CNC Universal Milling Machines

DMU 60 / 80 / 100 monoBLOCK® classic Series

DMG MORI SEIKI

DMU monoBLOCK® Series:
Best results for simple to complex cubic components, manufactured in single work piece or small series production.

DMU monoBLOCK® Series: compact 3 to 5-axis machines – for flexibility in every industry.

The demand for optimised and low cost production continues to grow in the chip removal industry for both single work pieces and small series manufactured on universal milling machines. Is there a machine design that covers this application range at a reasonable price / performance ratio? In a compact space? With simple expansion options? The answer is: The DMU monoBLOCK® Series. A new design unparalleled in this machine class – with an application range for cubic components from all industries. Whether for classic universal operation, for the tool and mould making industry with 3 to 5 axes, for the complete machining with 5-sided / 5-axis simultaneous machining, or where negative angles are required, the DMU monoBLOCK® Series offers state-of-the-art, efficient machining.

Job order production

Power engineering Gas turbine

Impeller

Tool + mould making

Mechanical engineering

Power engineering Hydropower

Aerospace

Medical

DMU 60 / 80 / 100 monoBLOCK®: Excellent dynamics with the best accessibility and ergonomics.

The innovative monoBLOCK® design has numerous benefits: greater sturdiness, better dynamics, more precision, higher surface quality and lower space requirements. The table traverses only in a vertical direction and when combined with the large linear guide ways, leads to better sturdiness in order to produce superb surface quality, regardless of the application height.

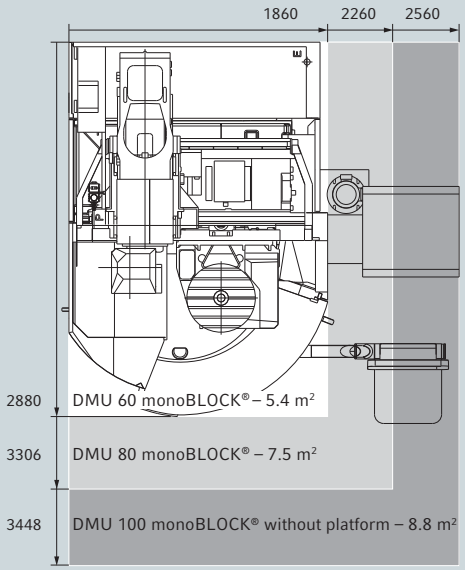
The excellent dynamics of the machine series is reflected in rapid traverse speeds of 30 rpm and up to 60 rpm in the rotary axes. The modular monoBLOCK® design ensures the required sturdiness and also provides optimal ergonomics and easy handling through a door that gives wide access to the large work area. The extensive standard equipment, a large range of expansion options, the advanced CNC controls and numerous software features create a machine ideally equipped for state-of-the-art, complete machining.

|1| Large work area with an integrated NC rotary table and NC controlled milling head (optional)
|2| Machining with a B-axis and negative angles

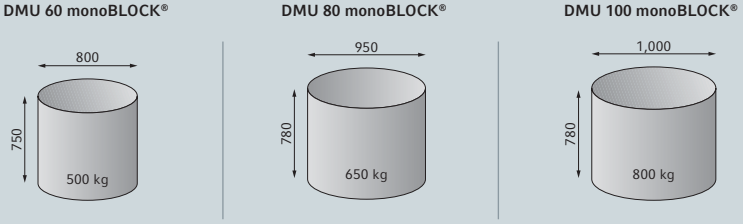
DMU monoBLOCK® Highlights

_ New design: optimal access and greater visibility into the work area, DMG ERGO*line*® Control, a 19" screen and Heidenhain or Siemens CNC
_ Compact design: machine foot print of only 5.4 m² (DMU 60 monoBLOCK®)
_ Excellent dynamics – acceleration up to 0.8 g and a rapid traverse of 30 m/min
_ In the standard version: scraper-belt chip conveyor, 250-l coolant / lubricant tank, geometric temperature compensation, fully enclosed safety cabin, energy supply integrated into the milling head and a trailing cable installation in the base
_ Max. load up to 1,100 kg with a fixed table and up to 800 kg with the NC rotary table*
_ 3 to 5 axes – ideally suited for 5-sided and simultaneous 5-axis milling
_ Chain magazine with 60 tool pockets as an option
_ Optional: HSC motor spindles* – 24,000 rpm, power spindles* with 10,000 rpm and 286 Nm (not for the DMU 60 monoBLOCK®), as well as 18,000 rpm, 35 kW and 119 Nm for all machine sizes
_ Production package* with a 600-l coolant tank and internal coolant supply (40 bar)
_ CollisionMonitoring for the 5-axis version and Heidenhain iTNC 530 in the standard version
_ 3D quickSET®*, ATC* (Application Tuning Cycle), Advanced Surface*, MPC (Machine Protection Control)

* depending on the machine and control type



Maximum work piece dimension / weight



* with the HSK-A63 version

DMU 100 monoBLOCK® – BLADE-package

Machining of large turbine blades:
Blade table with
_ 1 × NC indexing head with Direct Drive on the manually sliding table
_ 1 × NC indexing head with Direct Drive on the controlled sliding table

18,000 rpm motor spindle / HSK-A63, chain tool magazine with 60 pockets, B-axis with a swivel range of ±75 degrees, blade table with openings for chip fall.

