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$= 'Q 40 N N 9 D - d$ length of workpiece Set-over = 2 length of taper length of

workpiece Set-over = Ratio 2 ; $\tan = 2L$ Leading angle = $90 - (\text{Helix angle} + \text{clearance angle})$

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

= No. of starts pitch Pitch

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MACHINING THEORY N2 FORMULA SHEET $f = f_t \times T \times N$ $S = 60 \text{ SDN}$ $S = \text{SDN}$
 $N = 40$ $9q = N$ Set-over = length of taper length of workpiece $2 D d u \tan L \times 2 T$
Leading angle = $90^\circ -$

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