  | 80.0  | 18   | 10.00   | 8.00  | 3   | 7.90  | 34.00 |
| E5331/2 <sup>1)</sup>  | 1/2  | 12  | 12.700 | 89.0  | 22   | 9.00    | 7.10  | 3   | 10.50 | —     |
| E5331/2BLUE            | 1/2  | 12  | 12.700 | 89.0  | 22   | 9.00    | 7.10  | 3   | 10.50 | —     |
| E5335/8 <sup>1)</sup>  | 5/8  | 11  | 15.875 | 102.0 | 24   | 12.50   | 10.00 | 3   | 13.50 | —     |
| E5335/8BLUE            | 5/8  | 11  | 15.875 | 102.0 | 24   | 12.50   | 10.00 | 3   | 13.50 | —     |
| E5333/4 <sup>1)</sup>  | 3/4  | 10  | 19.050 | 112.0 | 29   | 14.00   | 11.20 | 3   | 16.50 | —     |
| E5333/4BLUE            | 3/4  | 10  | 19.050 | 112.0 | 29   | 14.00   | 11.20 | 3   | 16.50 | —     |

<sup>1)</sup> Bright Finish.