Cat.-No.		ET01	ET01
P1	Steel < 500 N/mm²	■ v_c = 15–25 m/min	■ v_c = 15–25 m/min
P2	Steel 500–1000 N/mm²	■ v_c = 10–20 m/min	■ v_c = 10–20 m/min
P3	Steel > 1000 N/mm²	■ v_c = 8–15 m/min	■ v_c = 8–15 m/min
M1	Stainless steel austenitic	■ v_c = 6–12 m/min	■ v_c = 6–12 m/min
M2	Stainless steel martensitic		
K1	Grey cast iron		
K2	Nodular cast iron	■ v_c = 8–20 m/min	■ v_c = 8–20 m/min
N1	Alu- & Copper alloys long chipping < 5 % Si	■ v_c = 15–40 m/min	■ v_c = 15–40 m/min
N2	Alu- & Copper alloys long chipping 5–10 % Si	■ v_c = 15–40 m/min	■ v_c = 15–40 m/min
N3	Alu- & Copper alloys short chipping > 10 % Si	■ v_c = 10–30 m/min	■ v_c = 10–30 m/min
N4	Graphite		
S1	Titanium alloys medium strength < 900 N/mm²		
S2	Titanium alloys high strength < 1300 N/mm²		
H1	Chilled steel and Hardened steel 45–55 HRC		