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 $= 60 S = D n 40 N N 9 D - d$  length of  
workpiece Set-over = 2 length of taper  
length of workpiece Set-over = Ratio 2  $X$   
 $\tan = 2L$  Leading angle =  $90 - (\text{Helix angle} +$

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clearance angle) Following angle =  $90 + (\text{Helix angle} - \text{clearance angle})$   
Lead = No. of starts pitch Pitch

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N2 FORMULA SHEET  $f = f_t \times T \times N$   $S = 60 \text{ SDN}$   $S = \text{SDN}$   $N 40 9q N$  Set-over =  
length of taper length of workpiece  $2 D d u$   
 $\tan L \times 2 T$  Leading angle =  $90^\circ - (\text{Helix angle} + \text{clearance angle})$  Following angle  
=  $90^\circ + (\text{Helix angle} - \text{clearance angle})$   
Lead = No of starts  $\times$  pitch

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N2 FORMULA SHEET  $f = f T N t^{-1} S = 60$

$S = \frac{1}{4} Q 40 N N 9 D - d$  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

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$= 90 + (\text{Helix angle} - \text{clearance angle})$  Lead  
= No. of starts pitch Pitch

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