
HSC 20 *linear*

HSC 55 *linear*

HSC 75 *linear*

HSC 105 *linear*

High Speed Cutting – Highly dynamic 5-axis Precision Machining Centres

HSC 20 / 55 / 75 / 105 *linear*



Applications and Parts

5-axis HSC Precision Machining Centres

HSC Machines, Technology and Options

Automation / Innovations

Application Examples / Control Technology

Floor Plans / Power Diagrams / Technical Data



02



1



2



3



4



5



6

The complete range of HSC products in the new HSC Centre

Visit the HSC Centre to see the entire process chain for high speed machining. The latest milling and turning machines can be found in our 1,500 m² exhibition area. Together with our capable partners, we give you comprehensive support, from programming to tool selection, balancing, shrink-fitting and presetting.

In addition, our technology seminars will show you the latest trends and opportunities for production process optimisation.

Choose from a broad range of seminars. Dates and seminar programmes are available online at www.dmgmori.com

1: Machine 2: CAD / CAM 3: Tools
4: Control 5: Tool presetting 6: Balancing

HSC 20 / 55 / 75 / 105 linear

HSC newly defined – 5-axis HSC Precision Machines in a class of their own.

DMG MORI sets the course for a new dimension in high-speed machining on precision machining centres in the new HSC series, which are in a class of their own, with three to five simultaneous axes. Linear and high torque technologies in all five axes with accelerations $> 2g$ as well as spindle speeds up to 40,000 rpm deliver exceptional dynamics with absolute stability while maintaining the shortest machining times, the highest quality surfaces with $Ra < 0.2 \mu m$ and the greatest positioning accuracy at $< 5 \mu m$. Whether it is high-performance milling within large machining volumes for demanding mould making, HSC machining or micro-precision machining of complex components with filigree geometries, the HSC series has the best manufacturing solution for every application with the highest quality requirements.

Medical / Dental



Coins / Medals



Precision mechanics



Impeller



Automotive



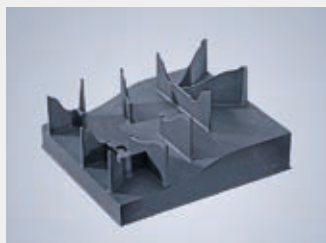
Stamping tools



Tool & mould making



Electrodes



Aerospace

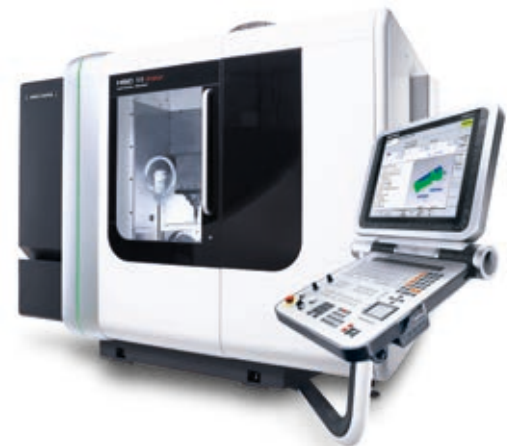


HSC 20 / 55 / 75 / 105 *linear*

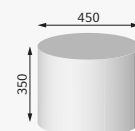
5-axis HSC Precision Machining Centres with standard technology features.

Machines in DMG MORI's HSC series are renowned for their consistently high performance, down to the last detail. Besides highly dynamic drives and high performance spindle options, numerous high-tech features provide maximum flexibility and productivity. HSC machining comprises specially calibrated software features, including Advanced Surface* or ATC (Application Tuning Cycle) which, together with the high performance SIEMENS 840D solutionline and HEIDENHAIN iTNC 530 controls, guarantee the simplest operation and the best possible machining results. The optional integration of ULTRASONIC technology in the HSC 20 / 55 *linear* expands the machining spectrum to a vast range of materials, including soft and hard, all the way up to advanced materials, glass and ceramics.

* only with SIEMENS



		HSC 20 <i>linear</i>	HSC 55 <i>linear</i>
Traverse paths			
X-axis	mm	200 */**	450* / 450**
Y-axis	mm	200 */**	580* / 650**
Z-axis	mm	280 */**	460* / 460**
Work table			
Measurements	mm	380 × 320* ø 200**	460 × 600* 400 × 400**
Workpiece weight	kg	100* / 10**	600* / 200**





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2



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- 1: Standard 5-axis options package
- 2: Linear drives with precision cooling in X / Y / Z as standard
- 3: Individual automation solutions for palletised and unpalletised workpiece handling

Highlights

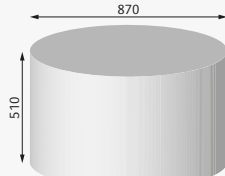
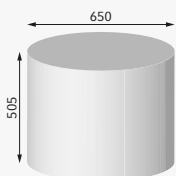
- + Thermosymmetrical portal design: high stability and consistent precision
- + Outstanding flexibility: **5-axis precision machining** with integrated swivelling / rotary axis
- + Highest dynamics and precision: **linear technology in X / Y / Z** with > 2g; water cooled torque motors in the rotary axes
- + **Max. 40,000 rpm**, water cooled HSC high performance spindle
- + **DMG MORI ERGOline® Control** with 19" screen and 3D software
- + **Consistent user interface:** available with SIEMENS 840D solutionline or HEIDENHAIN iTNC 530
- + Special software features: **ATC, MDynamics*, 3D quickSET®**

* only with SIEMENS



05

HSC 75 linear	HSC 105 linear
750* / 885**	1,050* / 1,110**
600* / 600**	800* / 800**
560* / 600**	560* / 600**
950 × 650* ø 750**	1,200 × 850* ø 950**
1,000* / 800**	1,800* / 800**



HSC 20 linear

5-axis portal machine with 42,000 rpm and linear drives with > 2 g as standard; compact, requiring only 3.5 m².

