

TITLE OF SET UP SHEET.

SET UP OPERATION NUMBER#	MACHINE	OPERATION DESCRIPTION	NC PROGRAM/S #
0001	SHERLINE MILL 3 AXIS	STOCK FACING A SQUARING	

JIG/ PART HOLDER# & VICE	SET UP DESCRIPTION	IMAGE #	TORQUE RECOMMENDATION

STOCK DIMENSIONS	
MATERIAL	

TOOL #	TOOL DESCRIPION	TOOL HOLDER	RPM	IPT	SFM	IPR	IPM	PITCH
TOOL 1								
TOOL 2.								
TOOL 3.								
TOOL 4.								
TOOL 5.								
TOOL 6.								
TOOL 7.								

RPM = $3.82 * \text{SFM} / \text{TOOL DIAMETER (INCHES)}$

IPT found in manufactures reference book or web page.

SFM = tool manufactures or technical reference book or web page

IPR= IPT *number of flutes or teeth

IPM=IPR*RPM

STOCK AMOUNT #	PARTS PRODUCED #	SCRAP PRODUCED #

MACHINE OPERATORS' INITIALS AND COMPANY NUMBER
