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

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