

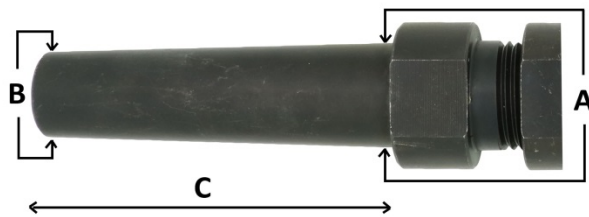
Morse Taper #1 vs. Morse Taper #2

What is a Morse Taper used for?

A Morse Taper is a tapered spindle used on lathes and drill presses to mount tooling. Morse Tapers on the headstock of your lathe have a hollow housing that is designed to fit a male ended arbor. When spinning, the arbor is forced farther into the housing, increasing the surface pressure between the two metal parts. The resulting friction prevents slippage. The design provides accurate centering and quick installation of arbors and lathe centers.

What is the difference between Morse Taper #1 and Morse Taper #2?

An MT1 and MT2 have the same taper per inch, but the length of the Morse Taper is different. The best way to know which taper you need for your lathe is to consult your owner's manual. Another way is to take the taper out of your lathe and measure it. You can refer to the chart below for MT1 and MT2 measurements.



	A	B	C
MT1	0.4750" 12.065 mm	0.3690" 9.373 mm	2.13" 54.10 mm
MT2	0.7000" 17.780 mm	0.5720" 14.529 mm	2.56" 65.02 mm

If your lathe doesn't have a hollow housing in the headstock, there are some mandrels that will screw onto the outside of the housing of some brands of lathes:

PKM-BL fits 1" x 8tpi headstock

PKM-CL fits 5/8" diameter (no thread) Shopsmith lathes

PKM-AL fits 3/4" 16tpi headstock