



HIGH PRODUCTIVITY
COMPACT VERTICAL MACHINING CENTER

DNM

4000



Doosan Machine Tools

DNM 4000

The DNM 4000 is a compact vertical machining center with a 400mm Y-axis stroke and a directly-coupled 40 taper spindle. By reducing the machine's width, the footprint has been minimized but productivity, owing to the DNM 4000's high acceleration/deceleration rates, has been increased.





EASY OPERATOR ACCESS AND EXCELLENT CHIP DISPOSAL

- Designed with two doors for easy operator access to the working area.
- Bed flushing occurs on both left and right sides to optimize chip removal. This is especially useful when high chip volumes are produced.

STANDARD DIRECTLY-COUPLED SPINDLE FOR HIGHER PRODUCTIVITY

- The directly-coupled spindle reduces vibration and noise, thereby improving the machine's performance and environmental-friendliness
- Higher productivity is achieved by improving and increasing the machine's acceleration/deceleration rates

AN ENVIRONMENTALLY-FRIENDLY MACHINE DESIGNED FOR RELIABLE AND EASY OPERATION

- Thermal error compensation function incorporated as standard.
- The Easy Operation function (EOP) can be viewed in the pop-up window of the main NC screen for convenient machine operation.
- Grease lubrication for the roller guideways is a standard feature and is a cleaner, greener, more efficient and more cost-effective lubrication system.

BASIC STRUCTURE

The DNM 4000 is a compact, high-productivity vertical machining centre with a #40 spindle delivering outstanding cutting performance.

Travel distance

X axis

520 mm 20.5 inch

Y axis

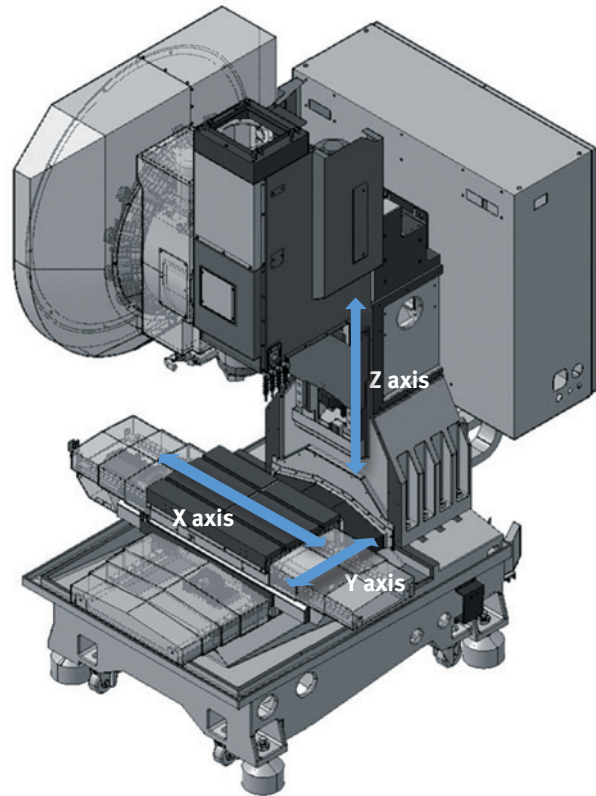
400 mm 15.7 inch

Z axis

480 mm 18.9 inch

CNC system

- **DOOSAN FANUC i**
- **SIEMENS**



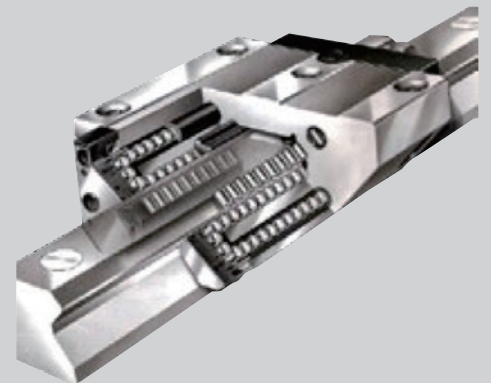
Axis system

Environmentally-friendly grease lubrication is used as standard for the axis feed system, and Roller-type LM Guideways enhance rigidity.

Rapid traverse rate (X / Y / Z axis)

48 m/min
1889.8 ipm

Roller-type LM guides are provided as a standard feature



Grease lubrication for all axes is a standard feature

Grease lubrication system

The standard grease lubrication system eliminates the need for an oil skimmer and reduces lubrication costs by about 60% compared to oil lubrication.

Yearly maintenance cost

Max. **60%**



SPINDLE | TABLE | TOOL CHANGE SYSTEM

Directly-coupled spindles, with the dual contact tool and spindle interface, are a standard feature and help reduce vibration and noise whilst enhancing productivity, the working environment and machining accuracy. An increase in table size and the maximum load capacity, over the previous model, improves the machine's flexibility and application potential.

Dual contact tool system support as standard.

