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 $\times N$ $S = 60$ SDN $S = SDN$ $N 40$ $9q$ N Set- over = length of taper
length of workpiece $2 D d u \tan L X 2 T$ Leading angle = $90^\circ -$
(Helix angle + clearance angle) Following angle = $90^\circ +$ (Helix
angle - clearance angle) Lead = No of starts \times pitch

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Set-over = 2 length of taper length of workpiece
Set-over = Ratio 2
 $\theta X \tan = 2L$ 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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