



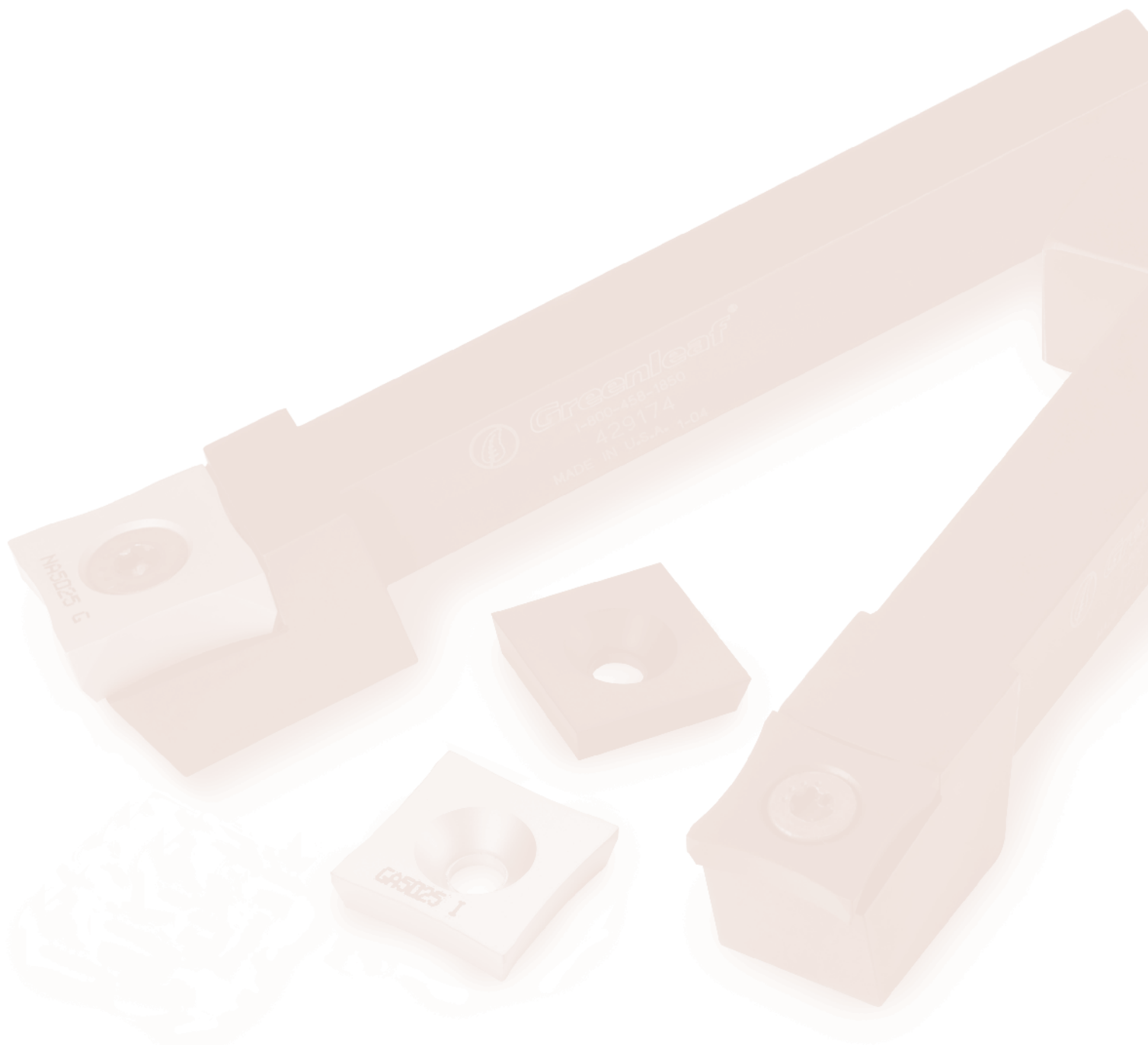
INTRODUCTION	
MILLING	
TURNING AND BORING	
HEAVY TURNING	
GROOVING, PROFILING AND CUT-OFF	
API RING-GROOVE MACHINING	
INDEXABLE DRILLING	
TUBE SCARFING	
SPECIAL ENGINEERING	
APPLICATION and TECHNICAL INFORMATION	