Max. spindle speed

FANUC / SIEMENS

12000 r/min

Max. spindle motor power

 FANUC / SIEMENS

18.5 kW / **16.5** kW

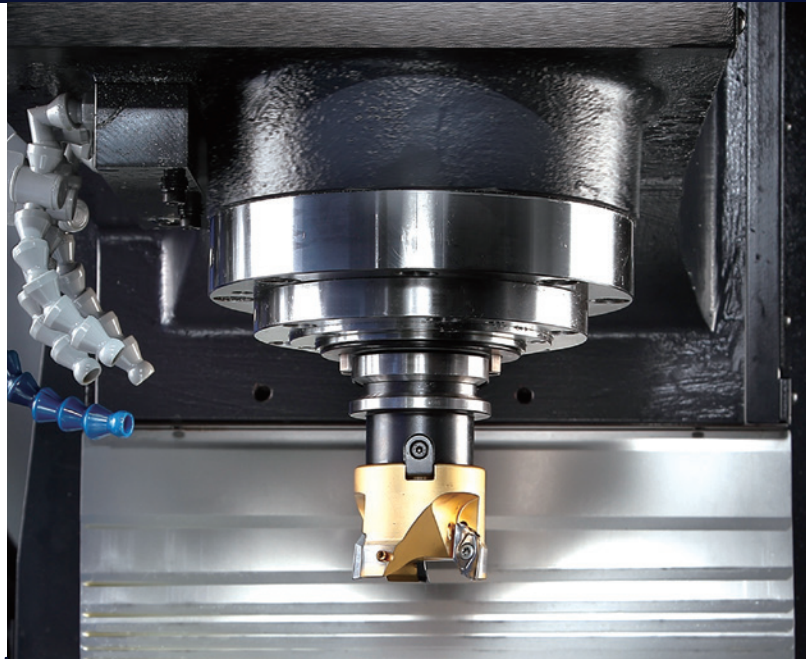
24.8 Hp / 22.1 Hp

Max. spindle motor torque

 FANUC / SIEMENS

117 N.m / **141** N.m

86.3 ft-lbs / 104.1 ft-lbs



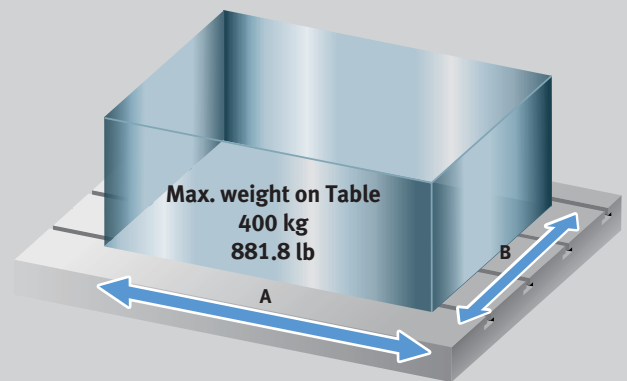
Max. weight on Table

400 kg 881.8 lb

Table size (A x B)

650 x **400** mm

25.6 x 15.7 inch



Tool Change System (ATC)

The highly-reliable tool magazine can accommodate up to 20 tools as standard.

Tool storage capacity

20 ea

Tool-to-Tool time

1.3 sec

Chip-to-Chip* time

2.6 sec

* The Chip-to-Chip time has been tested in accordance with Doosan's strict testing conditions, but may vary depending on different conditions.



MACHINING PERFORMANCE

The machine's highly rigid structure with the 40 taper spindle ensures the best machining performance in its class.

Cutting performance

High-rigidity machining can be undertaken with speed and precision.

12000r/min, Direct, 18.5/11kW (24.8/14.8 Hp)

Face mill (ø80mm) Carbon steel (SM45C)			
Chip removal rate cm ³ /min (inch ³ /min)	Spindle speed r/min	Feedrate mm/min (ipm)	
596 (36.4)	1500	2700 (106.3)	
Face mill (ø80mm) Aluminium(AL6061)			
Chip removal rate cm ³ /min (inch ³ /min)	Spindle speed r/min	Feedrate mm/min (ipm)	
2016 (123.0)	1500	6300 (248.0)	
Drill (ø50 mm) Carbon steel (SM45C)			
Chip removal rate cm ³ /min (inch ³ /min)	Spindle speed r/min	Feedrate mm/min (ipm)	
530 (32.3)	1500	270 (10.6)	
Tap Carbon steel (SM45C)			
Tap size mm (inch)	Spindle speed r/min	Feedrate mm/min (ipm)	
M36 (1.4) x P4.0	221	884 (34.8)	
M3 (0.1) x P0.5	3000	1500 (59.1)	

* The results, indicated in this catalogue, are provided as examples only. They may not always be achieved owing to different cutting and environmental conditions.

High Productivity



Material : Aluminium (AL6061)

	Non-cutting time	Cutting time	Run hours
Previous model	3 min. 27 sec.	6 min. 22 sec.	9 min. 49 sec.
	Reduced by 17%		Reduced by 7%
DNM 4000	2 min. 52 sec.	6 min. 19 sec.	9 min. 11 sec.

* The results, indicated in this catalogue, are provided as examples only. They may not always be achieved owing to different cutting and environmental conditions.

STANDARD | OPTIONAL SPECIFICATIONS

Various optional features are available to meet customers' specific machining requirements and applications.