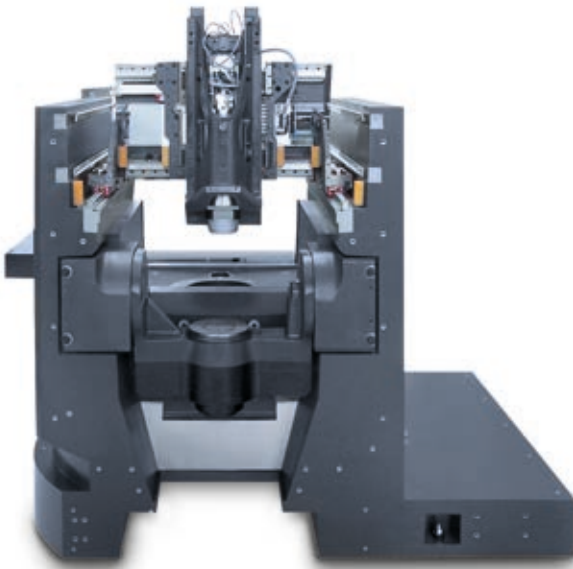
Requiring only 3.5 m² of floor space, the HSC 20 *linear* is the most compact machine in the HSC series, combining high dynamics, precision, compactness and stability in one high-tech machine tool. Linear drives with acceleration > 2 g in X / Y / Z, the water cooled, high frequency spindle with 42,000 rpm and HSK-E32 tool interface as standard (optional: 42,000 rpm with HSK-E40; 60,000 rpm with HSK-E32) as well the 5-axis portal design in a thermosymmetrical monoBLOCK[®] construction with integrated NC swivelling rotary table result in the best possible surface quality up to Ra < 0.2 µm while maintaining the greatest accuracy and dimensional stability.

HSC 20 linear:
with > 2g acceleration and
a footprint of 3.5 m², this
machine is the most
dynamic and most compact
HSC Precision Machine.





1: Workspace – integrated NC swivelling rotary table 2: 5-axis complete machining of a bone plate in titanium 3: Finish machining of a CoCr femur component
4: Linear drive in X / Y / Z with > 2g 5: 24-pocket tool changer as standard (optional: 60 pockets) 6: Watch mechanism plate



Highlights HSC 20 *linear*

- + **5-axis gantry-type portal machine** with integrated NC swivelling rotary table (A and C axes)
- + **Stable, vibration damping, cast polymer concrete base in monoBLOCK® design** – compact, requiring only 3.5 m² of floor space
- + **Linear drives in X / Y / Z with > 2g**; water cooled torque motors in the rotary axes
- + **42,000 rpm HSC spindle** with active cooling and HSK-E32 as standard
- + **24-pocket tool changer** as standard (optional: 60 pockets)

HSC 20 *linear* principal options

- + **ULTRASONIC:** flexible integration of the HSK-S32 / 40 actuator systems (optional)
- + **High performance spindle** with increased spindle torque (max. 7.8 Nm) (optional: 42,000 rpm with HSK-E40; 60,000 rpm with HSK-E32)
- + **Graphite package:** extraction unit / system for machining dust
- + **Anti-static system** for PE machining, for example
- + **Can be automated** using PH 10|100 linear magazine

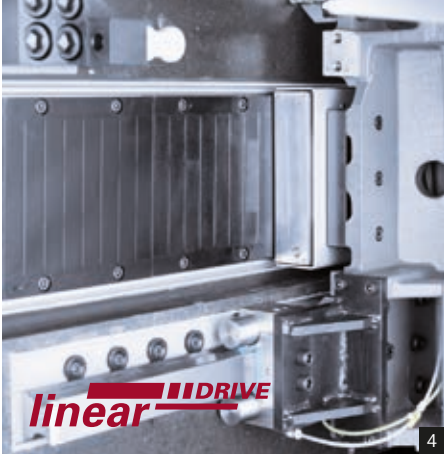
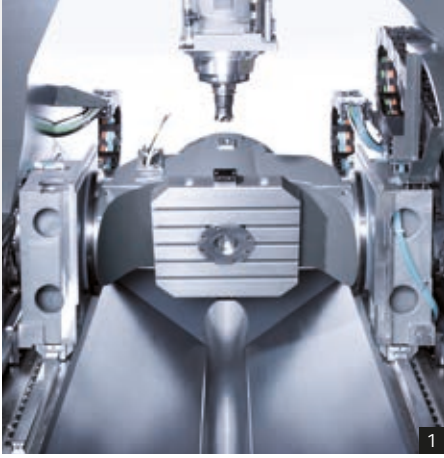
HSC 55 linear

HSC newly defined – the highest precision and dynamics.

Next generation, high speed cutting. The combination of a highly stable design, the latest drive technology and high-end spindle technology give the HSC 55 *linear* unparalleled performance during HSC machining. The foundation for the outstanding dynamics and precision of the HSC 55 *linear* is the mineral-composite machine bed in the closed gantry design. The thermosymmetrical design ensures the highest precision. Linear drives in all axes allow rapid traverses up to 80 m/min and 2.3g acceleration. In the standard version, the 28,000 HSC spindle combined with the HSK-A63 interface guarantees not only longer tool life but also improved surface finish, even during multi-axis and high metal removal rate cycles.

HSC 55 linear:
5-axis simultaneous machining
with the NC rotary table with a
gantry drive in the Y-axis.





