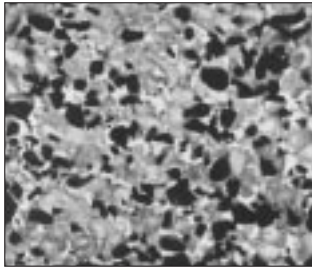


Cermet for milling ***NX2525***

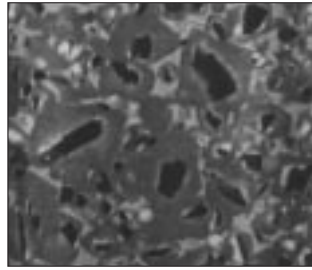
- Micro-grain - consistent grain structure, results in superior fracture resistance.
- Extremely high hardness improves wear resistance.
- Stable cutting is exhibited with both steel milling and cast iron milling.



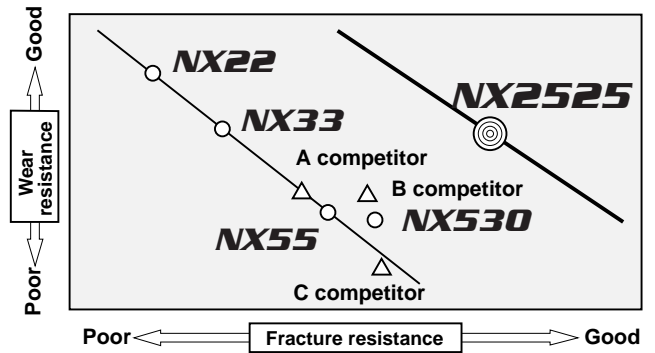
CERMET FOR MILLING **NX2525**



NX2525 micro structure

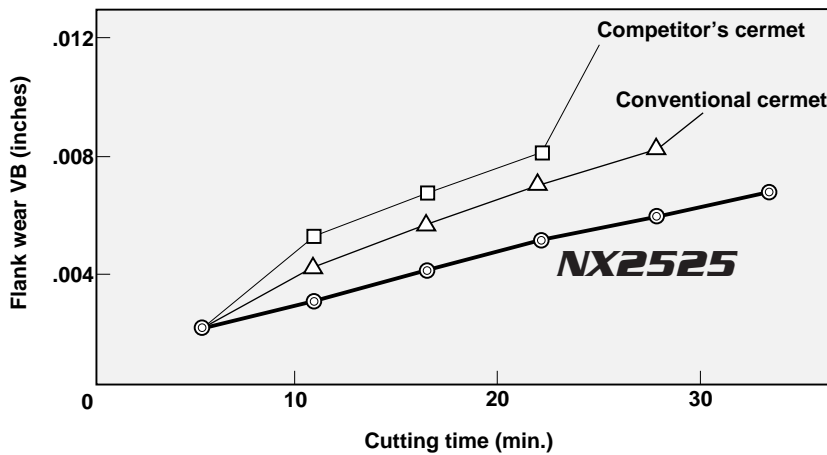


Conventional cermet micro structure



The new cermet NX2525 supersedes the existing cermet NX530. Stock is to be gradually replaced with new NX2525 stock.

CUTTING PERFORMANCE



Workpiece : ANSI 4140
 Insert : SEEN42AFTN1
 Cutting speed : 1150 (SFM)
 Feed : .008 (IPT)
 Depth of cut : .10 (inches)
 Dry cutting

RECOMMENDED CUTTING CONDITIONS

Workpiece	Hardness (HB)	Depth of cut (inches)	Cutting speed (SFM)	Feed (IPT)
Mild steel Carbon steel Alloy steel	≤180	~.04	1150 (980~1310)	.006 (.002~.012)
		.04~.12	980 (820~1150)	.008 (.004~.012)
	180~280	~.04	980 (820~1150)	.006 (.004~.012)
		.04~.12	820 (660~980)	.008 (.004~.012)
	280~350	~.04	660 (490~820)	.006 (.004~.012)
		.04~.12	490 (330~660)	.008 (.004~.012)
Grey cast iron Ductile cast iron	80~280	~.04	980 (660~1310)	.008 (.004~.012)
		.04~.12	660 (490~820)	.008 (.004~.012)
Stainless steel	180~280	~.04	980 (820~1310)	.008 (.008~.012)