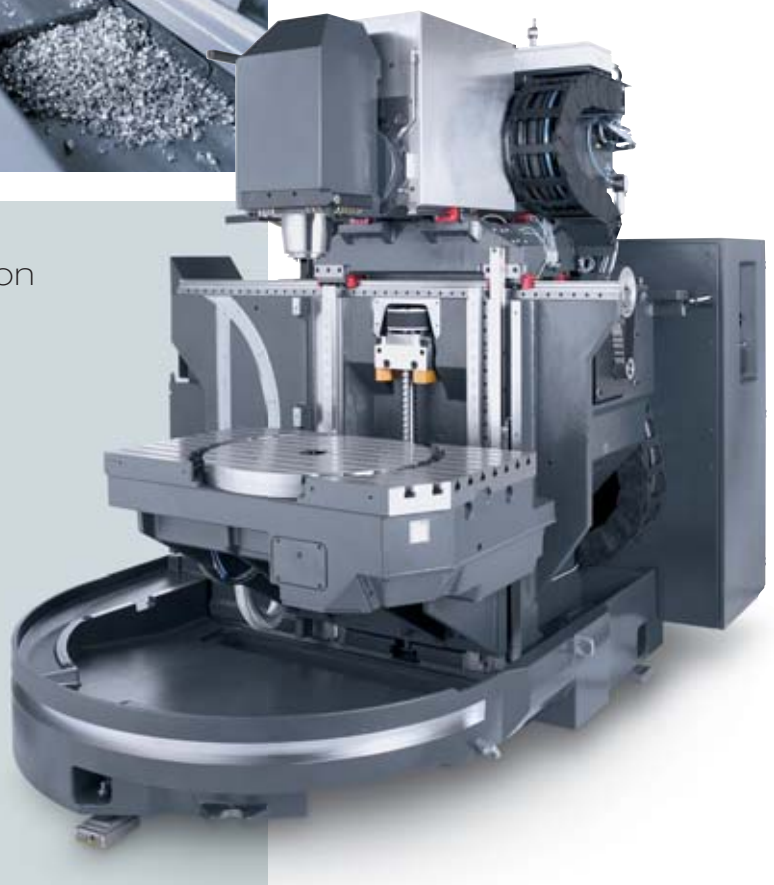
All purpose machine with extensive standard equipment – the right solution for every application.

Performance without limits and with maximum flexibility – The new DMU monoBLOCK® machines offer optimal accessibility and maximum ease of operation. The extensive standard equipment includes the liquid-cooled motor spindle, digital drives with direct measuring systems, free floating linear roller guide ways, 3-point support for fast installation, a scraper-belt chip conveyor, geometric temperature compensation and the latest open CNC controls.

|1| Optimised tool magazine for 24 or 32 tools in the standard version **|2|** Integrated scraper-belt chip conveyor in the standard version

Highlights of the standard version

_ Digital drives and direct measuring systems
_ Linear roller guide ways free from float
_ 3-point support for fast installation
_ Geometric temperature compensation
_ Pickup tool changer with a plate magazine – with up to 32 tool pockets
_ Liquid-cooled motor spindles
_ Scraper-belt chip conveyor
_ Manual swivel milling head
_ Advanced, open CNC controls



Tool measurement in the work area via laser beam and measuring cycles specifically designed for this purpose. For the monitoring and correction of tool length and radius in the work area of the machine. Also available as the TT 140 load cell from Heidenhain.

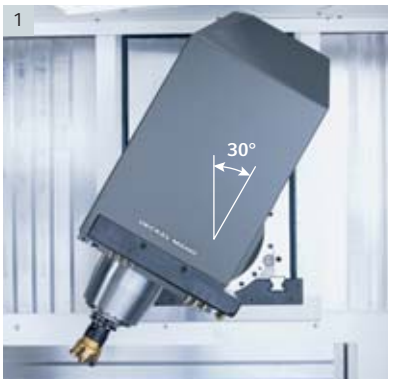
DMG infrared measuring probes, type Renishaw OMP 60 or Heidenhain TS 649, both equipped with pressurised air for cleaning of the measuring points. For the setup of work pieces, the correction of tool length and radius during the manufacturing of small tolerances, for process control in serial production, etc. Also, extensive measuring cycles for programming support.