1: Thermosymmetrical gantry design with a gantry drive 2: Tool magazine with a double gripper 3: 5-axis simultaneous machining of an injection mould made from hardened steel 4: Linear drives in X / Y / Z with > 2 g 5: 5-axis machining: integrated NC-swivelling rotary table with torque drives

Highlights HSC 55 *linear*

- + **Excellent dynamics and precision** with linear drives in all axes
- + **28,000 rpm spindle** with HSK in the standard version: high stability during chip removal, better tool life / reduced tool costs and better surfaces
- + **High performance spindle with 40,000 rpm** and the HSK-E50 (optional)
- + **Optional integration of ULTRASONIC Technology**
- + **Optimal work area configuration for HSC and graphite machining** – all drives and guideways outside the work area
- + **Thermosymmetrical design** for high, long-lasting precision
- + **Optional 5-axis machining** with a gantry drive and water-cooled torque drives
- + **16x tool changer** in the standard version (optional: 30 / 60 / 120)
- + **DMG MORI ERGOline® Control** with a 19" screen and 3D-software
- + DMG MORI developed control features especially for HSC machining, such as **ATC** (Application Tuning Cycle), **AAC** (Automatic Acceleration Control) and **AFC** (Automatic Feedrate Control)



HSC 55 *linear*: machine bed made from mineral composite: in a thermosymmetrical gantry design.

HSC 75 / 105 *linear*

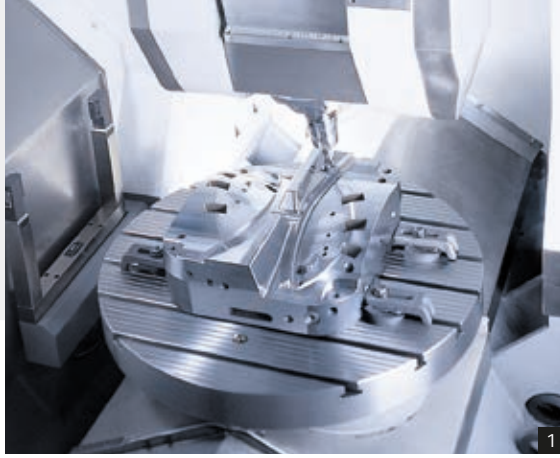
Top-class HSC Precision Machining Centres.

The HSC 75 / 105 *linear* will impress you with the highest dynamics and precision. The cast iron machine bed in a thermo symmetrical design offers absolute stability for challenging operations and forms the foundation for exceptional precision and long-lasting accuracy. Linear drives in all axes allow accelerations of > 2g as well as rapid traverses up to 90 m/min. Linear scales guarantee the highest contouring accuracy and the best surface quality.

The high torque, 18,000 rpm motor spindle in the standard version has a broad range of applications in tool and mould making. The optional 40,000 rpm high performance spindle, tool magazines with up to 180 pockets and the flexible automation solutions increase productivity and expand the range of applications.



HSC 75 / 105 *linear*:
5-axis simultaneous machining
with the NC rotary table and
a swivelling spindle (optional).



1: 5-axis simultaneous machining 2: 18,000 rpm motor spindle 3: Linear drives and measuring systems in all axes



HSC 75 / 105 linear:
cast iron machine bed: thermosymmetrical gantry design and doors at the front and side for outstanding accessibility.



Highlights HSC 75 / 105 *linear*

- + **Linear drives in all axes** for the highest precision, accelerations of > 2g and 90 m/min rapid traverse
- + **5-axis simultaneous machining** with direct drive in the spindle head and an NC rotary table (optional)
- + **18,000 rpm motor spindle in the standard version**, optional motor spindle with **28,000 rpm** (HSK-A63) or **40,000 rpm** (HSK-E50)
- + **DMG MORI ERGOline® Control** – with a 19" screen and **3D-software** HEIDENHAIN iTNC 530 or SIEMENS 840D solutionline – optimal user convenience and reduction of programming time
- + Especially for HSC machining, DMG MORI developed control features such as **ATC** (Application Tuning Cycle), **AAC** (Automatic Acceleration Control) and **AFC** (Automatic Feedrate Control)



5-axis simultaneous machining of an injection mould with the highest contour accuracy on an HSC 105 *linear* with direct drive in the spindle head and an NC rotary table.



1: Stable pallet change of < 30 seconds

2: PH 10|100 integrated automation with max. 99 pallet positions

HSC 20 linear

HSC 20 linear with a linear magazine PH 10|100 – flexible for all fixturing systems.

The integrated PH 10|100 automation solution allows up to 99 palletised workpieces to be exchanged from above. All fixturing systems on the market can be integrated. A pallet change takes < 30 seconds. Optimal accessibility and automation are assured by the 10|100 compact integrated design.



Moreover, the PH 10|100 linear magazine is available as various multi-automation upgrades including an optional double gripper for palletised and unpalletised workpiece handling (WH 10|100).



HSC 20 linear with PH 10|100 linear magazine

- + **Integrated linear magazine** with max. 99 pallet positions (max. 10 kg)
- + Dynamic and stable **pallet change < 30 seconds from above**
- + Flexibility: **integration of all available fixturing systems**
- + **Six levels as standard**, optional five additional levels
- + Configurable **pallet levels** with **3, 5, 7 or 9 pallet positions**
- + **Best accessibility**; compact, requiring only 6 m² of floor space
- + **ADVANCED version** for palletised and unpalletised workpiece handling: max. 99 workpieces (single automation), max. 297 workpieces (multi-automation, unpalletised)
- + **PROFESSIONAL version** for unpalletised workpiece handling via WH 10|100 with part drawer: max. 470 workpieces (single-automation), max 1,410 workpieces (multi-automation)



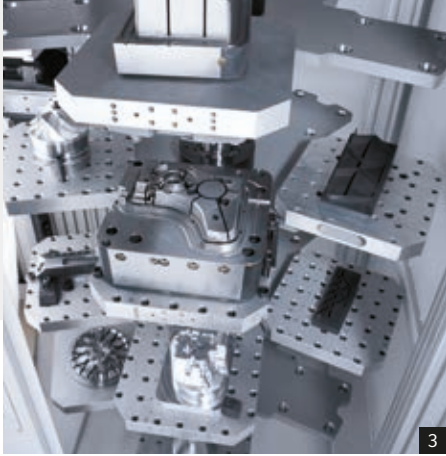
HSC 55 linear

HSC 55 linear – PH 130|70.