2016

TUBE SCARFING



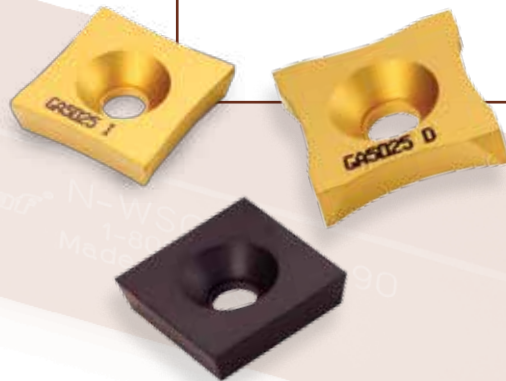
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<i>Grade Descriptions</i>	<i>TS 04</i>
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**Greenleaf Sales**

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Tube Scarfing

Greenleaf's modern tube scarfing system using indexable inserts offers greatly increased productivity potential from decreased downtime, longer tool life, faster tool change time, decreased tool costs and elimination of regrinding problems. In addition, a superior seam can be expected since an accurate radius form is always available on each side of the insert.



Greenleaf Corporation is continually upgrading its products.
For the most current information, please visit our web site at:

www.greenleafglobalsupport.com

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CARBIDE

Greenleaf offers a comprehensive line of carbide inserts in grades ranging from sub-micron C-1 through C-8 classifications. An industry pioneer in coated carbide, Greenleaf offers a variety of uncoated, MT-CVD coated and PVD-coated grades. Carbide inserts are available in ANSI standard geometries.

COATED

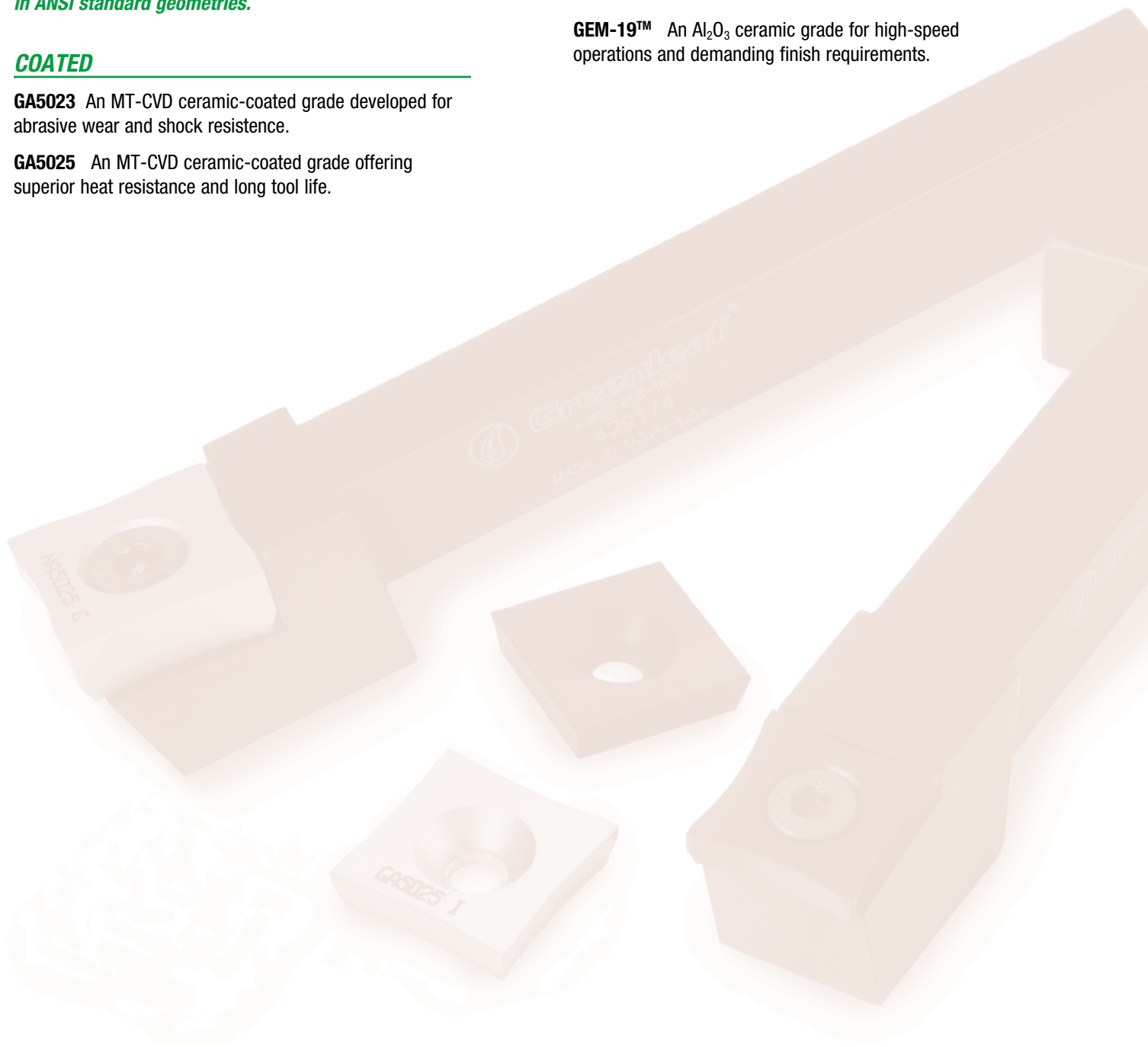
GA5023 An MT-CVD ceramic-coated grade developed for abrasive wear and shock resistance.

