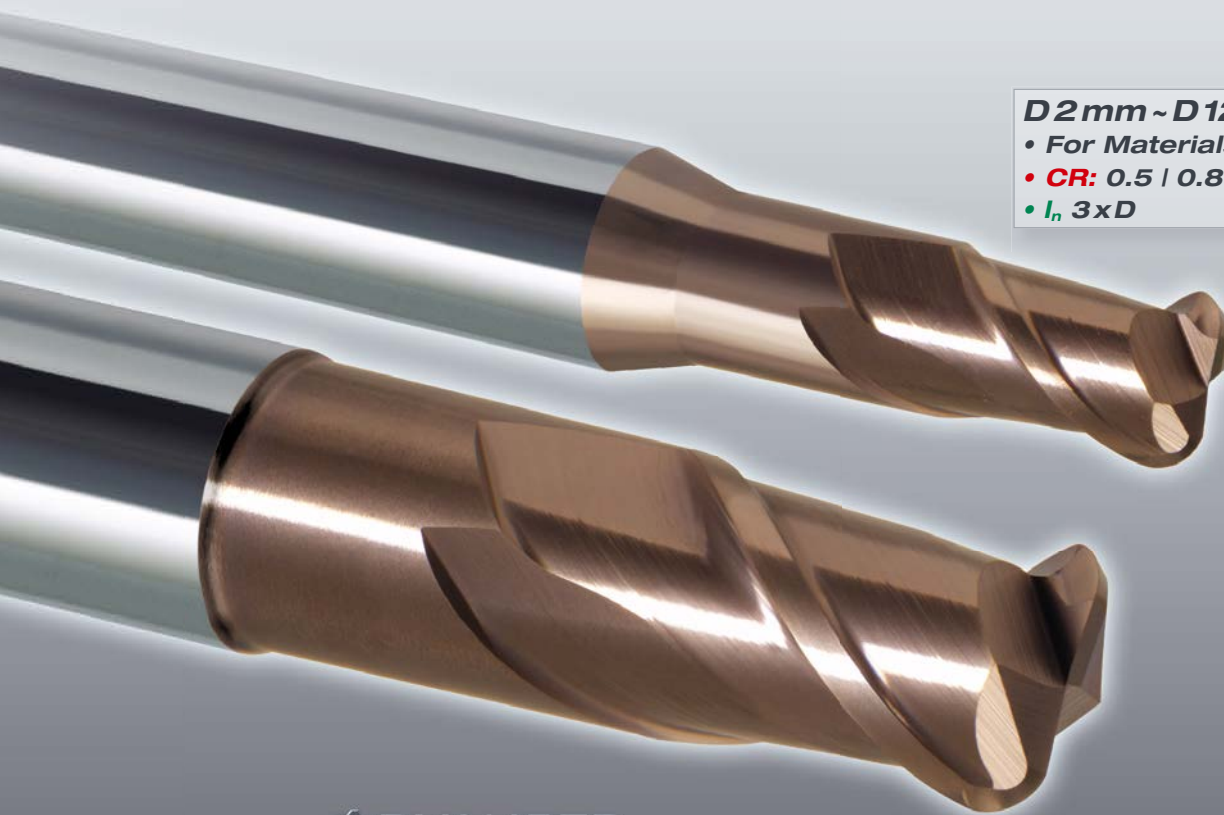


GO-Line HGOF-2-TH

Multi High Feed Solid Carbide End Mill



D2mm ~ D12mm

• For Materials $\leq 65\text{HRC}$

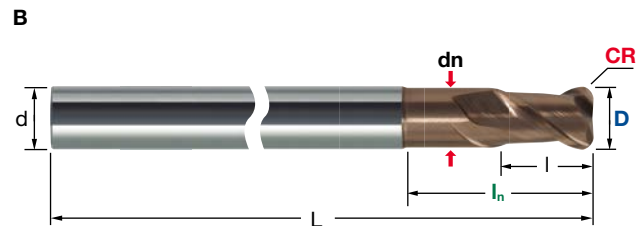
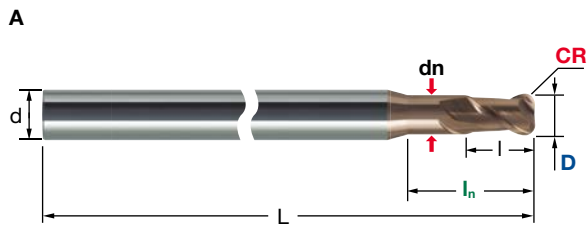
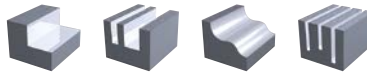
• **CR:** 0.5 | 0.8 | 1 | 1.2 | 1.5 | 2

