

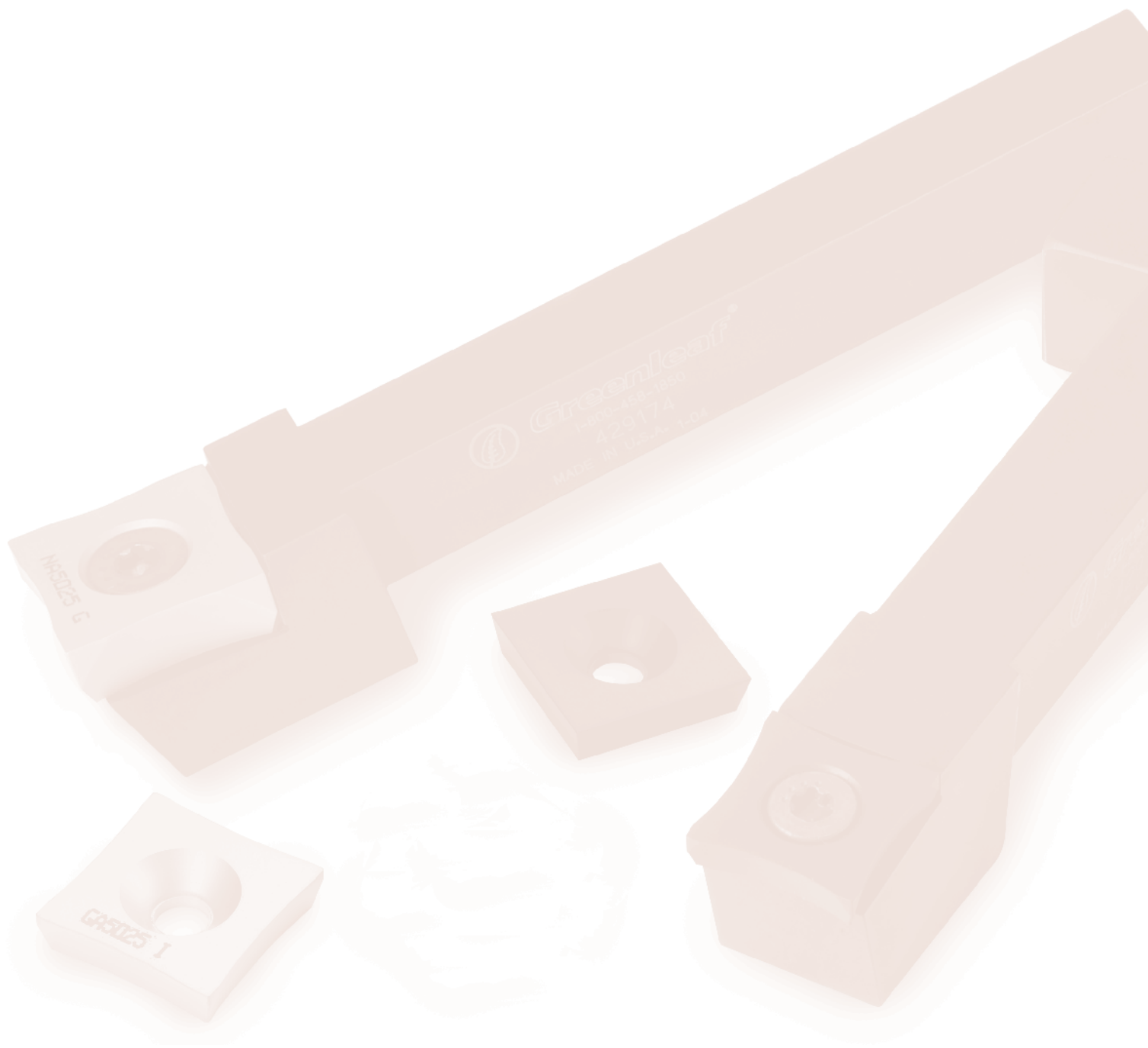


INTRODUCTION	
MILLING	
TURNING AND BORING	
HEAVY TURNING	
GROOVING, PROFILING AND CUT-OFF	
API RING-GROOVE MACHINING	
INDEXABLE DRILLING	
TUBE SCARFING	
SPECIAL ENGINEERING	
APPLICATION and TECHNICAL INFORMATION	

