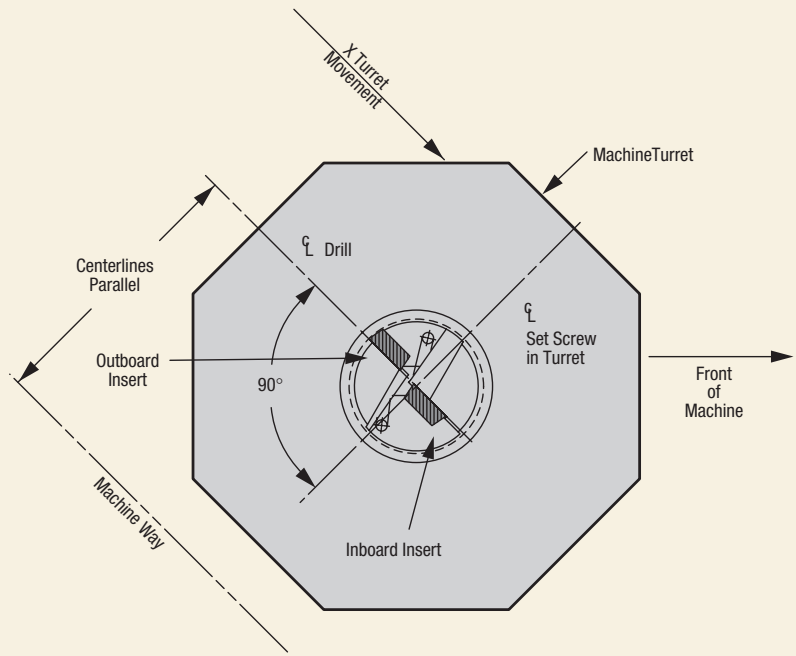


Feed and Speed for Greenleaf Hole Mill

Material	Hardness (Rc)	SFM	Feed Rate per Revolution (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, 17-4 PH	up to 32	250-550	.003-.007	.004-.008

Greenleaf Hole Mill Operational Information

For best results in static drilling, set up the Greenleaf Hole Mill 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