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 $60 S = 'Q 40 N N 9 D - d$  length of

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workpiece Set-over =  $2 \times$  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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$N S = 60 S = D n 40 N N 9 D - d$

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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