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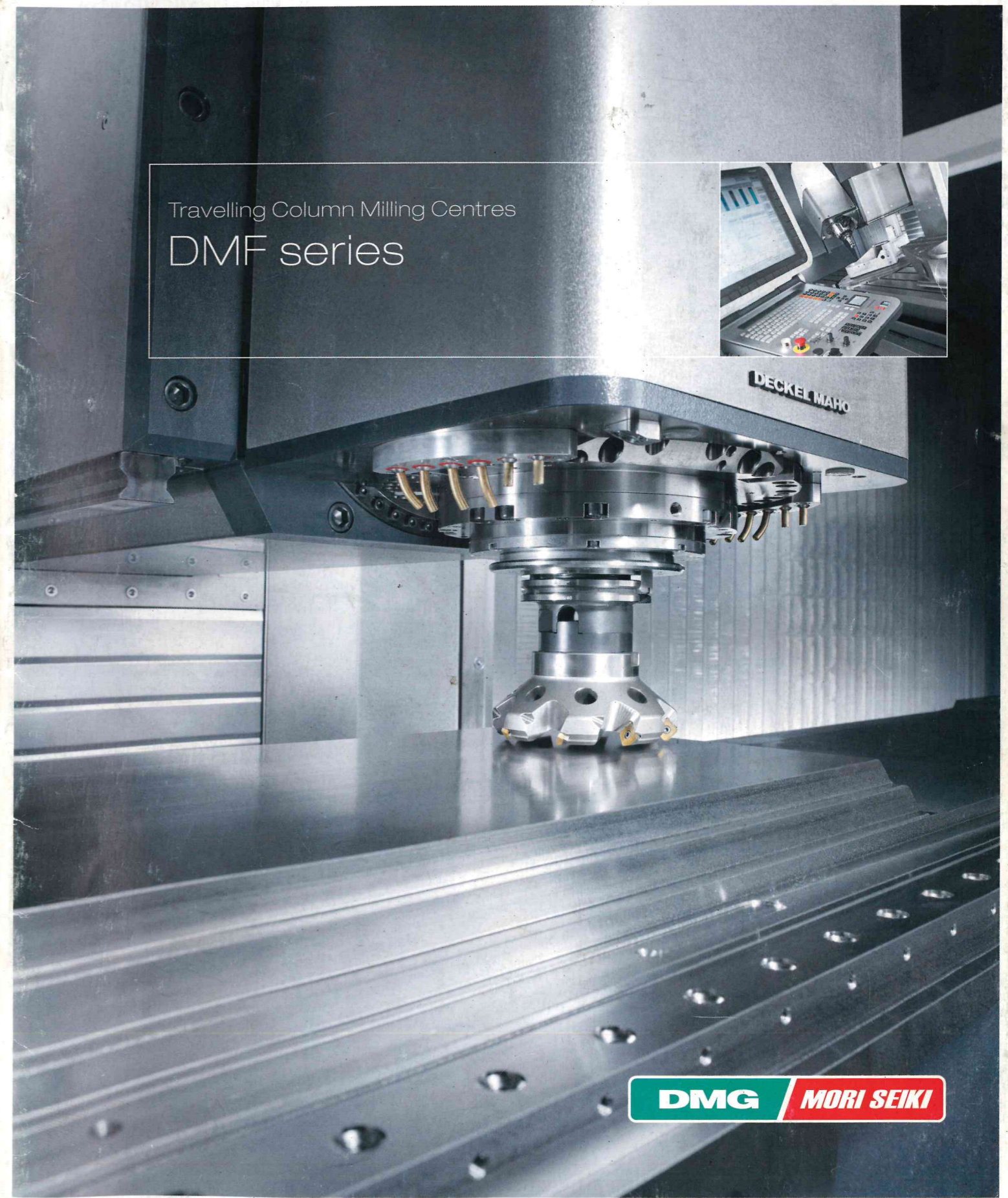
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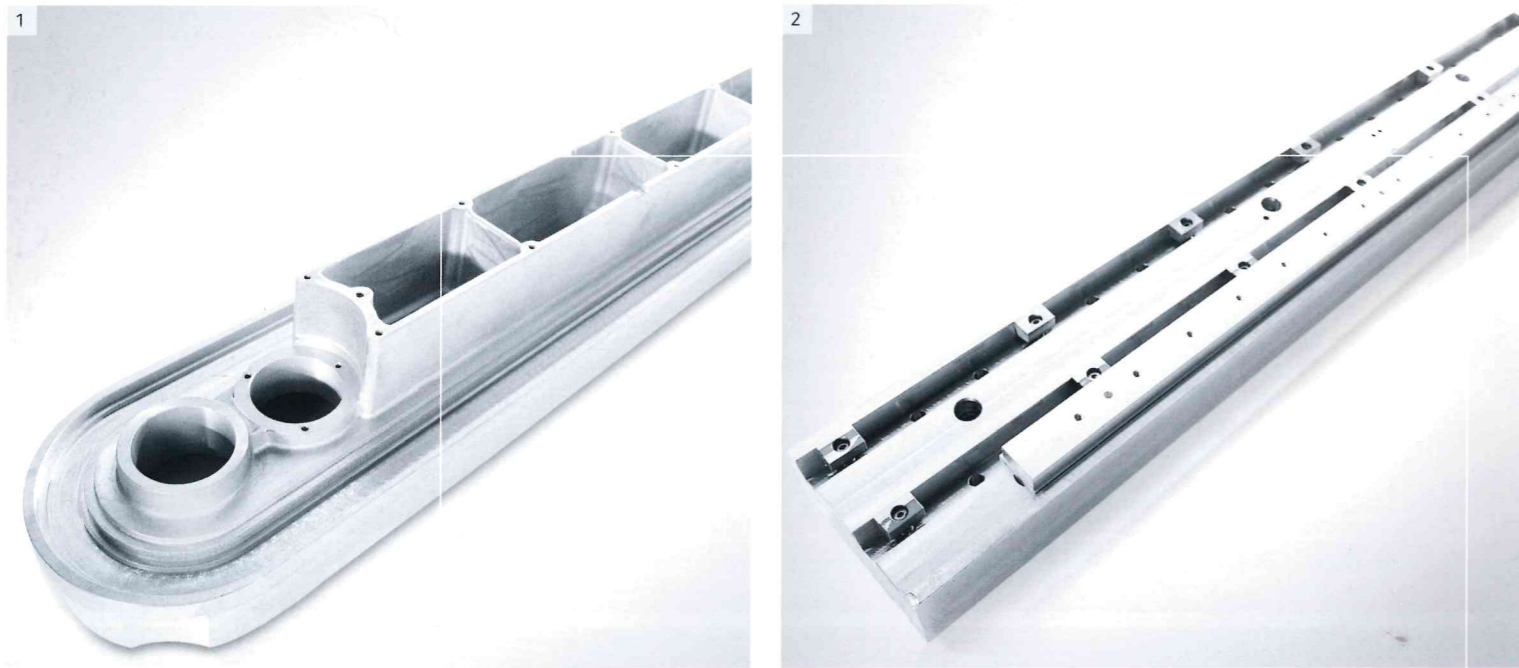
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Travelling Column Milling Centres
DMF series

MONTFORT WEHRUNG
 CC PRO D5582_0512UJK Subject to modification. Technical update rights reserved. The machines depicted here may include some options, equipment and CNC alternatives.

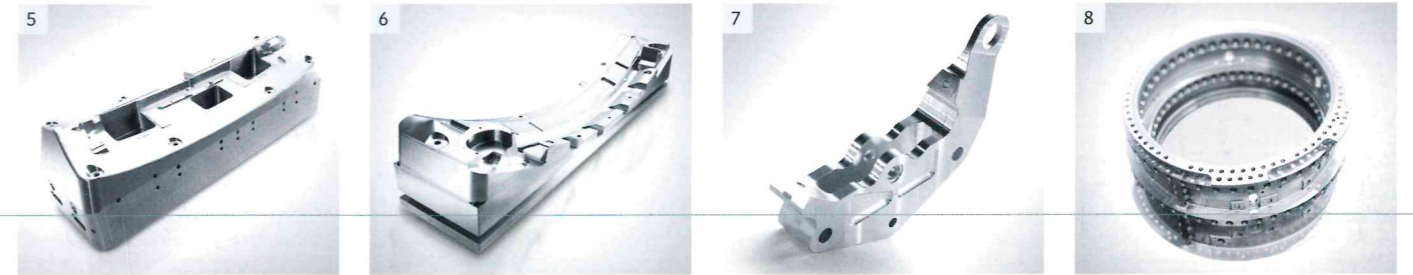


DMF series:
 Excellent chip-removal performance
 increases productivity for both long and
 complex workpieces.

DMF 180 / 260 / 360 – the 2nd generation of Travelling Column Milling Centres.

As a leading manufacturer in the travelling column milling centre product range, DMG / MORI SEIKI sets standards with the new DMF series. The DMF 180 / 260 / 360 will persuade you with impressive performance data and with an intelligent building block principle.

