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 $S = 'Q 40 N N 9 D - d$  length of workpiece  
Set-over = 2 length of taper length of  
workpiece Set-over = Ratio 2 ;  $\tan = 2L$   
Leading angle =  $90 - (\text{Helix angle} +$   
clearance angle) Foll uu q u u q owing angle

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$= 90 + (\text{Helix angle} - \text{clearance angle}) \text{ Lead}$   
 $= \text{No. of starts pitch Pitch}$

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clearance angle) Foll  $' \quad ' \quad \circ \quad ' \quad ' \quad \circ$   
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