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 $T N t \pi D N S = 60 S = \pi D$
 $n 40 N N 9 D - d$ length of workpiece Set-over = 2 length of taper length of workpiece Set-over = Ratio $2 \theta X \tan = 2L$
 Leading angle = $90 -$ (Helix angle + clearance angle) $Foll \text{ } ^\circ \text{ } ^\circ \text{ } ^\circ$ owing angle = $90 +$ (Helix angle - clearance angle) Lead =

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 tool is used to
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 material so that the

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 remains •Most common
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 metal parts •Machining is
 the most versatile and
 accurate of all
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 $= 2L$ Leading angle = $90 -$
 (Helix angle + clearance angle)
 Following angle = $90 +$ (Helix angle - clearance angle)
 Lead = No. of starts pitch
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