The DMF series is especially suitable for the machining of long work pieces, but can be set up and retrofitted for diverse tasks and industries. This applies to operations ranging from 3-axis milling up to 5-axis simultaneous machining, and from parts, roll or mould machining, all the way to applications in the aerospace industry. The series is available in two sizes: Y 700 mm and Y 1,100 mm, and in addition to the cost-effective version, it offers a dynamic version with a linear drive in the X-axis. With higher values for feed and accelerations also in Y and Z, the DMF *linear* offers the highest dynamics and precision for challenging production.



11| Connector / Automotive industry 12| Rail / Machine construction 13| FD part / Mechanical engineering
 14| Structural component / Aerospace 15| Injection mould / Tool and mould making 16| Mould insert / Tool making
 17| Actuating lever / Drive technology 18| Compressor housing / Aerospace

The sizes of the DMF series at a glance

The small series with a 700 mm traverse path in the Y-axis:

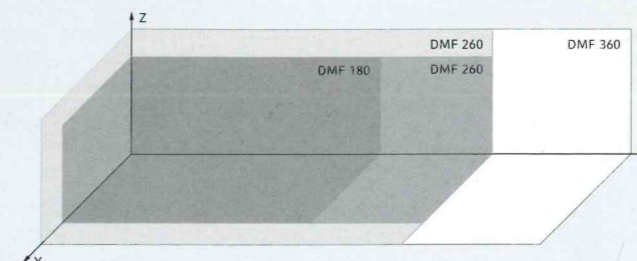
DMF 180: 1,800 / 700 / 700

DMF 260: 2,600 / 700 / 700

The large series with 1,100 mm traverse path in the Y-axis:

DMF 260: 2,600 / 1,100 / 900

DMF 360: 3,600 / 1,100 / 900



15 % greater chip-removal volume, maximum precision and a unique design.

The new DMF generation machines with thermo-symmetrical travelling column and a new work area design make 5-axis machining with large travels of 700 mm in Y and Z possible, due to the integration of NC rotary table and a swivel milling head as a controlled B-axis. The distance between the centre of the milling spindle and the table surface when the spindle is in the full pivoted position, has been reduced by 30 % in comparison to the previous model.

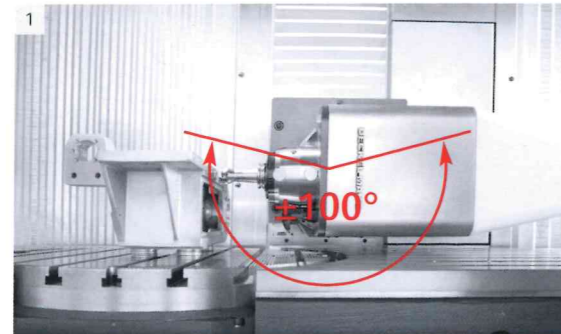
Noticably reduced chip-to-chip times due to the new design of the glide-along tool magazine as well as a 15 % increase in chip-removal volume, demonstrate the potential for production. The stability of the work area allows greater workpiece weight yet does not affect the excellent dynamic capabilities of the machine. Large viewing windows into the well-illuminated work area and the DMG ERGOline® Control with a 19" screen provide excellent ease-of-use.



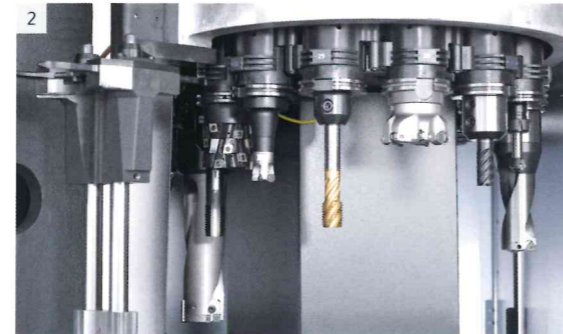
DMF 180: Precision and productivity in a new design – with a thermo-symmetrical travelling column and DMG ERGOline® Control.



DMF 260 linear: Large work area for multiple clampings with an integrated NC rotary table for 5-axis machining.



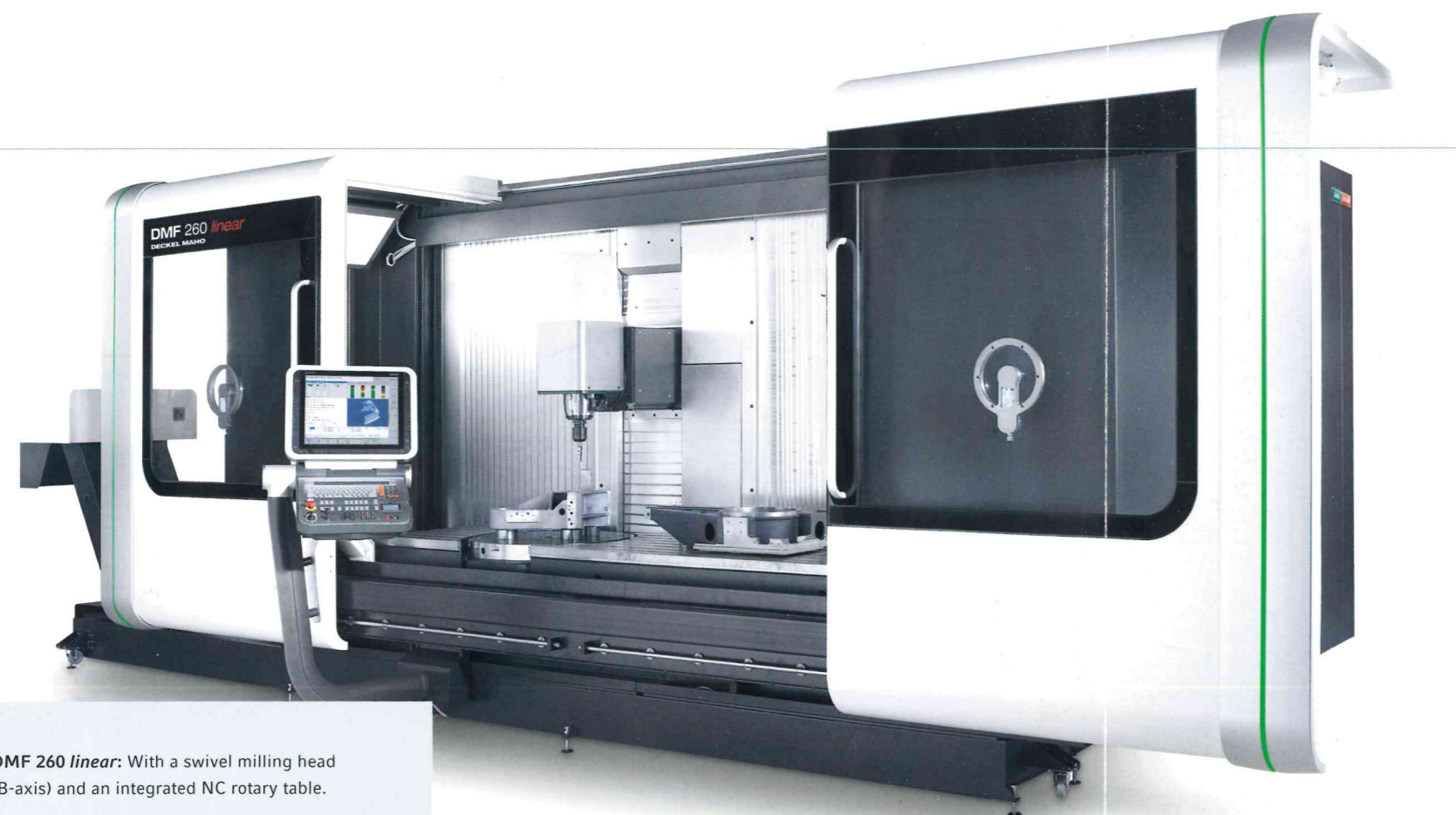
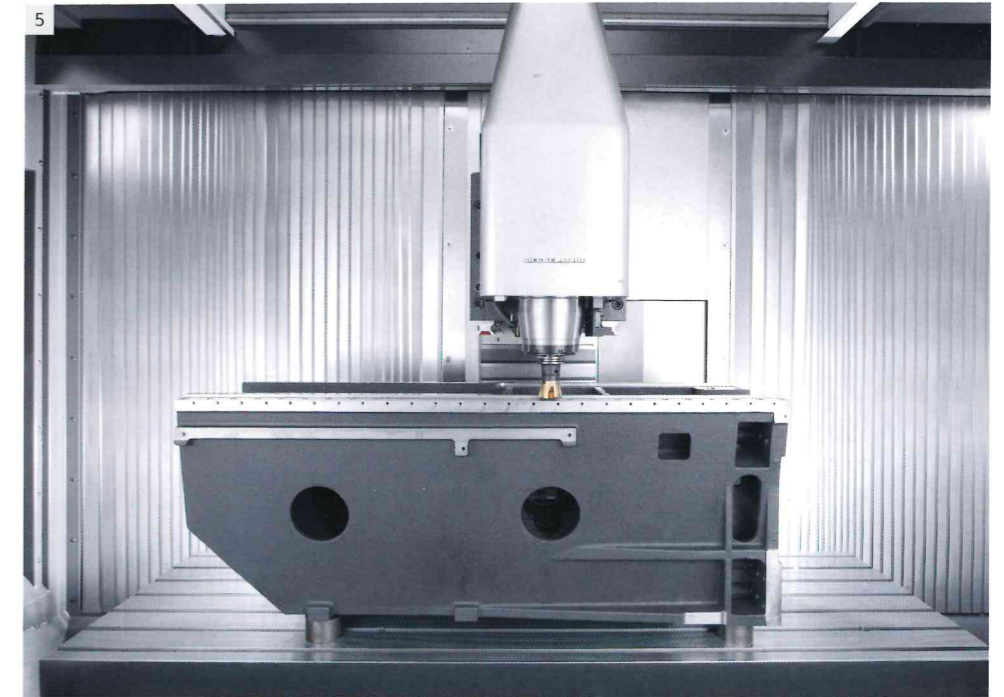
1|1 Swivel milling head (B-axis)