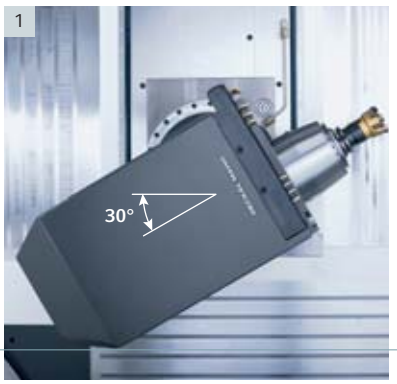
Oil and emulsion mist separator unit with electrostatic filter, for direct integration into the work area. For the extraction of oil and coolant / lubricant mist, also while machining is in progress. For a stable indoor climate, as well as for environmentally friendly production.

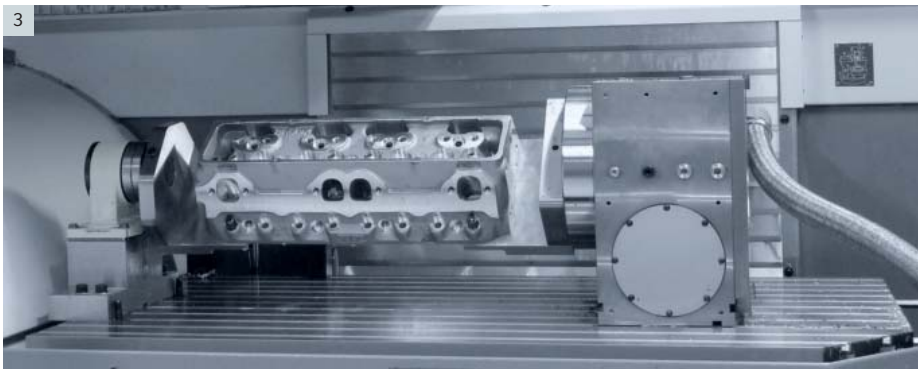
Dust extraction unit for installation onto the fixed table, with a volume flow rate of V = 3,500 m³/h. Powerful extraction of graphite dust during machining, offering maximum protection for the operator and machine.

Production package with 20 or 40 bar pump output. Includes 600-l coolant / lubricant tank, paper band filter, rotating viewing glass, chip flushing in the work area door, and type AD internal coolant supply through the spindle centre. For the delivery and filtering of coolant lubricant agents during the machining of steel and aluminium alloys. Brings the coolant lubricant directly to the machining point and offers the best protection for the work piece and tool.

Tool chain magazine with 60 tool pockets of the SK40 tool fitting, or selected tool fittings (optional), such as HSK-A63, etc. for utilisation of the machine in production, as well as in small serial production, whenever a large number of tools is required. Chip-to-chip times of up to 9 seconds.







|1| Milling head as an NC controlled B-axis with a swivel range of 150°
|2| NC rotary table integrated into the fixed table |3| NC indexing head with cylindrical head machining |4| Vane manufacturing on the BLADE table |5| Cylinder head machining

DMU monoBLOCK® – 5-Axis- / 5-sided machining without compromise.

The DMU monoBLOCK® as a 5-axis version is used in every industry. It features a rigid table with an up to 1,100 kg load tolerance and the following options: an integrated max. 40 rpm NC rotary table as well as an NC-controlled B-axis with 35 rpm and a swivel range of 150°. All machines allow the machining of up to 30° negative angles, with the capability to swivel the B-axis from the vertical to the horizontal position in no more than 1.5 seconds.

A NC indexing head with 80 rpm and 160 mm peak height is also available. The BLADE table for the machining of large rotor blades on the DMU 100 monoBLOCK® can be equipped with one or two work piece units, with or without an arrester.

4

5

A uniquely extensive range of spindles – select the right spindle for every application.

Motor spindles with 12,000 rpm in the standard version or an optional 18,000 or 24,000 rpm deliver high chip removal performance and superior surface qualities through a wide range of available type SK40 or HSK-A63 tool fittings, and their balanced output and torque characteristics.

A power spindle with 10,000 rpm, optionally for the DMU 80 / 100 monoBLOCK®, meets all your requirements with a performance of 30 kW and 286 Nm, even during the machining of high-tensile steels and alloys.

