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 $f = f T N t$   
 $S = 60 S$   
 $= 'Q 40 N N 9 D - d$  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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workpiece Set-over = Ratio 2 ;  $\tan = 2L$

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