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= f T N t  $\pi$  D N S =

60 S =  $\pi$  D n 40 N

N 9 D - d length of

workpiece Set-over

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Question

= 2 length of taper  
length of workpiece  
Set-over = Ratio 2

$$\theta \times \tan = 2L$$

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Leading angle = 90

- (Helix angle +  
clearance angle)

Foll ' ' ° ' ' ° owing  
angle = 90 + (Helix  
angle - clearance  
angle) Lead = No.  
of starts pitch Pitch

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Machining Theory

April 2016

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FORMULA SHEET f

$$= f_t \times T \times N \quad S = 60$$

$$SDN \quad S = SDN \quad N \quad 40$$

9q N Set- over =

length of taper

length of workpiece

$$2 D d u \tan L \times 2 T$$

Leading angle =

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Fitting And

$90^\circ - (\text{Helix angle} + \text{clearance angle})$

Following angle

$= 90^\circ + (\text{Helix}$

angle - clearance

angle) Lead = No

of starts  $\times$  pitch

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$S = 'Q 40 N N 9 D -$

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

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angle) Following angle =  $90^\circ$

+ (Helix angle -

clearance angle)

Lead = No. of

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