Motor spindles	**Machine**		
rpm / Tool fitting **Output / Torque**	**DMU 60** **monoBLOCK®**	**DMU 80** **monoBLOCK®**	**DMU 100** **monoBLOCK®**
12,000 rpm / SK40 / HSK-A63* 15 kW / 130 Nm	Standard	Standard	Standard
18,000 rpm / SK40 / HSK-A63* 35 kW / 119 Nm	•	•	•
10,000 rpm / SK40 / HSK-A63* 30 kW / 286 Nm	–	•	•
24,000 rpm** / HSK-A63 26 kW / 85 Nm	•	•	•

● optionally available, * optional, ** including active spindle cooling


1


2


3

|1| Standard motor spindle 12,000 rpm
|2| Optional HSC spindle 24,000 rpm
|3| Machine Protection Control – MPC

Rough milling of a mould component for a hand drill housing
Complete machining on the DMU 80 monoBLOCK®

Industry	**Mould making**	**Machining focus:**
Material	Tool steel	5-axis simultaneous machining with an NC controlled B-axis and NC rotary table
Tools	VHM ball miller ø 4 mm	
Spindle	24,000 rpm	
Output / Torque	26 kW / 85 Nm	

Finish machining of a template – soft and hard milling
Complete machining on the DMU 80 monoBLOCK®

Industry	**Mechanical engineering**	**Machining focus:**
Material	40CrMnMo7	5-axis simultaneous machining with an NC controlled B-axis and NC rotary table; with hard milling 60 HRC
Tools	VHM ball miller ø 6 mm	
Spindle	18,000 rpm	
Output / Torque	35 kW / 119 Nm	

Rough milling of a forming die for a hip pin
Complete machining on the DMU 60 monoBLOCK®

Industry	**Medical technology**	**Machining focus:**
Material	Tool steel	5-axis simultaneous machining with an NC controlled B-axis and NC rotary table; surface roughness Ra < 0.2 µm
Tools	VHM shaft miller ø 12 mm	
Spindle	24,000 rpm	
Output / Torque	26 kW / 85 Nm	

Pre-finishing of a Pelton wheel with ø 700 mm
Complete machining on the DMU 100 monoBLOCK®

Industry	**Power engineering**	**Machining focus:**
Material	X3CrNiMo13-4	5-axis simultaneous machining with an NC controlled B-axis and NC rotary table; negative angles up to 30°
Tools	VHM shaft miller ø 12 mm	
Spindle	12,000 rpm	
Output / Torque	15 kW / 130 Nm	

Rough chip removal BLADE, raw material 750 × 100 × 60 mm (X20Cr13)
Machining time < 60 min on the DMU 100 monoBLOCK®

Industry	**Power engineering**	**Machining focus:**
Material	X20Cr13 (turbine steel)	Heavy machining of a turbine blade made from stainless steel with a 286 Nm torque spindle and 2 NC work piece units on a BLADE table
Tools	Corner milling head > ø 63 mm	
Spindle	10,000 rpm	
Output / Torque	30 kW / 286 Nm	

PH 150|8 – compact automation solution with excellent accessibility for maximum productivity.

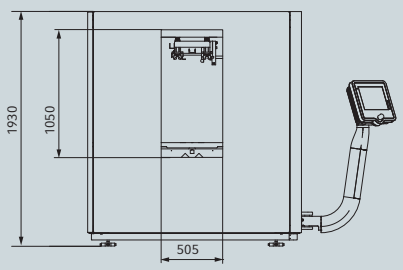
The pallet handling system with a pallet-specific gripper is integrated into the base of the cabin. The safety cabin encloses the entire system, including the integrated pallet magazine. A large work area door gives optimal access for manual loading of oversize and heavy machining work pieces, even with a crane. Various zero point clamping systems are available, which can be easily connected to the various DMU monoBLOCK® machines via pre-defined interfaces.

PH 150|8 Specifications

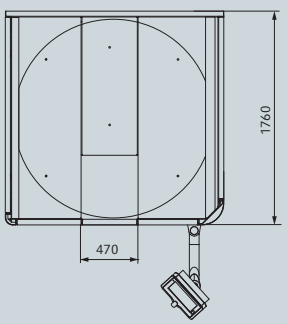
_ Pallet handling system with a max. pallet weight of 150 kg (optional 250 kg)
_ 8 pallet storage positions with a max. pallet size of 320 × 320 mm (number of pallets as well as differing pallet sizes are available as options upon request)
_ Sturdy tubular steel frame construction with a fully enclosed cabin and an access door that is monitored and locked by a safety switch
_ Cell dimensions: (L / W / H): 2,200 / 1,800 / 2,450 mm
_ Predefined connection to the monoBLOCK® machine

