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$f = f T N t '1 S = 60 S = 'Q 40 N N 9 D - d$ length of workpiece

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

Ratio 2 ; $\tan = 2L$ Leading angle = $90 - (\text{Helix angle} +$

clearance angle) Foll uu q u u q owing angle = $90 + (\text{Helix}$

angle - clearance angle) Lead = No. of starts pitch Pitch

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Set-over = Ratio 2 $\cdot X \tan = 2L$ Leading angle = $90 - (\text{Helix}$

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angle + clearance angle) $\text{Foll } \frac{\pi}{4} \text{ } \frac{\pi}{4} \text{ } \text{owing angle} = 90 +$
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