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length of workpiece Set-over = 2 length of taper length of workpiece

Set-over = Ratio  $2 X \tan = 2L$  Leading angle =  $90 - (\text{Helix angle} + \text{clearance angle})$  Foll  $' ' \circ ' ' \circ$  owing angle =  $90 + (\text{Helix angle} - \text{clearance angle})$  Lead = No. of starts pitch Pitch Mean

diameter =  $OD - 2 \text{ Lead tan} \dots$

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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) Foll uu q u u q owing angle =  $90 + (\text{Helix angle} - \text{clearance}$   
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