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$T N t '1 S = 60 S = 'Q 40 N N 9 D - d$ 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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 $f = \frac{v}{1000} \times \frac{\pi D N}{1000}$
 $T = \frac{1000}{\pi D N}$
 $S = \frac{D}{40}$
 $N = \frac{90}{D - d}$ length of workpiece
Set-over = $2 \times \text{length of taper}$ length of workpiece
Set-over = $\text{Ratio} \times 2 \times \tan(\text{angle})$
Leading angle = $90 - (\text{Helix angle} + \text{clearance angle})$
Following angle = $90 + (\text{Helix angle} - \text{clearance angle})$
Lead = No. of starts ...

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