1|2 Tool magazine with 30 magazine pockets
(optional 60 or 120 pockets)

1|3 DMG ERGOline® Control with a 19" screen

1|4 Fast tool changer

1|5 Large work area in the DMF 180



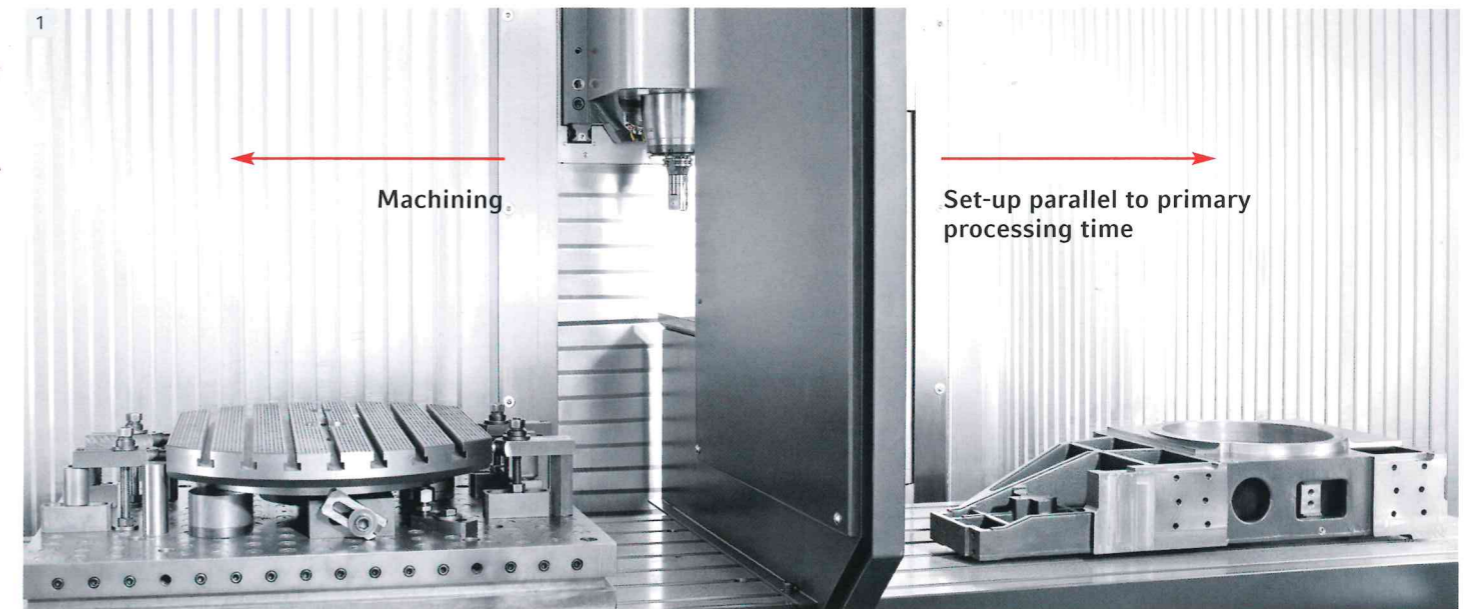
DMF 260 linear: With a swivel milling head (B-axis) and an integrated NC rotary table.

DMF 180 / 260 Highlights

- _ **Precision:** Excellent sturdiness due to a machine bed made from mineral composite, thermo-symmetrical travelling column, high precision due to linear drives with a dynamics package
- _ **Efficiency:** Standard machine with a ball screw drive at 40 m/min rapid traverse and short tool-exchange times
- _ **Productivity:** Machine with a dynamics package, linear drive at 80 m/min rapid traverse and optimised tool-exchange times
- _ **Flexibility:** Work area separator wall, integrated NC tables, proven NC attachment table, uniform expansion options
- _ **Work area:** Larger Y-travel at 700 mm (25 % more), X-axis length 1,800 mm or 2,600 mm and Z-axis length 700 mm, reduced distance between the spindle axis to the table surface in a full, pivoted position
- _ **Swivel milling head** with increased continuous torque
- _ **New design with large viewing windows** and optimal access to the work area
- _ **DMG ERGOline® Control** with a 19" screen and Siemens 840D solutionline or Heidenhain iTNC 530

Flexible power milling with 80 m/min rapid traverse and 1,100 mm in the Y-axis.

The large DMF series with 1,100 mm in Y is based on the same design as the small series. The cast iron machine bed and the thermo-symmetric travelling columns, guarantee high rigidity and long-lasting stability. Spindle options up to 18,000 rpm and the ability to integrate two NC rotary tables offer you many application possibilities, including milling / turning operations. With larger guides and higher feed forces, the large series is especially suited for heavy roughing. This picture is completed with the powerful SK50 spindle with 10,000 rpm and 303 Nm torque.



1| Work area with a traverse path in the X-axis up to 3,600 mm, 1,100 mm in Y and 900 mm in Z, for long work pieces and effective twin-table machining with a work area partition wall | 2| Linear drive in the X-axis | 3| Tool magazine with up to 120 pockets | 4| Spindle option: 10,000 rpm motor spindle with SK50 or HSK-A100



DMF 260 linear: A large work area with a 1,100 mm traverse path in the Y-axis, a B-axis with 18,000 rpm and a tool magazine with 60 pockets.

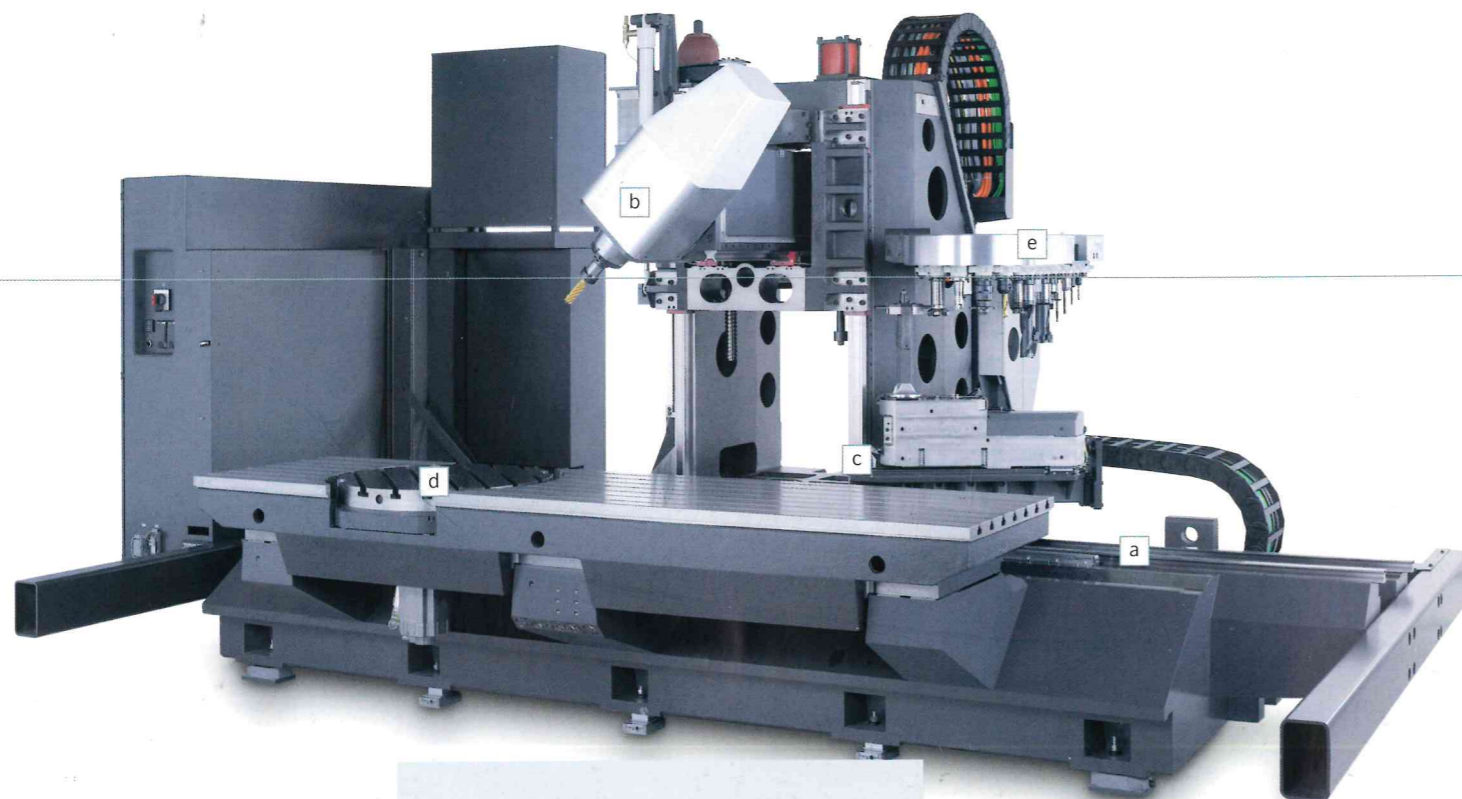
DMF 260 / 360 Highlights

- _ **Linear drive in the X-axis (optional)** for high rapid traverses and precision
- _ **Large work area** with up to a 3,600 mm traverse path in X, 1,100 mm in Y and 900 mm in Z for long work pieces and respectively the most effective twin-table machining
- _ **Standard milling spindle** with 8,000 rpm for high chip volume
- _ **Tool magazine** for 30 tools in the standard version or for 60 to 120 tools
- _ **Powerful spindle** with 10,000 rpm and SK50 / HSK-A100 (optional) also in the B-axis

New travelling column design – offered with a dynamics package with chip-to-chip times of less than 6 seconds.

