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N2 FORMULA SHEET  $f = f T N t^{-1} S =$

$60 S = 'Q 40 N N 9 D - d$  length of

workpiece Set-over = 2 length of taper

length of workpiece Set-over = Ratio 2 ;

$\tan = 2L$  Leading angle =  $90 - (\text{Helix angle}$

+ clearance angle) Following

angle =  $90 + (\text{Helix angle} - \text{clearance}$

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angle) Lead = No. of starts pitch Pitch

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