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D - d length of workpiece Set-over = 2 length of taper length of workpiece Set-over = Ratio 2 ;  
 $\tan = 2L$  Leading angle =  $90 - (\text{Helix angle} + \text{clearance angle})$  Foll uu q u u q owing angle =  $90 + (\text{Helix angle} - \text{clearance angle})$  Lead = No. of starts pitch Pitch

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