The new PH130|70 workpiece magazine can be simultaneously equipped with pallets of multiple sizes (such as 6 × UPC 320, 30 × ITS 148, 30 × ITS 50) and thus allows maximum flexibility. With a transfer weight of up to 130 kg, the system offers up to 70 storage positions. The machine can be loaded through the portal from behind, maintaining the unrestricted accessibility of the workspace.

HSC 55 linear with PH 130|70

- + Individual placement means the greatest flexibility
- + Pallet magazine with 70 positions for pallets of different sizes (UPC 320, ITS 148, ITS 50)
- + Simplest pallet handling with unrestricted accessibility to the workspace
- + Set-up station with control panel for loading during machining



3



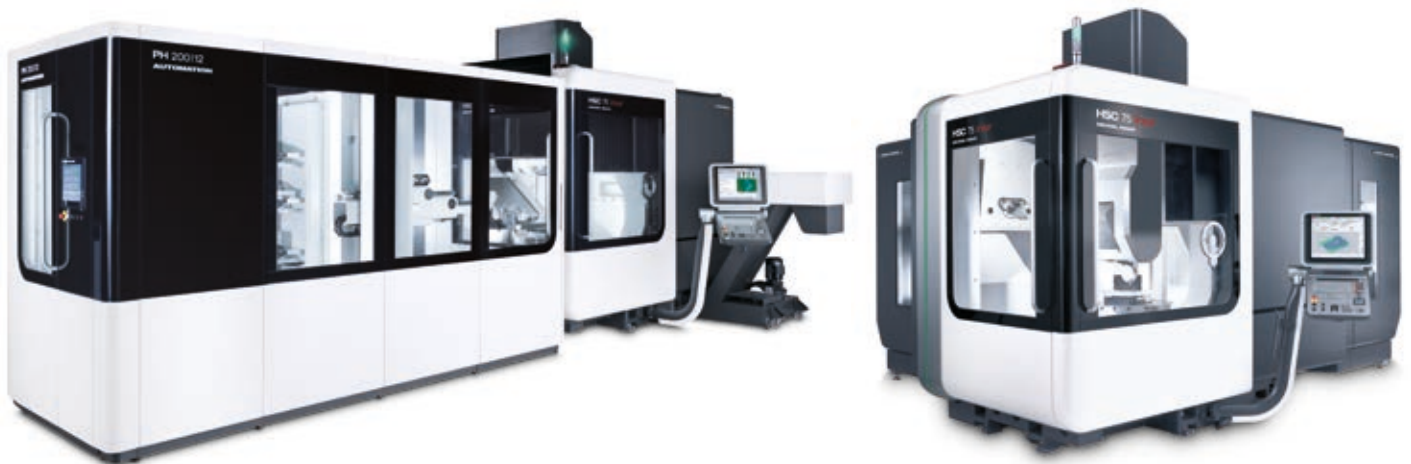
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3: Pallet storage for 20 workpieces 4: Pallet handling for parts up to 200 kg

HSC 75 / 105 linear

HSC 75 / 105 linear – pallet storage.

The HSC 75 linear and HSC 105 linear are both available with optional 20× pallet storage. Parts on standardised pallets weighing up to 100 kg can be exchanged automatically. In order to achieve the shortest set-up times, the system can be expanded through the innovative 180× tool magazine.



HSC 75 / 105 linear with pallet storage

- + **Pallet storage for 20 workpieces for the HSC 75 / 105 linear:** fully-automated exchange of the pallets through a portal, pallet sizes 320 × 320 mm and transfer weight up to 100 kg
- + **Low space requirements and great accessibility** for easy mounting
- + **Modular pallet magazine** with a transfer weight up to 500 kg
- + **Tool magazine** with up to 180 pockets

HSC 75 linear with PH 200 | 12

- + Max. 200 kg handling weight for large, heavy components
- + Pallet magazine with 12 positions for pallets of 500 × 500 mm
- + Simplest pallet handling with best accessibility and excellent visibility
- + Set-up station with control panel for loading during machining

HSC 20 / 55 / 75 / 105 *linear*

Innovations – 5-axis package and ULTRASONIC integration.



5-axis package

Standard 5-axis options packages
at an attractive price including:

- + 5-axis machine versions
- + Infrared probe for workpiece measurement
- + Laser tool measurement
- + 3D quickSET®
- + ATC software



ULTRASONIC

Flexible integration of ULTRASONIC
technology (optional)

- + ULTRASONIC integration in the HSC 20 *linear* (HSK-E32 / 40) and HSC 55 *linear* (HSK-E63)
- + Technology combination: HSC milling and ULTRASONIC hard machining of brittle, difficult-to-machine materials (advanced materials)

ULTRASONIC Technology

By means of the ULTRASONIC HSK-actuator system, the ultrasonic high frequency is transferred via induction from the spindle to the tool holder. Oscillating motion in the Z axis is generated on the rotating tool and the active process energy is significantly reduced.

HSC 20 / 55 / 75 / 105 *linear*

Application examples.