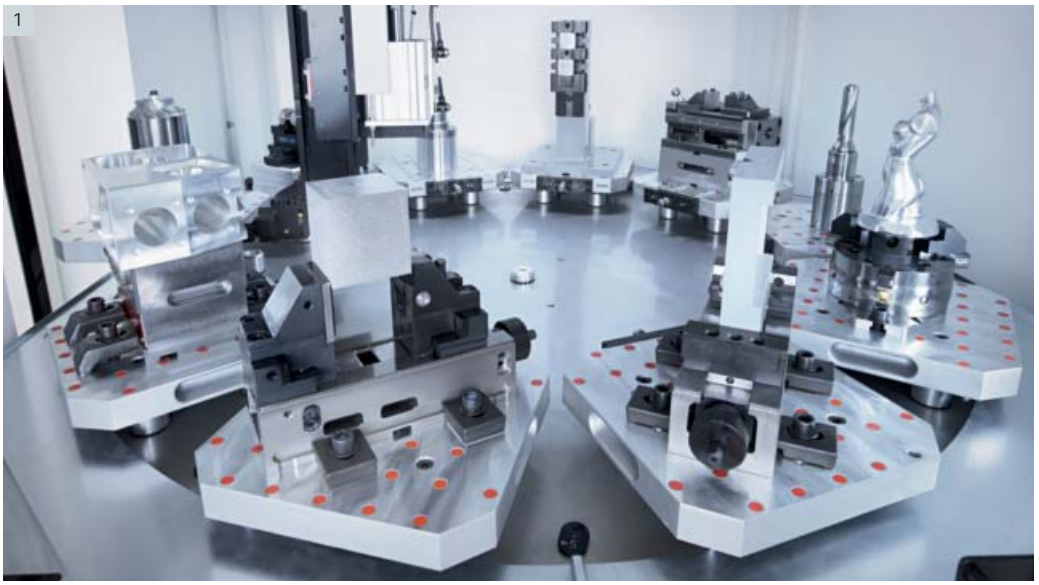
PH 150|8 Floor Plan

Side view



Top view





|1| Automatic pallet-handling, pallet magazine with 8 pockets |2| Pallet-handling in the magazine
|3| Pallet handling in the work area of the machine

DMG ERGO*line*® Control with a 19" screen and 3D work piece simulation.

The most significant highlight of the new machine design is the DMG ERGO*line*® Control with a 19" screen. The larger screen ensures better readability and allows the integration of additional DMG SOFT*keys*® and status information, which leads to more efficient operation overall. Optimal ergonomic adjustment of both the screen and operator panel. This is also true for the optional seat and mouse pad. The key switch is replaced by the intelligent DMG SMART*key*® with a chip, which offers complete ease of operation with features ranging from retrievable machine operating modes to personalised user access.

The operator has access to state-of-the-art software, such as the Heidenhain iTNC 530 or the new Heidenhain MillPlus iT V610.

All CNC control alternatives are seamlessly integrated into the performance range of the DMU / DMC monoBLOCK® Series and feature large storage capacities and ultra-fast processors.

ATC – Application Tuning Cycle

Simple tuning of the feed-drives at the press of a button

This means: Three available settings (surface, speed, precision) can be freely selected from anywhere within a work piece programme. **Your benefit:** Minimised machining time combined with maximum quality, also in relation to work piece weight.

For all controls.

ATC Application Tuning Cycle

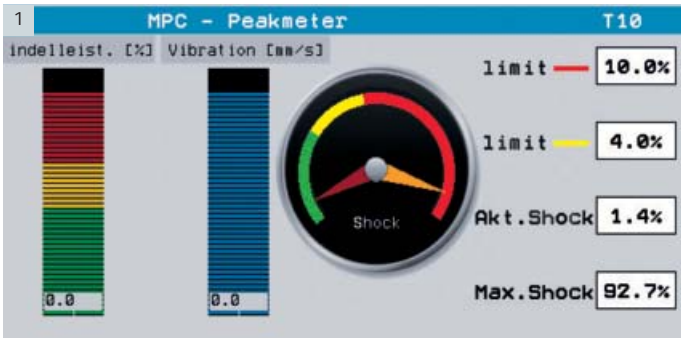
3D quickSET®

Monitoring and adjustment of axis-accuracy in the work area

This means: A correction function for the precision of the delivery status. **Your benefit:** Easy handling and programming for the operator, always maximum precision, even during 5-axis machining.

For all controls.

3D quickSET



|1| MPC – Machine Protection Control: Preventative protection for the machine and tools

|2| DMG SMART*key*® – Electronic access control for the personalised authorisation of the operator with user-specific access privileges for the control and machine

|3| CollisionMonitoring

CollisionMonitoring –

Standard equipped with the 5-axis version with Heidenhain iTNC 530

Avoids collision of the individual machine components (including tools) during manual or automatic operation.