• **l_n** 3xD

ADVANCED
TH60+
NANO-PVD COATING

HGOF-2 | GO-Line High Feed

V max High Speed	▽ Roughing	▽▽ Semi-Finishing	▽▽▽ Finishing	HRC 65
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Carbide Micro Grain	TH60+ Nano-PVD Coating	Rake Angle Negative
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







R Tol. [mm]	D Tol. [mm]	d Tol.
+/- 0.01	0/-0.03	h5

ID Code	Item Code	Flutes	D	CR	I	In	dn	L	d	Type
EL110	HGOF-2020-05-TH	2	2	0.5	3	6	1.9	60	6	A
EL111	HGOF-2030-08-TH		3	0.8	4.5	9	2.9			
EL112	HGOF-2040-10-TH		4	1	6	12	3.8			
EL113	HGOF-2050-12-TH		5	1.2	7.5	15	4.7			
EL114	HGOF-2060-15-TH		6	1.5	9	18	5.7			
EL115	HGOF-2080-20-TH		8	2	12	24	7.6	75	8	B
EL116	HGOF-2100-20-TH		10		15	30	9.5	80	10	
EL117	HGOF-2120-20-TH		12		18	36	11.5	100	12	

HGOF-2 | Recommended Cutting Conditions

D 2 - 3



				D2/CR 0.5				D3/CR 0.8			
											
				Side	Slotting	Z-Constant	2D/3D HSC	Side	Slotting	Z-Constant	2D/3D HSC
I	Cast Iron Carbon Steels Alloy Steels (150 ~ 250HB)	V _c (m/min)	110	70	85	250	110	70	85	250	
		n (min ⁻¹)	17500	11100	13500	39800	11700	7400	9000	26500	
		f _z (mm/tooth)	0.014	0.009	0.112	0.024	0.023	0.015	0.193	0.041	
		V _f (mm/min)	470	190	3020	1910	540	220	3480	2190	
		a _p (mm)	3.00	2.00	0.10	0.25	4.50	3.00	0.15	0.25	
		a _e (mm)	0.30	2.00	0.80	0.25	0.45	3.00	1.20	0.25	
	II	Stainless Steels (25 ~ 35HRC)	V _c (m/min)	77	49	60	175	77	49	60	175
			n (min ⁻¹)	12300	7800	9500	27900	8200	5200	6300	18600
			f _z (mm/tooth)	0.011	0.007	0.095	0.020	0.020	0.013	0.164	0.035
			V _f (mm/min)	280	120	1810	1140	320	130	2070	1310
			a _p (mm)	3.00	0.10	0.10	0.25	4.50	0.15	0.15	0.25
			a _e (mm)	0.20	0.80	0.80	0.25	0.30	1.20	1.20	0.25
	III	Tool Steels (25 ~ 35HRC)	V _c (m/min)	110	70	85	250	110	70	85	250
			n (min ⁻¹)	17500	11100	13500	39800	11700	7400	9000	26500
			f _z (mm/tooth)	0.011	0.007	0.095	0.020	0.020	0.013	0.164	0.035
			V _f (mm/min)	400	160	2570	1620	460	190	2960	1870
			a _p (mm)	3.00	1.00	0.10	0.25	4.50	1.50	0.15	0.25
			a _e (mm)	0.20	2.00	0.80	0.25	0.30	3.00	1.20	0.25
	IV	Tool Steels (35 ~ 45HRC)	V _c (m/min)	99	63	77	225	99	63	77	225
			n (min ⁻¹)	15800	10000	12200	35800	10500	6700	8100	23900
			f _z (mm/tooth)	0.010	0.007	0.084	0.018	0.017	0.011	0.145	0.031
			V _f (mm/min)	320	130	2050	1290	370	150	2350	1480
			a _p (mm)	3.00	0.80	0.08	0.25	4.50	1.20	0.12	0.25
			a _e (mm)	0.14	2.00	0.80	0.25	0.21	3.00	1.20	0.25
	V	Tool Steels Hardened Steels (45 ~ 55HRC)	V _c (m/min)	88	56	68	200	88	56	68	200
			n (min ⁻¹)	14000	8900	10800	31800	9300	5900	7200	21200
			f _z (mm/tooth)	0.009	0.006	0.078	0.017	0.016	0.011	0.135	0.029
			V _f (mm/min)	260	110	1690	1070	300	120	1950	1230
			a _p (mm)	2.00	0.40	0.06	0.20	3.00	0.60	0.09	0.20
			a _e (mm)	0.10	2.00	0.80	0.20	0.15	3.00	1.20	0.20
	VI	Hardened Steels (55~65HRC)	V _c (m/min)	66		51	150	66		51	150
			n (min ⁻¹)	10500		8100	23900	7000		5400	15900
			f _z (mm/tooth)	0.005		0.039	0.008	0.008		0.068	0.014
			V _f (mm/min)	100		640	400	110		730	460
			a _p (mm)	2.00		0.04	0.20	3.00		0.06	0.20
			a _e (mm)	0.06		0.80	0.20	0.09		1.20	0.20