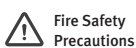
Description	Features		DNM 4000	
Spindle	12000 r/min	Direct 18.5/11 kW (24.8/14.8 Hp)	●	
Spindle cooling system (Oil cooler)	12000 r/min	Direct	○	
Magazin	Tool storage capacity	20 ea	●	
Tool shank type	ISO #40	BIG PLUS BT40	●	
		BIG PLUS CAT40	○	
		BIG PLUS DIN40	○	
Coolant	Flood coolant	0.69 MPa (1.8 kW)	●	
	TSC	None	●	
		2 MPa (1.5kW)	○	
	Flushing/Shower	Flushing coolant	0.10 MPa (1.1 kW)	●
		Flushing /Shower coolant	0.30 MPa (1.8 kW)	○
	Oil skimmer	Belt type	○	
MQL		○		
Chip disposal	Chip pan		●	
	Chip conveyor	Hinged type(Rear)	○	
		Magnetic scraper type(Rear)	○	
	Chip bucket	CAPACITY	220 L (58.1 gallon)	○
			300 L (79.3 gallon)	○
			380 L (100.4 gallon)	○
TYPE		ROTATION	○	
		FORKLIFT	○	
Precision machining options	AICC II (200block)		●	
	SSP (Smooth Surface Package)		○	
Measurement & Automation	Automatic tool measurement	TS27R	○	
	Automatic tool breakage detection		○	
	Automatic workpiece measurement	OMP60	○	
	Automatic front door with safety device		○	
Accessories	WORK LIGHT	LED LAMP	●	
	OPERATOR CALL LAMP	3-COLOR SIGNAL TOWER(LED)	●	
	LEVELING BLOCK & BOLT	-	●	
	SMART THERMAL CONTROL	SENSORLESS TYPE(ONLY SPINDLE)	●	
	ASSEMBLY & OPERATION TOOLS KIT	-	●	
	4TH AXIS PREPARATION CABLING FOR SERVO/1-PNEUMATIC PIPING	FACTORY READY MADE	●	
	AIR GUN		○	
	Air blower		○	
	Coolant gun		○	
	Mist collector		○	
Customized special option	ANCHORING ⁽¹⁾	SLIDE CLAMP & CHEMINCAL ANCHOR BOLT	○	
	TSA ⁽²⁾	0.54	○	
	ATC AUTO SHUTTER	20 TOOL	○	
	RASING BLOCK	150 mm	○	
		200 mm	○	
		300 mm	○	
	SCALE	SCALE BUILT-IN LM GUIDE	○	
	DRUM CHIPCONVEYOR	HINGE TYPE	○	
		SCRAPER TYPE	○	
	OIL LUBRICATION	X, Y, Z AXIS	○	
	20 BAR TSC with INVERTER	50Hz → 60Hz	○	
	AUTO TOOL LENGTH MEASUREMENT	RENISHAW / LTS	○	
AUTO TOOL BREAKAGE DETECTION	MSC/BK9(NEEDLE TYPE ON MAGAZINE)	○		

* Please contact Doosan for detailed specification information.

(1) Please refer to foundation drawing in relation to anchoring. If more detail information want, consult with doosan service

(2) In case of TSC is not required and only TSA is needed, this option can be selected.

● Standard ○ Optional X Not applicable



There is a high risk of fire when using non-water-soluble cutting fluids, processing flammable materials, neglecting the controlled and careful use of coolants and modifying the machine without the consent of the manufacturer. Always check the SAFETY GUIDELINES carefully before using the machine.

PERIPHERAL EQUIPMENT

Oil Cooler option

An oil cooler correlated to room temperature can be equipped for a long-term operation at high speed. Cooling oil circulates around the spindle bearings to prevent thermal error of the spindle and maintain machining accuracy.



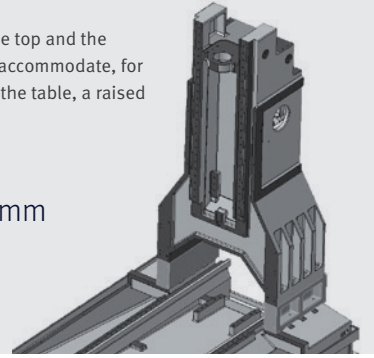
Raised column option

When the distance between the table top and the spindle nose has to be extended to accommodate, for example, a rotary table or fixture on the table, a raised column can be used.

