Tube Scarfing

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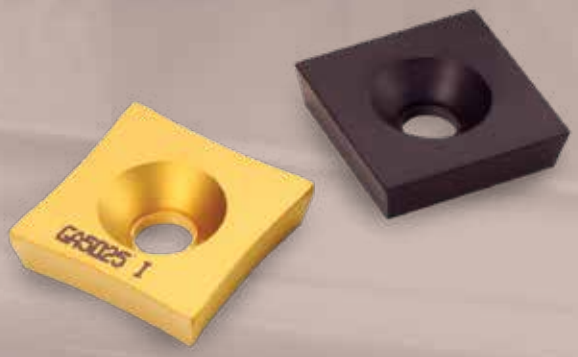

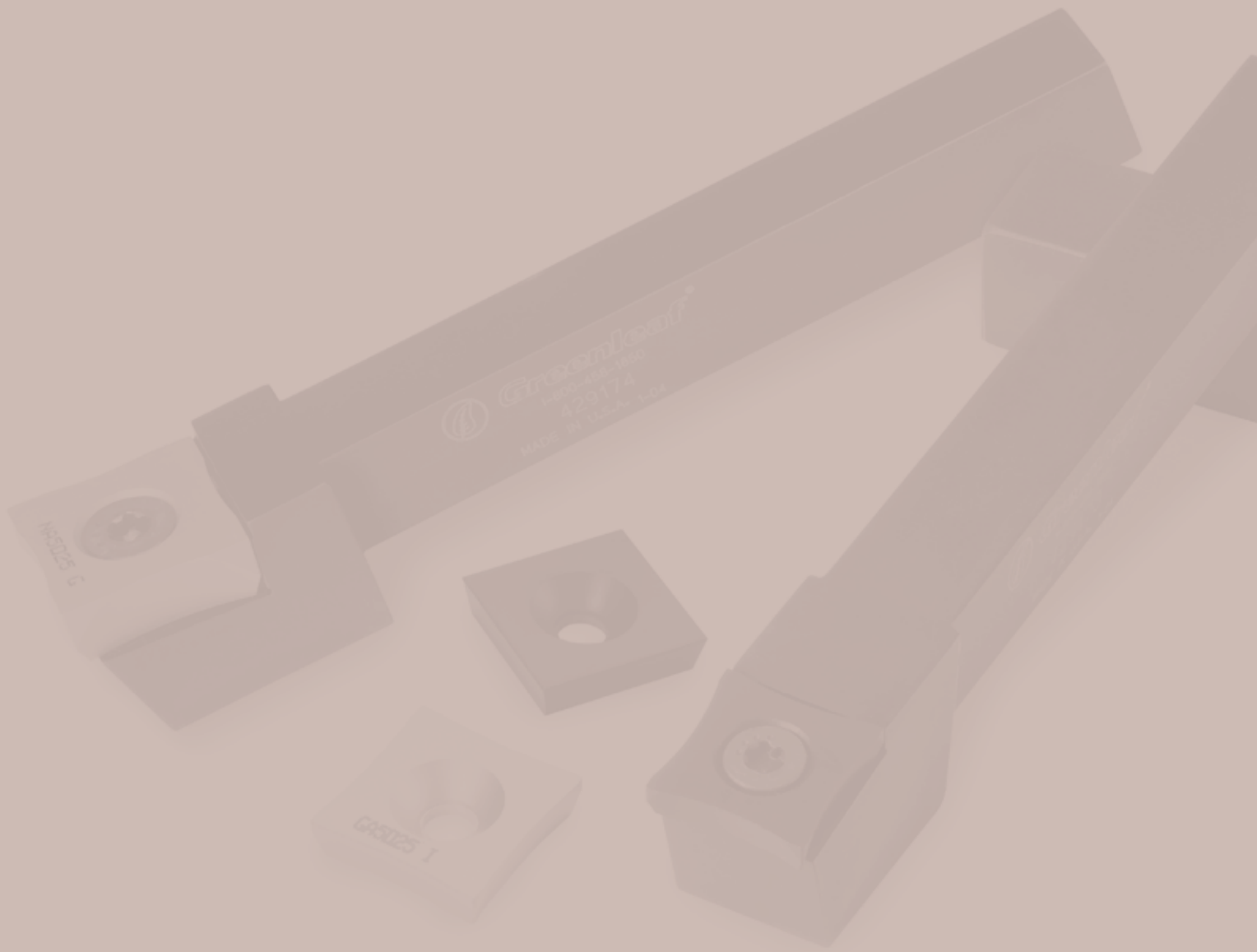

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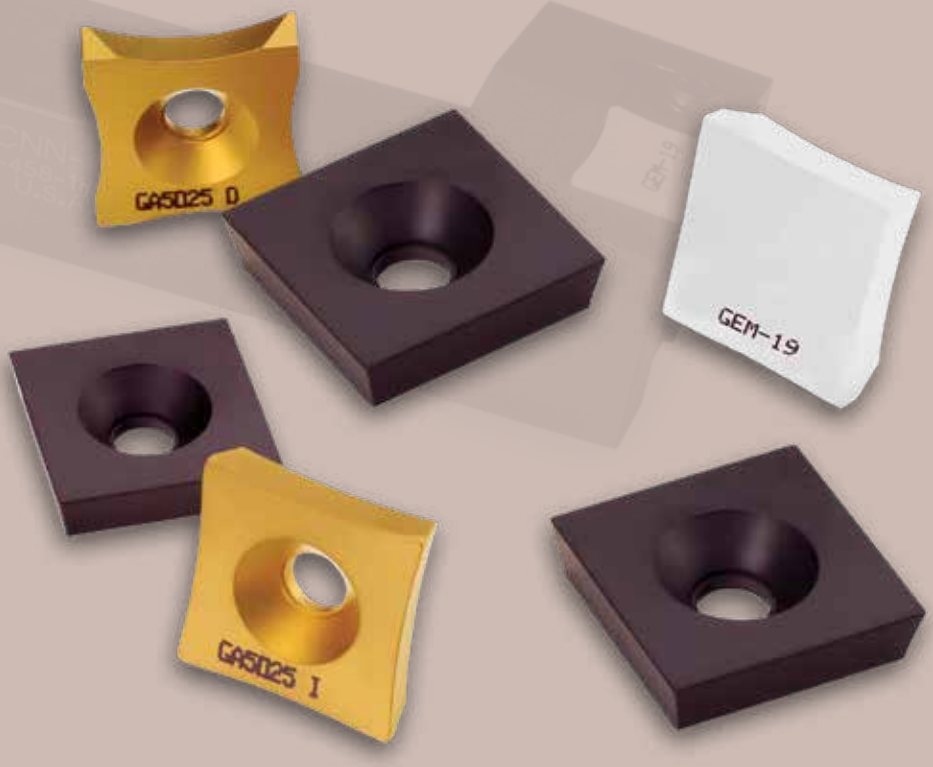
Tube Scarfing

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 Tune-Up Kits

A Tune-Up Kit consists of all the standard hardware to refurbish a particular toolholder, boring bar, or milling cutter. A toolholder will have a readily visible, laser-inscribed Tune-Up Kit number on it for ease in ordering. This number will prevent any confusion created by searching a catalog for hardware, and it will help reduce downtime.



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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.

GA5023

A combination of an advanced MT-CVD coating and medium-grain substrate makes GA5023 an excellent choice for tube scarfing applications where toughness and abrasive wear resistance are required. The GA5023 grade is a tougher alternative option to GA5025 for any tube scarfing application.

GA5025

Primarily developed for high-speed steel turning, GA5025 also excels as a grade for tube scarfing applications thanks to its thick MT-CVD coating and hard, heat-resistant substrate. GA5025 is a great first choice when tool life and superior heat resistance are top priorities.

Ceramic

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

GEM-19™

A cold-pressed and sintered Al_2O_3 ceramic, GEM-19™ provides an economical tube scarfing solution for high-speed operations with demanding finish requirements.

