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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 =  $90 -$   
(Helix angle + clearance angle) Foll uu q u u q owing angle =  $90 +$   
(Helix angle - clearance angle) Lead = No. of starts pitch Pitch

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