At the heart of the DMF series is the highly stable machine bed, made of vibration-reducing cast iron and the thermo-symmetric travelling columns. Due to the high mass of the mineral cast, the machine possesses a lower centre of gravity and markedly higher rigidity in contrast to welding construction.

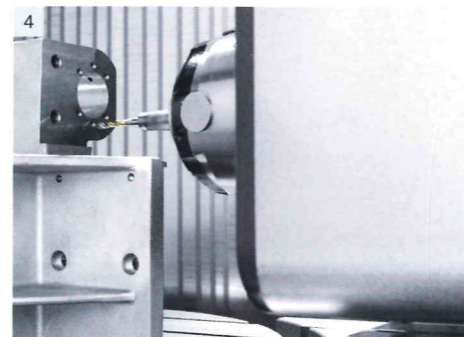
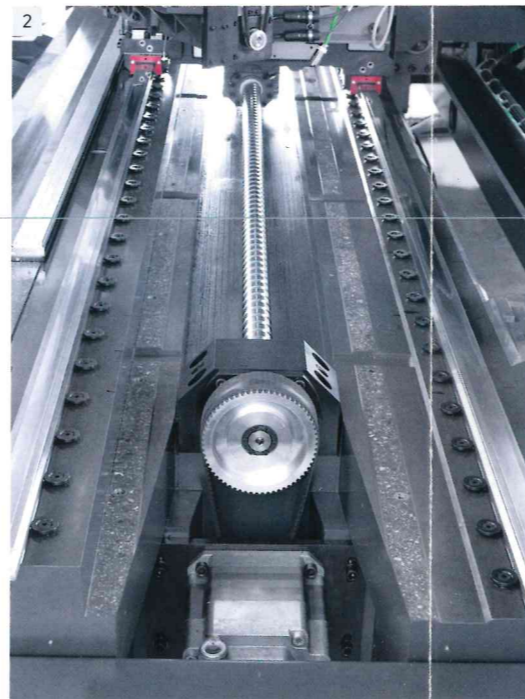
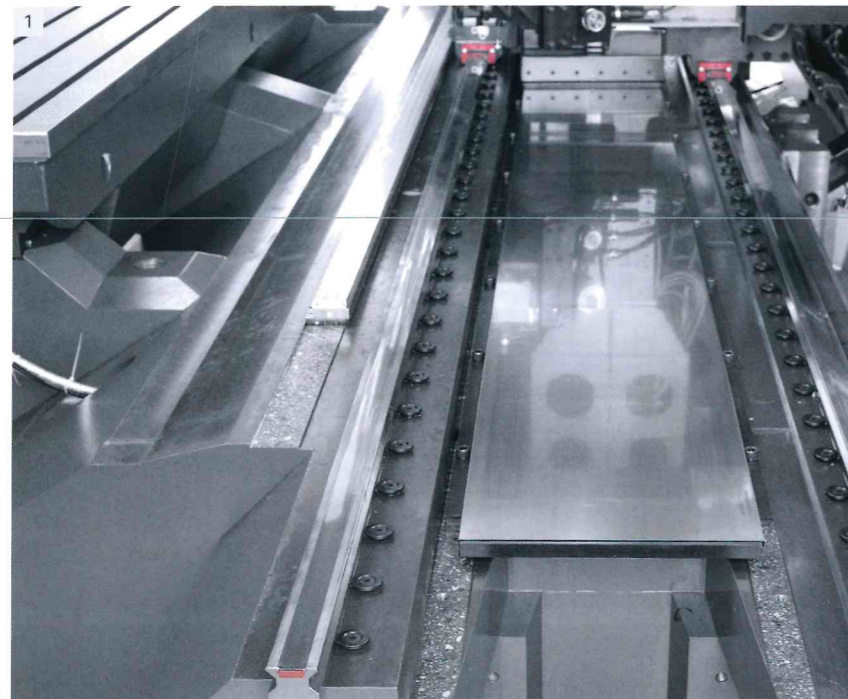
Right next to it, the travelling tool magazine is positioned so that the standard version carries 30 tools and has chip-to-chip times of less than 8 seconds. With a dynamics package, even faster chip-to-chip times of less than 6 seconds can be achieved.



DMF 260 linear: Precision and dynamics – with a thermo-symmetrical travelling column and linear drive in the X-axis.



DMF 260 linear: The configuration with the B-axis and with the integrated NC rotary table makes the new DMF fit for challenging 5-axis milling.

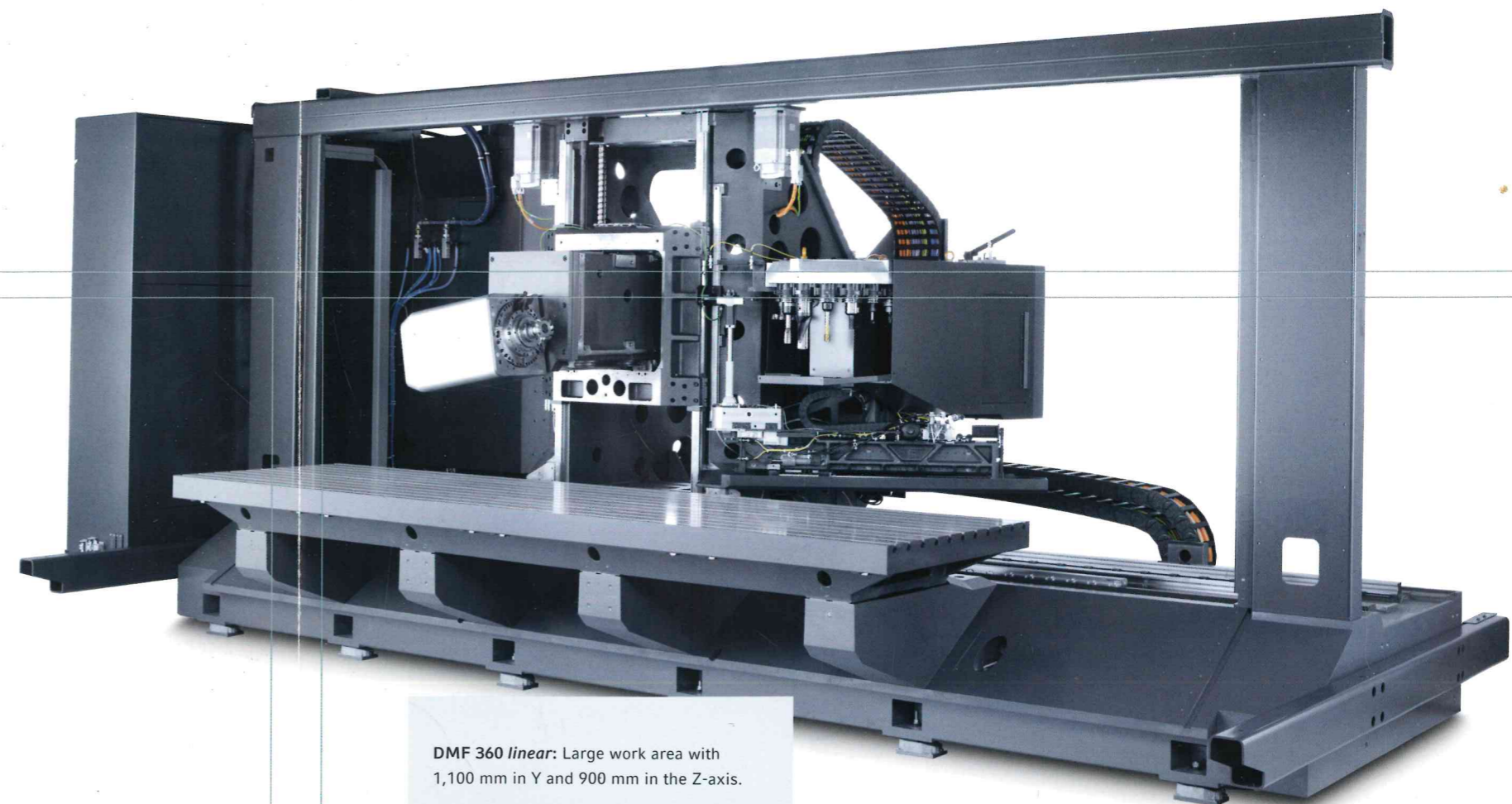


1| Direct measuring systems and linear drive in the X-axis with optional dynamics package
 2| Drive in the standard version with a ball bearing spindle
 3| Vertical spindle up to 18,000 rpm
 4| B-axis
 5| Integrated NC-rotary table

