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 $f = f T N t \pi D N S = 60$
 $S = \pi D n 40 N N 9 D -$
d length of workpiece
Set-over = 2 length of
taper length of
workpiece Set-over =
Ratio $2 \theta X \tan = 2L$
Leading angle = $90 -$
(Helix angle +
clearance angle) Foll
 $\circ \prime \prime \circ$ owing angle =
 $90 +$ (Helix angle -

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clearance angle) Lead
= No. of starts pitch
Pitch

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N2 FORMULA SHEET
 $f = \frac{f T N t}{1 S} = \frac{60 S}{Q 40 N N 9 D - d}$

length of workpiece Set-
over = 2 length of
taper length of
workpiece Set-over =
Ratio 2 ; $\tan = \frac{2L}{2}$

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Leading angle = $90 -$
(Helix angle + clearance angle) $F_{\text{cut}} = \frac{V_c}{4000} \times \frac{1}{N} \times \frac{1}{S}$
Cutting angle = $90 +$
(Helix angle - clearance angle) $L = \frac{P}{N}$
Lead = No. of starts P Pitch

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N2 FORMULA SHEET

$f = \frac{V_c}{4000} \times \frac{1}{N} \times \frac{1}{S}$

$L = \frac{P}{N}$

length of workpiece Set-

over = $2 \times$ length of

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

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