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$f = f T N t$  '1 S = 60 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 =  $90 - (\text{Helix angle} + \text{clearance angle})$  Following angle =  $90 + (\text{Helix angle} - \text{clearance angle})$   
Lead = No. of starts pitch Pitch

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