GA5025 An MT-CVD ceramic-coated grade offering superior heat resistance and long tool life.

CERAMIC

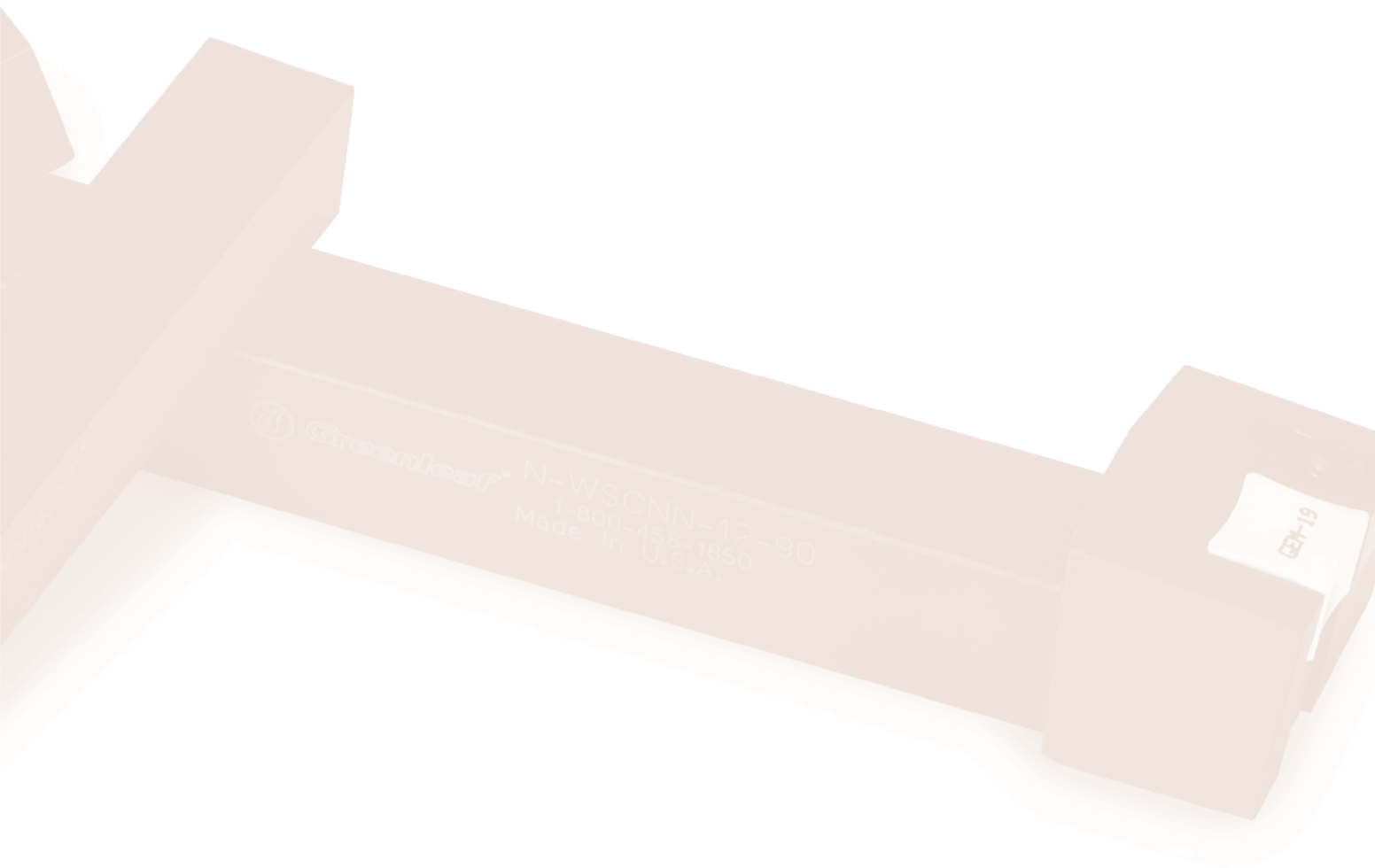
Greenleaf is the industry leader in the development and manufacture of ceramic and coated ceramic inserts in ANSI standard and special geometries. One of the most prominent is:

GEM-19™ An Al_2O_3 ceramic grade for high-speed operations and demanding finish requirements.



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Insert Style

S-SPUB-63

Shape: Scarfing	Product Number	Tube Size	Radius
	S-SPUB-63-B	Up to .875"	0.475
	S-SPUB-63-C	.875-1.125"	0.590
	S-SPUB-63-D	1.125-1.500"	0.785
	S-SPUB-63-E	1.500-1.875"	0.980
	S-SPUB-63-F	1.875-2.250"	1.180
	S-SPUB-63-G	2.250-3.125"	1.575
	S-SPUB-63-H	3.125-3.875"	1.970
	S-SPUB-63-I	3.875-4.675"	2.470
	S-SPUB-63-J	4.675-5.875"	2.970
	S-SPUB-63-K	5.875-6.875"	3.470
