Optimal working depth – Ideal for training

+ Perfect accessibility through the wide working area door, 580 mm on the NEF 400 and 1,360 mm on the NEF 600
+ Space requirements of just 4.1 m² and 7.1 m² with the NEF 400 and the NEF 600 respectively
+ Optimal working depth: NEF 400 with 289 mm and NEF 600 with 424 mm

Massive cast bed with four slideways

+ 45° slant bed for maximised stability and perfect machining results
+ Optimal chip removal from the vertical slideways of the tailstock and steady rest

12 station turret

+ Servo-controlled turret for maximum functional safety
+ Driven tools* for machining complex workpieces
  NEF 400: VDI 30, 6x 4,500 rpm, 17.5 Nm, 5.5 kW
  NEF 600: VDI 40, 12x 4,000 rpm, 36 Nm, 7.5 kW

* Option
Integrated spindle motor (ISM)

+ Integrated and liquid-cooled spindle motors for maximum temperature stability
+ Maximum precision thanks to the C axis with 0.001° resolution for machining complex components*
+ NEF 400: ISM 65 rated at 4,500 rpm, 340 Nm and 11.5 kW
+ NEF 600: ISM 90 rated at 3,500 rpm, 790 Nm and 37 kW

The latest control technology

+ CELOS from DMG MORI with 21.5° ERGOline® and SIEMENS
+ Alternative 19° ERGOline® with Operate 4.5 on SIEMENS 840D solutionline and ShopTurn 3G or HEIDENHAIN CNC PILOT 640
+ Flexible and quick thanks to very short programming times for up to 30% increased productivity
+ Efficient tool management
+ Simulation for more safety

* Option
NEF 400 / NEF 600

More performance with the integrated spindle motor.

**Highlights**

+ Compact design thanks to the massive, highly stable cast iron bed
+ Optimal accessibility and working depth thanks to the wide working area door (NEF 400: 580 mm, NEF 600: 1,360 mm)
+ The ideal machine for training, with just 4.1 m² space requirement and a working depth of just 289 mm to the main spindle (NEF 600: 7.1 m² and 424 mm working depth)
+ Increased productivity with up to 12 driven tools (optional)
+ The latest 3D control technology: CELOS from DMG MORI with 21.5” ERGOLine® and SIEMENS
+ Alternative 19” ERGOLine® with Operate 4.5 on SIEMENS 840D solutionline and ShopTurn 3G or HEIDENHAIN CNC PILOT 640
The very highest, consistent quality due to the new, highly modern assembly line at Bielefeld

Quick delivery times due to faster cycle times in assembly line production

<table>
<thead>
<tr>
<th></th>
<th>NEF 400</th>
<th>NEF 600</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maximum workpiece length</td>
<td>mm</td>
<td></td>
</tr>
<tr>
<td></td>
<td>650</td>
<td>1,190</td>
</tr>
<tr>
<td>Maximum swing</td>
<td>mm</td>
<td></td>
</tr>
<tr>
<td>over bed // over slide</td>
<td>Ø 385 // Ø 350</td>
<td>Ø 600 // Ø 490</td>
</tr>
<tr>
<td>Maximum cutting diameter</td>
<td>mm</td>
<td></td>
</tr>
<tr>
<td>over bed // over slide</td>
<td>Ø 350 // Ø 350</td>
<td>Ø 600 // Ø 490</td>
</tr>
<tr>
<td>Main drive</td>
<td>rpm</td>
<td></td>
</tr>
<tr>
<td>ISM 65 // 4,500</td>
<td></td>
<td>ISM 90 // 3,500</td>
</tr>
<tr>
<td>Torque / power</td>
<td>Nm / kW</td>
<td></td>
</tr>
<tr>
<td></td>
<td>340 / 11.5</td>
<td>790 / 37</td>
</tr>
<tr>
<td>Space requirements</td>
<td>m²</td>
<td></td>
</tr>
<tr>
<td></td>
<td>4.0</td>
<td>6.9</td>
</tr>
</tbody>
</table>
Highlights

Machine and technology

Technology and options

Applications and parts

Control technology

Technical data

**NEF 400 / NEF 600 technology**

+ High stability and perfect machining results thanks to the massive GG 30 cast iron bed with four slideways

+ Maximum stability during machining thanks to widely spaced slideways at 346 mm and Ø 40 mm ball screws (NEF 400: 240 mm and Ø 32 mm)

+ Integrated spindle motors with high torque
  NEF 400  ISM 65  340 Nm
  NEF 600  ISM 90  790 Nm

+ Maximum precision and temperature stability thanks to the liquid-cooled main drives and spindle bearing with a diameter up to 160 mm (NEF 400 with Ø 130 mm), plus the use of linear scales

+ VDI 30 and VDI 40 12 station turrets for the NEF 600 and a hydraulically controlled tailstock as standard

+ Traversable steady rest* (optional) and tailstock thanks to the four slideway bed design

**Options**

+ The highest technical specification thanks to the integrated spindle motor and tailstock as standard

+ Optional 6 (or 12)* live tool stations including main spindle with C axis

+ Tool measurement device

+ Bar package with parts catcher, workpiece size:
  NEF 400  Ø 65  length 150 mm  weight 3 kg
  NEF 600  Ø 90  length 200 mm  weight 5 kg

+ Steady rests for the NEF 600, workpieces up to a diameter of 200 mm

* Data for the NEF 600

The use of top-quality components from Germany, e.g. control systems, measurement systems, hydraulics, spindles and turrets from: SIEMENS, HEIDENHAIN, Bosch, Rexroth, Kessler and Sauter.
1: Massive, highly stable cast iron bed, compact design – 45° slant bed
2: ISM – integrated spindle motor for the highest performance
3: NEF 400 working area with automatic tailstock
4: Machining a shaft on an NEF 600 with driven tools
5: Integrated parts catcher
6: Hydraulically centring steady rest on the vertical slideways on the NEF 600
7: Tool measuring device – removable from the working area
NEF 400 / NEF 600

Integrated spindle drives rated at up to 790 Nm for the highest machining performance.