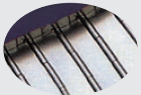
Height

150/200/300 mm

5.9 / 7.9 / 11.8 inch



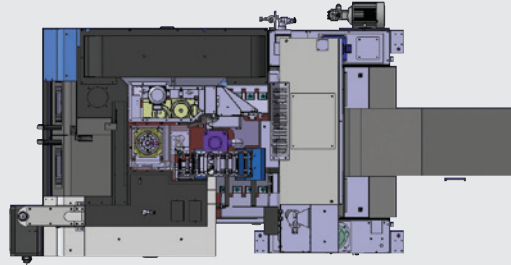
Chip conveyor option



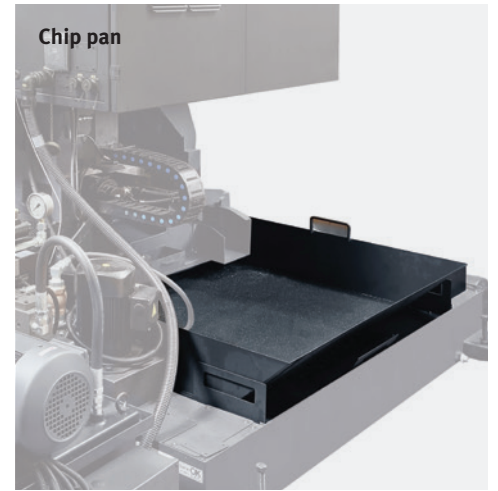
Hinged type



Magnetic scraper



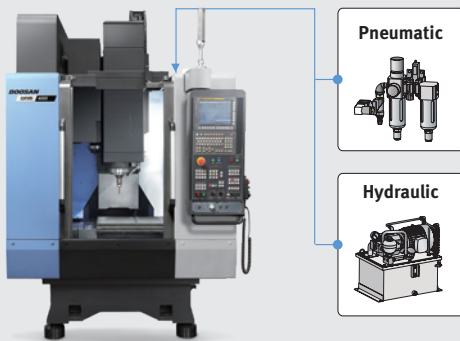
Chip pan



Chip conveyor type	Material	Description
Hinged belt	Steel	Hinged belt chip conveyor, which is most commonly used for steel work [for cleaning chips longer than 30mm(1.2inch)], is available as an option.
Magnetic scraper	Cast Iron	Magnetic scraper type chip conveyor, which is ideal for die-casting work [for cleaning small chips], is available as an option.

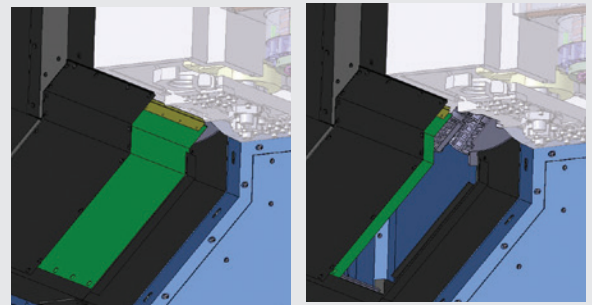
Hydraulic / Pneumatic fixture line option

The user should prepare pipelines for hydraulic/pneumatic fixtures whose detailed specifications should be determined by discussion with Doosan.



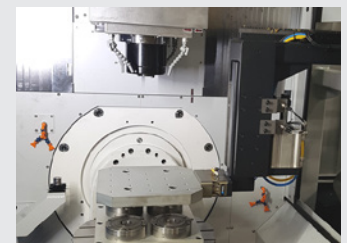
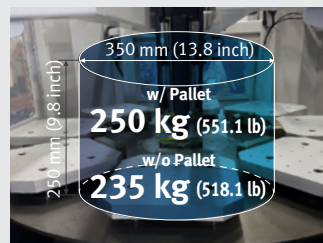
Auto shutter option

An auto shutter is included to prevent chips from entering the tool magazine during high speed machining of Aluminium parts.



AWC system option

The optimized solution to realize compact automation system through automatic work-piece change system.



DOOSAN FANUC i PLUS

DOOSAN Fanuc i Plus is optimized for maximizing customer productivity and convenience.

15 inch screen + new operation panel

DOOSAN Fanuc i Plus' operation panel enhances operating convenience by incorporating common-design buttons and layout, and features the Qwerty keyboard for fast and easy operation.

Doosan Fanuc i Plus

- 15 inch color display
- Intuitive and user-friendly design

USB & PCMCIA card

QWERTY keyboard

- EZ-guide i standard
- Ergonomic operator panel
- 2MB Memory
- Hot key



iHMI touchscreen option

iHMI provides an intuitive interface that uses a touchscreen for quick and easy operation.

Range of applications

Providing various applications related to planning, machining, improvement and utility, for customer convenience.

NUMERIC CONTROL SPECIFICATIONS

FANUC

Item	Specifications	Doosan Fanuc i (FOI-F Plus) DNM 4digit	
Controlled axis	Controlled axes	3 (X,Y,Z)	
	Simultaneously controlled axes	4 axes	
	Additional controlled Axis	●	
Data input/output	Fast data server	○	
	Memory card input/output	●	
	USB memory input/output	●	
	Large capacity memory(2GB)*2	○	
Interface function	Embedded Ethernet	●	
	Fast Ethernet	○	
	Enhanced Embedded Ethernet function	●	
Operation	DNC operation	Included in RS232C interface. ●	
	DNC operation with memory card	●	
Program input	Workpiece coordinate system	G52 - G59 ●	
	Addition of workpiece coordinate system	G54.1 P1 X 48 (48 pairs) ●	
	Tool number command	T4 digits	
	Tilted working plane indexing command	G68.2 TWP X	
Feed function	AI contour control I	G5.1 Q , 40 Blocks X	
	AI contour control II	G5.1 Q , 200 Blocks ●	
	AI contour control II	G5.1 Q , 600 Blocks X	
	AI contour control II	G5.1 Q , 1000 Blocks X	
Operation guidance function	High smooth TCP	X	
	EZ Guidei (Conversational Programming Solution)	○	
	iHMI with Machining Cycle	Note *1) Only with 15" Touch LCD standard X	
Setting and display	EZ Operation package	●	
	CNC screen dual display function	●	
Network	FANUC MTConnect	⊕	
	FANUC OPC UA	⊕	
Others	Display unit	10.4" color LCD	X
		15" color LCD	●
		15" color LCD with Touch Panel	○
		640M(256KB)_500 programs	X
	Part program storage size & Number of registerable programs	1280M(512KB)_1000 programs	X
		2560M(1MB)_1000 programs	X
		5120M(2MB)_1000 programs	●
		10240M(4MB)_1000 programs	X
		20480M(8MB)_1000 programs	X
		2560M(1MB)_2000 programs	X
5120M(2MB)_4000 programs	X		

* 2) Only for Fanuc i plus iHMI

Network: FANUC MTConnect and FANUC OPC UA available.

