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$f = f T N t \cdot D N S = 60 S = \cdot D n 40 N N 9 D - d$ length of

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

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

angle + clearance angle) Foll $'' \circ '' \circ$ owing angle = $90 +$

(Helix angle - clearance angle) Lead = No. of starts pitch

Pitch

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$f = f_t \times T \times N$ $S = 60$ $SDN S = SDN N 40 9q N$ Set-over = length of taper length of workpiece $2 D d u \tan L X 2 T$
Leading angle = $90^\circ - (\text{Helix angle} + \text{clearance angle})$
Following angle = $90^\circ + (\text{Helix angle} - \text{clearance angle})$ Lead = No of starts \times pitch

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