

# Indexable Drilling

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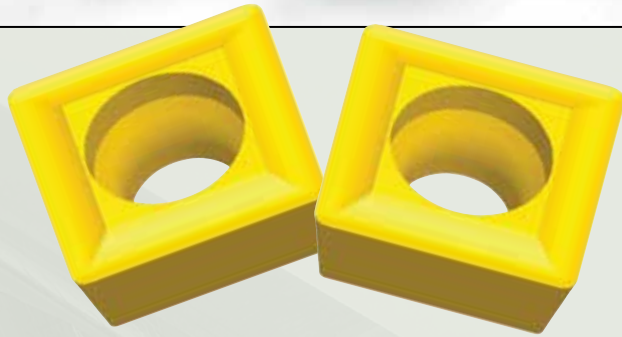
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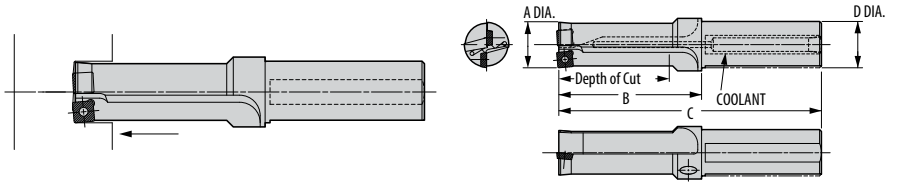
**INDEXABLE DRILLING**

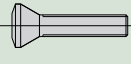


## *Indexable Drilling*

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



# Holemill™ System

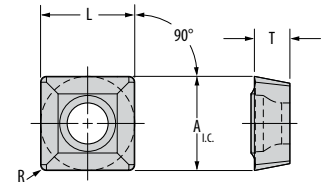



Part Number	Gage				Dimensions (mm)					Standard Components 	*Tune-Up Kit
	 Insert Inboard	Qty	 Insert Outboard	Qty	A	Depth of Cut	B	C	D		
M-HM3X-24	SPMT-070308-X2	1	SPMT-070308-X2	1	24	72	99	164	32	PT-543-T	TK-00737
M-HM3X-25	SPMT-070308-X2	1	SPMT-070308-X2	1	25	75	104	169	32	PT-543-T	TK-00737
M-HM3X-26	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 ANSI	Insert Position	Steel		Stainless Steel		Cast Iron		Heat-Resistant Super Alloys		Part Number ISO	Dimensions (mm)			
			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-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

CARBIDE COATINGS: **ME-CVD Coated** PVD Coated Uncoated

First Choice ◆ Second Choice ● Alternative ▲ Interrupted/Milling ◇

Grade descriptions — pages ID 7

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

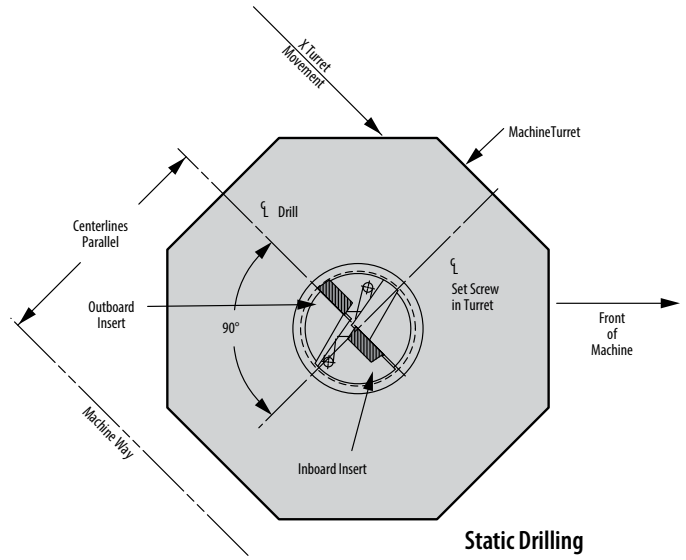
# Feed and Speed for Greenleaf Holemill™

Material	Hardness (HRC)	Vc (m/min)	Fn (mm/rev)	
			25,40 – 50 Dia.	50 – 80 Dia.
Low Carbon Steel / Free Machining 1010, 1018, 12L14	up to 25	140–305	0,1–0,2	0,13–0,25
High Carbon Steel 1080, 1541, Nitralloy, 52100	25-40	60–180	0,1–0,2	0,13–0,25
Alloy Steel 4140, 4340, 6150, 8620	15-30	120–275	0,1–0,2	0,13–0,25
Tool Steel A-6, D-2, P-20, H-13	up to 30	75–180	0,1–0,2	0,13–0,25
High-Temp Alloys Inconel, Hastelloy, Waspaloy, Stellite	up to 45	25–70	0,075–0,13	0,075–0,13
Stainless Steel 304, 316, 17-4PH	up to 32	75–170	0,075–0,18	0,1–0,2

INDEXABLE DRILLING

## 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.



# 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.