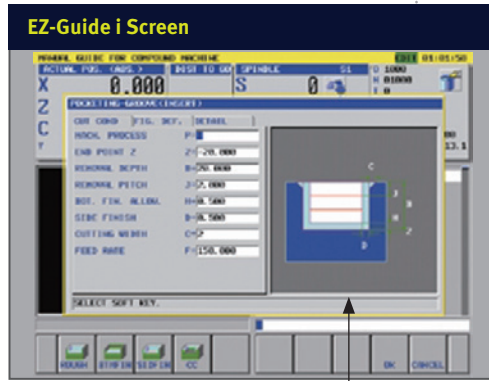
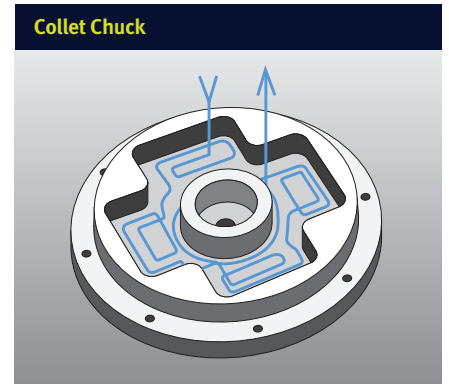
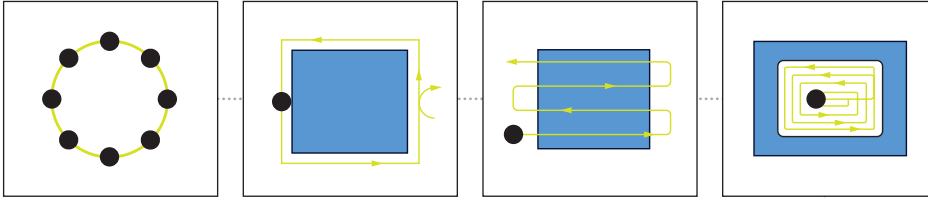
● Standard ○ Optional X Not Available ⊕ Available

DOOSAN FANUC I PLUS

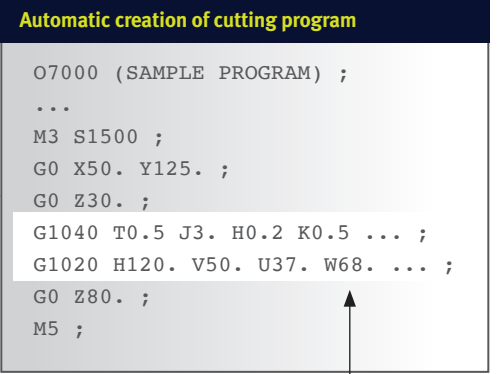
EZ-Guide i

Using the DOOSAN EZ-Guide i, users can create a cutting program for any desired shape, including patterns, by entering the appropriate figures only.

Exemplary Programming : Cutting shape



Enter the dimensions of the desired shape.



A cutting program is automatically created with the entered values.

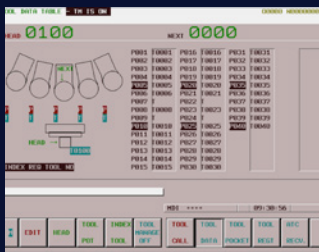
Easy operation package

The software developed by Doosan provides a range of different functions designed for fast, efficient and convenient operation



EOP Main screen

On the operation panel, press the CUSTOM1 button to see the initial EOP screen



Tool management

This function provides information on the tools in the tool magazine pots.



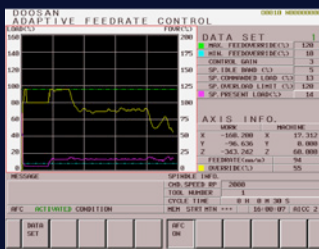
ATC recovery

In the event of an error during ATC (automatic tool changer) operations, on-screen instructions deliver easy-to-understand and prompt solutions.



Tool load monitoring

During cutting operations, abnormal loads caused by wear and tear of the tool are detected and an alarm is triggered to prevent further damage from occurring.



Adaptive Feedrate Control(AFC)

If tool overload is detected during operation, the feed rate is controlled to prevent the tool from being damaged.



Thermal compensation function

A thermal error compensation function is provided as a standard feature to ensure stable and reliable cutting performance by reducing the effects of thermal growth and drift.

