

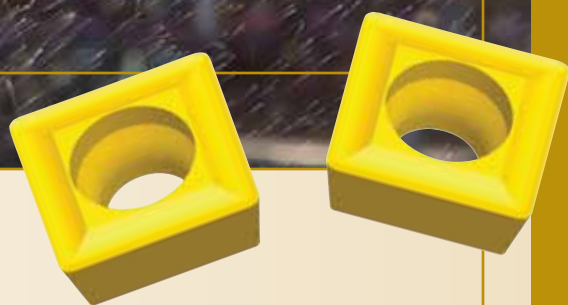


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2016

INDEXABLE DRILLING



Holemill™ Drilling System ID 04

Technical Data ID 05



Greenleaf Sales

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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.



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

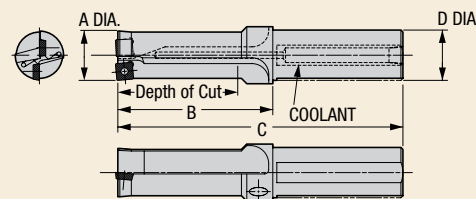
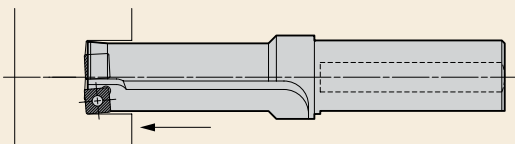
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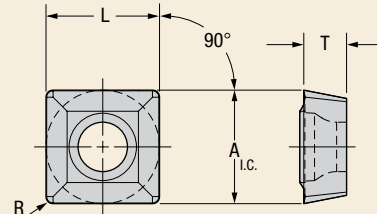
Holemill™ System



Part Number	Stock	Gage				Dimensions (inches)					Standard Components	* Tune-Up Kit
		Insert Inboard	Qty	Insert Outboard	Qty	A	Depth of Cut	B	C	D	Insert Screw	Includes All Standard Components
HM3X-094	○	SPMT-2.522-X2	1	SPMT-2.522-X2	1	0.937	3.000	4.130	8.00	1.25	PT-543-T	TK-00737
HM3X-100	○	SPMT-2.522-X2	1	SPMT-2.522-X2	1	1.000	3.000	4.130	8.00	1.25	PT-543-T	TK-00737
HM3X-112	○	SPMT-2.522-X2	1	SPMT-32.52-X2	1	1.125	3.375	4.380	8.25	1.25	PT-543-T & PT-559-T	TK-02619
HM3X-125	○	SPMT-32.52-X2	1	SPMT-32.52-X2	1	1.250	3.750	4.880	8.75	1.25	PT-559-T	TK-00738
HM3X-138	○	SPMT-432-X2	1	SPMT-32.52-X2	1	1.375	4.500	5.880	9.75	1.50	PT-588-T & PT-559-T	TK-00936
HM3X-150	○	SPMT-432-X2	1	SPMT-432-X2	1	1.500	4.500	5.880	9.75	1.50	PT-588-T	TK-00739
HM3X-162	○	SPMT-432-X2	1	SPMT-432-X2	1	1.625	5.250	6.630	10.50	1.50	PT-588-T	TK-00739
HM3X-175	○	SPMT-432-X2	1	SPMT-432-X2	1	1.750	5.250	6.630	10.50	1.50	PT-588-T	TK-00739
HM3X-188	○	SPMT-32.52-X2	1	SPMT-32.52-X2	2	1.875	6.000	7.580	11.50	2.00	PT-559-T	TK-00734
HM3X-200	○	SPMT-32.52-X2	1	SPMT-432-X2	2	2.000	6.000	7.620	11.50	2.00	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	12.25	2.00	PT-588-T & PT-544-T	TK-01961
HM3X-238	○	SPMT-432-X2	1	SPMT-432-X2	2	2.375	7.500	9.130	13.00	2.00	PT-588-T	TK-00751
HM3X-250	○	SPMT-432-X2	1	SPMT-432-X2	2	2.500	7.500	9.130	13.00	2.00	PT-588-T	TK-00751
HM3X-275	○	SPMT-32.52-X2	2	SPMT-432-X2	2	2.750	8.250	9.880	13.75	2.00	PT-588-T & PT-544-T	TK-02353
HM3X-288	○	SPMT-432-X2	2	SPMT-432-X2	2	2.875	9.000	10.630	14.50	2.00	PT-588-T	TK-00752
HM3X-300	○	SPMT-432-X2	2	SPMT-432-X2	2	3.000	9.000	10.630	14.50	2.00	PT-588-T	TK-00752

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

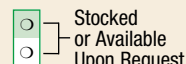
Holemill™ Inserts SPMT-X2



Inserts	Part Number ANSI	Insert Position	P M K S				Part Number ISO	Dimensions (inches)			
			G-935	G-915	G-915	G-935		A	L	T	R
 SPMT	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
			G-935	G-915	G-915	G-935	G-915 (PVD coated) Excellent for high-temp alloys, stainless steel, and low-carbon steels. Should be run at moderate speeds and moderate to high feeds. G-935 (PVD coated) Multi-layer grade for steel milling and turning applications requiring additional resistance to mechanical and thermal shock. The multi-layered PVD coating increases the speed capability and wear resistance in tough milling and interrupted turning applications.				
			P	M	K	S					