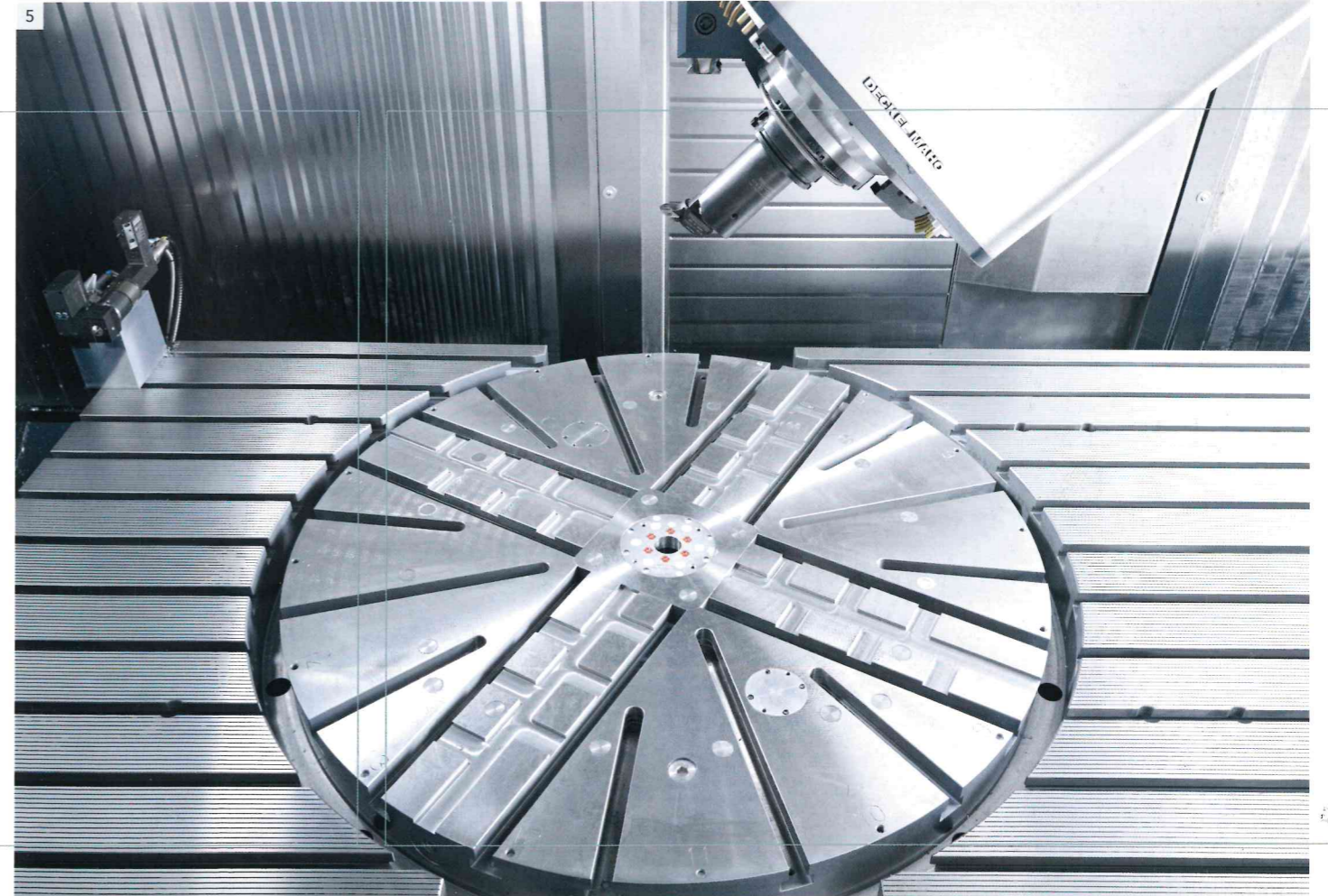
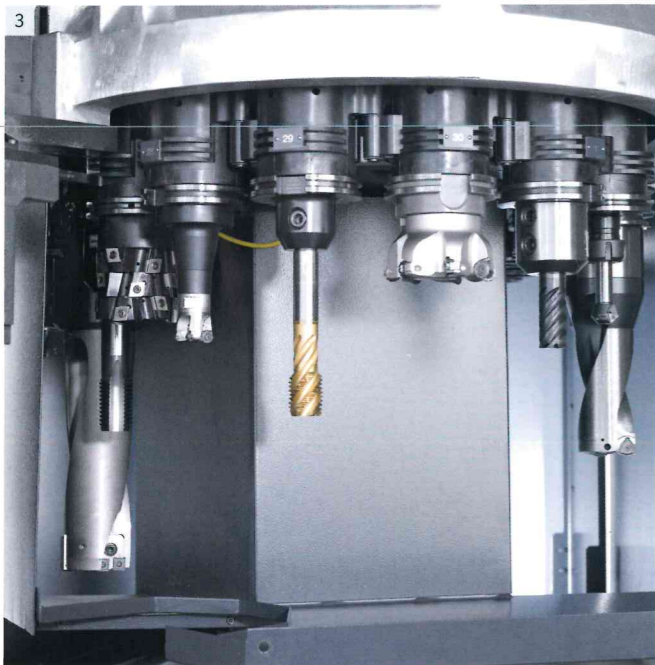
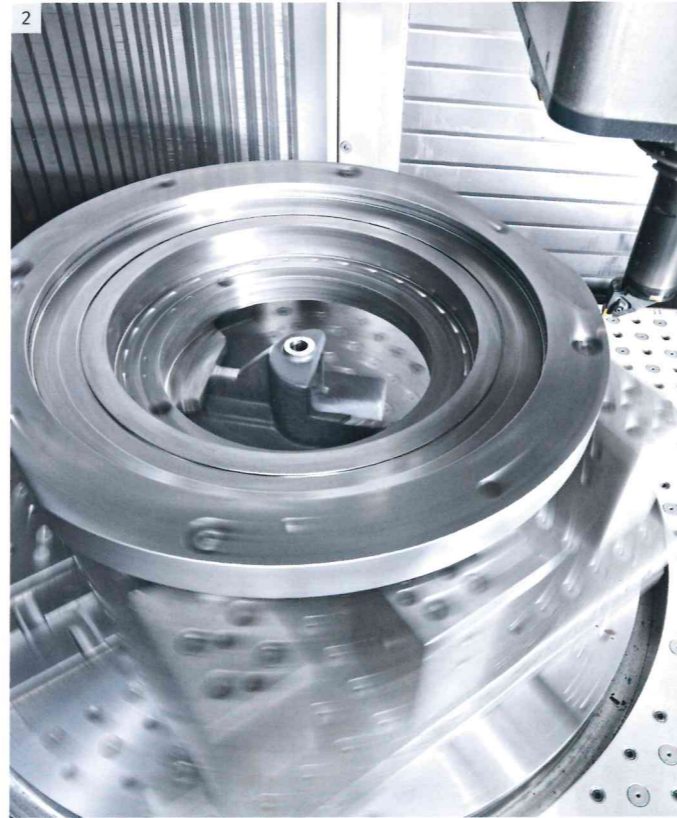
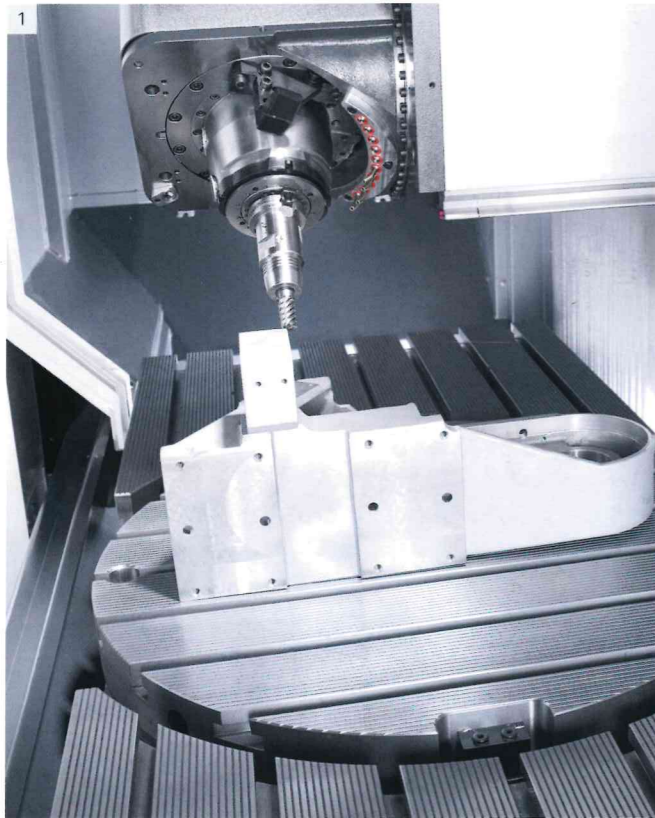
Travelling column design of the 2nd generation

- 1a| Linear drive in the X-axis* for up to 80 m/min rapid traverse, standard machine with ball screws and 40 m/min rapid traverse
- 1b| 8,000, 14,000, 18,000 or 10,000 rpm (SK50 / HSK-A100)
- 1c| Large work area with up to 1,100 mm in Y and up to 900 mm in Z
- 1d| Work table with an integrated C-axis*
- 1e| Travelling tool magazine for short chip-to-chip times

* Option



DMF 360 linear: Large work area with 1,100 mm in Y and 900 mm in the Z-axis.

