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 $N N 9 D - d$  length of workpiece Set-over = 2 length of taper length of workpiece Set-over = Ratio 2  $\cdot X$   
 $\tan = 2L$  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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 $N 40 9q N$  Set- over = length of taper length of workpiece  $2 D d u \tan L X 2 T$  Leading angle =  $90^\circ -$

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

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