2016 METRIC TUBE SCARFING



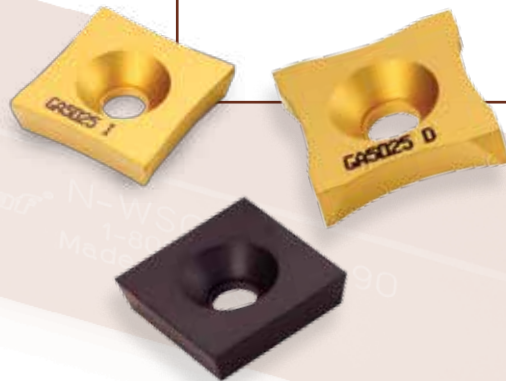
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**Greenleaf Sales**

US +814-763-2915 • sales@greenleafcorporation.com
EU +31-45-404-1774 • eurooffice@greenleafcorporation.com
CN +86-731-89954796 • info@greenleafcorporation.com.cn
www.greenleafglobalsupport.com • www.greenleafcorporation.com

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

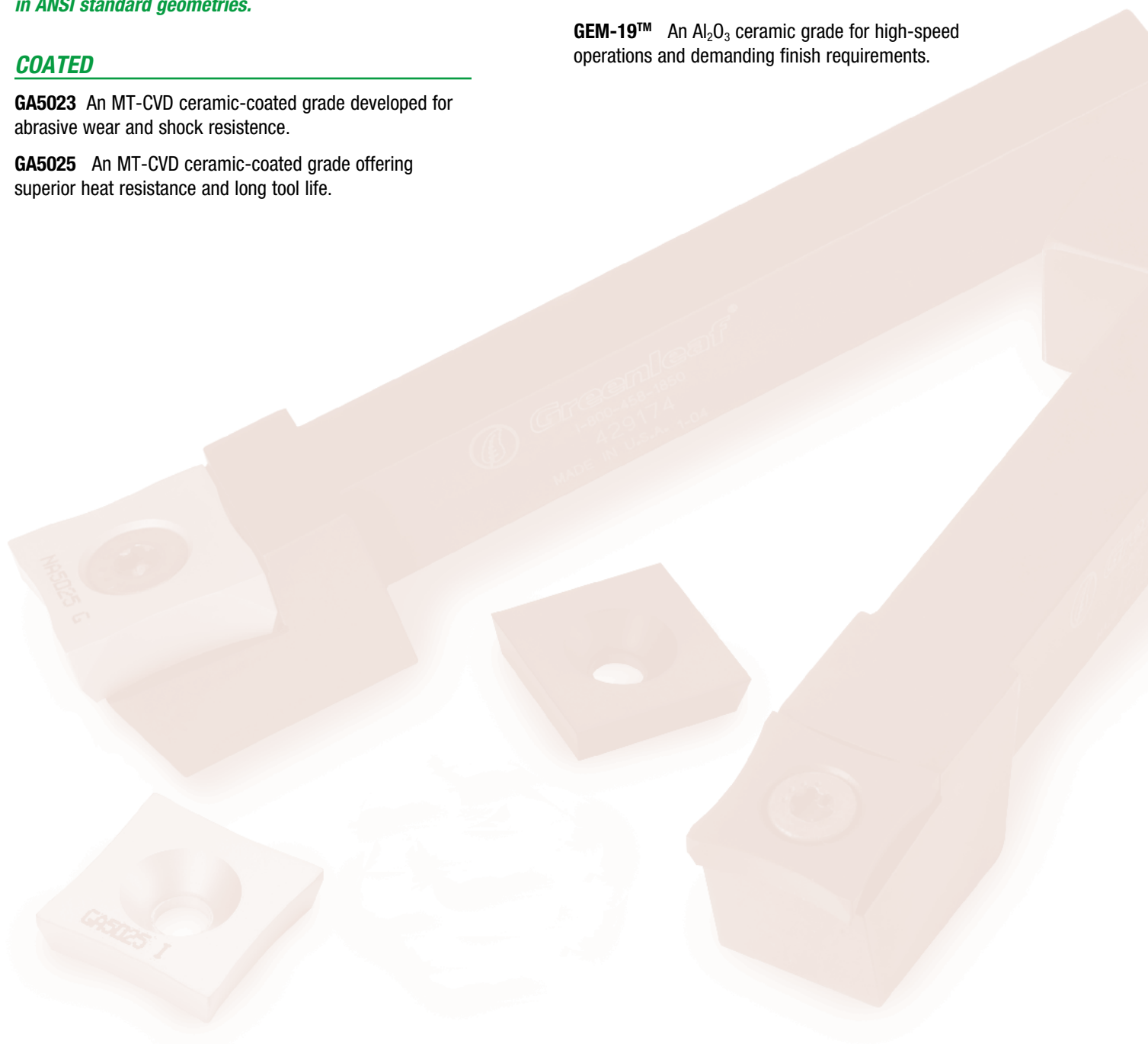
GA5023 An MT-CVD ceramic-coated grade developed for abrasive wear and shock resistance.

