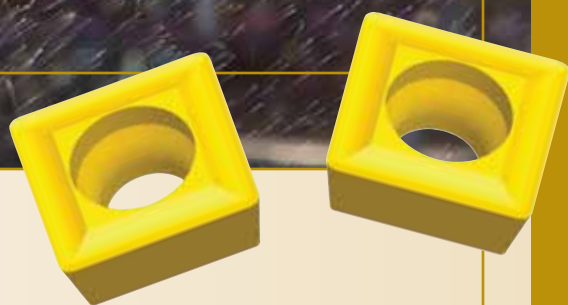




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MILLING	
TURNING AND BORING	
HEAVY TURNING	
GROOVING, PROFILING AND CUT-OFF	
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SPECIAL ENGINEERING	
APPLICATION and TECHNICAL INFORMATION	

2016 METRIC INDEXABLE DRILLING



Holemill™ Drilling System ID 04

Technical Data ID 05

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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 from 24mm to 40mm diameters in increments of 1mm.



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

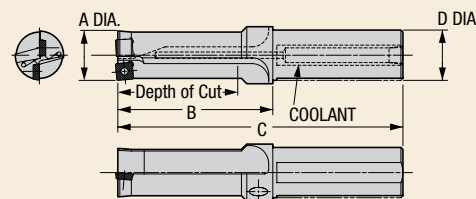
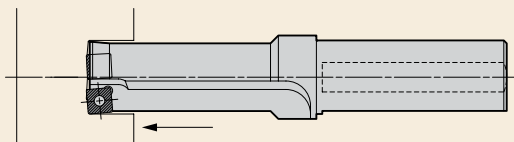
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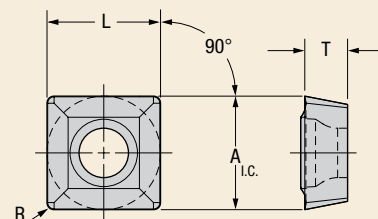
Holemill™ System



Part Number	Stock	Gage				Dimensions (millimeters)					Standard Components	* Tune-Up Kit
		Insert Inboard	Qty	Insert Outboard	Qty	A	Depth of Cut	B	C	D	Insert Screw	Includes All Standard Components
M-HM3X-24	○	SPMT-070308-X2	1	SPMT-070308-X2	1	24	72	99	164	32	PT-543-T	TK-00737
M-HM3X-25	○	SPMT-070308-X2	1	SPMT-070308-X2	1	25	75	104	169	32	PT-543-T	TK-00737
M-HM3X-26	○	SPMT-070308-X2	1	SPMT-09T308-X2	1	26	78	107	172	32	PT-543-T & PT-559-T	TK-02619
M-HM3X-27	○	SPMT-070308-X2	1	SPMT-09T308-X2	1	27	81	110	175	32	PT-543-T & PT-559-T	TK-02619
M-HM3X-28	○	SPMT-070308-X2	1	SPMT-09T308-X2	1	28	84	118	183	32	PT-588-T & PT-559-T	TK-02619
M-HM3X-29	○	SPMT-09T308-X2	1	SPMT-09T308-X2	1	29	87	121	186	32	PT-559-T	TK-00738
M-HM3X-30	○	SPMT-09T308-X2	1	SPMT-09T308-X2	1	30	90	124	189	32	PT-559-T	TK-00738
M-HM3X-31	○	SPMT-09T308-X2	1	SPMT-09T308-X2	1	31	93	127	192	32	PT-559-T	TK-00738
M-HM3X-32	○	SPMT-09T308-X2	1	SPMT-09T308-X2	1	32	96	135	200	32	PT-559-T	TK-00738
M-HM3X-33	○	SPMT-09T308-X2	1	SPMT-120408-X2	1	33	99	138	213	40	PT-559-T & PT-588-T	TK-00936
M-HM3X-34	○	SPMT-09T308-X2	1	SPMT-120408-X2	1	34	102	141	216	40	PT-559-T & PT-588-T	TK-00936
M-HM3X-35	○	SPMT-09T308-X2	1	SPMT-120408-X2	1	35	105	144	219	40	PT-559-T & PT-588-T	TK-00936
M-HM3X-36	○	SPMT-09T308-X2	1	SPMT-120408-X2	1	36	108	147	222	40	PT-559-T & PT-588-T	TK-00936
M-HM3X-37	○	SPMT-09T308-X2	1	SPMT-120408-X2	1	37	111	150	225	40	PT-559-T & PT-588-T	TK-00936
M-HM3X-38	○	SPMT-120408-X2	1	SPMT-120408-X2	1	38	114	153	228	40	PT-588-T	TK-00739
M-HM3X-39	○	SPMT-120408-X2	1	SPMT-120408-X2	1	39	117	156	231	40	PT-588-T	TK-00739
M-HM3X-40	○	SPMT-120408-X2	1	SPMT-120408-X2	1	40	120	159	234	40	PT-588-T	TK-00739