	S-SPUB-63-L	6.875-7.875"	3.970
	S-SPUB-63-M	7.875" and Up	NONE
	S-SPUB-63-P		6.000
	S-SPUB-63-S		0.375

MT-CVD Coated Carbide

*Note: This insert has 11° positive clearance all around.

S-SPUB-86

Additional thickness and flank clearance for heavy-wall pipe and pipe diameters over 5" available.

Shape: Scarfing	Product Number	Tube Size	Radius
	S-SPUB-86-B	Up to .875"	0.475
	S-SPUB-86-C	.875-1.125"	0.590
	S-SPUB-86-D	1.125-1.500"	0.785
	S-SPUB-86-E	1.500-1.875"	0.980
	S-SPUB-86-F	1.875-2.250"	1.180
	S-SPUB-86-G	2.250-3.125"	1.575
	S-SPUB-86-H	3.125-3.875"	1.970
	S-SPUB-86-I	3.875-4.675"	2.470
	S-SPUB-86-J	4.675-5.875"	2.970
	S-SPUB-86-K	5.875-6.875"	3.470
	S-SPUB-86-L	6.875-7.875"	3.970
	S-SPUB-86-M	7.875" and Up	NONE
	S-SPUB-86-N		6.000
	S-SPUB-86-S		9.500
	S-SPUB-86-P		6.250

MT-CVD Coated Carbide

*Note: This insert has 13° positive clearance all around.