NOTE


1. Use the machine and chucking with the highest rigidity and accuracy as possible, especially for Maximum Feed Conditions!
2. These conditions are for general guidance; in actual machining conditions adjust the parameters according to your actual machine and work-piece conditions.
3. If the rpm available is lower than that recommended please reduce the feed rate to the same ratio.









BEMERKUNG

1. Nutzen Sie die Maschine und Werkzeugspannung mit der höchstmöglichen Präzision und Stabilität, insbesondere bei maximalem Vorschub!
2. Die in der Tabelle angegebenen Schnittbedingungen stellen eine allgemeine Empfehlung dar. Die Werte sollten immer an die jeweilige Bearbeitung, deren Form und die verwendete Maschine angepasst werden.
3. Sollte die Ihnen verfügbare Drehzahl niedriger als der in der Tabelle angegebene Wert sein, sollte der Vorschub im gleichen Verhältnis reduziert werden.

HGOF-2 | Recommended Cutting Conditions

D 4 - 5



			D4/CR 1.0				D5/CR 1.2				
											
			Side	Slotting	Z-Constant	2D/3D HSC	Side	Slotting	Z-Constant	2D/3D HSC	
D 4 - 5	I	Cast Iron Carbon Steels Alloy Steels (150 ~ 250HB)	V _c (m/min)	110	70	85	250	110	70	85	250
			n (min ⁻¹)	8800	5600	6800	19900	7000	4500	5400	15900
			f _z (mm/tooth)	0.032	0.021	0.269	0.058	0.046	0.029	0.378	0.081
			V _f (mm/min)	570	230	3660	2290	640	260	4080	2580
			a _p (mm)	6.00	4.00	0.20	0.25	7.50	5.00	0.25	0.25
			a _e (mm)	0.60	4.00	1.60	0.25	0.75	5.00	2.00	0.25
	II	Stainless Steels (25 ~ 35HRC)	V _c (m/min)	77	49	60	175	77	49	60	175
			n (min ⁻¹)	6100	3900	4700	13900	4900	3100	3800	11100
			f _z (mm/tooth)	0.028	0.018	0.228	0.049	0.039	0.025	0.321	0.069
			V _f (mm/min)	340	140	2150	1360	380	150	2440	1530
			a _p (mm)	6.00	0.20	0.20	0.25	7.50	0.25	0.25	0.25
			a _e (mm)	0.40	1.60	1.60	0.25	0.50	2.00	2.00	0.25
	III	Tool Steels (25 ~ 35HRC)	V _c (m/min)	110	70	85	250	110	70	85	250
			n (min ⁻¹)	8800	5600	6800	19900	7000	4500	5400	15900
			f _z (mm/tooth)	0.028	0.018	0.228	0.049	0.039	0.025	0.321	0.069