CONVENIENT OPERATION

SIEMENS 828D

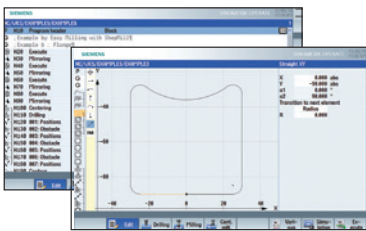
15.6" screen + new operation panel

The newly-designed operation panel improves the customer convenience by incorporating and using common-design buttons and layouts, and includes the familiar QWERTY keyboard for fast and easy operation.

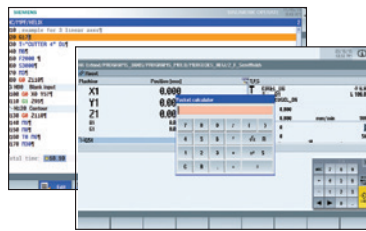
- 15.6" display
- 10MB high capacity user memory
- USB & ethernet (standard)
- QWERTY keyboard (standard)
- High-speed calculation and simulation can be fulfilled by improved processor functionality



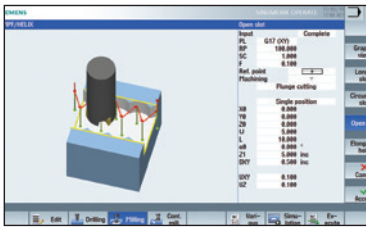
Conversational convenient function



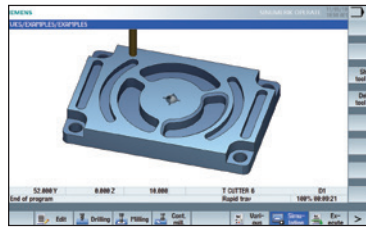
Shop Mill Part Programming



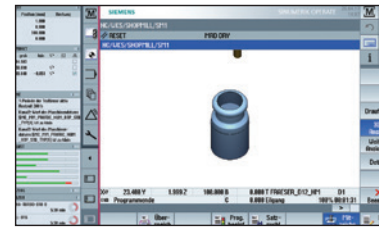
Smart function



Advanced program language programGUIDE



Simulation and machining contour monitoring



Side screen widget

NUMERIC CONTROL SPECIFICATIONS

SIEMENS

Item	Specifications	S828D
		DNM
Controlled axis	Controlled axes (제어축수)	3축
	Simultaneously controlled axes (동시 제어축수)	3축
Data input/output	Memory card input/output	X
	USB memory input/output	●
Interface function	Ethernet	●
Operation	On network drive	○
	On USB storage medium, e.g. memory stick	●
Program input	Workpiece coordinate system	●
	Addition of workpiece coordinate system	●
Interpolation & Feed function	Advanced surface	●
	Top surface	○
Programming & Editing function	Look ahead number of block	S/W version 4.8
	3D simulation, finished part	●
Operation Guidance Function	Simultaneous recording	●
	Measure kinematics	X
Setting and display	DXF Reader for PC integrated in SINUMERIK Operate	○
	ShopMill	●
Network	EZ Work	●
	Operation via a VNC viewer	●
Etc. function	MTConnect	⊕
	OPCUA	○
Etc. function	15.6" color display with touch screen	●
	19" color display without touch screen	X
	21.5" color display with touch screen	X
	CNC user memory	10 MB
	Expansion by increments	2 ~ 12 MB
	Collision avoidance	X
Collision avoidance ECO (machine, working area)	X	

