

# INTERNATIONAL STANDARD

**ISO  
239**

Second edition  
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## **Drill chuck tapers**

*Cônes d'emmanchement pour mandrins de perceuse*



Reference number  
ISO 239:1999(E)

## Foreword

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Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 239 was prepared by Technical Committee ISO/TC 29, *Small tools*.

This second edition cancels and replaces the first edition (ISO 239:1974) which has been technically revised.

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# Drill chuck tapers

## 1 Scope

This International Standard lays down the dimensions of drill chuck tapers and includes two distinct types :

- a) Morse taper type;
- b) Jacobs taper type.

It includes, for each type of taper, a table giving the dimensions.

## 2 Interchangeability

### 2.1 Morse taper type

See Figure 1 and Table 1.

The tapered portions are identical with the following Morse tapers:

- No.1, for tapers B6, B10 and B12;
- No.2, for tapers B16 and B18;
- No.3, for tapers B22 and B24.

The length of each of these tapers is, of course, distinctly less than the overall length of the corresponding Morse taper; each taper may be regarded as corresponding approximately either to that part of Morse taper nearest the small end (e.g. B10) or to the part nearest the large end (e.g. B12).

### 2.2 Jacobs taper type

See Figure 2 and Table 2.

Table 2 reproduces and classifies the normal dimensions of Jacobs tapers; they also observe the generally accepted designations, in spite of their somewhat illogical appearance.

The range of increasing values for diameter  $D$  contains two No. 2 tapers, the first of which is a short taper; between tapers Nos. 2 and 3, there are two interpolated tapers which bear the out-of-series numbers 33 and 6 respectively.