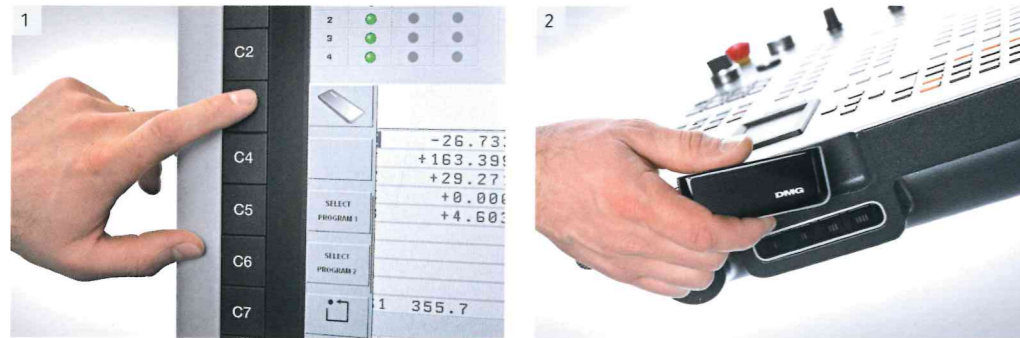


1| Integrated NC rotary table 2| Milling / drilling machining with up to 1,000 rpm 3| Tool magazine with 30 magazine pockets in the standard version, with an optional 60 or 120 pockets 4| Comfortable loading of the tool magazine through a separate door and optional setup aid 5| Integrated milling / turning table

The expansion options of the new DMF – now with a milling / turning table.

The client and his requirements decide the configuration of the machine. Whether as a standard machine with ball bearing drive or as a dynamic version with linear drive in the X-axis for the highest precision and dynamics, to the motor spindles that are available as vertical or pivoting milling heads, up to the tool magazines with 30, 60 or 120 tools or 5-axis machining. The DMF series offers the right solution for each task.

The long X-path of the DMF 260 / 360 allows the integration of two NC rotary tables, and in connection with the work area partition wall, also allows 5-axis twin-table machining of smaller work pieces with reduced set-up time. With the newly integrated FD table, now also turning operations with up to 1,000 rpm are performed in one setting. An additional offer is the familiar NC set-up table as a C- or A-axis, the corresponding tail stocks or counter bearings, as well as diverse cooling devices, air blast, minimal batch lubrication and industry-specific solutions.



1) DMG ERGOline® Control with DMG SOFTkeys® – Adaptable hot-keys for frequently used screen content or operational sequences
 2) DMG SMARTkey® – electronic access control for the personalised authorisation of the operator with user-specific access privileges for the control and the machine



ATC: Easy tuning of the feed drives at the press of a button:

This means three settings (surface, speed, precision) are made available and can be freely selected from anywhere within a workpiece program.

Your benefit: Minimised machining time combined with maximum relevant quality (for Heidenhain control).

3D quickSET: Monitoring and adjustment of axis-accuracy in the work area

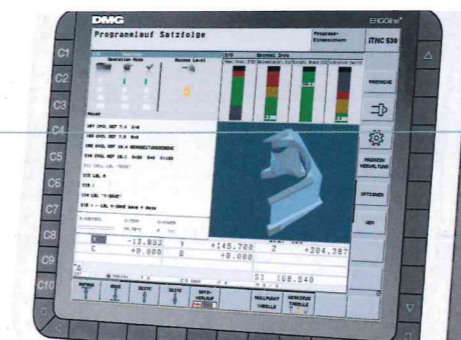
- _ Correction function for the precision of the delivery status
- _ Easy handling by the operator



DMG ERGOline® Control with a 19" screen and 3D-workpiece simulation.

The most significant highlight of the new machine design is the DMG ERGOline® Control with a 19" screen. The larger screen ensures better visibility, the integration of additional DMG SOFTkeys® and additional status information which leads to a more efficient operation. The key switch is replaced by an intelligent DMG SMARTkey® with a chip, which offers complete ease-of-use with features ranging from retrievable machine operating modes to personalised user access.

With the Heidenhain iTNC 530 or the Siemens 840D solutionline, the operator has access to state-of-the-art controls.



Heidenhain iTNC 530

- _ Shop floor or DIN-ISO programming
- _ 3D-workpiece simulation
- _ Coordinate transformation
- _ Fast program generation through visual programming
- _ Ease-of-use due to a wide range of available cycles
- _ CollisionMonitoring in the standard version for the 5-axis version



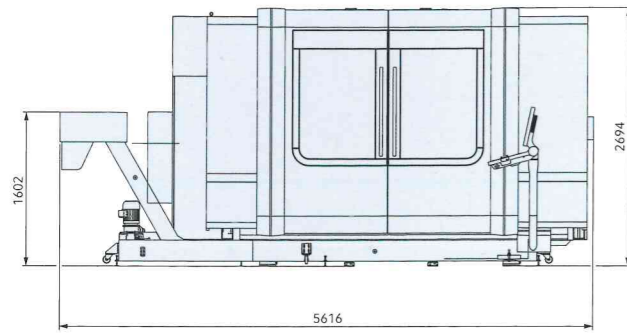
Siemens 840D solutionline

- _ Solutionline: The new systems platform for optimised communication, installation and diagnostics, based on the most advanced operating systems
- _ Online support with graphics and text
- _ 3D-workpiece graphics / 3D-cross section display
- _ Functionality for a broad application spectrum
- _ Modular 840D control system for all expansion levels

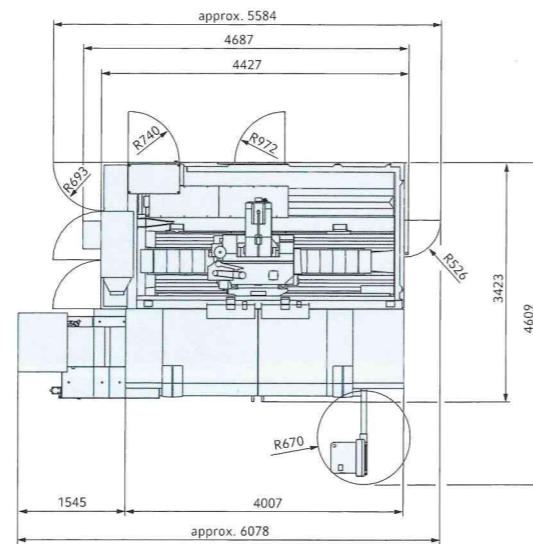
Floor Plans

DMF 180 linear with 30 tools and an optional chip conveyor

Front view

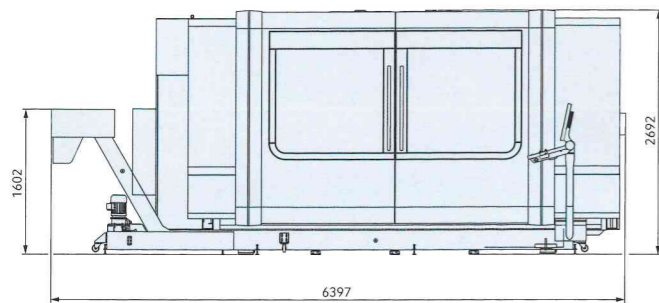


Top view

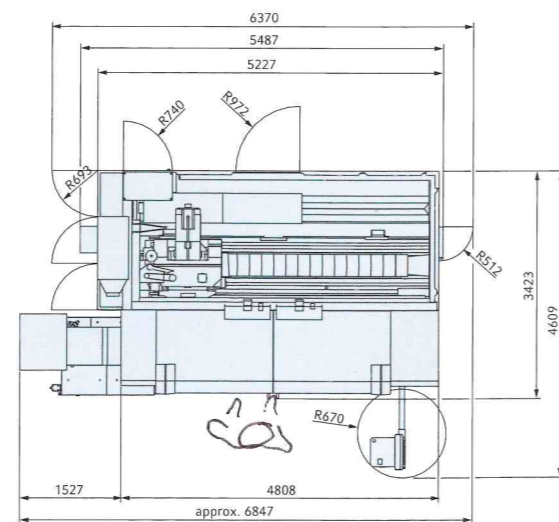


DMF 260 linear with 30 tools and an optional chip conveyor (Y = 700 mm)