_ Optimum protection of the machine from collisions
_ Dynamic monitoring and best utilisation of the work area
_ Less strain on the operator

CollisionMonitoring

MPC – Machine Protection Control

Precautionary protection from machine and tools,

through vibration sensor on the milling spindle:
_ Machine protection through quick shut off
_ Process monitoring by means of a teaching function and graph display on the control
_ Storage condition diagnosis of spindle
_ Planning of maintenance and repairs

MPC Machine Protection Control

Siemens 840D solutionline

_ Easy interactive programming through identical Look & Feel for turning & milling
_ New user SINUMERIK Operate interface
_ Quick-view simulation for complex work piece programmes
_ Powerful tool management
_ Extensive 5-axis functionality with numerous correction and intervention options
_ Powerful visual support during setup and measuring functions
_ Advanced Surface – option for maximum surface quality*. It is the perfect complement for the tool and mould making industry
_ Direct spline processing of CAD-data*

DMG Control Highlights

_ Control-identical AV programming with DMG Powertools
_ Integration of angle milling heads into standard 5-axis machining
_ Tool measurement with a Blum laser during the utilisation of angle milling heads*
_ HSC – fast, efficient milling with superb contour accuracy
_ Machine Protection Control – MPC
_ 3D quickSET®*
_ ATC (Application Tuning Cycle)*

Heidenhain iTNC 530

_ Shop floor or DIN-ISO programming
_ Fast programme creation through interactive programming
_ Visual programming
_ Upward compatible
_ 3D work piece representation
_ smarT.NC – new user-friendly interface
_ Extensive selection of cycles in the standard version (e.g. plane, cylinder barrel interpolation, etc.)
_ Powerful tool management
_ Mould making specific geometry functions*
_ DXF converter*
_ AFC – Adaptive Feed Control*

DMG Control Highlights

_ Shop floor-oriented programme processing
_ Integration of angle milling heads into standard 5-axis machining
_ Tool measurement with a Blum laser during the use of angle milling heads*
_ CollisionMonitoring in the standard version for the 5-axis version
_ HSC – fast, efficient milling with superb contour accuracy
_ Machine Protection Control – MPC
_ 3D quickSET®*
_ ATC (Application Tuning Cycle)*

Heidenhain MillPlus iT V610

_ New, future-oriented functions with the “look and feel” of the proven Heidenhain MillPlus iT
_ Simple, well laid-out and intuitive operation
_ Clearly structured programme architecture
_ Expansion of available cycles in the standard version (e.g. plane, cylinder barrel interpolation, etc.)
_ Fast loading and editing of memory intensive programmes
_ Programming with HLL elements and access to SQL tables
_ New mould making functions
_ Expanded diagnostic options

DMG Control Highlights

_ HSC – fast, efficient milling with superb contour accuracy
_ Machine Protection Control – MPC
_ 3D quickSET®*
_ ATC (Application Tuning Cycle)*

* optional

Screen angle
Continuously adjustable from 5–30°

Screen surface
The screen surface is smooth and easy to clean

DMG SOFT*keys*®
Hotkeys that can be customised for frequently-used screen selections or operational sequences

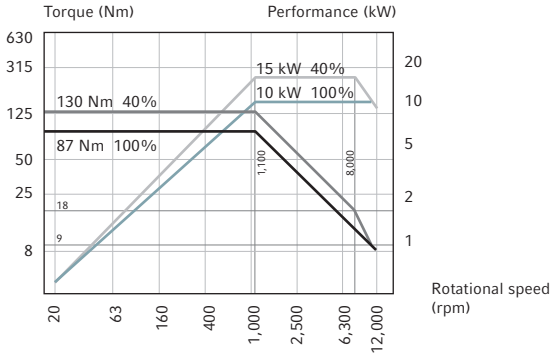
Keyboard angle
Continuously adjustable from 15–70°

DMG SMART*key*® with a transponder
Individual authorisation of the operator with user-specific access privileges for the control and machine. Expanded functionality through transponder technology: individual allocation of operational data, mode selector switch and a state-of-the-art security system against unauthorised operation.