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

CERAMIC

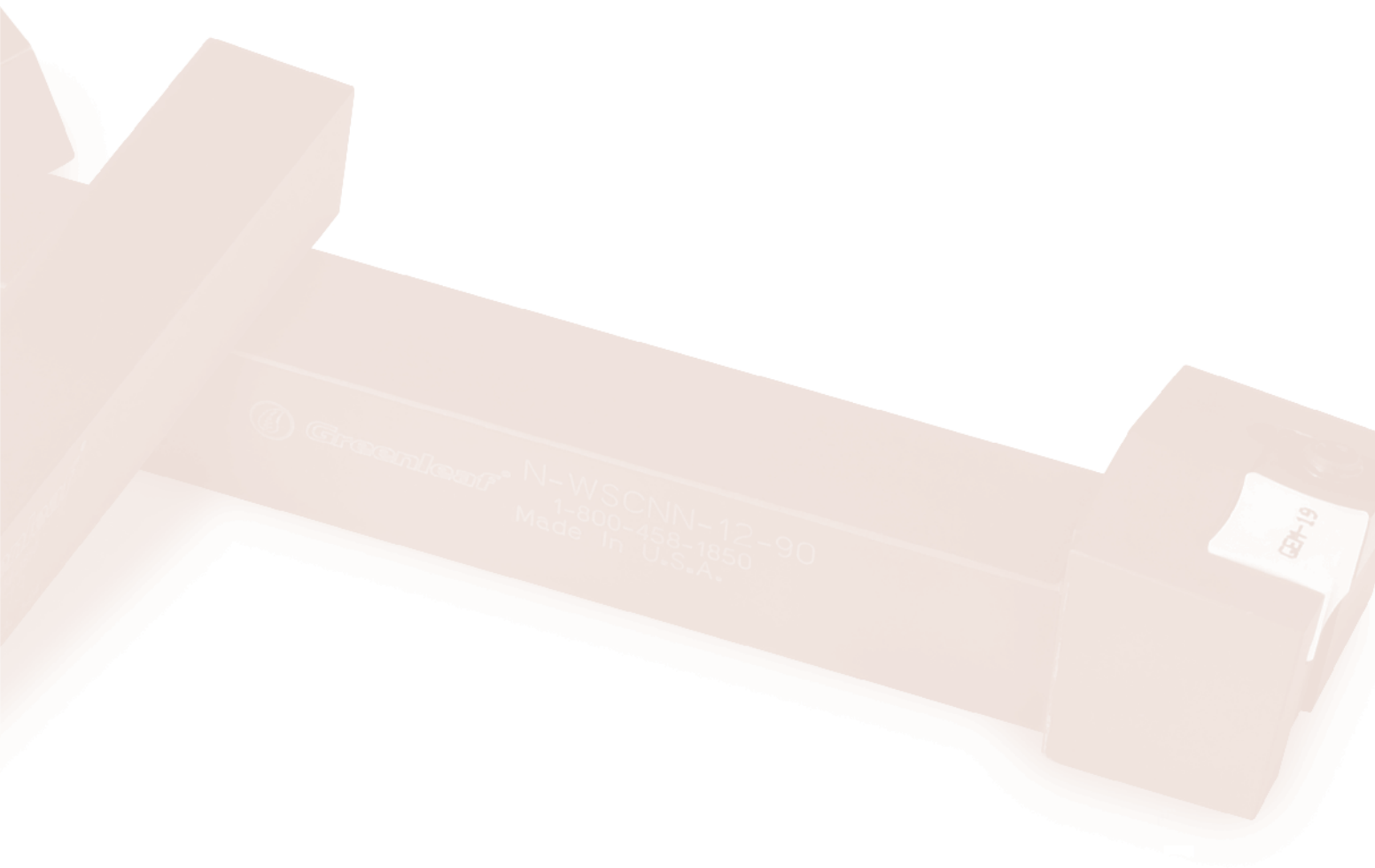
Greenleaf is the industry leader in the development and manufacture of ceramic and coated ceramic inserts in ANSI standard and special geometries. One of the most prominent is:

