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 $= 'Q 40 N N 9 D - d$ length of workpiece Set-over = 2 length of taper length of workpiece Set-over = Ratio 2 ; $\tan = 2L$ Leading angle = $90 -$ (Helix angle + clearance angle) Foll uu q u u q owing angle = $90 +$ (Helix angle - clearance angle) Lead = No. of starts pitch Pitch

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