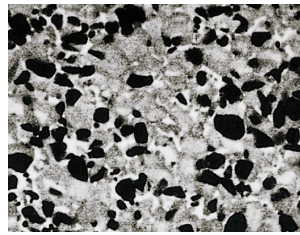


Cermet Grade for Steel and Cast Iron

**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	<b>FY</b> 	<b>First recommendation for finish cutting of mild steel</b> Double sided chipbreaker. Effectively controls adhesive chips. Suitable for mild steel finishing.	Mild Steel 
	<b>SY</b> 	<b>First recommendation for light cutting of mild steel</b> Double sided chipbreaker. Effectively controls adhesive chips. Suitable for mild steel light cutting.	Mild Steel 
Light Cutting	<b>SA</b> 	<b>Alternative chipbreaker for light cutting of carbon steel and alloy steel</b> 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)

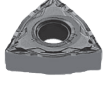
Work Material	Hardness	Cutting Mode	Breaker	vc (SFM)	f (IPR)	ap
P Mild Steel (ASTM A283, AISI 1010 etc.)	≤ 180HB	Finish Cutting	<b>FY</b>	920–1330	.004–.009	.008–.031
		Light Cutting	<b>SY</b>	835–1215	.006–.013	.020–.047
Carbon Steel • Alloy Steel (AISI 1045, AISI 4140 etc.)	180–280HB	Light Cutting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

## Inserts

### ● Negative Inserts

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

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

Shape	Order Number	Stock
		<i>NX2525</i>
<b>SA</b> 	<b>WNMG431SA</b> <b>WNMG432SA</b>	★ ★
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.

## MITSUBISHI MATERIALS CORPORATION



**AHB** Tooling & Machinery, Inc.  
 Complete Metalworking Solutions  
 Roseville Saginaw & Jackson, MI  
 ISO Certified  
 (800) 991-4225  
 www.ahbinc.com  
 customerservice@ahbinc.com