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

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Leading angle = $90 - (\text{Helix angle} + \text{clearance angle})$ Follow up
Following angle = $90 + (\text{Helix angle} - \text{clearance angle})$ Lead =
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