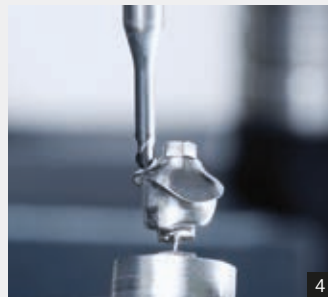
Medical

Additional application examples:

knee (zirconium), bone pin (1.2347), bone plates (titanium), prostheses (titanium), implants (Ti), cutting / drilling gauges (Ti)

1: Bone pin (1.2347)

2: Femur component (CoCr)



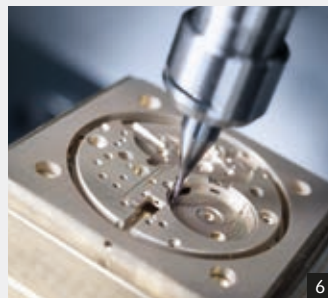
Dental

Additional application examples:

crowns, bridges, inlays, veneers, ligaments & abutments (CoCr, titanium, white ZrO₂), implants (titanium, white ZrO₂)

3: CoCr circular blank with dental crowns and bridges

4: Abutment in titanium



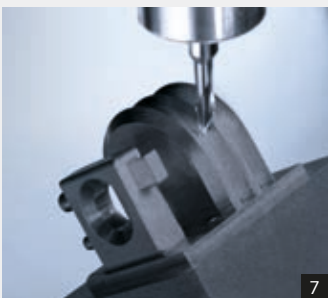
Precision mechanics

Additional application examples:

watch mechanism plates, bearing components, watch parts, watch faces, other high-precision components (light metal, steel, gold, mother-of-pearl)

5: Bores of \varnothing 0.4 mm in a light metal watch mechanism plate

6: Milling a watch mechanism plate in steel



Electrodes

Additional application examples:

graphite electrodes, copper electrodes

7 + 8: Complete machining of graphite electrodes with narrow cavities < 1 mm



Impeller

Additional application examples:

straight impeller (Ti, Al), impeller with a shaft (Ti, Al), "rolled & lined impellers" (Ti, Al), high-speed turbines (Ti), environmental technology (Al)

9 + 10: 5-axis simultaneous machining of compressor impellers in aluminium and titanium



Aerospace

Additional application examples:

impeller (titanium), blisks (titanium), blades (titanium), integral parts (Al), high-precision parts (Al)

11: Blade machining in Inconel

12: Blisk machining in titanium



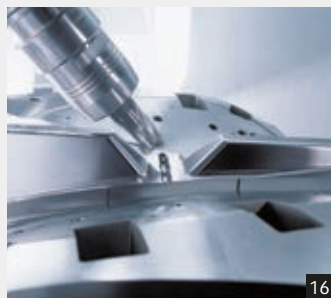
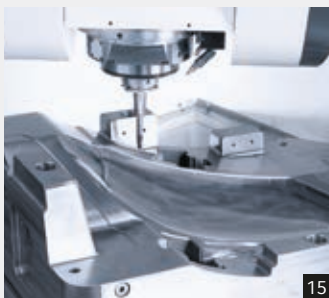
Automotive

Additional application examples:

dashboard (1.2312), radiator grill (1.2312), headlight reflector, engine cover (1.2312), tyres and rims (1.2312), gear wheels (1.2744)

13: 5-axis complete machining of an automotive rim mould in tool steel

14: Tyre mould tool



Tool and mould making

Additional application examples:

bottle mould (aluminium), fittings & screws (1.2344), embossing stamp (1.2379), forging die (1.2714), injection moulds (1.2312)

15: Highest contour accuracy: injection mould in tool steel

16: Forging die (1.2312)

HSC 20 / 55 / 75 / 105 *linear*

Modern control technology for perfect HSC performance.

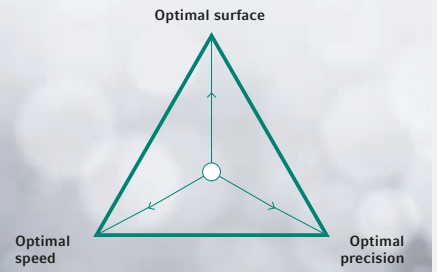
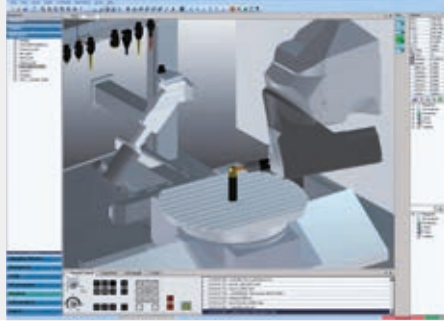
All machines in the HSC generation are equipped with the ergonomic DMG MORI *ERGoline*® Control with a 19" screen and are available with the SIEMENS 840D solutionline or with the HEIDENHAIN iTNC 530. Special functions of both control options directly support user-oriented and goal-oriented high-speed machining, and at the same time optimise the interfaces from CAD through to CNC.

Different software features are available as options such as ATC, MDynamics*, 3D quickSET® and DMG MORI Virtual Machine, which have a direct influence on workpiece quality and on process optimisation.

* only with SIEMENS



- **Screen tilt**
Continuously adjustable from 5–30°
- **Screen surface**
Easy to clean, level screen surface
- **DMG MORI SOFTkeys®**
Customisable hotkeys for frequently selected screen contents or operator sequences
- **Keyboard incline**
Continuously adjustable from 15–70°
- **DMG MORI SMARTkey® with a transponder**
Personalised user authorisation with respective access rights to the control and the machine. Additional functionality with transponder technology: individual allocation of user data, control mode selection switch and the latest safety system for unauthorised use.
- **Seat**
Integrated seating for the operator (optional)

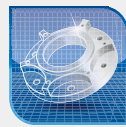


SIEMENS 840D solutionline

- + Easy, interactive CNC programming
- + Fast editing of large CNC programs
- + Comprehensive 5-axis functionality
- + Quick-view simulation of complex program sections
- + Direct spline machining from CAD data
- + Efficient tool management

DMG MORI Virtual Machine

The 1:1 simulation of your machine – integration of geometry, kinematics and dynamics with your DMG MORI machine including all functionalities of CNC and PLC – increase your efficiency with total production safety and a reduction in setup times of up to 80 %!



ATC

Easy tuning of the feed drives at the press of a button: using three settings (surface, speed, precision) that are customisable within a workpiece program. **Your benefit:** minimisation of processing times with maximisation of the relevant quality (also based on workpiece weight).

