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10.3.1 The process which allows for a 90 degree screw head to fit flush with the metal surface is called counter-sinking. 10.3.2 The feed of a sensitive drilling machine is transmitted by a gear-

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- 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 $'' \circ '' \circ$ owing angle = $90 + (\text{Helix angle} - \text{clearance angle})$ Lead = No. of starts ...

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