
**Long shank taps with nominal
diameters from M3 to M10 — Full-
diameter shank taps with recess**

*Tarauds à machine, à queue longue, de diamètre nominal M3 à
M10 — Tarauds à queue pleine, à gorge*

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

The committee responsible for this document is ISO/TC 29, *Small tools*, Subcommittee SC 2, *Holding tools, adaptive items and interfaces*.

This third edition cancels and replaces the second edition (ISO 8051:1999), of which it constitutes a minor revision with the following change:

- addition of [Annex A](#), which gives the relationship between the designations of this International Standard and the ISO 13399 series.

Long shank taps with nominal diameters from M3 to M10 — Full-diameter shank taps with recess

1 Scope

This International Standard specifies the dimensions for full-diameter shank taps with recess with nominal diameters from M3 to M10 and thus complements ISO 2283, which concerns relieved shank taps.

It applies to long shank machine taps.

Technical specifications for taps covered by this International Standard (including marking) are given in ISO 8830.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 529:1993, *Short machine taps and hand taps*

ISO 8830:1991, *High-speed steel machine taps with ground threads — Technical specifications*

3 Dimensions

Dimensions are given in [Figure 1](#) and [Table 1](#).

The threaded lengths of these taps are in accordance with those given in ISO 529.

Shank lengths ($L - l$) are increased by 50 % with respect to those given in ISO 529; total lengths therefore vary accordingly.

NOTE [Annex A](#) gives the relationship between the designations of this International Standard and ISO 13399 (all parts).

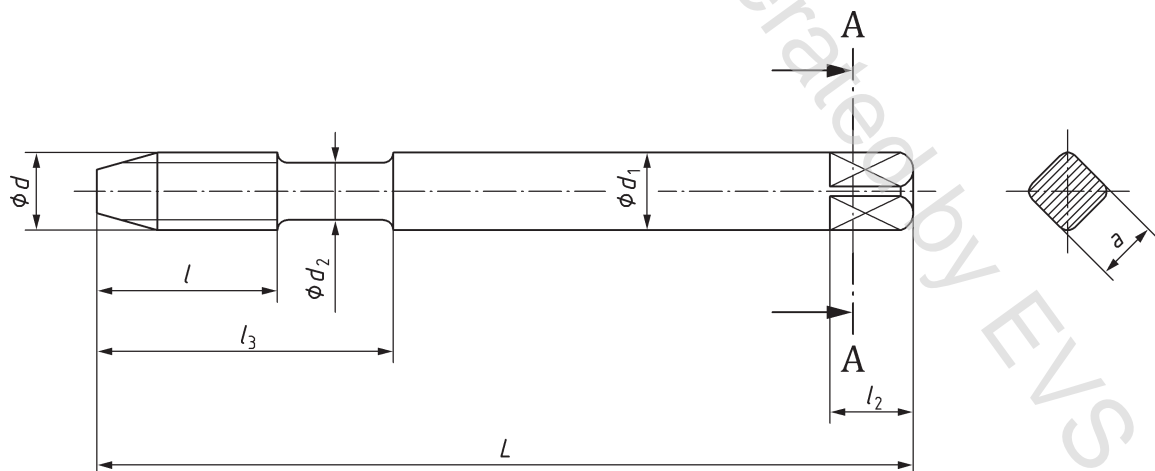


Figure 1