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



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S-SPUB-63

Shape: Scarfing	Product Number	Tube Size - mm	Dimensions (millimeters)
	S-SPUB-63-B	Up to 22	12
	S-SPUB-63-C	22-28	15
	S-SPUB-63-D	28-38	20
	S-SPUB-63-E	38-47	25
	S-SPUB-63-F	47-57	30
	S-SPUB-63-G	57-79	40
	S-SPUB-63-H	79-98	50
	S-SPUB-63-I	98-123	63
	S-SPUB-63-J	123-149	75
	S-SPUB-63-K	149-174	88
	S-SPUB-63-L	174-200	101
	S-SPUB-63-M	200 and up	NONE
	S-SPUB-63-P		192
	S-SPUB-63-S		5.5

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 127mm available.

Shape: Scarfing	Product Number	Tube Size - mm	Dimensions (millimeters)
	S-SPUB-86-B	Up to 22	12
	S-SPUB-86-C	22-28	15
	S-SPUB-86-D	28-38	20
	S-SPUB-86-E	38-47	25
	S-SPUB-86-F	47-57	30
	S-SPUB-86-G	57-79	40
	S-SPUB-86-H	79-98	50
	S-SPUB-86-I	98-123	63
	S-SPUB-86-J	123-149	75
	S-SPUB-86-K	149-174	88
	S-SPUB-86-L	174-200	101
	S-SPUB-86-M	200 and up	NONE
	S-SPUB-86-N		127
	S-SPUB-86-S		241
	S-SPUB-86-P		158

MT-CVD Coated Carbide

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

S-SGUB-63

Additional flank clearance for coated tube operations.

Shape: Scarfing	Product Number	Tube Size - mm	Dimensions (millimeters)
	S-SGUB-63-B	Up to 22	12
	S-SGUB-63-C	22-28	15
	S-SGUB-63-D	28-38	20
	S-SGUB-63-E	38-47	25
	S-SGUB-63-F	47-57	30
	S-SGUB-63-G	57-79	40
	S-SGUB-63-H	79-98	50
	S-SGUB-63-I	98-123	63
	S-SGUB-63-J	123-149	75
	S-SGUB-63-K	149-174	88
	S-SGUB-63-L	174-200	101
	S-SGUB-63-M	200 and up	NONE
	S-SGUB-63-N		22
	S-SGUB-63-S		9.6
	S-SGUB-63-P		152

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	Dimensions (millimeters)
	S-SNUN-46-B	Up to 22	12
	S-SNUN-46-C	22-28	15
	S-SNUN-46-D	28-38	20
	S-SNUN-46-E	38-47	25
	S-SNUN-46-F	47-57	30
	S-SNUN-46-G	57-79	40
	S-SNUN-46-H	79-98	50

Stacked or Available Upon Request

Stocking Status

☒ Stacked Standard
 ☐ Stacked or Available Upon Request

Insert Radius

☒ Stacked Standard
 ☐ Stacked or Available Upon Request

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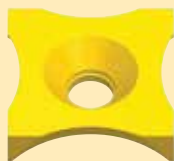
Inserts



S-SPUB-63
page: TS 08



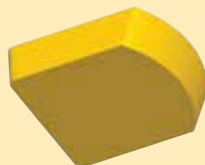
S-SPUB-86
page: TS 08



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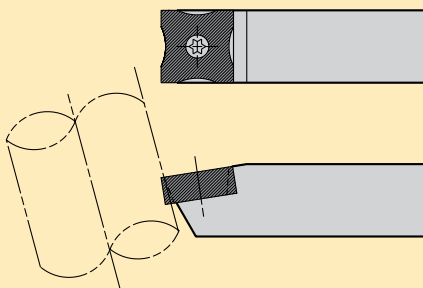
S-SNUN-46
page: TS 09



