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 $S = \pi D n 40 N N 9 D - d$  length of workpiece  
Set-over = 2 length of taper length of workpiece  
Set-over = Ratio 2  $\theta X \tan = 2L$  Leading angle =  $90 - (\text{Helix angle} + \text{clearance angle})$  Foll  $'' \circ ' ' \circ$   
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