POWER | TORQUE | TABLE DIMENSION

FANUC

MAX. SPINDLE SPEED

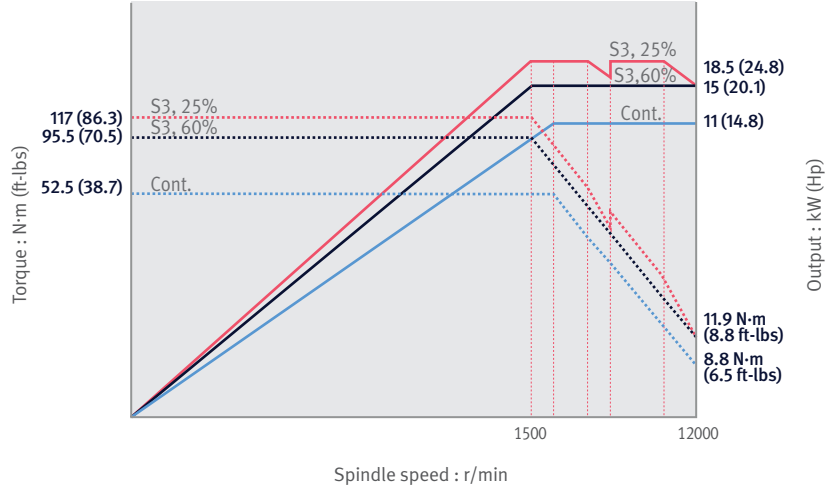
12000 r/min

MAX. SPINDLE POWER

18.5/11 kW 24.8/14.8 Hp

MAX. SPINDLE TORQUE

117 N·m 86.3 ft-lbs



SIEMENS

MAX. SPINDLE SPEED

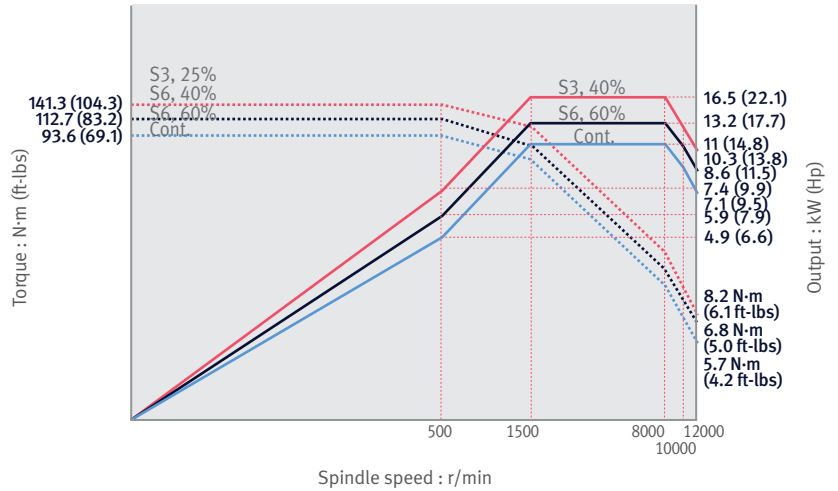
12000 r/min

MAX. SPINDLE POWER

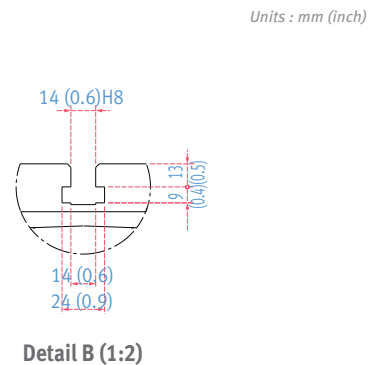
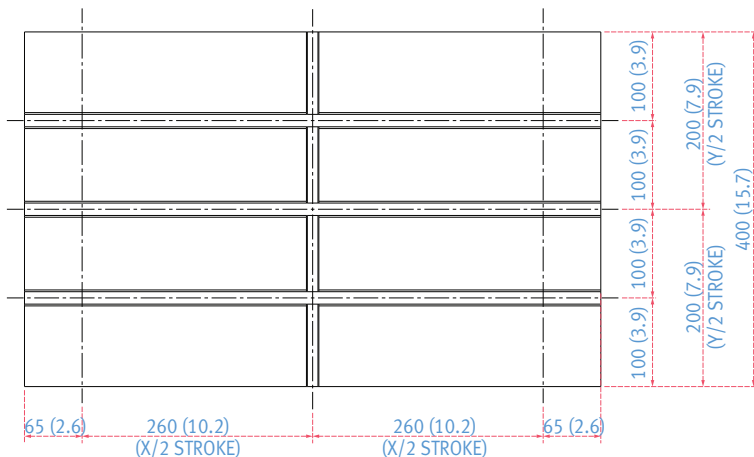
16.5/11 kW 12.2/14.8 Hp

