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$D N S = 60 S = \pi D n 40 N N 9 D -$

d length of workpiece Set-over =

2 length of taper length of

workpiece Set-over = Ratio $2 \theta X$

$\tan = 2L$ Leading angle = $90 -$

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(Helix angle + clearance angle)
Following angle = $90^\circ +$
(Helix angle - clearance angle)
Lead = No. of starts pitch Pitch

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 $S = 60 \text{ SDN}$ $S = \text{SDN}$ $N 40 9q N$
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 = $90^\circ + (\text{Helix angle} -$

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clearance angle) Lead = No of
starts \times pitch

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 $S = 60 S = 'Q 40 N N 9 D - d$
length of workpiece Set-over = 2
length of taper length of
workpiece Set-over = Ratio 2 ;
 $\tan = 2L$ Leading angle = $90 -$
(Helix angle + clearance angle)
Following angle = 90

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+ (Helix angle - clearance angle)
Lead = No. of starts pitch Pitch

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

length of workpiece Set-over = 2

length of taper length of

workpiece Set-over = Ratio 2 ;

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tan ϕ = 2L Leading...

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