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Flank Clearance

Insert IC and Thickness

Pipe Diameter

S-SGUE-63

Additional flank clearance for coated tube operations.

Shape: Scarfing	Product Number	Tube Size	Radius
	S-SGUE-63-B	Up to .875"	0.475
	S-SGUE-63-C	.875-1.125"	0.590
	S-SGUE-63-D	1.125-1.500"	0.785
	S-SGUE-63-E	1.500-1.875"	0.980
	S-SGUE-63-F	1.875-2.250"	1.180
	S-SGUE-63-G	2.250-3.125"	1.575
	S-SGUE-63-H	3.125-3.875"	1.970
	S-SGUE-63-I	3.875-4.675"	2.470
	S-SGUE-63-J	4.675-5.875"	2.970
	S-SGUE-63-K	5.875-6.875"	3.470
	S-SGUE-63-L	6.875-7.875"	3.970
	S-SGUE-63-M	7.875" and Up	NONE
	S-SGUE-63-N		1.750" DIA
	S-SGUE-63-S		0.875
	S-SGUE-63-P		6.000

MT-CVD Coated Carbide

*Note: This insert has 30° positive clearance all around.

S-SNUN-46

Ceramic-Style Insert

Shape: Scarfing	Product Number	Tube Size	Radius
	S-SNUN-46-B	Up to .875"	0.475
	S-SNUN-46-C	.875-1.125"	0.590
	S-SNUN-46-D	1.125-1.500"	0.785
	S-SNUN-46-E	1.500-1.875"	0.980
	S-SNUN-46-F	1.875-2.250"	1.180
	S-SNUN-46-G	2.250-3.125"	1.575
S-SNUN-46-H		3.125-3.875"	1.970

AlN

Stacked or Available Upon Request

Stacked Standard

Stacked or Available Upon Request

Stacked Standard

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Stocking Status

Insert Radius

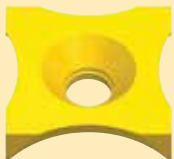
Inserts



S-SPUB-63
page: TS 08



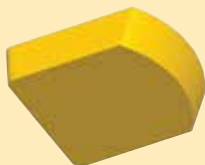
S-SPUB-86
page: TS 08



S-SGUB-63
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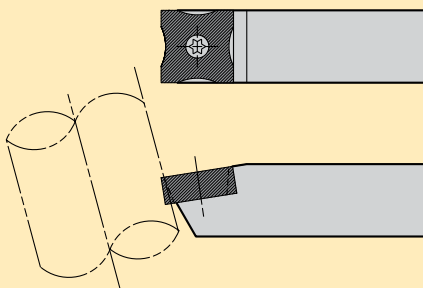
S-SNUN-46
page: TS 09



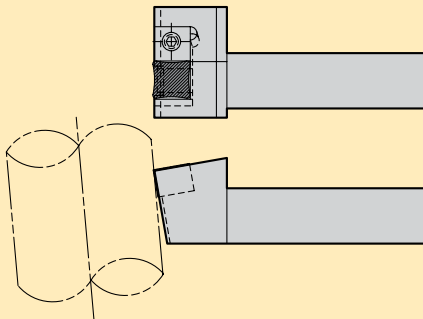
ID Scarfing
Insert
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Toolholders

N-SSCPS
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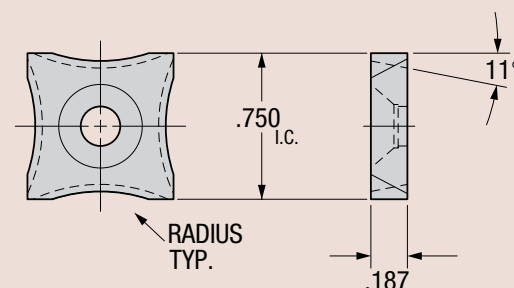
N-WSCNN
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S-SPUB-63