Available for SIEMENS and HEIDENHAIN controls

ATC Application Tuning Cycle



HEIDENHAIN iTNC 530

- + Shop floor or DIN / ISO programming
- + 3D workpiece simulation
- + Conversational programming
- + Coordinate transformation
- + Rapid program creation
- + Convenience with comprehensive cycle selection

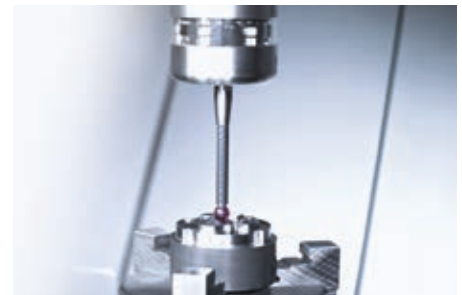


MDynamics

- + **Highest processing speed** with optimised change of direction
- + **Perfect surface quality** with an optimal speed profile through an integrated "Advanced Look-ahead" feature
- + **Exact contour accuracy** with an optimised compressor

Exclusive SIEMENS software package

MDynamics



3D quickSET®

Easy testing and correction of axis precision in the working area: precision balancing of the kinematics at the press of a button.

Available with the Renishaw or BLUM measuring probe

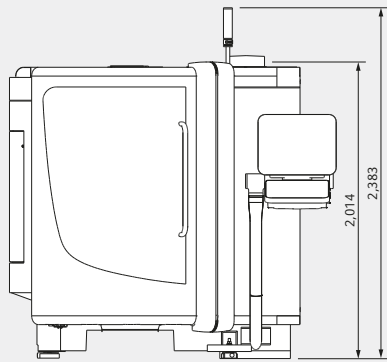
3D quickSET

HSC 20 / 55 / 75 / 105 *linear*

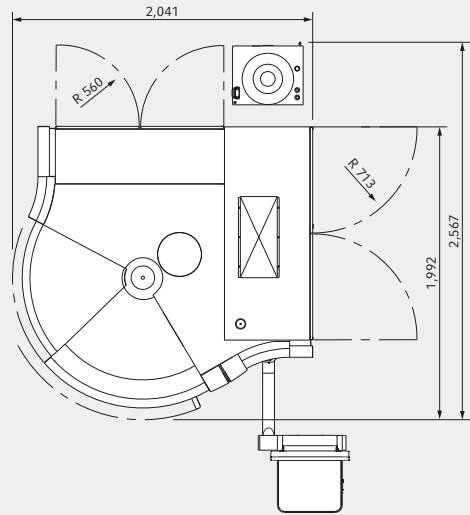
