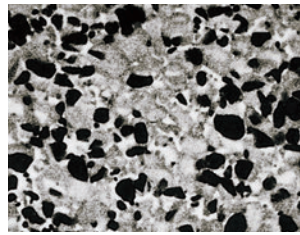


Cermet Grade for Steel and Cast Iron

NX2525

Added chipbreakers for negative inserts.



Micro-Structure of **NX2525**

NX2525 features hardened Ti compound particles within its microstructure providing excellent wear and fracture resistance properties.

Application	Breaker Name and Shape	Features	Cross Section Geometry
Finish Cutting	FY 	First recommendation for finish cutting of mild steel Double sided chipbreaker. Effectively controls adhesive chips. Suitable for mild steel finishing.	Mild Steel
	SY 	First recommendation for light cutting of mild steel Double sided chipbreaker. Effectively controls adhesive chips. Suitable for mild steel light cutting.	Mild Steel
Light Cutting	SA 	Alternative chipbreaker for light cutting of carbon steel and alloy steel Double sided chipbreaker. Superior chip control at small depth of cuts. Covers copying and back turning with wavy edge. Recommended for work material in the 200–300HB range.	Carbon Steel • Alloy Steel

Recommended Cutting Conditions





(inch)

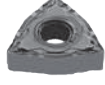
Work Material	Hardness	Cutting Mode	Breaker	vc (SFM)	f (IPR)	ap
P Mild Steel (ASTM A283, AISI 1010 etc.)	≤ 180HB	Finish Cutting	FY	920–1330	.004–.009	.008–.031
		Light Cutting	SY	835–1215	.006–.013	.020–.047
Carbon Steel • Alloy Steel (AISI 1045, AISI 4140 etc.)	180–280HB	Light Cutting	SA	620–900	.004–.016	.012–.079

Inserts

● Negative Inserts

Shape	Order Number	Stock
		<i>NX2525</i>
FY 	CNMG431FY CNMG432FY	★ ★
Finish Cutting		
SY 	CNMG431SY CNMG432SY	★ ★
Light Cutting		
SA 	CNMG431SA CNMG432SA	★ ★
Light Cutting		
FY 	DNMG431FY DNMG432FY	★ ★
Finish Cutting		
SY 	DNMG431SY DNMG432SY	★ ★
Light Cutting		
SA 	DNMG431SA DNMG432SA	★ ★
Light Cutting		

Shape	Order Number	Stock
		<i>NX2525</i>
FY 	TNMG331FY TNMG332FY	★ ★
Finish Cutting		
SY 	TNMG331SY TNMG332SY	★ ★
Light Cutting		
SA 	TNMG331SA TNMG332SA	★ ★
Light Cutting		
SA 	VNMG331SA VNMG332SA	★ ★
Light Cutting		
FY 	WNMG431FY WNMG432FY	★ ★
Finish Cutting		
SY 	WNMG431SY WNMG432SY	★ ★
Light Cutting		

Shape	Order Number	Stock
		<i>NX2525</i>
SA 	WNMG431SA WNMG432SA	★ ★
Light Cutting		

★ : Inventory maintained in Japan.

For your safety

●Don't touch breakers and chips without gloves. ●Please machine within recommended application range, and exchange expired tools with new parts in advance. ●Please use safety cover and wear safety glasses. ●When using compounded cutting oils, please take fire prevention. ●When attaching inserts or spare parts, please use the attached wrench or driver. ●When using tools in revolution machining, please make a trial run to check run-out, vibration, abnormal sounds etc.

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(Tools specifications subject to change without notice.)