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N Set-over = length of taper length of workpiece $2 D d u \tan L X 2 T$ Leading angle = $90^\circ - (\text{Helix angle} + \text{clearance angle})$ Following angle = $90^\circ + (\text{Helix angle} - \text{clearance angle})$ Lead = No of starts \times pitch

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FITTING AND MACHINING THEORY N2 FORMULA SHEET $f = f T N t \pi D N S = 60 S = \pi D n 40 N N 9 D$
- d length of workpiece 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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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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