Floor Plans

HSC 20 *linear*

Front view

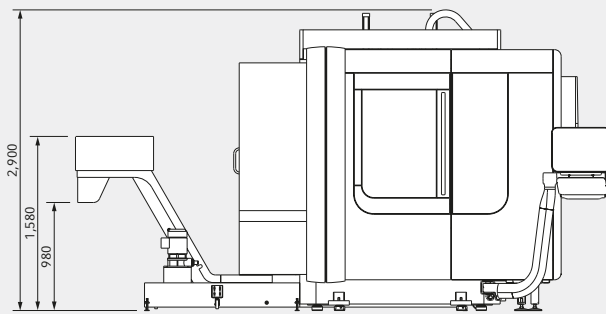


Plan view

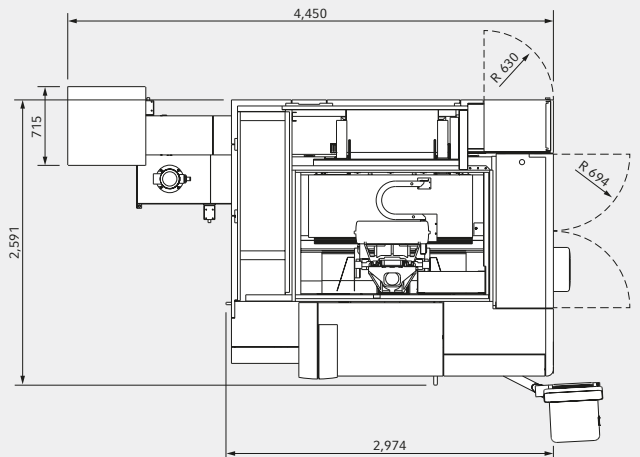


HSC 55 *linear*

Side view

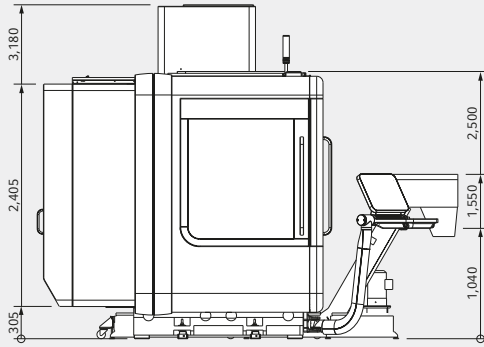


Plan view

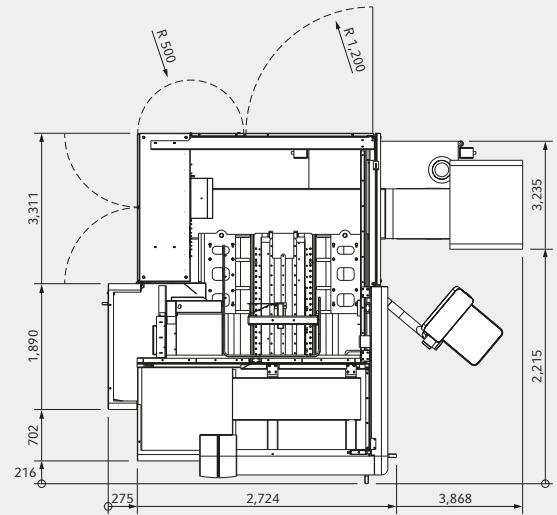


HSC 75 linear

Side view

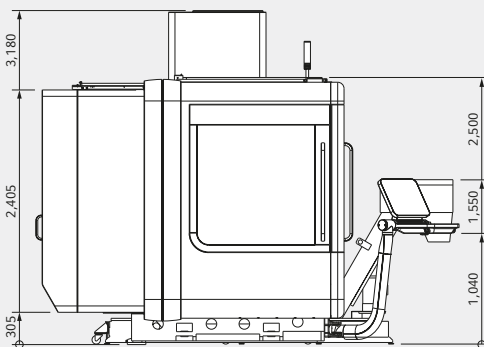


Plan view

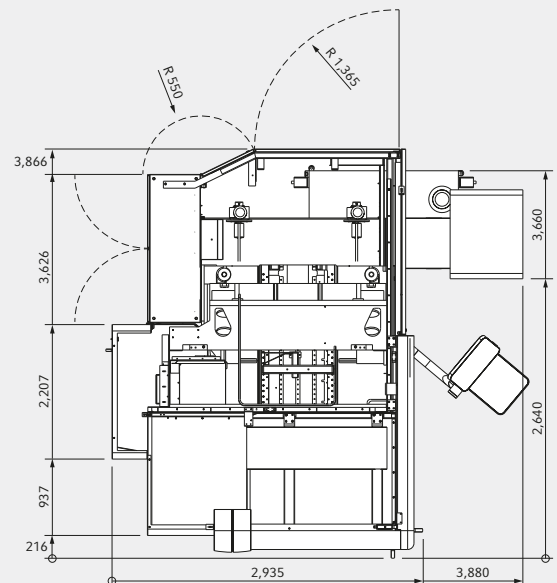


HSC 105 linear

Side view



Plan view

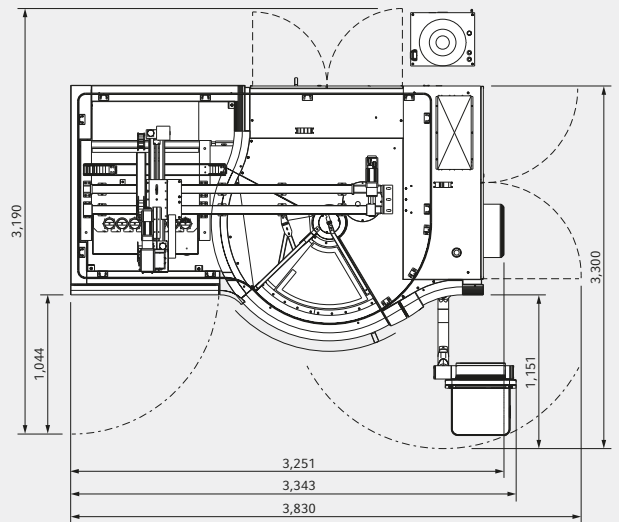
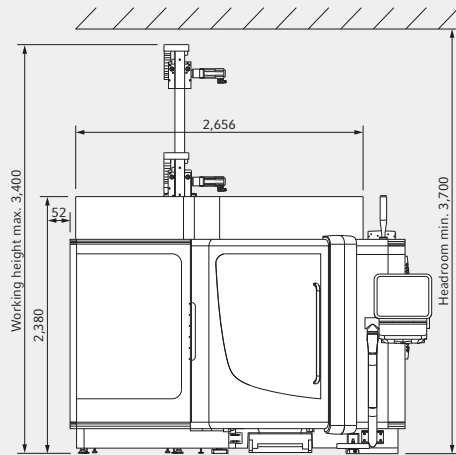


HSC 20 / 55 / 75 / 105 linear

Floor Plans

Automation with PH 101100

HSC 20 linear

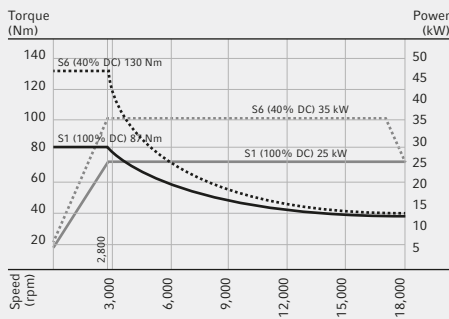


HSC 20 / 55 / 75 / 105 linear

Power Diagrams

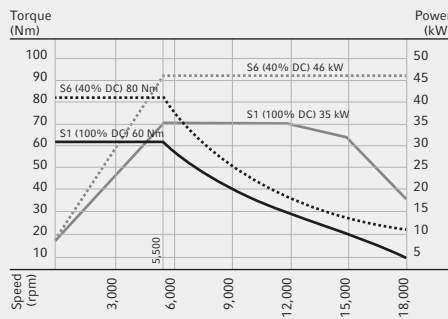
18,000 rpm

HSC 75 / 105 linear (3-axis version)



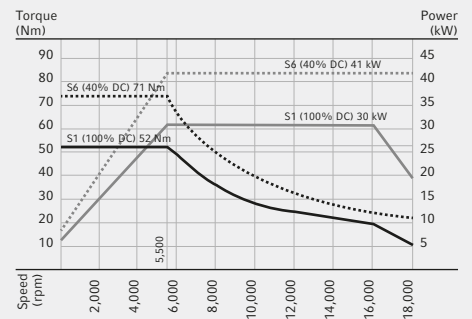
18,000 rpm

HSC 75 / 105 linear (5-axis version)



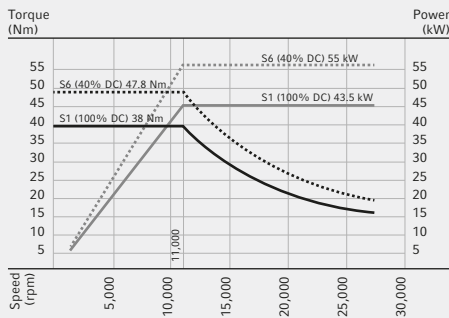
18,000 rpm

HSC 55 linear (3- / 5-axis version)