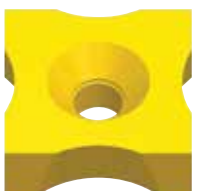
Shape: Scarfing	Product Number			Tube Size	Dimensions (inches)
		GA5023	GA5025		
	S-SPUB-63-B	○	●	Up to .875"	0.475
	S-SPUB-63-C	○	●	.875-1.125"	0.590
	S-SPUB-63-D	●	●	1.125-1.500"	0.785
	S-SPUB-63-R	○	○	1.750"	0.875
	S-SPUB-63-E	●	●	1.500-1.875"	0.985
	S-SPUB-63-F	●	●	1.875-2.250"	1.180
	S-SPUB-63-G	●	●	2.250-3.125"	1.575
	S-SPUB-63-H	●	●	3.125-3.875"	1.970
	S-SPUB-63-I	●	●	3.875-4.875"	2.470
	S-SPUB-63-J	●	●	4.875-5.875"	2.970
	S-SPUB-63-K	○	●	5.875-6.875"	3.470
	S-SPUB-63-L	○	●	6.875-7.875"	3.970
	* S-SPUB-63-M	●	●	7.875" and Up	NONE
	S-SPUB-63-P	○	○		6.000
	S-SPUB-63-S	○	●		0.375
 MT-CVD Coated Carbide					

*Note: This insert has 11° positive clearance all around.

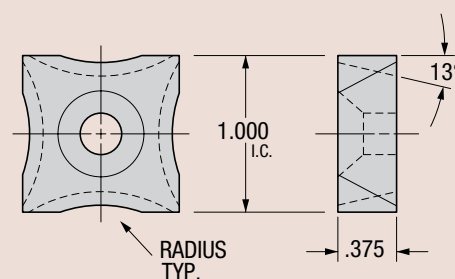


S-SPUB-86

Additional thickness and flank clearance for heavy-wall pipe and pipe diameters over 5" available.

Shape: Scarfing	Product Number			Tube Size	Dimensions (inches)
		GA5023	GA5025		
	S-SPUB-86-B	○	○	Up to .875"	0.475
	S-SPUB-86-C	○	○	.875-1.125"	0.590
	S-SPUB-86-D	○	○	1.125-1.500"	0.785
	S-SPUB-86-E	○	●	1.500-1.875"	0.985
	S-SPUB-86-F	○	●	1.875-2.250"	1.180
	S-SPUB-86-G	○	●	2.250-3.125"	1.575
	S-SPUB-86-H	○	●	3.125-3.875"	1.970
	S-SPUB-86-I	○	●	3.875-4.875"	2.470
	S-SPUB-86-J	○	●	4.875-5.875"	2.970
	S-SPUB-86-K	○	●	5.875-6.875"	3.470
	S-SPUB-86-L	○	●	6.875-7.875"	3.970
	* S-SPUB-86-M	○	●	7.875" and Up	NONE
	S-SPUB-86-N	○	○		5.000
	S-SPUB-86-S	○	○		9.500
	S-SPUB-86-P	○	●		6.250
 MT-CVD Coated Carbide					

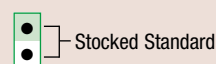
*Note: This insert has 13° positive clearance all around.



*Note: This insert has 13° positive clearance all around.

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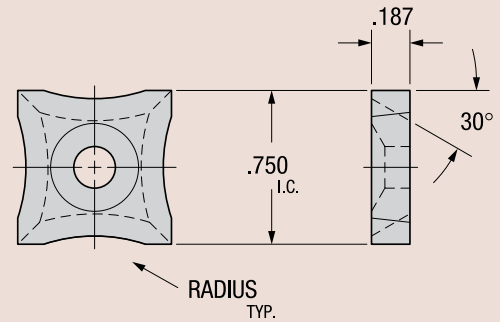
S-SGUB-63

Additional flank clearance for coated tube operations.

