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

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

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

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Following angle = $90^\circ +$ (Helix angle - clearance angle) Lead = No. of starts pitch Pitch

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

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

$u \tan L \times 2 T$ Leading angle = $90^\circ -$ (Helix angle + clearance angle) Following angle = $90^\circ +$ (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 angle = $90 -$ (Helix angle + clearance angle)

Following angle = $90 +$ (Helix angle -

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