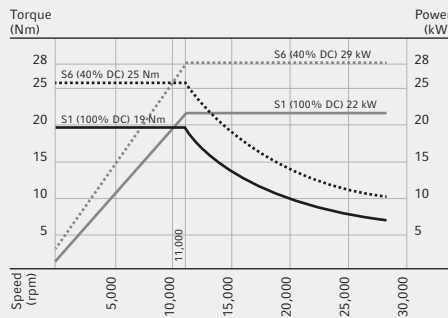
28,000 rpm

HSC 75 / 105 linear



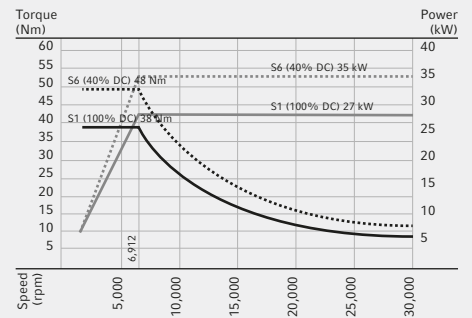
28,000 rpm

HSC 55 linear (standard spindle)



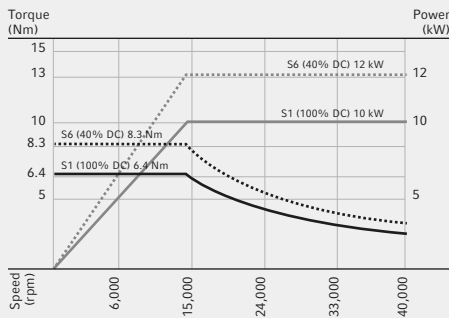
28,000 rpm

HSC 55 linear (power spindle)



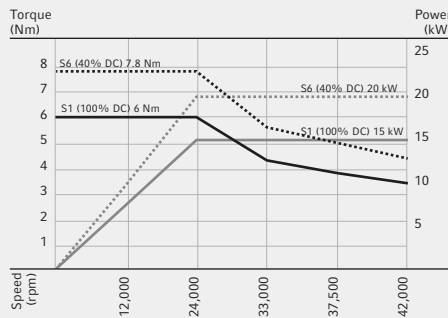
40,000 rpm

HSC 55 / 75 / 105 linear



42,000 rpm

HSC 20 linear



HSC 20 / 55 / 75 / 105 *linear*

Technical Data

Work area

X-axis	mm
Y-axis	mm
Z-axis	mm
Swivel axes (A / B)	degrees
Rotary axis (C)	degrees

Spindle

Maximum spindle speed	rpm
Power (40 / 100 % DC)	kW
Torque (40 / 100 % DC)	Nm
Toolholder	DIN 69893
Speed (optional)	rpm
Power	kW
Torque (40 / 100 % DC)	Nm
Toolholder	DIN 69893
Speed (optional)	rpm
Power (40 / 100 % DC)	kW
Torque (40 / 100 % DC)	Nm
Toolholder	DIN 69893

Feed

Maximum feed rate	mm/min
Rapid traverse X / Y / Z	m/min

Table

Clamping surface fixed table	mm
Max. workpiece weight	kg
Clamping surface NC table	mm
Speed of the rotary axis (C)	rpm
Max. workpiece weight	kg

Acceleration

Max. acceleration	g
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Tool

Tool magazine	pockets
Max. tool length	mm
Max. tool diameter	mm
Chip-to-chip time	s

Options packages

Integration ULTRASONIC***
Standardised 5-axis package***
Automation***

Control

DMG MORI ERGOline® Control with a 19" screen and 3D-software

Software options with SIEMENS: ATC, MDynamics, 3D quickSET®

Software options with HEIDENHAIN: ATC, 3D quickSET®

• standard, ◦ optional, – not available, * optional, ** 5-axis version, *** see pages 14–17

HSC 20 linear	HSC 55 linear	HSC 75 linear	HSC 105 linear
200	450	750 (885)**	1,050 (1,110)**
200	580 (650)**	600	800
280	460	560 (600)**	560 (600)**
-10 / +130	+10 / -110	-10 / +110	-10 / +110
360	360	360	360
42,000	28,000	18,000	18,000
20 / 15	29 / 22 (35 / 27)	35 / 25 (46 / 35)	35 / 25 (46 / 35)
7.8 / 6	25 / 19 (48 / 38)	130 / 86 (80 / 60)	130 / 86 (80 / 60)
HSK-E32	HSK-A63	HSK-A63	HSK-A63
42,000	18,000*	28,000*	28,000*
-	41 / 30	55 / 43.5	55 / 43.5
-	71 / 52	47.8 / 38	47.8 / 38
HSK-E40	HSK-A63	HSK-A63	HSK-A63
60,000	40,000*	40,000*	40,000*
-	12 / 10	12 / 10	12 / 10
-	8 / 6	8 / 6	8 / 6
HSK-E32	HSK-E50	HSK-E50	HSK-E50
40,000	80,000	90,000	90,000
40 / 40 / 40	80 / 80 / 80	90 / 90 / 90	90 / 90 / 90
380 × 320	460 × 600	950 × 650	1,200 × 850
100	600	1,000	1,300
∅ 200	400 × 400	∅ 750	∅ 950
200	110	100	100
10	200	800	800
> 2 g	> 2 g	> 2 g	> 2 g
24 (60)*	16 (30 / 60 / 120)*	30 (60 / 120 / 150 / 180)*	30 (60 / 120 / 150 / 180)*
200	250	300	300
30	80	80 / 140	80 / 140
7	6	6	6
◦	◦	-	-
◦	◦	◦	◦
◦	◦	◦	◦

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