			V _f (mm/min)	480	200	3110	1950	540	220	3470	2190
			a _p (mm)	6.00	2.00	0.20	0.25	7.50	2.50	0.25	0.25
			a _e (mm)	0.40	4.00	1.60	0.25	0.50	5.00	2.00	0.25
	IV	Tool Steels (35 ~ 45HRC)	V _c (m/min)	99	63	77	225	99	63	77	225
			n (min ⁻¹)	7900	5000	6100	17900	6300	4000	4900	14300
			f _z (mm/tooth)	0.024	0.016	0.202	0.043	0.034	0.022	0.284	0.061
			V _f (mm/min)	380	160	2460	1550	430	180	2780	1740
			a _p (mm)	6.00	1.60	0.16	0.25	7.50	2.00	0.20	0.25
			a _e (mm)	0.28	4.00	1.60	0.25	0.35	5.00	2.00	0.25
	V	Tool Steels Hardened Steels (45 ~ 55HRC)	V _c (m/min)	88	56	68	200	88	56	68	200
			n (min ⁻¹)	7000	4500	5400	15900	5600	3600	4300	12700
			f _z (mm/tooth)	0.023	0.015	0.188	0.040	0.032	0.021	0.265	0.057
			V _f (mm/min)	320	130	2030	1280	360	150	2280	1440
			a _p (mm)	4.00	0.80	0.12	0.20	5.00	1.00	0.15	0.20
			a _e (mm)	0.20	4.00	1.60	0.20	0.25	5.00	2.00	0.20
	VI	Hardened Steels (55~65HRC)	V _c (m/min)	66		51	150	66		51	150
			n (min ⁻¹)	5300		4100	11900	4200		3200	9500
			f _z (mm/tooth)	0.011		0.094	0.020	0.016		0.132	0.028
			V _f (mm/min)	120		770	480	130		850	540
			a _p (mm)	4.00		0.08	0.20	5.00		0.10	0.20
			a _e (mm)	0.12		1.60	0.20	0.15		2.00	0.20


NOTE









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2. These conditions are for general guidance; in actual machining conditions adjust the parameters according to your actual machine and work-piece conditions.
3. If the rpm available is lower than that recommended please reduce the feed rate to the same ratio.

BEMERKUNG

1. Nutzen Sie die Maschine und Werkzeugspannung mit der höchstmöglichen Präzision und Stabilität, insbesondere bei maximalem Vorschub!
2. Die in der Tabelle angegebenen Schnittbedingungen stellen eine allgemeine Empfehlung dar. Die Werte sollten immer an die jeweilige Bearbeitung, deren Form und die verwendete Maschine angepasst werden.
3. Sollte die Ihnen verfügbare Drehzahl niedriger als der in der Tabelle angegebene Wert sein, sollte der Vorschub im gleichen Verhältnis reduziert werden.

