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$T N t \quad D N S = 60 S =$

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$D_n = 40$ $N = 9$ $D = d$

length of workpiece Set-

over = 2 length of taper

length of workpiece Set-

over = Ratio $2 \times \tan =$

$2L$ Leading angle = $90 -$

(Helix angle + clearance

angle) Follow ' ' ° ' ' ' °

Following angle = $90 +$

(Helix angle - clearance

angle) Lead = No. of

starts pitch Pitch

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 $f_t \times T \times N$ $S = 60 \text{ SDN}$
 $S = \text{SDN}$ $N = 40$ $9q$ N Set-
over = length of taper
length of workpiece $2 D$
 $d \text{ u tan } L \times 2 T$ Leading
angle = $90^\circ - (\text{Helix}$
angle + clearance angle)

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

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$N N 9 D - d$ length of

workpiece Set-over = 2

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