Torque / Performance Diagrams

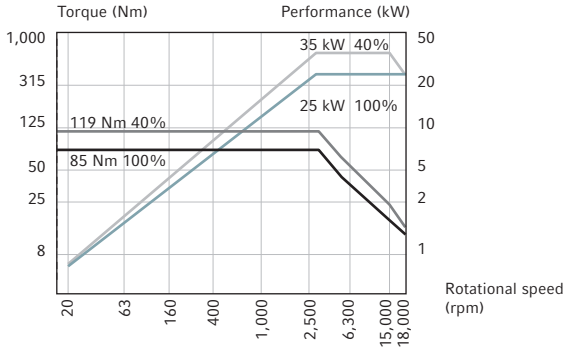
DMU 60 / 80 / 100 monoBLOCK®

Standard 12,000 rpm



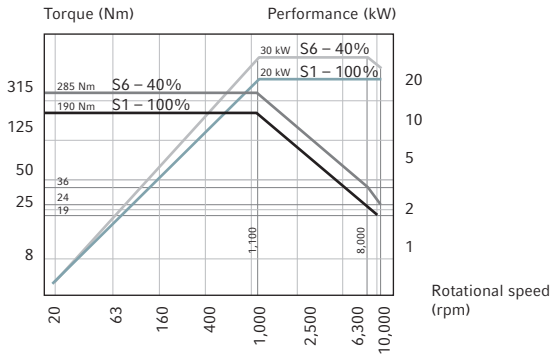
DMU 60 / 80 / 100 monoBLOCK®

Optional 18,000 rpm



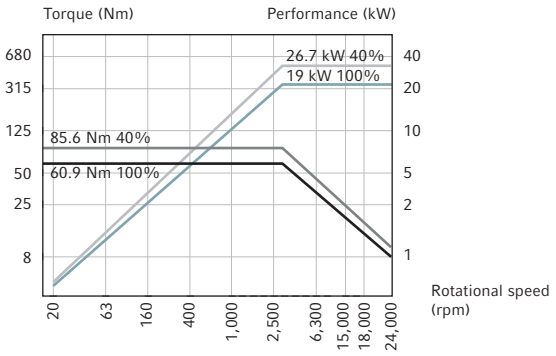
DMU 80 / 100 monoBLOCK®

Optional 10,000 rpm



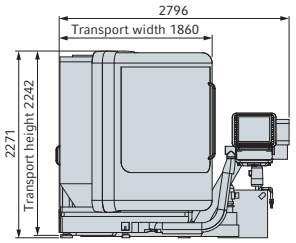
DMU 60 / 80 / 100 monoBLOCK®

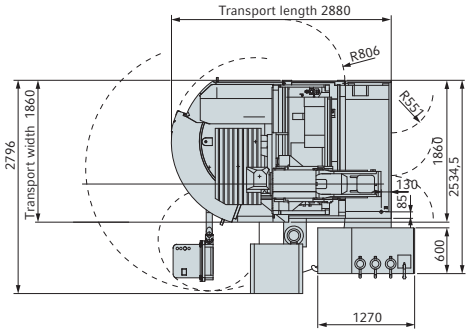
Optional 24,000 rpm



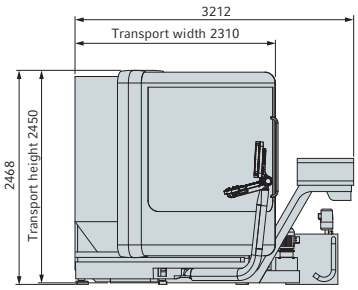
Floor Plans

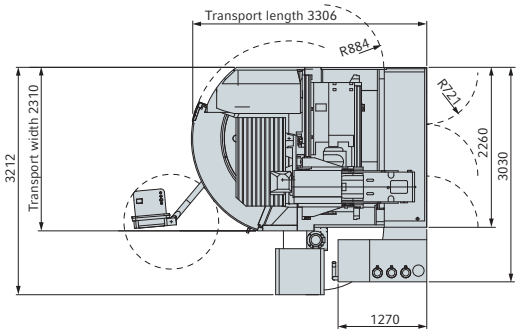
DMU 60 monoBLOCK®



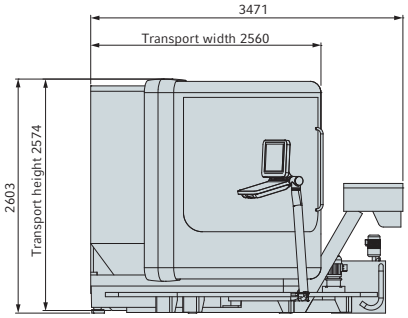


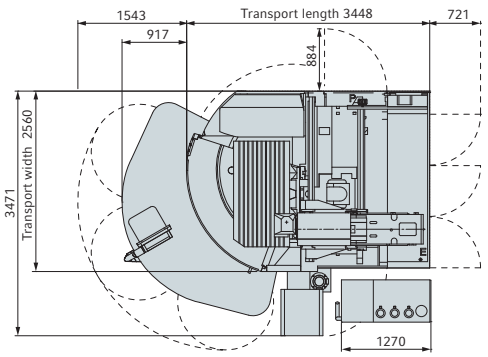
DMU 80 monoBLOCK®





DMU 100 monoBLOCK®





Technical Data

		DMU 60	DMU 80	DMU 100
Work area				
X / Y / Z-axis	mm	730 (630)* / 560 / 560	980 (880)* / 630 / 630	1,250 (1,150)* / 710 / 710
Max. rapid traverse	m/min	30	30	30
Max. feed rate	mm/min	30,000	30,000	30,000
Max. acceleration X / Y / Z	m/s^2	6 / 7 / 4	5 / 5 / 4	5 / 5 / 4
Machine weight	kg	6,800	9,500	10,700
Tool changer		•	•	•
Tool fitting		SK40	SK40	SK40
Tool magazine	type	plate magazine	plate magazine	plate magazine
Number of magazine pockets		24	32	32
Chip-to-chip time	sec	9	10	10
Main drive motor spindle		•	•	•
Output (40 / 100% DC)	kW	15 / 10	15 / 10	15 / 10
Max. torque (40 / 100% DC)	Nm	130 / 87	130 / 87	130 / 87
Max. spindle speed	rpm	12,000	12,000	12,000
Manual swivel milling head		•	•	•
Swivel range (0 = vertical / –90 = horizontal)	degrees	+12 / –91	+12 / –91	+12 / –91
NC-controlled swivel milling head (B-axis)		o	o	o
Swivel range (0 = vertical / –90 = horizontal)	degrees	+30 / –120	+30 / –120	+30 / –120
Swivel time	sec	1.5	1.5	1.5
Max. acceleration	$°/s^2$	2,300	2,300	2,300
Rapid traverse	rpm	35	35	35
Fixed table		•	•	•
Dimensions	mm	1,000 × 600	1,250 × 700	1,500 × 800
Max. load	kg	700	900	1,100
NC rotary table (C-axis)		o	o	o
Table / pallet dimensions	mm	600	700	800
Max. load	kg	500	900	1,100
Max. table speed	rpm	40	40	40
Coolant tank, standard version	litres	250	250	250
Scraper-belt chip conveyor		•	•	•
Digital drives and direct measuring systems		•	•	•
