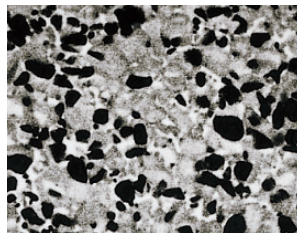


Cermet Grade for Steel and Cast Iron

NX2525

Added chipbreakers for negative 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	FY 	First recommendation for finish cutting of mild steel Double sided chipbreaker. Effectively controls adhesive chips. Suitable for mild steel finishing.	Mild Steel Cross Section Geometry: Nose 15°, Flank 0.2, 15°
	SY 	First recommendation for light cutting of mild steel Double sided chipbreaker. Effectively controls adhesive chips. Suitable for mild steel light cutting.	Mild Steel Cross Section Geometry: Nose 10°, Flank 0.2, 10°
	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 Cross Section Geometry: Nose 25°, 0.3, 10°, Flank 0.34, 25°, 8°



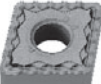



Recommended Cutting Conditions


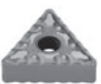
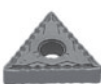



(mm)

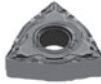
Work Material	Hardness	Cutting Mode	Breaker	vc (m/min)	f (mm/rev)	ap
Mild Steel (SS400, S10C etc.)	≤ 180HB	Finish Cutting	FY	280–405	0.09–0.23	0.20–0.80
		Light Cutting	SY	255–370	0.16–0.33	0.50–1.20
Carbon Steel • Alloy Steel (S45C, SCM440 etc.)	180–280HB	Light Cutting	SA	190–275	0.10–0.40	0.30–2.00

Inserts

● Negative Inserts

Shape	Order Number	Stock
		<i>NX2525</i>
FY 	CNMG120404-FY CNMG120408-FY	● ●
Finish Cutting		
SY 	CNMG120404-SY CNMG120408-SY	● ●
Light Cutting		
SA 	CNMG120404-SA CNMG120408-SA	● ●
Light Cutting		
FY 	DNMG150404-FY DNMG150408-FY	● ●
Finish Cutting		
SY 	DNMG150404-SY DNMG150408-SY	● ●
Light Cutting		
SA 	DNMG150404-SA DNMG150408-SA	● ●
Light Cutting		

Shape	Order Number	Stock
		<i>NX2525</i>
FY 	TNMG160404-FY TNMG160408-FY	● ●
Finish Cutting		
SY 	TNMG160404-SY TNMG160408-SY	● ●
Light Cutting		
SA 	TNMG160404-SA TNMG160408-SA	● ●
Light Cutting		
SA 	VNMG160404-SA VNMG160408-SA	● ●
Light Cutting		
FY 	WNMG080404-FY WNMG080408-FY	● ●
Finish Cutting		
SY 	WNMG080404-SY WNMG080408-SY	● ●
Light Cutting		

Shape	Order Number	Stock
		<i>NX2525</i>
SA 	WNMG080404-SA WNMG080408-SA	● ●
Light Cutting		

● : Inventory maintained in Japan.

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.

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(Tools specifications subject to change without notice.)