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$f = f T N t ? D N S = 60 S = ? D n 40 N N 9 D - d$ length of workpiece
Set-over = 2 length of taper length of workpiece
Set-over = Ratio 2 $?X \tan = 2L$ Leading angle = $90 - (\text{Helix angle} + \text{clearance angle})$
Foll $'' \circ ' ' \circ$ owing angle = $90 + (\text{Helix angle} - \text{clearance angle})$
Lead = No. of starts pitch
Pitch

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$f = f_t \times T \times N$ $S = 60$ 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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