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$f = \frac{V}{T} \cdot \frac{N}{t} \cdot \frac{D}{N} \cdot S = 60 \cdot \frac{S}{D} \cdot \frac{N}{40} \cdot \frac{N}{9} \cdot D - d$  length of workpiece  
Set-over =  $2 \cdot \frac{\text{length of taper}}{\text{length of workpiece}}$   
Set-over =  $\frac{2 \cdot X \cdot \tan \alpha}{L}$  Leading angle =  $90^\circ - (\text{Helix angle} + \text{clearance angle})$   
Following angle =  $90^\circ + (\text{Helix angle} - \text{clearance angle})$   
Lead = No. of starts ...

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