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

Holemill™ Inserts SPMT-X2



Inserts	Part Number ISO	Insert Position					Part Number ANSI	Dimensions (millimeters)			
			G-935	G-915	G-915	G-935		A	L	T	R
 SPMT	SPMT-070308-X2	Inboard	●			●	SPMT-2.522-X2	7,92	7,92	3,18	0,79
	SPMT-070308-X2	Outboard	●	●	●	●	SPMT-2.522-X2	7,92	7,92	3,18	0,79
	SPMT-09T308-X2	Inboard	●			●	SPMT-32.52-X2	9,53	9,53	3,96	0,79
	SPMT-09T308-X2	Outboard	●	●	●	●	SPMT-32.52-X2	9,53	9,53	3,96	0,79
	SPMT-120408-X2	Inboard	●			●	SPMT-432-X2	12,70	12,70	4,75	0,79
	SPMT-120408-X2	Outboard	●	●	●	●	SPMT-432-X2	12,70	12,70	4,75	0,79
			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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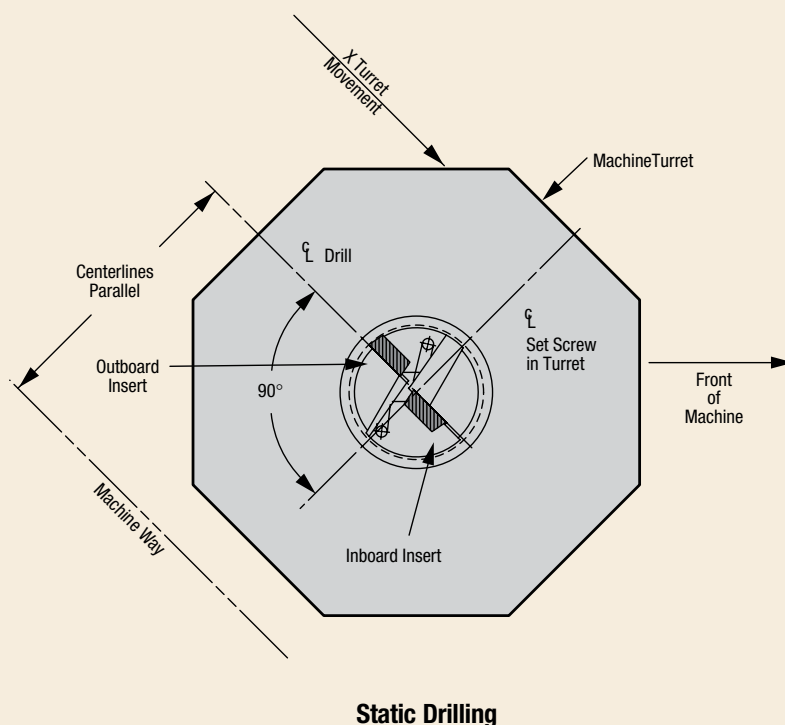
Stocked Standard
 Stocked or Available Upon Request
 Not Recommended

Feed and Speed for Greenleaf Holemill™

Material	Hardness (Rc)	Vc M/M	Feed Rate per Revolution (MMPR)	
			25,40 – 50 Dia.	50 – 80 Dia.
Unalloyed Steel	up to 25	140–305	0,1–0,2	0,13–0,25
C-10, C-15, 9SMnPb36				
High-Carbon Steel	25-40	60–180	0,1–0,2	0,13–0,25
36Mn7, 100Cr6				
Low-Alloy Steel	15-30	120–275	0,1–0,2	0,13–0,25
42CrMo4, 20MoCrS4				
High-Alloy Tool Steel	up to 30	75–180	0,1–0,2	0,13–0,25
X155CrVMo12-1, 40CrMnNiMo8-6-4, X40CrMoV51				
High-Temp Alloys	up to 45	25–70	0,075–0,13	0,075–0,13
ISO-S Material				
Stainless Steel	up to 32	75–170	0,075–0,18	0,1–0,2
Austenitic Alloys				

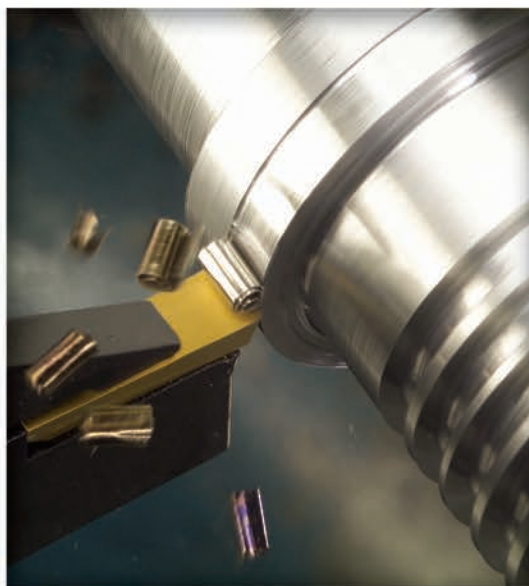
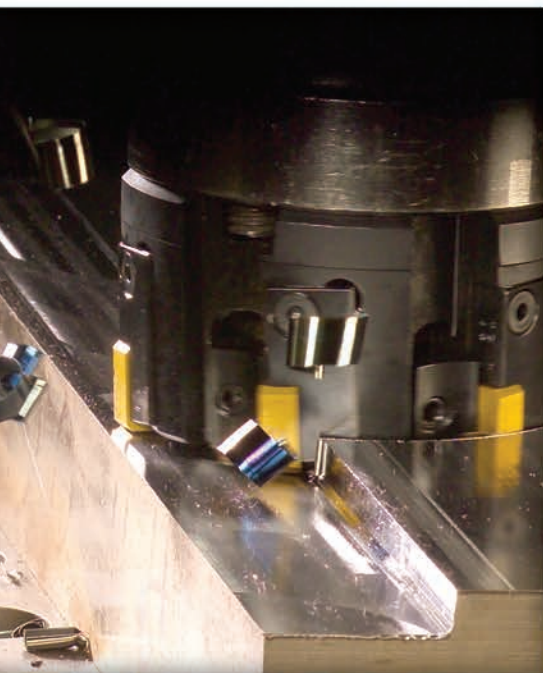
Greenleaf Holemill™ Operational Information

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.



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MADE IN THE USA

Greenleaf Corporation
is ISO 9001 Certified.

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