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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  
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