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'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 -

(Helix angle + clea

rance angle) Foll uu q u

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Following angle = $90 +$
(Helix angle - clearance angle) Lead = No.
of starts pitch Pitch

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