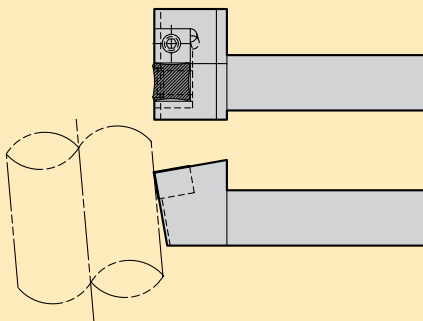
ID Scarfing
Insert
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Toolholders

M-SSCPS
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M-WSCNN
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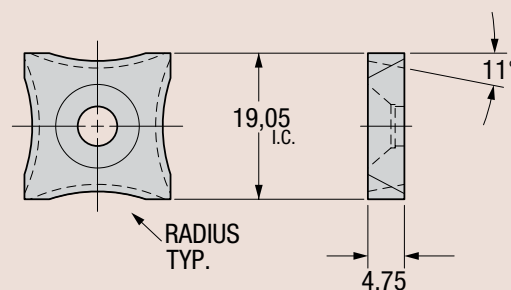




S-SPUB-63

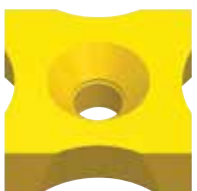
Shape: Scarfing	Product Number	GA5023	GA5025	Tube Size – mm	Dimensions (millimeters) Radius
	S-SPUB-63-B	○	●	Up to 22	12
	S-SPUB-63-C	○	●	22–28	15
	S-SPUB-63-D	●	●	28–38	20
	S-SPUB-63-R	○	○	44	22
	S-SPUB-63-E	●	●	38–47	25
	S-SPUB-63-F	●	●	47–57	30
	S-SPUB-63-G	●	●	57–79	40
	S-SPUB-63-H	●	●	79–98	50
	S-SPUB-63-I	●	●	98–123	63
	S-SPUB-63-J	●	●	123–149	75
	S-SPUB-63-K	○	●	149–174	88
	S-SPUB-63-L	○	●	174–200	101
	* S-SPUB-63-M	●	●	200 and Up	NONE
	S-SPUB-63-P	○	○		152
	S-SPUB-63-S	○	●		9,5
 MT-CVD Coated Carbide					

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

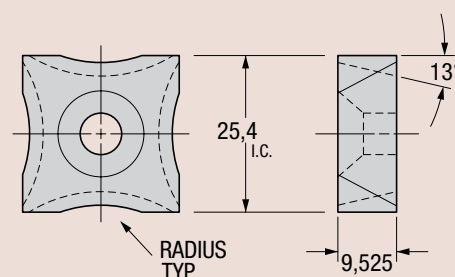


S-SPUB-86

Additional thickness and flank clearance for heavy-wall pipe and pipe diameters over 127mm available.

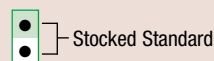
Shape: Scarfing	Product Number	GA5023	GA5025	Tube Size – mm	Dimensions (millimeters) Radius
	S-SPUB-86-B	○	○	Up to 22	12
	S-SPUB-86-C	○	○	22–28	15
	S-SPUB-86-D	○	○	28–38	20
	S-SPUB-86-E	○	●	38–47	25
	S-SPUB-86-F	○	●	47–57	30
	S-SPUB-86-G	○	●	57–79	40
	S-SPUB-86-H	○	●	79–98	50
	S-SPUB-86-I	○	●	98–123	63
	S-SPUB-86-J	○	●	123–149	75
	S-SPUB-86-K	○	●	149–174	88
	S-SPUB-86-L	○	●	174–200	101
	* S-SPUB-86-M	○	●	200 and Up	NONE
	S-SPUB-86-N	○	○		127
	S-SPUB-86-S	○	○		241
	S-SPUB-86-P	○	●		158
 MT-CVD Coated Carbide					

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



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S-SGUB-63

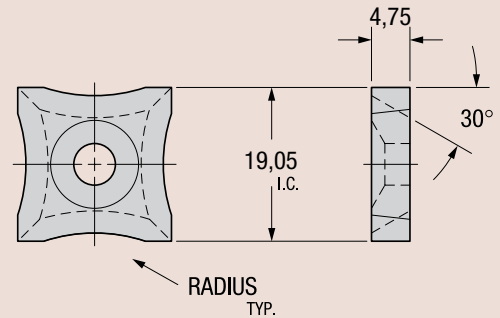
Additional flank clearance for coated tube operations.

