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length of workpiece $2 D d u \tan L X 2 T$ Leading angle = $90^\circ -$
(Helix angle + clearance angle) Following angle = $90^\circ +$ (Helix
angle - clearance angle) Lead = No of starts \times pitch

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FITTING AND MACHINING THEORY N2 FORMULA SHEET $f = f_t N t$
 $\pi D N S = 60$ $S = \pi D n$ $40 N N 9 D - d$ length of workpiece Set-
over = 2 length of taper length of workpiece Set-over = Ratio 2
 $\theta X \tan = 2L$ Leading angle = $90 -$ (Helix angle + clearance angle)
Following angle = $90 +$ (Helix angle - clearance angle)
Lead = No. of starts pitch Pitch

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 $'1 S = 60 S = 'Q$ $40 N N 9 D - d$ length of workpiece Set-over = 2
length of taper length of workpiece Set-over = Ratio 2 ; $\tan = 2L$
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