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FITTING AND MACHINING THEORY N2 FORMULA SHEET $f = ft \times T$
 $\times N S = 60 S D N S = S D N N 40 9q N$ Set-over = length of taper
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 $f = f T N t$
'1 S = 60 S = 'Q 40 N N 9 D - d length of workpiece Set-over = 2

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length of taper length of workpiece Set-over = Ratio 2 ; $\tan = 2L$
Leading angle = $90 - (\text{Helix angle} + \text{clearance angle})$ Follow up
Following angle = $90 + (\text{Helix angle} - \text{clearance angle})$ Lead =
No. of starts pitch Pitch

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 $f = f T N t$
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 $\theta X \tan = 2L$ Leading angle = $90 - (\text{Helix angle} + \text{clearance angle})$
Foll ° ° ° ° owing angle = $90 + (\text{Helix angle} - \text{clearance angle})$
Lead = No. of starts pitch Pitch

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