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Pictorial & Reference Index

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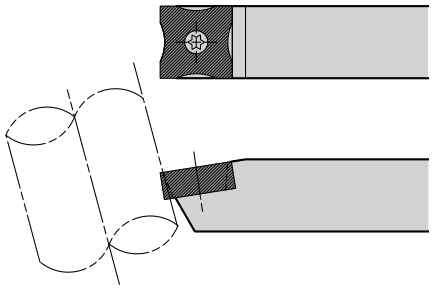

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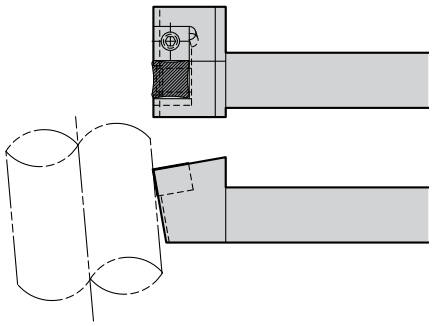

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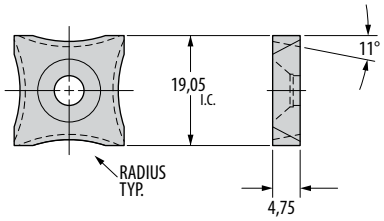
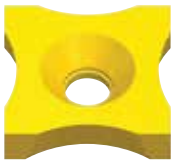
S-SPUB-63



Shape: Scarfing	Part Number	GA5023	GA5025	Dimensions (mm)	
				Tube Size	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

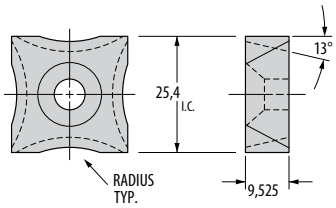
CARBIDE COATINGS: MT-CVD Coated | PVD Coated | Uncoated — First Choice ◆ Second Choice ● Alternative ▲ — *Grade descriptions — pages TS 04*

CERAMIC CLASSIFICATION: Whisker Ceramic | Phase-Toughened | Silicon Nitride | Alumina TiC | Alumina

Note: Applicable for thin-wall pipe up to 6,35mm thick

** 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 are available.

Shape: Scarfing	Part Number	GA5023	GA5025	Dimensions (mm)	
				Tube Size	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

CARBIDE COATINGS: MT-CVD Coated | PVD Coated | Uncoated — First Choice ◆ Second Choice ● Alternative ▲ — *Grade descriptions — pages TS 04*

CERAMIC CLASSIFICATION: Whisker Ceramic | Phase-Toughened | Silicon Nitride | Alumina TiC | Alumina

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

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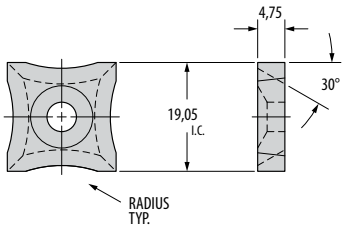
S-SGUB-63



Additional flank clearance for coated tube operations.

Shape: Scarfing	Part Number	GA5025	Dimensions (mm)	
			Tube Size	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

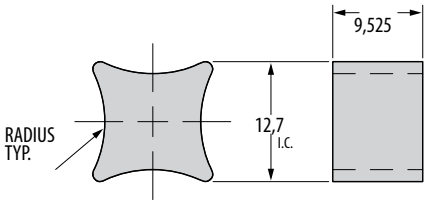
CARBIDE COATINGS: MT-CVD Coated | PVD Coated | Uncoated — First Choice ◆ Second Choice ● Alternative ▲ — *Grade descriptions — pages TS 04*

CERAMIC CLASSIFICATION: Whisker Ceramic | Phase-Toughened | Silicon Nitride | Alumina TiC | Alumina

