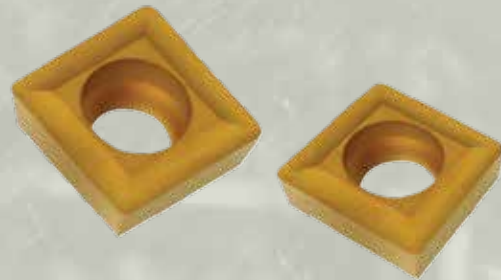


Indexable Drilling

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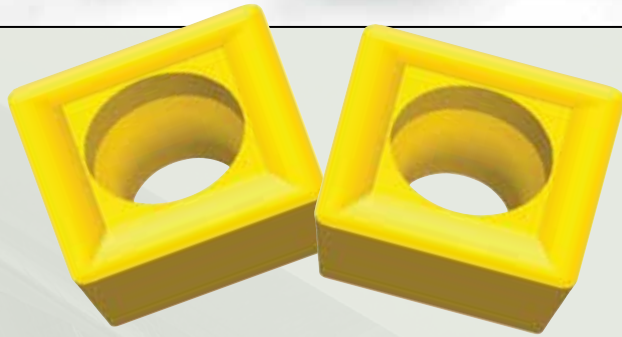




INDEXABLE DRILLING

Indexable Drilling

The Holemill™ is an indexable drill utilizing Greenleaf's advanced coated-carbide grades for higher speeds, quieter cutting, longer tool life and reduced horsepower consumption. Inserts are positive squares (SPMT) for four indexes per insert. The Holemill is available in 1" to 3" diameters in 1/8" increments.



Insert Grades

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 with multi-purpose chipbreakers for heavy roughing through finishing.

PVD Coated

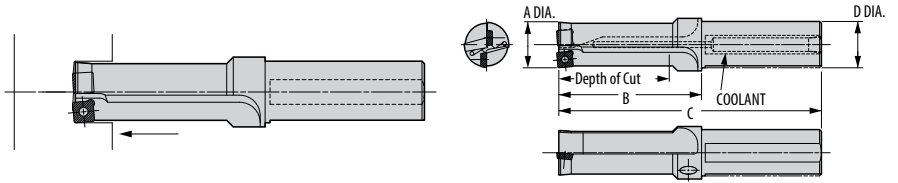
G-915



A multi-layer PVD-coated grade, G-915 is excellent for heat-resistant alloys, stainless steels, and low-carbon steels. The multi-layer PVD coating adds heat and abrasion resistance to the tough, impact-resistant substrate. G-915 should be used at moderate speeds and moderate to high feeds.

G-935

G-935 is a multi-layer PVD-coated grade for applications requiring additional resistance to mechanical and thermal shock. The multilayered PVD coating raises the speed envelope and wear resistance, particularly in indexable drilling.