Shape: Scarfing	Product Number	GA5025	Tube Size	Dimensions (inches)
	S-SGUB-63-B	●	Up to .875"	0.475
	S-SGUB-63-C	●	0.875-1.125"	0.590
	S-SGUB-63-D	●	1.125-1.500"	0.785
	S-SGUB-63-E	●	1.500-1.875"	0.985
	S-SGUB-63-F	●	1.875-2.250"	1.180
	S-SGUB-63-G	●	2.250-3.125"	1.575
	S-SGUB-63-H	●	3.125-3.875"	1.970
	S-SGUB-63-I	○	3.875-4.875"	2.470
	S-SGUB-63-J	○	4.875-5.875"	2.970
	S-SGUB-63-K	○	5.875-6.875"	3.470
	S-SGUB-63-L	○	6.875-7.875"	3.970
	* S-SGUB-63-M	●	7.875" and Up	NONE
	S-SGUB-63-R	○	1.750" DIA	0.875
	S-SGUB-63-S	○		0.375
	S-SGUB-63-P	○		6.000

 MT-CVD Coated Carbide

*Note: This insert has 30° positive clearance all around.

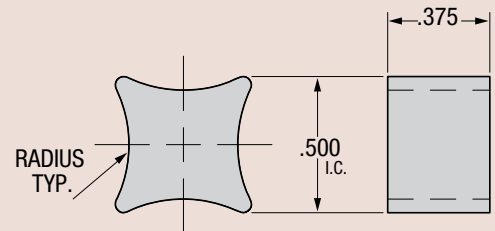


S-SNUN-46

Ceramic-Style Insert

Shape: Scarfing	Product Number	GEM-19	Tube Size	Dimensions (inches)
	S-SNUN-46-B	○	Up to .875"	0.475
	S-SNUN-46-C	○	.875-1.125"	0.590
	S-SNUN-46-D	○	1.125-1.500"	0.785
	S-SNUN-46-E	○	1.500-1.875"	0.985
	S-SNUN-46-F	○	1.875-2.250"	1.180
	S-SNUN-46-G	○	2.250-3.125"	1.575
	S-SNUN-46-H	○	3.125-3.875"	1.970

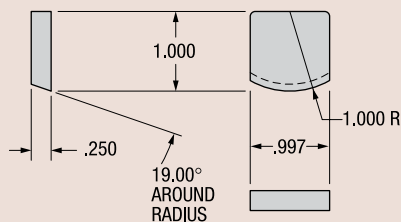
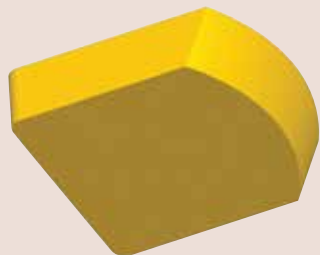
 Al₂O₃





ID Scarfing Insert

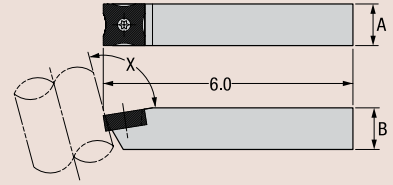
Other sizes available upon request.



