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Lead = No. of starts pitch Pitch

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T Leading angle = $90^\circ - (\text{Helix angle} + \text{clearance angle})$ Following angle = $90^\circ + (\text{Helix angle} - \text{clearance angle})$ Lead = No of starts \times pitch

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 $40 N N 9 D - d$ length of workpiece Set-over = 2 length of taper length of workpiece
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