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FORMULA SHEET $f = f T N t$ $D N S =$

$60 S = D n 40 N N 9 D - d$ length of

workpiece Set-over = 2 length of

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taper length of workpiece $\text{Set-over} = \frac{D-d}{2} \times \tan L$
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

N2 Fitting and Machining Theory

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FORMULA SHEET $f = f_t \times T \times N$ $S = 60$

$\text{SDN} \quad S = \text{SDN} \quad N \quad 40 \quad 9q \quad N$ Set-over =

length of taper length of workpiece $\frac{D-d}{2}$

$\text{D} \quad d \quad u \quad \tan L \quad X \quad 2 \quad T$ Leading angle = 90°

- (Helix angle + clearance angle)

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

clearance angle) Lead = No of starts \times

pitch

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 $= 'Q 40 N N 9 D - d$ length of
workpiece Set-over = 2 length of
taper length of workpiece Set-over =
Ratio 2 ; $\tan = 2L$ Leading angle = $90 -$
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Quantity \times (Helix angle - clearance angle) Lead = No. of starts pitch Pitch

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