HGOF-2 | Recommended Cutting Conditions



			D6/CR 1.5				D8/CR 2.0				
											
			Side	Slotting	Z-Constant	2D/3D HSC	Side	Slotting	Z-Constant	2D/3D HSC	
D 6 - 8	I	Cast Iron	V_c (m/min)	110	70	85	250	110	70	85	250
		Carbon Steels	n (min ⁻¹)	5800	3700	4500	13300	4400	2800	3400	9900
		Alloy Steels	f_z (mm/tooth)	0.057	0.037	0.470	0.101	0.081	0.052	0.672	0.144
		(150 ~ 250HB)	V_f (mm/min)	660	270	4230	2680	710	290	4570	2850
			a_p (mm)	9.00	6.00	0.30	0.50	12.00	8.00	0.40	0.50
			a_e (mm)	0.90	6.00	2.40	0.50	1.20	8.00	3.20	0.50
	II	Stainless Steels	V_c (m/min)	77	49	60	175	77	49	60	175
		(25 ~ 35HRC)	n (min ⁻¹)	4100	2600	3200	9300	3100	1900	2400	7000
			f_z (mm/tooth)	0.048	0.031	0.400	0.086	0.069	0.044	0.571	0.122
			V_f (mm/min)	400	160	2560	1590	430	170	2740	1710
			a_p (mm)	9.00	0.30	0.30	0.50	12.00	0.40	0.40	0.50
			a_e (mm)	0.60	2.40	2.40	0.50	0.80	3.20	3.20	0.50
	III	Tool Steels	V_c (m/min)	110	70	85	250	110	70	85	250
		(25 ~ 35HRC)	n (min ⁻¹)	5800	3700	4500	13300	4400	2800	3400	9900
			f_z (mm/tooth)	0.048	0.031	0.400	0.086	0.069	0.044	0.571	0.122
			V_f (mm/min)	560	230	3600	2280	610	250	3880	2420
			a_p (mm)	9.00	3.00	0.30	0.50	12.00	4.00	0.40	0.50
			a_e (mm)	0.60	6.00	2.40	0.50	0.80	8.00	3.20	0.50
	IV	Tool Steels	V_c (m/min)	99	63	77	225	99	63	77	225
		(35 ~ 45HRC)	n (min ⁻¹)	5300	3300	4100	11900	3900	2500	3000	9000
			f_z (mm/tooth)	0.043	0.027	0.353	0.076	0.061	0.039	0.504	0.108
			V_f (mm/min)	450	180	2890	1800	470	200	3020	1940
			a_p (mm)	9.00	2.40	0.24	0.40	12.00	3.20	0.32	0.40
			a_e (mm)	0.42	6.00	2.40	0.40	0.56	8.00	3.20	0.40
	V	Tool Steels	V_c (m/min)	88	56	68	200	88	56	68	200
		Hardened Steels	n (min ⁻¹)	4700	3000	3600	10600	3500	2200	2700	8000
		(45 ~ 55HRC)	f_z (mm/tooth)	0.040	0.026	0.329	0.071	0.057	0.037	0.470	0.101
			V_f (mm/min)	370	150	2370	1500	400	160	2540	1610
			a_p (mm)	6.00	1.20	0.18	0.40	8.00	1.60	0.24	0.40
			a_e (mm)	0.30	6.00	2.40	0.40	0.40	8.00	3.20	0.40
	VI	Hardened Steels	V_c (m/min)	66		51	150	66		51	150
		(55~65HRC)	n (min ⁻¹)	3500		2700	8000	2600		2000	6000
			f_z (mm/tooth)	0.020		0.165	0.035	0.028		0.235	0.050
			V_f (mm/min)	140		890	560	150		940	600
			a_p (mm)	6.00		0.12	0.40	8.00		0.16	0.40
			a_e (mm)	0.18		2.40	0.40	0.24		3.20	0.40

NOTE


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







BEMERKUNG

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2. Die in der Tabelle angegebenen Schnittbedingungen stellen eine allgemeine Empfehlung dar. Die Werte sollten immer an die jeweilige Bearbeitung, deren Form und die verwendete Maschine angepasst werden.
3. Sollte die Ihnen verfügbare Drehzahl niedriger als der in der Tabelle angegebene Wert sein, sollte der Vorschub im gleichen Verhältnis reduziert werden.