Shape: Scarfing	Product Number	GA5025	Tube Size – mm	Dimensions (millimeters) Radius
	S-SGUB-63-B	●	Up to 22	12
	S-SGUB-63-C	●	22–28	15
	S-SGUB-63-D	●	28–38	20
	S-SGUB-63-E	●	38–47	25
	S-SGUB-63-F	●	47–57	30
	S-SGUB-63-G	●	57–79	40
	S-SGUB-63-H	●	79–98	50
	S-SGUB-63-I	○	98–123	63
	S-SGUB-63-J	○	123–149	75
	S-SGUB-63-K	○	149–174	88
	S-SGUB-63-L	○	174–200	101
	* S-SGUB-63-M	●	200 and Up	NONE
	S-SGUB-63-R	○	44	22
	S-SGUB-63-S	○		9,5
	S-SGUB-63-P	○		152



MT-CVD Coated Carbide

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



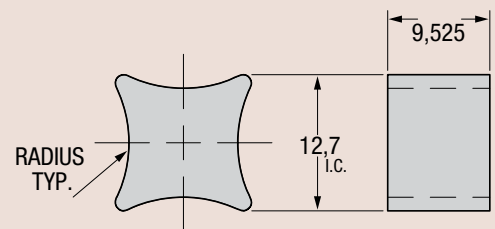
S-SNUN-46

Ceramic-Style Insert

Shape: Scarfing	Product Number	GEM-19	Tube Size	Dimensions (millimeters) Radius
	S-SNUN-46-B	○	Up to 22	12
	S-SNUN-46-C	○	22–28	15
	S-SNUN-46-D	○	28–38	20
	S-SNUN-46-E	○	38–47	25
	S-SNUN-46-F	○	47–57	30
	S-SNUN-46-G	○	57–79	40
	S-SNUN-46-H	○	79–98	50



Al₂O₃



Stocked
or Available
Upon Request



Stocked Standard

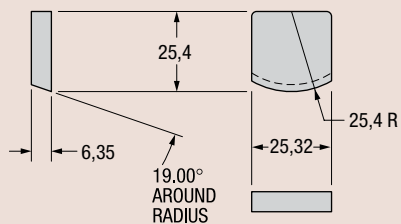
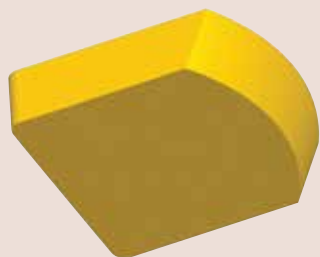


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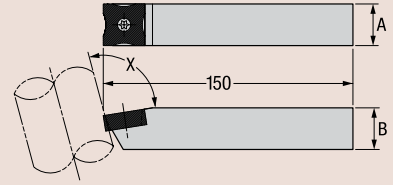


ID Scarfing Insert

Other sizes available upon request.