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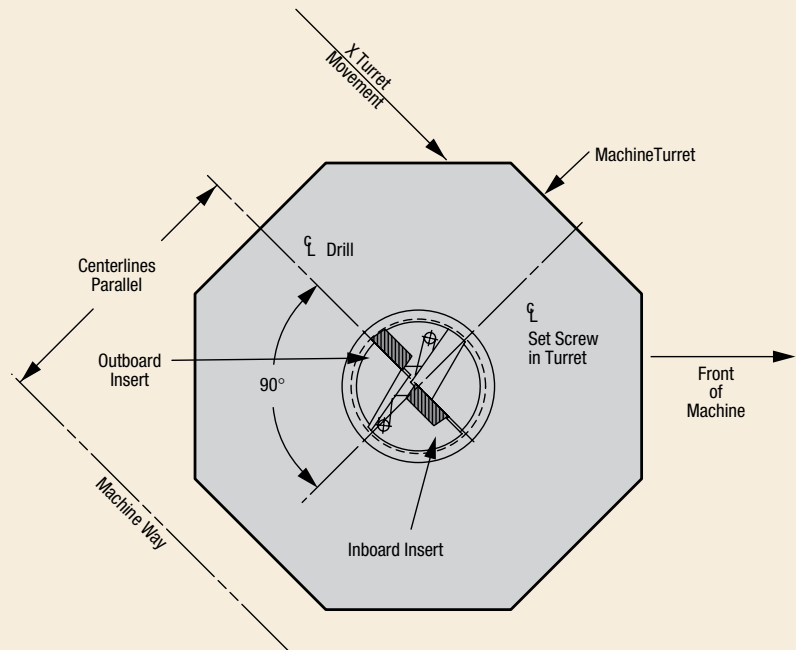


Feed and Speed for Greenleaf Holemill™

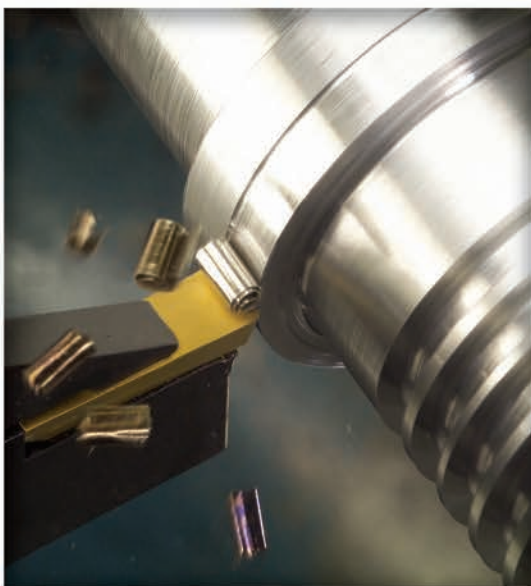
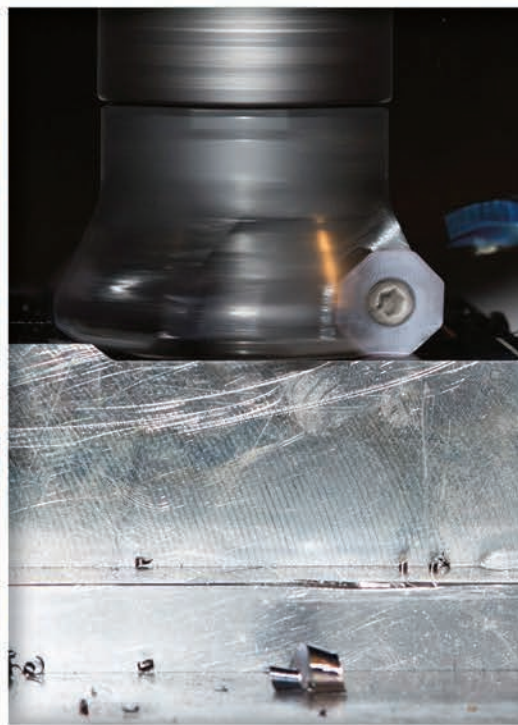
Material	Hardness (Rc)	SFM	Feed Rate per Revolution (IPR)	
			1-1.75" Dia.	1.75-3" Dia.
Low Carbon Steel/ Free Machining	up to 25	450-1000	.004-.008	.005-.010
1010, 1018, 12L14				
High Carbon Steel	25-40	200-600	.004-.008	.005-.010
1080, 1541, Nitralloy, 52100				
Alloy Steel	15-30	400-900	.004-.008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

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.



Static Drilling



MADE IN THE USA

Greenleaf Corporation
is ISO 9001 Certified.

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