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$f T N t ? D N S = 60 S =$

$? D n 40 N N 9 D - d$

length of workpiece Set-

over = 2 length of taper

length of workpiece Set-

over = Ratio 2 $? X \tan =$

$2L$ Leading angle = $90 -$

(Helix angle + clearance

angle) $Foll \text{ } ^{\circ} \text{ } ^{\circ}$

owing angle = $90 +$

(Helix angle - clearance

angle) Lead = No. of

starts pitch Pitch

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

Set- over = length of
taper length of
workpiece $2 D d u \tan L$
 $X 2 T$ Leading angle =

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

Following angle $= 90^\circ + (\text{Helix angle} - \text{clearance angle})$
Lead = No of starts \times pitch

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workpiece Set-over = 2
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