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- d length of workpiece Set-over = 2 length of taper length of workpiece Set-over = Ratio  $2 \theta X \tan$   
= 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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