HGOF-2 | Recommended Cutting Conditions

D 10 – 12



			D 10 / CR 2.0				D 12 / CR 2.0				
											
			Side	Slotting	Z-Constant	2D/3D HSC	Side	Slotting	Z-Constant	2D/3D HSC	
I	Cast Iron Carbon Steels Alloy Steels (150 ~ 250HB)	V_c (m/min)	110	70	85	250	110	70	85	250	
		n (min ⁻¹)	3500	2200	2700	8000	2900	1900	2300	6600	
		f_z (mm/tooth)	0.095	0.061	0.784	0.168	0.105	0.068	0.874	0.187	
		V_f (mm/min)	660	270	4230	2690	610	260	4020	2470	
		a_p (mm)	15.00	10.00	0.50	0.50	18.00	12.00	0.60	0.50	
		a_e (mm)	1.50	10.00	4.00	0.50	1.80	12.00	4.80	0.50	
	II	Stainless Steels (25 ~ 35HRC)	V_c (m/min)	77	49	60	175	77	49	60	175
			n (min ⁻¹)	2500	1600	1900	5600	2000	1300	1600	4600
			f_z (mm/tooth)	0.080	0.052	0.666	0.143	0.090	0.058	0.743	0.159
			V_f (mm/min)	400	170	2530	1600	360	150	2380	1460
			a_p (mm)	15.00	0.50	0.50	0.50	18.00	0.60	0.60	0.50
			a_e (mm)	1.00	4.00	4.00	0.50	1.20	4.80	4.80	0.50
	III	Tool Steels (25 ~ 35HRC)	V_c (m/min)	110	70	85	250	110	70	85	250
			n (min ⁻¹)	3500	2200	2700	8000	2900	1900	2300	6600
			f_z (mm/tooth)	0.080	0.052	0.666	0.143	0.090	0.058	0.743	0.159
			V_f (mm/min)	560	230	3600	2280	520	220	3420	2100
			a_p (mm)	15.00	5.00	0.50	0.50	18.00	6.00	0.60	0.50
			a_e (mm)	1.00	10.00	4.00	0.50	1.20	12.00	4.80	0.50
	IV	Tool Steels (35 ~ 45HRC)	V_c (m/min)	99	63	77	225	99	63	77	225
			n (min ⁻¹)	3200	2000	2400	7200	2600	1700	2000	6000
			f_z (mm/tooth)	0.071	0.046	0.588	0.126	0.079	0.051	0.655	0.140
			V_f (mm/min)	450	180	2820	1810	410	170	2620	1680
			a_p (mm)	15.00	4.00	0.40	0.40	18.00	4.80	0.48	0.40
			a_e (mm)	0.70	10.00	4.00	0.40	0.84	12.00	4.80	0.40
	V	Tool Steels Hardened Steels (45 ~ 55HRC)	V_c (m/min)	88	56	68	200	88	56	68	200
			n (min ⁻¹)	2800	1800	2200	6400	2300	1500	1800	5300
			f_z (mm/tooth)	0.066	0.043	0.549	0.118	0.074	0.048	0.612	0.131
			V_f (mm/min)	370	150	2410	1510	340	140	2200	1390
			a_p (mm)	10.00	2.00	0.30	0.40	12.00	2.40	0.36	0.40
			a_e (mm)	0.50	10.00	4.00	0.40	0.60	12.00	4.80	0.40
	VI	Hardened Steels (55~65HRC)	V_c (m/min)	66		51	150	66		51	150
			n (min ⁻¹)	2100		1600	4800	1800		1400	4000
			f_z (mm/tooth)	0.033		0.274	0.059	0.037		0.306	0.066
			V_f (mm/min)	140		880	560	130		860	520
			a_p (mm)	10.00		0.20	0.40	12.00		0.24	0.40
			a_e (mm)	0.30		4.00	0.40	0.36		4.80	0.40

NOTE

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BEMERKUNG

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2. Die in der Tabelle angegebenen Schnittbedingungen stellen eine allgemeine Empfehlung dar. Die Werte sollten immer an die jeweilige Bearbeitung, deren Form und die verwendete Maschine angepasst werden.
3. Sollte die Ihnen verfügbare Drehzahl niedriger als der in der Tabelle angegebene Wert sein, sollte der Vorschub im gleichen Verhältnis reduziert werden.

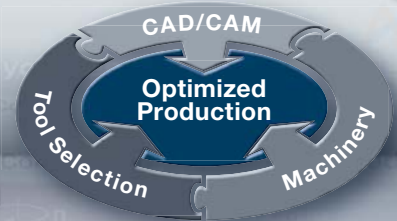


The electronic MOLDINO Tool product catalogue

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P50QF | Production50 QuickFinder

The Quickly-Finding Software for Tools and Tool Accessories

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- Cutting conditions calculation with project planning
- Shop system
- Online update

Die Software zum schnellen Finden von Werkzeugen und Zubehör

- Suche in Echtzeit mit Katalog-Browser
- Schnittwerte-Berechnung mit Projektierung
- Bestellsystem
- Online-Update
- Komplett in Deutsch & English

Function Buttons
Funktions-Schaltflächen

QuickFinder Help:
Details of tools etc.
QuickFinder Hilfe:
Werkzeugdetails usw.

