http://littlemachineshop.com/images/1ptrans.gif**Morse tapers**

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| **taper** | **angle** | **large end**  **diameter** | **small end diameter** | **length** | **taper/ foot** | **taper/ inch** |
| #0 | 1.4908 | 0.3561 | 0.2520 | 2.00 | .6246 | .0521 |
| #1 | 1.4287 | 0.4750 | 0.3690 | 2.13 | .5986 | .0499 |
| #2 | 1.4307 | 0.7000 | 0.5720 | 2.56 | .5994 | .0500 |
| #3 | 1.4377 | 0.9380 | 0.7780 | 3.19 | .6024 | .0502 |
| #4 | 1.4876 | 1.2310 | 1.0200 | 4.06 | .6233 | .0519 |
| #4-1/2 | 1.4894 | 1.5000 | 1.2660 | 4.50 | .6240 | .0520 |
| #5 | 1.5073 | 1.7480 | 1.4750 | 5.19 | .6315 | .0526 |
| #6 | 1.4933 | 2.4940 | 2.1160 | 7.25 | .6257 | .0521 |
| #7 | 1.4894 | 3.2700 | 2.7500 | 10.00 | .6240 | .0520 |

*Dimensions in inches, angles in degree from center*

**Jacobs’s tapers**

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| **taper** | **angle** | **large end diameter** | **small end diameter** | **length** | **taper/ foot** | **taper/ inch** |
| #0 | 1.4117 | 0.2500 | 0.2284 | 0.44 | .5915 | .0493 |
| #1 | 2.2074 | 0.3840 | 0.3334 | 0.66 | .9251 | .0771 |
| #2 | 2.3350 | 0.5590 | 0.4876 | 0.88 | .9786 | .0816 |
| #2 Short | 2.3350 | 0.5488 | 0.4876 | 0.75 | .9786 | .0816 |
| #3 | 1.5251 | 0.8110 | 0.7461 | 1.22 | .6390 | .0532 |
| #4 | 1.5009 | 1.1240 | 1.0372 | 1.66 | .6289 | .0524 |
| #5 | 1.4801 | 1.4130 | 1.3161 | 1.88 | .6201 | .0517 |
| #6 | 1.4868 | 0.6760 | 0.6241 | 1.00 | .6229 | .0519 |
| #33 | 1.8184 | 0.6240 | 0.5605 | 1.00 | .7619 | .0635 |

**Brown & Sharpe tapers**

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| **Taper** | **Angle From Center** | **Large End** | **Small End** | **Length** | **Taper/ Foot** | **Taper/ Inch** |
| #1 | 1.1983 | 0.2392 | 0.2000 | 0.94 | .5020 | .0418 |
| #2 | 1.1983 | 0.2997 | 0.2500 | 1.19 | .5020 | .0418 |
| #3 | 1.1983 | 0.3753 | 0.3125 | 1.50 | .5020 | .0418 |
| #4 | 1.1992 | 0.4207 | 0.3500 | 1.69 | .5024 | .0419 |
| #5 | 1.1973 | 0.5388 | 0.4500 | 2.13 | .5016 | .0418 |
| #6 | 1.2013 | 0.5996 | 0.5000 | 2.38 | .5033 | .0419 |
| #7 | 1.1970 | 0.7201 | 0.6000 | 2.88 | .5015 | .0418 |
| #8 | 1.1959 | 0.8987 | 0.7500 | 3.56 | .5010 | .0418 |

**Jarno tapers**

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| **taper** | **angle** | **large end diameter** | **small end diameter** | **length** | **taper/ foot** | **taper/ inch** |
| #2 | 1.4321 | 0.2500 | 0.2000 | 1.00 | .6000 | .0500 |
| #3 | 1.4321 | 0.3750 | 0.3000 | 1.50 | .6000 | .0500 |
| #4 | 1.4321 | 0.5000 | 0.4000 | 2.00 | .6000 | .0500 |
| #5 | 1.4321 | 0.6250 | 0.5000 | 2.50 | .6000 | .0500 |
| #6 | 1.4321 | 0.7500 | 0.6000 | 3.00 | .6000 | .0500 |
| #7 | 1.4321 | 0.8750 | 0.7000 | 3.50 | .6000 | .0500 |
| #8 | 1.4321 | 1.0000 | 0.8000 | 4.00 | .6000 | .0500 |
| #9 | 1.4321 | 1.1250 | 0.9000 | 4.50 | .6000 | .0500 |
| #10 | 1.4321 | 1.2500 | 1.0000 | 5.00 | .6000 | .0500 |
| #11 | 1.4321 | 1.3750 | 1.1000 | 5.50 | .6000 | .0500 |
| #12 | 1.4321 | 1.5000 | 1.2000 | 6.00 | .6000 | .0500 |
| #13 | 1.4321 | 1.6250 | 1.3000 | 6.50 | .6000 | .0500 |
| #14 | 1.4321 | 1.7500 | 1.4000 | 7.00 | .6000 | .0500 |
| #15 | 1.4321 | 1.8750 | 1.5000 | 7.50 | .6000 | .0500 |
| #16 | 1.4321 | 2.0000 | 1.6000 | 8.00 | .6000 | .0500 |
| #17 | 1.4321 | 2.1250 | 1.7000 | 8.50 | .6000 | .0500 |
| #18 | 1.4321 | 2.2500 | 1.8000 | 9.00 | .6000 | .0500 |
| #19 | 1.4321 | 2.3750 | 1.9000 | 9.50 | .6000 | .0500 |
| #20 | 1.4321 | 2.5000 | 2.0000 | 10.00 | .6000 | .0500 |

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