M-SSCPS

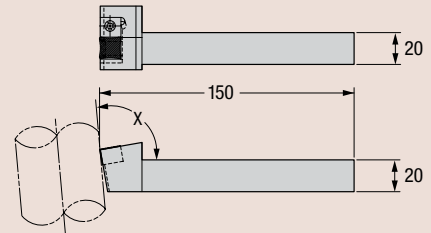


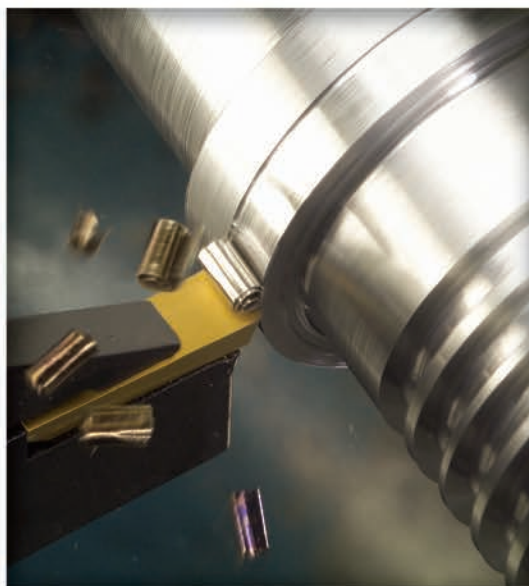
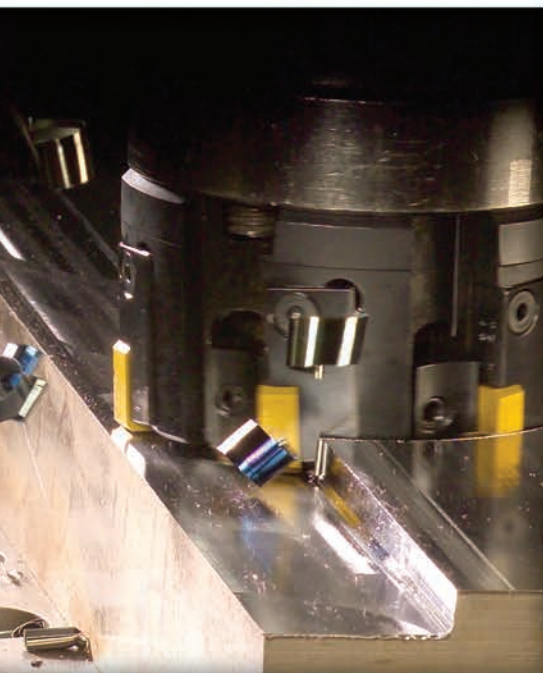
Product Number	Gage Insert	Stock	Angle X	Dimensions (mms)		Standard Component Insert Screw	Tune-Up Kit Includes All Standard Components
				A	B		
M-SSCPS-2090	S-SPUB-63	●	90°	20	20	TORX SCREW #10-32 x 1/2 TFHCS	TK-00576
M-SSCPS-2095	S-SPUB-63	○	95°	20	20	TORX SCREW #10-32 x 1/2 TFHCS	TK-00576
M-SSCPS-20100	S-SPUB-63	●	100°	20	20	TORX SCREW #10-32 x 1/2 TFHCS	TK-00576
M-SSCPS-20105	S-SPUB-63	●	105°	20	20	TORX SCREW #10-32 x 1/2 TFHCS	TK-00576
M-SSCPS-2590	S-SPUB-86	○	90°	25	25	TORX SCREW 1/4-20 x 3/4 TFHCS	TK-00760
M-SSCPS-2595	S-SPUB-86	○	95°	25	25	TORX SCREW 1/4-20 x 3/4 TFHCS	TK-00760
M-SSCPS-25100	S-SPUB-86	○	100°	25	25	TORX SCREW 1/4-20 x 3/4 TFHCS	TK-00760
M-SSCPS-25105	S-SPUB-86	●	105°	25	25	TORX SCREW 1/4-20 x 3/4 TFHCS	TK-00760

M-WSCNN Ceramic Insert Holder



Product Number	Gage Insert	Stock	Angle X	Standard Components		Tune-Up Kit Includes All Std. Components
				Wedge	Wedge Screw	
M-WSCNN-2090	S-SNUN-46	○	90°	313393	STCM-11	TK-02624
M-WSCNN-2095	S-SNUN-46	○	95°	313393	STCM-11	TK-02624
M-WSCNN-20100	S-SNUN-46	○	100°	313393	STCM-11	TK-02624
M-WSCNN-20105	S-SNUN-46	○	105°	313393	STCM-11	TK-02624





MADE IN THE USA

Greenleaf Corporation
is ISO 9001 Certified.

GREENLEAF CORPORATION

18695 Greenleaf Drive
PO Box 1040
Saegertown, PA 16433 USA
US Phone: +1-814-763-2915
sales@greenleafcorporation.com

GREENLEAF EUROPE BV

De Steeg 2
6333 AP Schimmert
The Netherlands
EU Phone: +31-45-404-1774
eurooffice@greenleafcorporation.com

GREENLEAF (HUNAN) HIGH-TECH MATERIALS CO., LTD.

6F, Building C1, Lu Gu Com-Park
No. 27 Wenxuan Road
High-Tech Zone
Changsha, Hunan 410205
China
CN Phone: +86-731-89954796
info@greenleafcorporation.com.cn