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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

$\pi X \tan = 2L$  Leading angle =  $90 - (\text{Helix angle} + \text{clearance angle})$

Foll  $''^\circ \ '^\circ$  owing angle =  $90 + (\text{Helix angle} - \text{clearance angle})$

Lead = No. of starts pitch Pitch

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Machining A material removal process in which a sharp cutting tool is used to mechanically cut away material so that the desired part geometry remains

- Most common application: to shape metal parts
- Machining is the most versatile and accurate of all manufacturing processes in its capability to produce

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