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

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Set-over = Ratio 2 ; tan = 2L

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FITTING AND MACHINING THEORY N2 FORMULA SHEET $f = f T N t '1 S = 60 S = 'Q 40 N N 9 D - d$ length of workpiece Set-over = 2 length of taper length of workpiece Set-over = Ratio 2 ; $\tan = 2L$ Leading angle = $90 - (\text{Helix angle} + \text{clearance angle})$ Following angle = $90 + (\text{Helix angle} - \text{clearance angle})$ Lead = No. of starts pitch Pitch

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FITTING AND MACHINING THEORY N2 | Van Schaik

FITTING AND MACHINING THEORY N2 FORMULA SHEET $f = ft \times T \times N$ $S = 60$ SDN $S = SDN$ $N 40$ $9q$ N Set-over = length of taper length of workpiece $2 D d u \tan L X 2 T$ Leading angle = 90° -

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