Front view



Top view

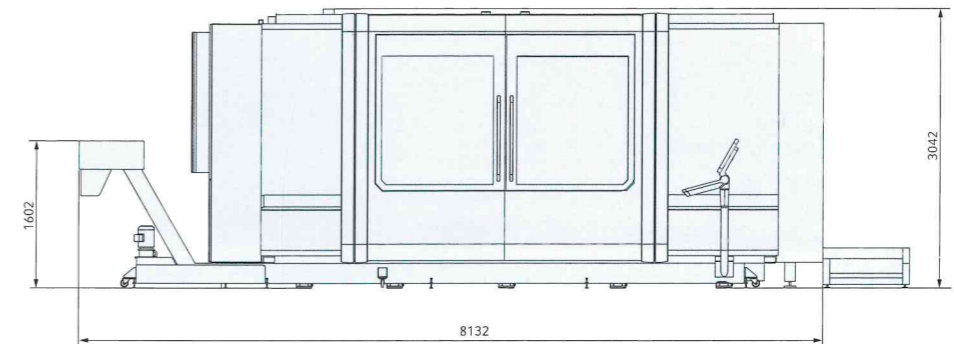


DMG / MORI SEIKI recommends

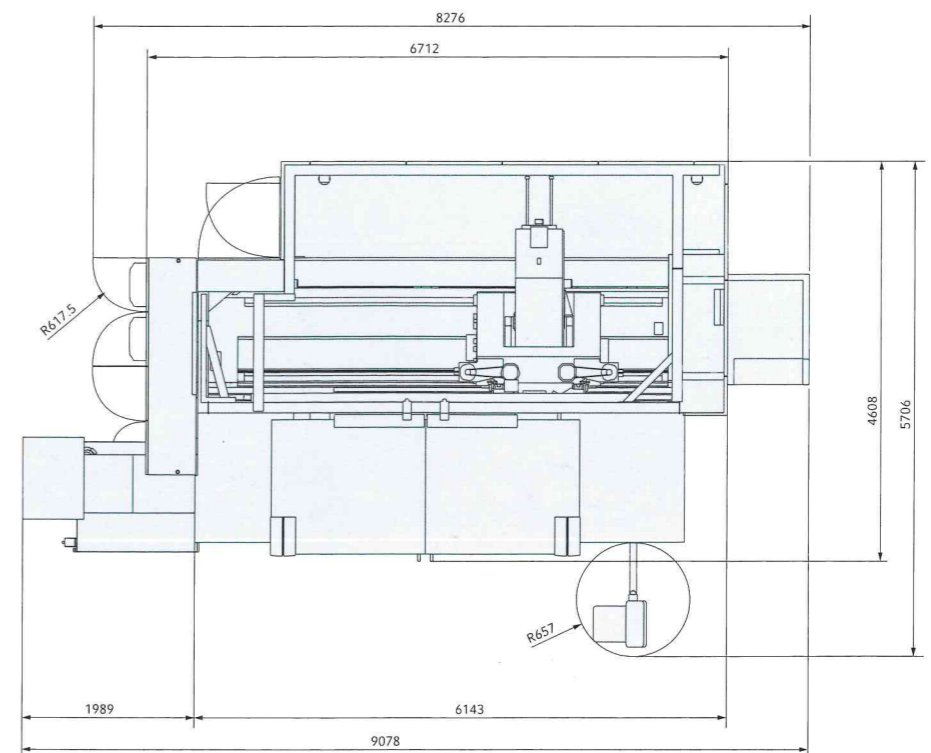


DMF 260 linear with 30 tools and an optional chip conveyor (Y = 1.100 mm)

