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$D - d$ 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 = $90 + (\text{Helix angle} -$

clearance angle) Lead = No. of starts pitch Pitch

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FITTING AND MACHINING THEORY N2 FORMULA

SHEET $f = f_t \times T \times N$ $S = 60$ $SDN S = SDN$ $N 40$ $9q$

N Set-over = length of taper length of workpiece $2 D d$

$u \tan L \times 2 T$ Leading angle = $90^\circ - (\text{Helix angle} +$

clearance angle) Following angle = $90^\circ + (\text{Helix angle}$

- clearance angle) Lead = No of starts \times pitch

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