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FITTING AND MACHINING THEORY N2

FITTING AND MACHINING THEORY N2 FORMULA SHEET $f = f T N t \pi D N S = 60 S = \pi D n 40 N N 9 D - d length of workpiece Set-over = 2 length of taper length of workpiece Set-over = Ratio 2 <math>\theta X$ tan = 2L Leading angle = 90 - (Helix angle + clearance angle) Foll '' o' o' owing angle = 90 + (Helix angle - clearance angle) Lead = No. of starts pitch Pitch

N2 Fitting and Machining Theory November 2016

FITTING AND MACHINING THEORY N2 FORMULA SHEET f = f T N t '1 S = 60 S = 'Q 40 N N 9 D - d length of workpiece Set-over = 2 length of taper length of workpiece Set-over = Ratio 2; tan = 2L Leading angle = 90 - (Helix angle + clea rance angle) Foll uu q u u q owing angle = 90 + (Helix angle - cleara nce angle) Lead = No. of starts pitch Pitch

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