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$D - d$ length of workpiece Set-over = 2 length of taper

length of workpiece Set-over = Ratio 2 $X \tan = 2L$

Leading angle = $90 - (\text{Helix angle} + \text{clearance angle})$

Foll $' \ ' \ ^\circ \ ' \ ' \ ^\circ$ owing angle = $90 + (\text{Helix angle} -$

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clearance angle) Lead = No. of starts pitch Pitch

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SHEET $f = f_t \times T \times N$ $S = 60 \text{ SDN}$ $S = \text{SDN} \times N$ 40 9q

N Set- over = length of taper length of workpiece $2 D d$

$u \tan L \times 2 T$ Leading angle = $90^\circ - (\text{Helix angle} +$

clearance angle) Following angle = $90^\circ + (\text{Helix angle}$

- clearance angle) Lead = No of starts \times pitch

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length of workpiece Set-over = 2 length of taper length of workpiece Set-over = Ratio 2 ; $\tan = 2L$ Leading

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angle = $90 - (\text{Helix angle} + \text{clearance angle})$ Follow up
owing angle = $90 + (\text{Helix angle} - \text{clearance angle})$
Lead = No. of starts pitch Pitch

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