3D CNC Control		•	•	•

*5-axis version

DMG / MORI SEIKI recommends

Castrol

Options

		DMU 60	DMU 80	DMU 100
NC rotary table integrated into fixed table		o	o	o
Dimensions of the rotary table	mm	ø 600	ø 700	ø 800
Dimensions of the fixed table	mm	1,000 × 600	1,250 × 700	1,500 × 800
Max. load	kg	500	650	800
Max. acceleration	°/s²	2,000	1,200	1,200
Max. rapid traverse and feed rate	rpm	40	30	30
NC work piece unit DECKEL MAHO High-Performance		o	o	o
Swing	mm	160	160	160
Max. rapid traverse and feed rate	m/min	80	80	80
Integrated motor spindle 10,000 rpm		–	o	o
Output (40 / 100 % DC)	kW	–	30 / 20	30 / 20
Max. torque (40 / 100 % DC)	Nm	–	286 / 190	286 / 190
Tool fitting	DIN	–	SK40	SK40
Integrated motor spindle 18,000 rpm		o	o	o
Output (40 / 100 % DC)	kW	35 / 25	35 / 25	35 / 25
Max. torque (40 / 100 % DC)	Nm	119 / 85	119 / 85	119 / 85
Tool fitting	DIN	SK40	SK40	SK40
Integrated motor spindle 24,000 rpm		o	o	o
Output (40 / 100 % DC)	kW	26 / 19	26 / 19	26 / 19
Max. torque (40 / 100 % DC)	Nm	85 / 60	85 / 60	85 / 60
Tool fitting	DIN	HSK-A63	HSK-A63	HSK-A63
Tool chain magazine with 60 tool pockets		o	o	o
Chip-to-chip time	sec	10	10	10
Production package with internal coolant supply 20 or 40 bar through the spindle centre (Form AD), 600-l coolant tank, paper band filter, RotoClear, chip flusher in the work area door		o	o	o
Tool holder BT40, CAT40, HSK-A63		o	o	o
Measuring probe infrared, Heidenhain TS 649 or Renishaw OMP 60		o	o	o
Tool measurement in the work area through a laser		o	o	o
Oil and emulsion mist separator, minimal quantity lubrication, pressurised air through the spindle centre, 4-color signal lamp, dust extraction and operating mode 4		o	o	o
Machine Protection Control – MPC		o	o	o
3D quickSET® – Tool kit / Expansion package		o	o	o
ATC – Application Tuning Cycle		o	o	o
MDynamics		o	o	o
3D CNC control: Siemens 840D solutionline, Heidenhain MillPlus iT V610, or iTNC 530		o	o	o

● = standard, o = optional, – = not available, * in combination with a B-axis, ** provided that max. loads of the optional components are observed

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