MAX. SPINDLE TORQUE

141.3 N·m 104.3 ft-lbs



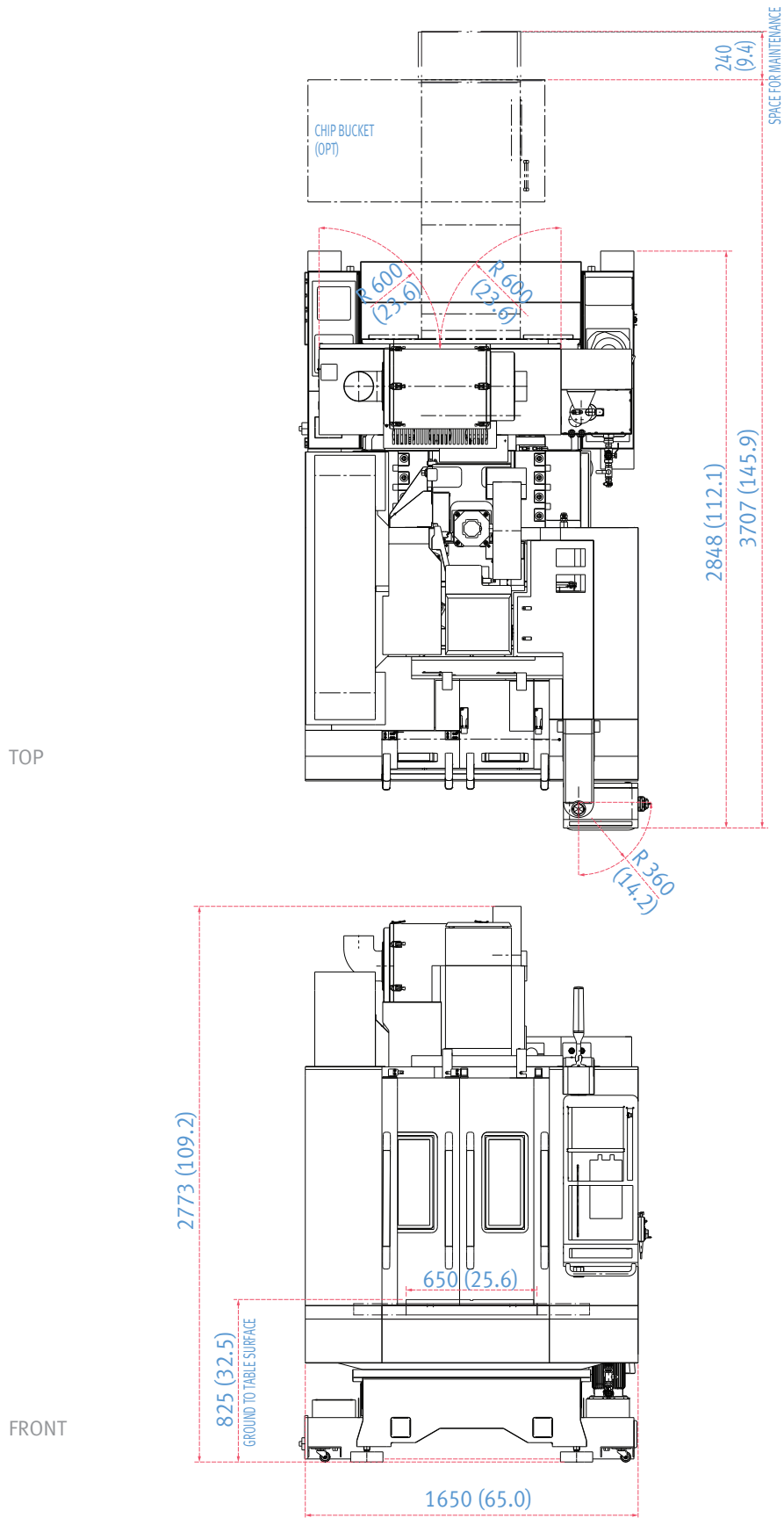
TABLE



Units : mm (inch)

DIMENSIONS

Units : mm (inch)



* Some peripheral equipment can be placed in other places

MACHINE SPECIFICATIONS

Description		Unit	DNM 4000	
Travels	Travel distance	X axis	mm (inch)	520 (20.5)
		Y axis	mm (inch)	400 (15.7)
		Z axis	mm (inch)	480 (18.9)
	Distance from spindle nose to table top		mm (inch)	150 ~ 630 (5.9~24.8)
Table	Table size		mm (inch)	650 x 400 (25.6 x 15.7)
	Table loading capacity		kg (lb)	400 (881.8)
	Table surface type		mm (inch)	T-SLOT (3-100(3.9) x 14(0.6)H8)
Spindle	Max. spindle speed		r/min	12000
	Taper		-	ISO #40
	Max. spindle power		kW (Hp)	18.5/11 (24.8/14.8)
	Max. spindle torque		N·m (ft·lbs)	117 (86.3)
Feedrates	Rapid traverse rate	X axis	m/min (ipm)	48 (1889.8)
		Y axis	m/min (ipm)	48 (1889.8)
		Z axis	m/min (ipm)	48 (1889.8)
Automatic Tool Changer	Type of tool shank	Tool shank	-	BT 40 {CAT40/DIN40}*
		Pull stud	-	PS806
	Tool storage capa.		ea	20
	Max. tool diameter	Continuous	mm (inch)	90 (3.5)
		Without adjacent tools	mm (inch)	125 (4.9)
	Max. tool length		mm (inch)	270 (10.6)
	Max. tool weight		kg (lb)	5 (11)
	Max. tool moment		N·m (ft·lbs)	9.8 (7.2)
	Tool selection			MEMORY RANDOM
	Tool change (Tool-to-Tool)		sec	1.3
	Tool change (Chip-to-Chip)		sec	2.6
Power source	electric power supply(rated capacity)		kVA	29.5
	Compressed air supply		Mpa (psi)	0.54 (78.3)
Tank capacity	Coolant tank capacity		L (gal)	200 (52.8)
Machine Dimensions	Height		mm (inch)	2753 (108.4)
	Length		mm (inch)	2853 (112.3)
	Width		mm (inch)	1650 (65.0)
	Weight		kg (lb)	3300 (7275.3)
Control	CNC system		-	DOOSAN Fanuc i Plus

*{ } : Option

RESPONDING TO CUSTOMERS

ANYTIME, ANYWHERE

Doosan Machine Tools' Global Network

Doosan Machine Tools provides systems-based professional support services, before and after the machine tool sale, by responding quickly and efficiently to customers. By supplying spare parts, product training, field service and technical support, we provide the expert care, attention and assistance our customers expect from a market leader.

Global sales and service support network		51	Technical centers Technical center, Sales support, Service support, Parts support
4	Corporations	200	Service posts
167	Dealer networks	3	Factories



CUSTOMER SUPPORT AND SERVICES

We're there for you whenever you need us.

We help our customers operate at maximum efficiency by providing them with a range of tried, tested and trusted services - from pre-sales consultancy to post-sales support.



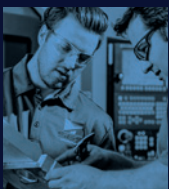
Field services

- On-site service
- Machine installation and testing
- Scheduled preventive maintenance
- Machine repair service



Parts supply

- Supplying a wide range of original Doosan spare parts
- Parts repair service



Training

- Programming, machine setup and operation
- Electrical and mechanical maintenance
- Applications engineering



Technical support

- Supports machining methods and technology
- Responds to technical queries
- Provides technical consultancy



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