Holemill™ System

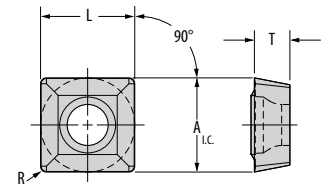



Part Number	Gage				Dimensions (inches)					Standard Components	*Tune-Up Kit
	 Insert Inboard	Qty	 Insert Outboard	Qty	A	Depth of Cut	B	C	D		
HM3X-094	SPMT-2.522-X2	1	SPMT-2.522-X2	1	0.937	3.000	4.130	8.000	1.250	PT-543-T	TK-00737
HM3X-100	SPMT-2.522-X2	1	SPMT-2.522-X2	1	1.000	3.000	4.130	8.000	1.250	PT-543-T	TK-00737
HM3X-112	SPMT-2.522-X2	1	SPMT-32.52-X2	1	1.125	3.375	4.380	8.250	1.250	PT-543-T & PT559-T	TK-02619
HM3X-125	SPMT-32.52-X2	1	SPMT-32.52-X2	1	1.250	3.750	4.880	8.750	1.250	PT-559-T	TK-00738
HM3X-138	SPMT-432-X2	1	SPMT-32.52-X2	1	1.375	4.500	5.880	9.750	1.500	PT-588-T & PT-559-T	TK-00936
HM3X-150	SPMT-432-X2	1	SPMT-432-X2	1	1.500	4.500	5.880	9.750	1.500	PT-588-T	TK-00739
HM3X-162	SPMT-432-X2	1	SPMT-432-X2	1	1.625	5.250	6.630	10.500	1.500	PT-588-T	TK-00739
HM3X-175	SPMT-432-X2	1	SPMT-432-X2	1	1.750	5.250	6.630	10.500	1.500	PT-588-T	TK-00739
HM3X-188	SPMT-32.52-X2	1	SPMT-32.52-X2	2	1.875	6.000	7.580	11.500	2.000	PT-559-T	TK-00734
HM3X-200	SPMT-32.52-X2	1	SPMT-432-X2	2	2.000	6.000	7.620	11.500	2.000	PT-588-T & PT-544-T	TK-01961
HM3X-225	SPMT-32.52-X2	1	SPMT-432-X2	2	2.250	6.750	8.380	12.250	2.000	PT-588-T & PT-544-T	TK-01961
HM3X-238	SPMT-432-X2	1	SPMT-432-X2	2	2.375	7.500	9.130	13.000	2.000	PT-588-T	TK-00751
HM3X-250	SPMT-432-X2	1	SPMT-432-X2	2	2.500	7.500	9.130	13.000	2.000	PT-588-T	TK-00751
HM3X-275	SPMT-32.52-X2	2	SPMT-432-X2	2	2.750	8.250	9.880	13.750	2.000	PT-588-T & PT-544-T	TK-02353
HM3X-288	SPMT-432-X2	2	SPMT-432-X2	2	2.875	9.000	10.630	14.500	2.000	PT-588-T	TK-00752
HM3X-300	SPMT-432-X2	2	SPMT-432-X2	2	3.000	9.000	10.630	14.500	2.000	PT-588-T	TK-00752

* Tune-Up Kits include one complete set of standard components to allow you to refurbish the Holemill.

Holemill™ Inserts

SPMT-X2



Inserts	Part Number ANSI	Insert Position	Steel		Stainless Steel		Cast Iron		Heat-Resistant Super Alloys		Part Number ISO	Dimensions (inches)			
			P		M		K		S			A	L	T	R
			G-935	G-915	G-915	G-935	G-915	G-935	G-935	G-915					
	SPMT-2.522-X2	Inboard	◆	●	◆	●	◆	●	◆	●	SPMT-070308-X2	0.312	0.312	0.125	0.031
	SPMT-2.522-X2	Outboard	●	◆	●	◆	●	◆	●	◆	SPMT-070308-X2	0.312	0.312	0.125	0.031
	SPMT-32.52-X2	Inboard	◆	●	◆	●	◆	●	◆	●	SPMT-09T308-X2	0.375	0.375	0.156	0.031
	SPMT-32.52-X2	Outboard	●	◆	●	◆	●	◆	●	◆	SPMT-09T308-X2	0.375	0.375	0.156	0.031
	SPMT-432-X2	Inboard	◆	●	◆	●	◆	●	◆	●	SPMT-120408-X2	0.500	0.500	0.187	0.031
	SPMT-432-X2	Outboard	●	◆	●	◆	●	◆	●	◆	SPMT-120408-X2	0.500	0.500	0.187	0.031

CARBIDE COATINGS: MF-CVD Coated PVD Coated Uncoated
 CERAMIC CLASSIFICATION: Whisker Ceramic Phase-Toughened Silicon Nitride Alumina TiC
 First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ✦ Grade descriptions — pages ID 7

INDEXABLE DRILLING

Feed and Speed for Greenleaf Holemill™

Material	Hardness (HRC)	SFM	Feed Rate (IPR)	
			1–1.75" Dia.	1.75–3" Dia.
Low Carbon Steel / Free Machining 1010, 1018, 12L14	up to 25	450-1000	.004-.008	.005-.010
High Carbon Steel 1080, 1541, Nitralloy, 52100	25-40	200-600	.004-.008	.005-.010
Alloy Steel 4140, 4340, 6150, 8620	15-30	400-900	.004-.008	.005-.010
Tool Steel A-6, D-2, P-20, H-13	up to 30	250-600	.004-.008	.005-.010
High-Temp Alloys Inconel, Hastelloy, Waspaloy, Stellite	up to 45	90-225	.003-.005	.003-.005
Stainless Steel 304, 316, 17-4PH	up to 32	250-550	.003-.007	.004-.008

Greenleaf Holemill™ Operational Information

For best results in static drilling, set up the Greenleaf Holemill with the drill in the turret in an attitude that puts the inserts parallel to the ways of the machine with the inboard insert located toward the operator as shown.

