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Write only the answer ... THIRD ANGLE ORTHOGRAPHIC  
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 $\pi D N S = 60 S = \pi D n 40 N N 9 D - d$  length of workpiece Set-over = 2 length of taper length of workpiece Set-over = Ratio 2  
 $\theta X \tan = 2L$  Leading angle =  $90 - (\text{Helix angle} + \text{clearance angle})$   
Foll  $'' \circ '' \circ '' \circ$  owing angle =  $90 + (\text{Helix angle} - \text{clearance angle})$   
Lead = No. of starts ...

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