Filtering by contour shape
Gefiltert nach Bearbeitungs-Kontur

Additional search parameters
Zusätzliche Parameter-Suche

Selected product
Ausgewähltes Produkt

ID code	Item code	Z	ØD	ØH	CR	Ln	s	I	Ødn	L	Ød	Grade	Inserts1	Inserts2	Inserts3
EP697	ETMP-4040-40-10	4	4	1	40	1	6	10	90	8					
EP370	ETMP-4050-12	4	5	1.2	15	1	10	70	6						
EP598	ETMP-4050-30-12	4	5	1.2	30	1	7.5	90	6						
EP599	ETMP-4050-40-12	4	5	1.2	40	1	7.5	100	8						
EP600	ETMP-4050-50-12	4	5	1.2	50	1	7.5	110	8						
EP371	ETMP-4050-15	4	6	1.5			12	90	6						
EP379	ETMLN-4050-30-15	4	6	1.5	30		9	5.7	75	6					
EP380	ETMLN-4050-42-15	4	6	1.5	42		9	5.7	90	6					
EP381	ETMLN-4050-54-15	4	6	1.5	54		9	5.7	100	6					
EP601	ETMP-4050-40-15	4	6	1.5	40	1	9	100	9						
EP602	ETMP-4050-55-15	4	6	1.5	55	1	9	110	8						
EP603	ETMP-4050-67-15	4	6	1.5	67	1	9	125	8						
EP372	ETMP-4050-20	4	8	2			16	100	8						
EP382	ETMLN-4050-40-20	4	8	2	40		12	7.6	85	8					
EP383	ETMLN-4050-58-20	4	8	2	58		12	7.6	100	9					
EP384	ETMLN-4080-72-20	4	8	2	72		12	7.6	120	8					
EP373	ETMP-4100-20	4	10	2			20		110	10					

Download: www.moldino.eu/quickfinder

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Attentions on Safety

1. Cautions regarding handling

- (1) When removing the tool from its case (packaging), be careful that the tool does not pop out or is dropped. Be particularly careful regarding contact with the tool flutes.
- (2) When handling tools with sharp cutting flutes, be careful not to touch the cutting flutes directly with your bare hands.

2. Cautions regarding mounting

- (1) Before use, check the outside appearance of the tool for scratches, cracks, etc. and that it is firmly mounted in the collet chuck, etc.
- (2) When preparing for use, be sure that the inserts are firmly mounted in place and that they are firmly mounted on the arbor, etc.
- (3) If abnormal chattering, etc. occurs during use, stop the machine immediately and remove the cause of the chattering.

3. Cautions during use

- (1) Before use, confirm the dimensions and direction of rotation of the tool and milling work material.
- (2) The numerical values in the standard cutting conditions table should be used as criteria when starting new work. The cutting conditions should be adjusted as appropriate when the cutting depth is large, the rigidity of the machine being used is low, or according to the conditions of the work material.
- (3) Cutting tools are made of a hard material. During use, they may break and fly off. In addition, cutting chips may also fly off. Since there is a danger of injury to workers, fire, or eye damage from such flying pieces, a safety cover should be attached when work is performed and safety equipment such as safety goggles should be worn to create a safe environment for work.
- (4) There is a risk of fire or inflammation due to sparks, heat due to breakage, and cutting chips. Do not use where there is a risk of fire or explosion. Please caution of fire while using oil base coolant, fire prevention is necessary.
- (5) Do not use the tool for any purpose other than that for which it is intended.

4. Cautions regarding regrinding

- (1) If regrinding is not performed at the proper time, there is a risk of the tool breaking. Replace the tool with one in good condition, or perform regrinding.
- (2) Grinding dust will be created when regrinding a tool. When regrinding, be sure to attach a safety cover over the work area and wear safety clothes such as safety goggles, etc.
- (3) This product contains the specified chemical substance cobalt and its inorganic compounds. When performing regrinding or similar processing, be sure to handle the processing in accordance with the local laws and regulations regarding prevention of hazards due to specified chemical substances.

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Specifications for the products listed in this catalog are subject to change without notice due to replacement or modification.

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