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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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