

# HAAS TM-2 / VF-3 PART SETUP SHEET

PART DESCRIPTION:

PART NUMBER:

PROGRAMMER:

<b>Tool #</b>	<b>Tool Description</b>	<b>Tool Mat'l</b>	<b>Tool LOC</b>	<b>No. of Flutes</b>	<b>Tool Speed</b>	<b>Tool Feedrate</b>
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## NOTES / SKETCHES ON OFFSETS, PROGRAMMING, & WORKHOLDING:

### [SPEEDS & FEEDS CALCS \(click hyperlink for tips and reference tables for V, fr, and ft\):](#)

$N [rpm] = 12 [in/ft] \times V [sfm] / (\pi \times D [in/rev])$ , where

*N is the rotational velocity of the tool (rpm)*

*V is the recommended peripheral velocity for the tool (ft/min)*

*D is the diameter of the tool*

$f [in/min] = N [rpm] \times fr [in/rev] = N [rpm] \times ft [in/tooth] \times m [\# \text{ of teeth}]$ , where

*f = linear feed rate of the drill / endmill [in/min]*

*N = spindle speed [rpm]*

*fr = feed per revolution of the drill bit [in]*

*ft = feed per tooth of the endmill / cutter [in/tooth]*

*m = number of teeth on endmill / cutter [integer]*