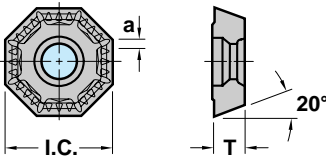
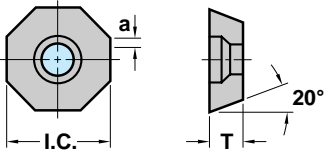
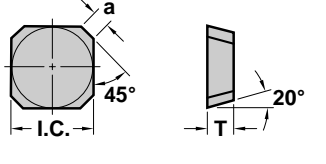
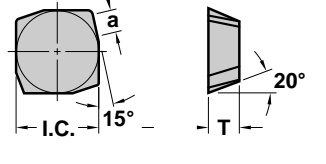
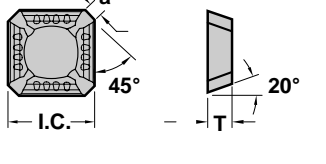
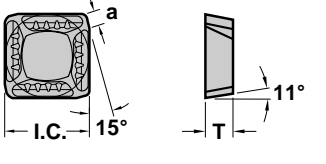
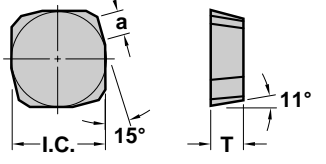
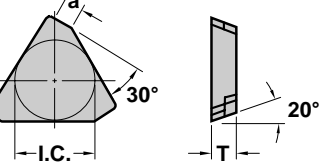
APPLICATION RANGE

USA	ISO	Steel milling
C8	P01	
C7	P10	
C6	P20	
C5	P30	
USA	ISO	Cast iron milling
C4	K01	
C3	K10	
C2	K20	
C1	K30	

In the case of abnormal wear due to thermal shocks, dry cutting is recommended. If wet cutting is to be applied, the above recommended cutting conditions should be lowered accordingly.

CERMET FOR MILLING ***NX2525***

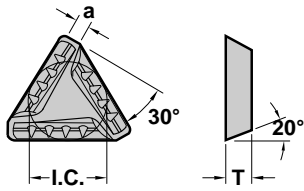
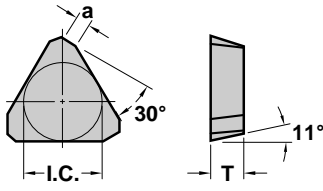
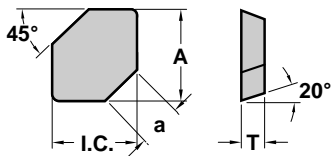
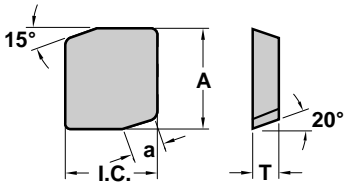
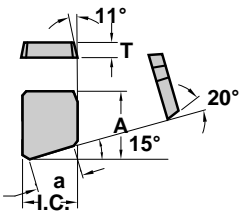
STANDARD INSERTS

Shape	Class	Order Number	Stocked <i>NX2525</i>	Dimensions (inch)		
				I.C.	T	a
	M	OEMX1705ETR1-JS	+	43/64	.196	.055
	M	OEMX1705ETR1	+	43/64	.196	.055
	E	SEEN42AFEN1	+	1/2	1/8	.055
		42AFTN1	+			
		53AFEN1	+	5/8	3/16	.055
		53AFTN1	+			
	E	SEEN42EFTR1	+	1/2	1/8	.055
		53EFTR1	+	5/8	3/16	.055
	N	SEER42AFEN-JS	+	1/2	1/8	.055
	E					
	M	SPER42EDER-JS	●	1/2	1/8	.055
	M	SPKN42EDR	●	1/2	1/8	.055
	E	TEEN32PETR1	+	3/8	1/8	.055
	N	43PETR1	+	1/2	3/16	.055

⊕ : Stock.

CERMET FOR MILLING *NX2525*

■ STANDARD INSERTS

Shape	Class	Order Number	Stocked	Dimensions (inch)			
			<i>NX2525</i>	I.C.	T	a	A
	E	TEER32PEER-JS	+	3/8	1/8	.055	-
		43PEER-JS	+	1/2	3/16	.055	
	K	TPKN32PPR	+	3/8	1/8	.047	-
		43PDR	+	1/2	3/16	.055	
	C	WEC42AFTR5C	+	1/2	1/8	.200	.604
		53AFTR5C	+	5/8	3/16	.200	.729
	C	WEC42EFTR5C	+	1/2	1/8	.200	.540
	C	WPC42EEER10C	+	1/2	1/8	.393	.591

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