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

S-SNUN-46

Ceramic-Style Insert



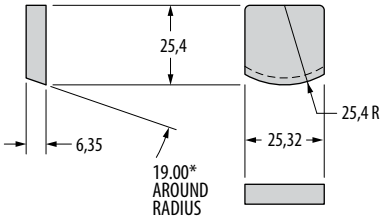
Shape: Scarfing	Part Number	GEM-19	Dimensions (mm)	
			Tube Size	Radius
	S-SNUN-46-B	◆	Up to 22	12
	S-SNUN-46-C	◆	22-28	15
	S-SNUN-46-D	◆	28-38	20
	S-SNUN-46-E	◆	38-47	25
	S-SNUN-46-F	◆	47-57	30
	S-SNUN-46-G	◆	57-79	40
	S-SNUN-46-H	◆	79-98	50

CARBIDE COATINGS: MT-CVD Coated | PVD Coated | Uncoated — First Choice ◆ Second Choice ● Alternative ▲ — *Grade descriptions — pages TS 04*

CERAMIC CLASSIFICATION: Whisker Ceramic | Phase-Toughened | Silicon Nitride | Alumina TiC | Alumina

ID Scarfing Insert

Other sizes available upon request.



NOTE: This illustration is for reference only

Greenleaf ID tube scarfing inserts are specially designed and manufactured to meet specific customer requirements for various tube scarfing applications.

For more information on Greenleaf's ID tube scarfing capabilities, please contact Greenleaf Technical Service at ***800-763-1820*** or ***techteam@greenleafcorporation.com.***

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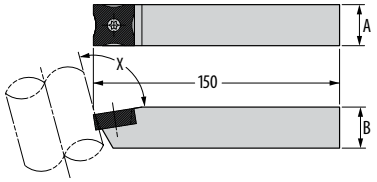
M-SSCPS

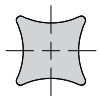


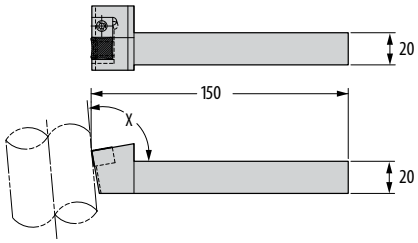
Part Number	Gage Insert	Angle X	Dimensions (inches) A	Dimensions (inches) B	Standard Component Insert Screw	Tune-Up Kit* Includes All Standard Components
M-SSCPS-2090	S-SPUB-63	90°	20	20	TORX SCREW #10-32 x 1/2 TFHCS	TK-00576
M-SSCPS-2095	S-SPUB-63	95°	20	20	TORX SCREW #10-32 x 1/2 TFHCS	TK-00576
M-SSCPS-20100	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

** Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.*

M-WSCNN

Ceramic Insert Holder

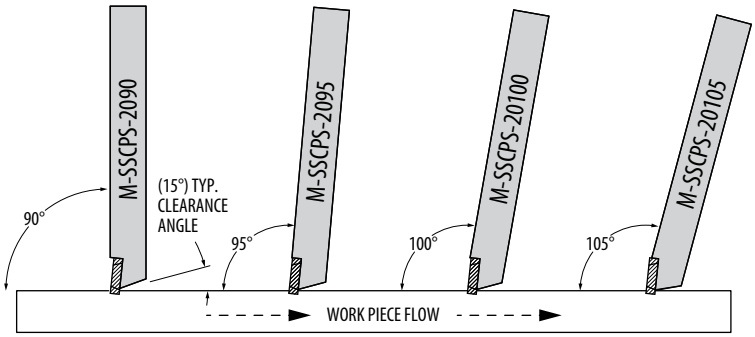




Part Number	Gage Insert	Angle X	Standard Component Wedge	Standard Component Wedge Screw	Tune-Up Kit* Includes All Standard Components
M-WSCNN-2090	S-SNUN-46	90°	313393	STCM-11	TK-02624
M-WSCNN-2095	S-SNUN-46	95°	313393	STCM-11	TK-02624
M-WSCNN-20100	S-SNUN-46	100°	313393	STCM-11	TK-02624
M-WSCNN-20105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

** Tune-Up Kits include one complete set of Standard Components to allow you to refurbish the toolholder.*

Tool Holder Selection Guide



Notes:

1. *The tool holder angle (Angle X) should match the angle of the tube mill tool post.*
2. *The correct setup will allow for 15° of clearance between the tool holder body, and the top of the tube.*