Front view



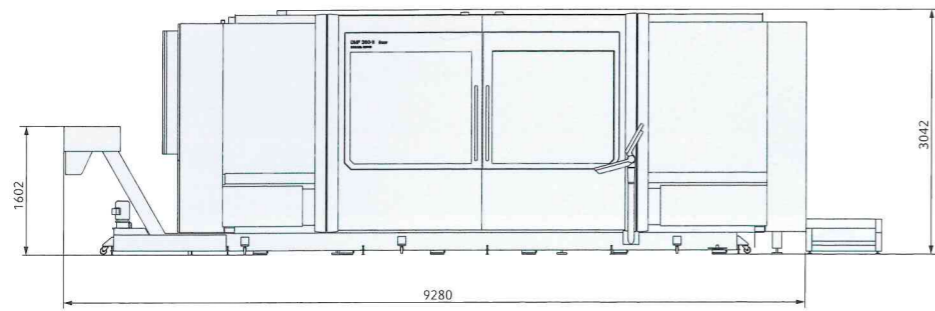
Top view



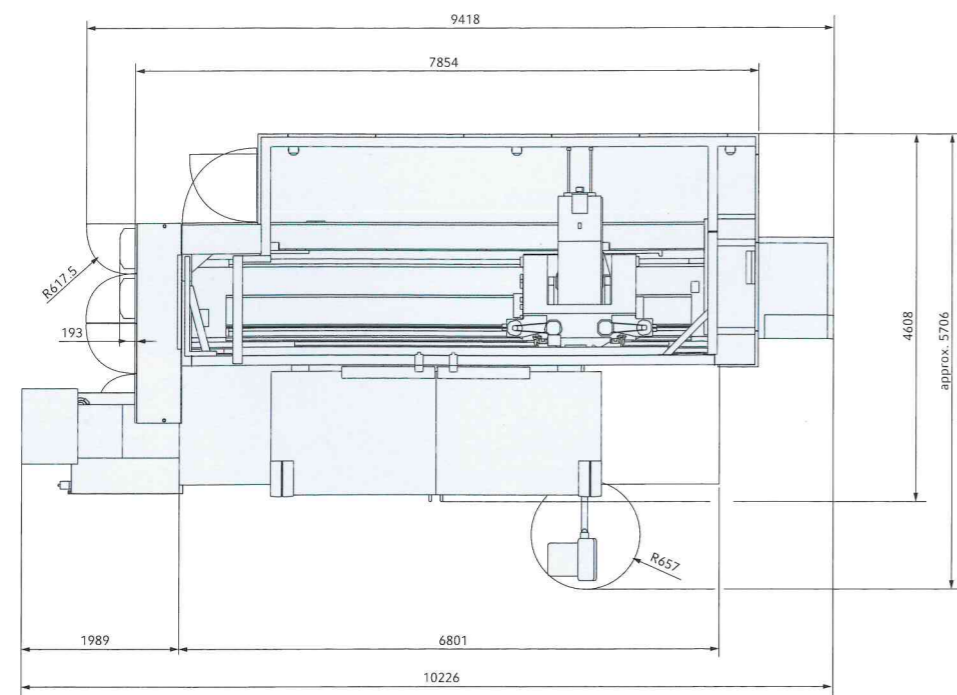
Floor Plans

DMF 360 linear with 30 tools and an optional chip conveyor

Front view



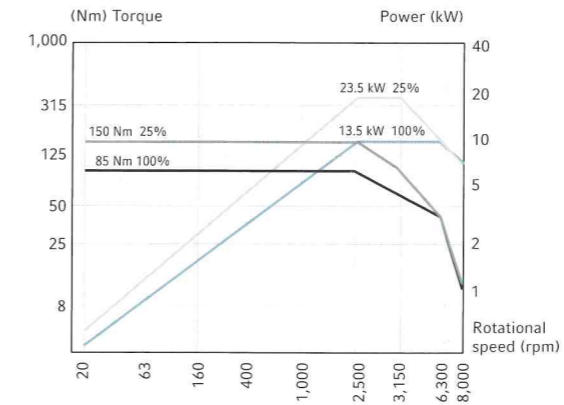
Top view



Performance Diagrams

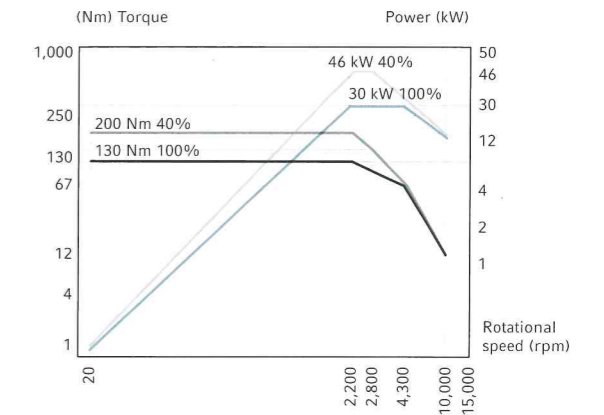
Standard 8,000 rpm

SK40



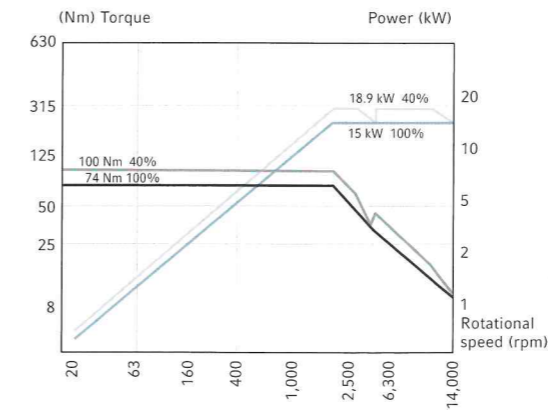
Special Option 10,000 rpm

SK40 / HSK-A63



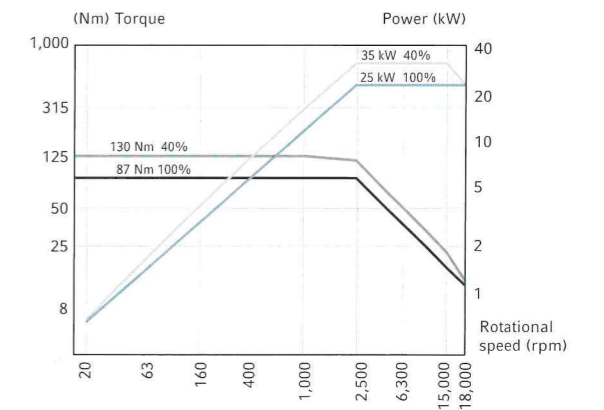
Optional 14,000 rpm

SK40 / HSK-A63



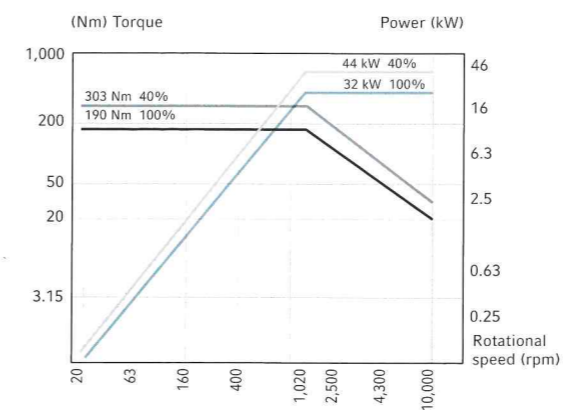
Optional 18,000 rpm

SK40 / HSK-A63



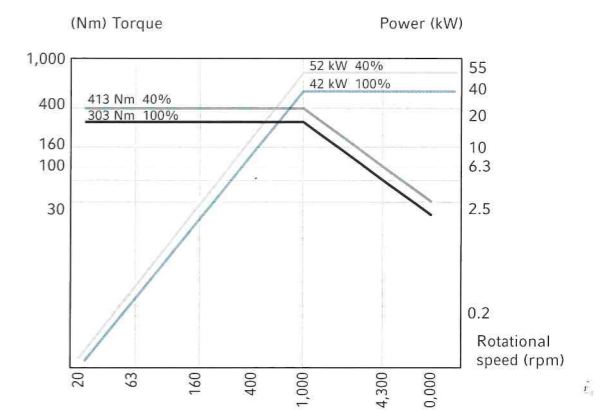
Option 10,000 rpm*

SK50 / HSK-A100



Special Option 10,000 rpm*

SK50 / HSK-A100



* Available for the large series with Y = 1,100 mm

Technical Data – Small Series

		DMF 180 / 180 linear	DMF 260 / 260 linear
Machine type			
Working range			
X-axis	mm	1,800	2,600
Y-axis	mm	700	700
Z-axis	mm	700	700
Main drive (standard)			
Speed range	rpm	8,000	8,000
Power (25 %)	kW	23.5	23.5
Tool holder		SK40	SK40
Main drive (optional)			
Speed range	rpm	14,000	14,000
Power (40 %)	kW	18.9	18.9
Tool holder		SK40 / HSK-A63	SK40 / HSK-A63
Main drive (optional)			
Speed range	rpm	18,000	18,000
Power (40 %)	kW	35	35
Tool holder		SK40 / HSK-A63	SK40 / HSK-A63
Main drive (optional)			
Speed range	rpm	-	-
Power (40 %)	kW	-	-
Tool holder		-	-
Feed drive			
Rapid traverse X (linear)	m/min	40 (80)	40 (80)
Rapid traverse Y / Z (linear)	m/min	40 (80)	40 (80)
Feed range (linear)	mm/min	40,000 (80,000)	40,000 (80,000)
Feed power X / Y / Z	kN	8	8
Measuring system for linear axes		direct (linear)	direct (linear)
Resolution	mm	0.001	0.001
Positioning accuracy P (VDI3441) X / Y / Z	µm	10	10
Tool magazine			
Number of pockets		30 (60, 120)	30 (60, 120)
Maximum tool weight	kg	6	6
Maximum tool diameter	mm	80	80
At open adjacent pockets	mm	130	130
Maximum tool lengths	mm	300	300
Work table			
Measuring of fixed table	mm	2,100 x 700	2,900 x 700
Table load	kg	1,500	2,150
Integrated NC rotary table			
Diameter	mm	750	750
Table load	kg	500	500
Control			
DMG ERGOline® Control with a 19" screen and 3D-software		Siemens 840D solutionline with ShopMill Open, Heidenhain iTNC 530 with smarT.NC	Siemens 840D solutionline with ShopMill Open, Heidenhain iTNC 530 with smarT.NC

Options

		DMF 180 / 180 linear	DMF 260 / 260 linear
Options			
Dynamics package		•	•
B-axis – swivel range	degrees	±100°	±100°
Integrated NC rotary table (C-axis)		•	•
NC dividing head (A-axis)		•	•
NC set-up table (C-axis)		•	•
Alternative tool clamps		CAT 40 / BT 40	CAT 40 / BT 40
Work area partition wall		•	•
Chip conveyor		•	•
Internal cooling devices 40 bar / 80 bar		•	•
Rotating viewing glass		•	•
Sealing air measuring systems		•	•
Tool measuring		Blum-Laser / TT140	Blum-Laser / TT140
Work piece measuring		TS649 / PP60	TS649 / PP60
Milling / turning table		•	•
Minimal batch lubrication		•	•
Air blast through the spindle centre		•	•
Clamping hydraulics		•	•
Automatic doors		•	•

Technical Data – Large Series

		DMF 260 / 260 linear	DMF 360 / 360 linear
Machine type			
Working range			
X-axis	mm	2,600	3,600
Y-axis	mm	1,100	1,100
Z-axis	mm	900	900
Main drive (standard)			
Speed range	rpm	8,000	8,000
Power (25 %)	kW	23.5	23.5
Tool holder		SK40	SK40
Main drive (optional)			
Speed range	rpm	14,000	14,000
Power (40 %)	kW	18.9	18.9
Tool holder		SK40 / HSK-A63	SK40 / HSK-A63
Main drive (optional)			
Speed range	rpm	18,000	18,000
Power (40 %)	kW	35	35
Tool holder		SK40 / HSK-A63	SK40 / HSK-A63
Main drive (optional)			
Speed range	rpm	10,000	10,000
Power (40 %)	kW	44	44
Tool holder		SK50 / HSK-A100	SK50 / HSK-A100
Feed drive			
Rapid traverse X (linear)	m/min	40 (80)	40 (80)
Rapid traverse Y / Z (linear)	m/min	40 (60)	40 (60)
Feed range (linear)	mm/min	40,000 (80,000)	40,000 (80,000)
Feed power X / Y / Z	kN	12 / 10 / 12	12 / 10 / 12
Measuring system for linear axes		direct (linear)	direct (linear)
Resolution	mm	0.001	0.001
Positioning accuracy P (VDI3441) X / Y / Z	µm	-	-
Tool magazine			
Number of pockets		30 (60, 120)	30 (60, 120)
Maximum tool weight	kg	6 (12)	6 (12)
Maximum tool diameter	mm	80 (115)	80 (115)
At open adjacent pockets	mm	130 (160)	130 (160)
Maximum tool lengths	mm	300 (360)	300 (360)
Work table			
Measuring of fixed table	mm	3,200 x 1,100	4,200 x 1,100
Table load	kg	4,000	5,000
Integrated NC rotary table			
Diameter	mm	1,050	1,050
Table load	kg	1,200	1,200
Control			
DMG ERGOline® Control with a 19" screen and 3D-software		Siemens 840D solutionline with ShopMill Open, Heidenhain iTNC 530 with smarT.NC	Siemens 840D solutionline with ShopMill Open, Heidenhain iTNC 530 with smarT.NC

		DMF 260 / 260 linear	DMF 360 / 360 linear
Options			
Dynamics package		•	•
B-axis – swivel range	degrees	±100°	±100°
Integrated NC rotary table (C-axis)		•	•
NC dividing head (A-axis)		•	•
NC set-up table (C-axis)		•	•
Alternative tool clamps		CAT 40 / BT 40 / CAT 50 / SK 50 / HSK-A100	CAT 40 / BT 40 / CAT 50 / SK 50 / HSK-A100
Work area partition wall		•	•
Chip conveyor		•	•
Internal cooling devices 40 bar / 80 bar		•	•
Rotating viewing glass		•	•
Sealing air measuring systems		•	•
Tool measuring		Blum-Laser / TT140	Blum-Laser / TT140
Work piece measuring		TS649 / PP60	TS649 / PP60
Milling / turning table		•	•
Minimal batch lubrication		•	•
Air blast through the spindle centre		•	•
Clamping hydraulics		•	•
Automatic doors		•	•