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N-SSCPS

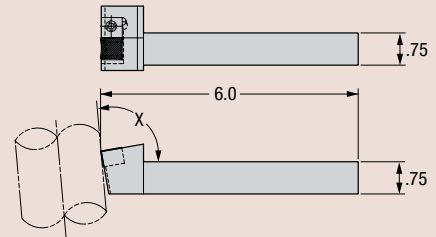


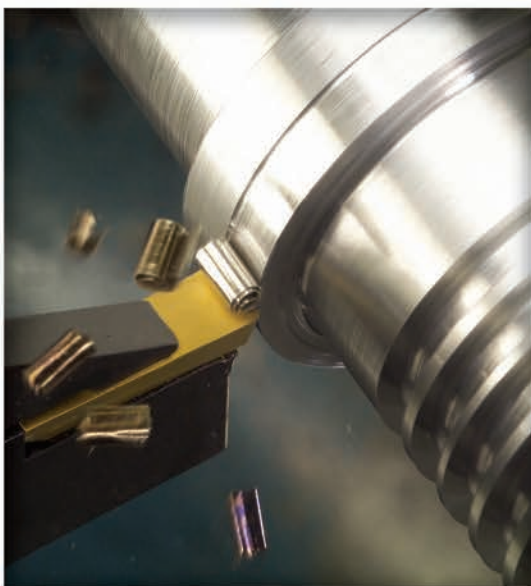
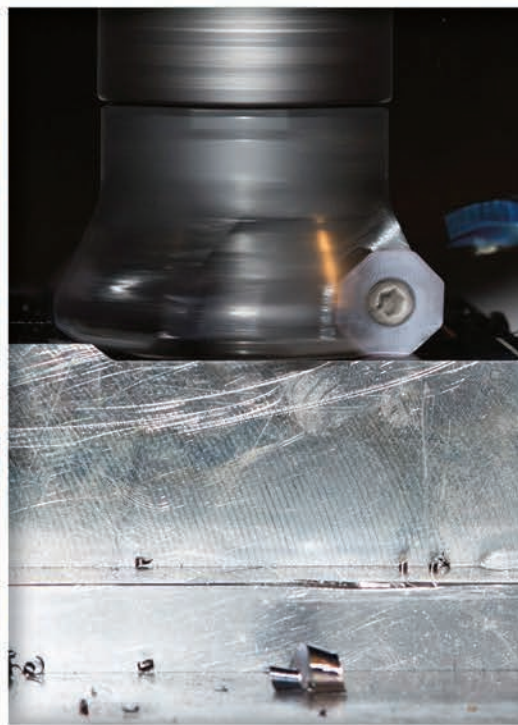
Product Number	Gage 	Stock	Angle X	Dimensions (inches)		Standard Component 	Tune-Up Kit Includes All Standard Components
	Insert			A	B	Insert Screw*	
N-SSCPS-12-90	S-SPUB-63	●	90°	0.75	0.75	10/32 x 1/2 IPFHCS	TK-00576
N-SSCPS-12-95	S-SPUB-63	○	95°	0.75	0.75	10/32 x 1/2 IPFHCS	TK-00576
N-SSCPS-12-100	S-SPUB-63	●	100°	0.75	0.75	10/32 x 1/2 IPFHCS	TK-00576
N-SSCPS-12-105	S-SPUB-63	●	105°	0.75	0.75	10/32 x 1/2 IPFHCS	TK-00576
N-SSCPS-16-8-90	S-SPUB-86	○	90°	1.00	1.00	1/4-20 x 3/4 IPFHCS	TK-00760
N-SSCPS-16-8-95	S-SPUB-86	○	95°	1.00	1.00	1/4-20 x 3/4 IPFHCS	TK-00760
N-SSCPS-16-8-100	S-SPUB-86	○	100°	1.00	1.00	1/4-20 x 3/4 IPFHCS	TK-00760
N-SSCPS-16-8-105	S-SPUB-86	●	105°	1.00	1.00	1/4-20 x 3/4 IPFHCS	TK-00760

N-WSCNN Ceramic Insert Holder



Product Number	Gage 	Stock	Angle X	Standard Components		Tune-Up Kit Includes All Std. Components
	Insert			Wedge 	Wedge Screw 	
N-WSCNN-12-90	S-SNUN-46	○	90°	303996	38309	TK-00577
N-WSCNN-12-95	S-SNUN-46	○	95°	303996	38309	TK-00577
N-WSCNN-12-100	S-SNUN-46	○	100°	303996	38309	TK-00577
N-WSCNN-12-105	S-SNUN-46	○	105°	303996	38309	TK-00577





MADE IN THE USA

Greenleaf Corporation
is ISO 9001 Certified.

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