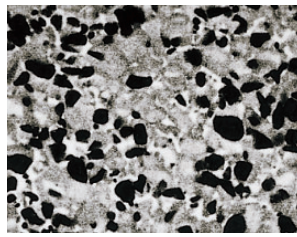
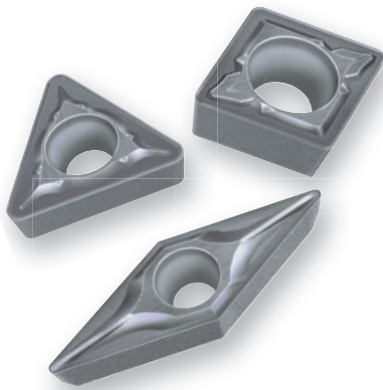


CERMET Grade

NX2525

New chipbreakers for 5° and 7° positive inserts.



Micro-Structure of **NX2525**

NX2525 has highly hardened Ti compound particles within its microstructure therefore the grade has both excellent wear and fracture resistance properties.







Application	Breaker Name and Shape	Features	Cross Section Geometry
Finish Cutting	NEW FP 	First recommendation for finishing of mild steel, carbon steel, and alloy steel. Breaker protrusion at the corner controls chips even at small depth of cut. Maintains edge strength at the corner and prevents sudden fractures.	
Light Cutting	NEW LP 	First recommendation for light cutting of mild steel, carbon steel, and alloy steel. Sharp cutting edge due to a large rake angle. Prevents welding of the insert and controls white turbidity of the surface finish. The chipbreaker protrusion achieves a wide range of chip control.	
Medium Cutting	NEW MP 	First recommendation for medium cutting of mild steel, carbon steel, and alloy steel. Good balance of wear resistance and fracture resistance because of the flat land cutting edge. A wide chip pocket controls the cutting resistance, reduces vibration, and chip jamming even at large depth of cut.	







Recommended Cutting Conditions







	Work Material	Hardness	Cutting Mode	Breaker	Cutting Speed (m/min)	Feed Rate (mm/rev)	Depth of Cut (mm)
P	Mild Steel (SS400, S10C etc.)	≤180HB	Finish Cutting	FP	225–320	0.04–0.20	0.20–0.90
			Light Cutting	LP	225–320	0.06–0.25	0.20–1.00
			Medium Cutting	MP	185–265	0.08–0.30	0.30–2.00
	Carbon Steel • Alloy Steel (S45C, SCM440 etc.)	180–280HB	Finish Cutting	FP	165–235	0.04–0.20	0.20–0.90
			Light Cutting	LP	165–235	0.06–0.25	0.20–1.00
			Medium Cutting	MP	135–195	0.08–0.30	0.30–2.00
Carbon Steel • Alloy Steel (SNCM439 etc.)	280–350HB	Medium Cutting	MP	95–140	0.08–0.30	0.30–2.00	

Insert

● 5°, 7° Positive inserts (With hole)

Shape	Order Number	Stock NX2525
 Finish Cutting	CCMT060202-FP	●
	060204-FP	●
	09T302-FP	●
	09T304-FP	●
	09T308-FP	●
 Light Cutting	CCMT060204-LP	●
	060208-LP	●
	09T304-LP	●
	09T308-LP	●
 Medium Cutting	CCMT060204-MP	●
	060208-MP	●
	09T304-MP	●
	09T308-MP	●
	120404-MP	●
	120408-MP	●
	120412-MP	●
 Finish Cutting	DCMT070202-FP	●
	070204-FP	●
	11T302-FP	●
	11T308-FP	●
 Light Cutting	DCMT070204-LP	●
	070208-LP	●
	11T304-LP	●
	11T308-LP	●
 Medium Cutting	DCMT070204-MP	●
	070208-MP	●
	11T304-MP	●
	11T308-MP	●
	150404-MP	●
	150408-MP	●

Shape	Order Number	Stock NX2525
 Finish Cutting	SCMT09T304-FP	●
	09T308-FP	●
 Light Cutting	SCMT09T304-LP	●
	09T308-LP	●
 Medium Cutting	SCMT09T304-MP	●
	09T308-MP	●
	120404-MP	●
	120408-MP	●
 Finish Cutting	TCMT090202-FP	●
	090204-FP	●
	110202-FP	●
	110204-FP	●
 Light Cutting	TCMT090204-LP	●
	090208-LP	●
	110204-LP	●
	110208-LP	●
 Medium Cutting	16T304-FP	●
	TCMT090204-MP	●
	090208-MP	●
	110204-MP	●
	110208-MP	●
	130304-MP	●
	16T304-MP	●
	16T308-MP	●
16T312-MP	●	

Shape	Order Number	Stock NX2525
 Finish Cutting	VBMT110302-FP	●
	110304-FP	●
	110308-FP	●
	160404-FP	●
	160408-FP	●
 Light Cutting	VBMT110304-LP	●
	110308-LP	●
	160404-LP	●
	160408-LP	●
 Medium Cutting	VBMT160404-MP	●
	160408-MP	●
 Finish Cutting	VCMT110302-FP	●
	VCMT110304-FP	●
	VCMT160404-FP	●
	VCMT160408-FP	●
 Light Cutting	VCMT110304-LP	●
	110308-LP	●
	160404-LP	●
 Medium Cutting	160408-LP	●
	VCMT160404-MP	●
	160408-MP	●
	160412-MP	●

● : Inventory maintained.

For Your Safety

●Don't handle inserts and chips without gloves. ●Please machine within the recommended application range and exchange expired tools with new ones in advance of breakage. ●Please use safety covers and wear safety glasses. ●When using compounded cutting oils, please take fire precautions. ●When attaching inserts or spare parts, please use only the correct wrench or driver. ●When using rotating tools, please make a trial run to check run-out, vibration and abnormal sounds etc.

MITSUBISHI MATERIALS CORPORATION

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 (Tools specifications subject to change without notice.)