Integrated spindle motor (ISM)

+ Integrated and liquid-cooled spindle motor for maximum temperature stability
+ Improved precision on the C axis* thanks to the 0.001° resolution
+ Hollow clamping cylinder (optional) from the CTX beta range for more clamping force

* Option

ISM 65 // NEF 400
ø 65 mm maximum bar diameter
4,500 rpm // 11.5 / 8 kW // 340 / 240 Nm

High-performance turning (Ck 45 // 110 mm component diameter)

Material removal rate 250 cm³/min
Clamping depth 5.5 mm
Cutting speed 150 m/min
Feed 0.3 mm/rev

High-performance drilling (Ck 45)

Workpiece diameter 30 mm*
Spindle speed 850 rpm
Cutting speed 80 m/min
Feed 0.2 mm/rev

* Performance is limited by the Z drive

ISM 90 // NEF 600
ø 92 mm maximum bar diameter
3,000 rpm // 37 / 28 kW // 790 / 590 Nm

High-performance turning (Ck 45 // 150 mm component diameter)

Material removal rate 750 cm³/min
Clamping depth 10 mm
Cutting speed 150 m/min
Feed 0.5 mm/rev

High-performance drilling (Ck 45)

Workpiece diameter 50 mm*
Spindle speed 509 rpm
Cutting speed 80 m/min
Feed 0.24 mm/rev

* Performance is limited by the Z drive

* Up to 240 Nm with the HEIDENHAIN control system
### Tool drive

+ Quick and precise production thanks to the rapid servo-driven turret for maximum process reliability
  - NEF 400: 12-slot VDI 30 disc-type turret
  - NEF 600: 12-slot VDI 40 disc-type turret

+ Driven tools* for machining complex workpieces
  - NEF 400: 6 tool stations, 4,500 rpm, 17.5 Nm, 5.5 kW
  - NEF 600: 12 tool stations, 4,000 rpm, 36 Nm, 7.5 kW

* Option

### High-performance milling (Ck 45)

<table>
<thead>
<tr>
<th></th>
<th>NEF 400</th>
<th>NEF 600</th>
</tr>
</thead>
<tbody>
<tr>
<td>Material removal rate</td>
<td>97.4 cm³/min</td>
<td>151.5 cm³/min</td>
</tr>
<tr>
<td>Spindle speed</td>
<td>2,706 rpm</td>
<td>1,933 rpm</td>
</tr>
<tr>
<td>Power</td>
<td>5.2 kw</td>
<td>7.5 kw</td>
</tr>
<tr>
<td>Torque</td>
<td>17 Nm</td>
<td>36 Nm</td>
</tr>
<tr>
<td>Feed</td>
<td>0.2 mm / tooth</td>
<td>0.2 mm / tooth</td>
</tr>
<tr>
<td>Cutting depth / width</td>
<td>3 / 20 mm</td>
<td>3.5 / 28 mm</td>
</tr>
<tr>
<td>Cutting speed</td>
<td>170 m/min</td>
<td>170 m/min</td>
</tr>
<tr>
<td>Number of teeth</td>
<td>3</td>
<td>4</td>
</tr>
<tr>
<td>Mill diameter</td>
<td>20 mm</td>
<td>28 mm</td>
</tr>
<tr>
<td>Spec. Cutting force</td>
<td>1,450 N/mm²</td>
<td>1,450 N/mm²</td>
</tr>
</tbody>
</table>

### Tapping (Ck 45)

<table>
<thead>
<tr>
<th></th>
<th>NEF 400</th>
<th>NEF 600</th>
</tr>
</thead>
<tbody>
<tr>
<td>Thread size</td>
<td>M12 x 1.25</td>
<td>M22 x 1.5</td>
</tr>
<tr>
<td>Spindle speed</td>
<td>398 rpm</td>
<td>217 rpm</td>
</tr>
<tr>
<td></td>
<td>Distributor – NEF 400</td>
<td></td>
</tr>
<tr>
<td>---</td>
<td>--------------------------------------</td>
<td>---</td>
</tr>
<tr>
<td><strong>[1]</strong></td>
<td>Sector / material: Fluidics / 16MnCr5</td>
<td><strong>[2]</strong></td>
</tr>
<tr>
<td></td>
<td>Workpiece dimensions: ø 32 x 45 mm</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Machining time: 1.9 min</td>
<td></td>
</tr>
<tr>
<td>Highlight</td>
<td>Profile groove with repeat function in the groove cycle</td>
<td>Highlight</td>
</tr>
</tbody>
</table>

**[1]** Distributor – NEF 400

- Sector / material: Fluidics / 16MnCr5
- Workpiece dimensions: ø 32 x 45 mm
- Machining time: 1.9 min
- Highlight: Profile groove with repeat function in the groove cycle

**[2]** Fastener – NEF 400

- Sector / material: Hydraulics / Ck 45
- Workpiece dimensions: ø 100 x 82 mm
- Machining time: 4.5 min
- Highlight: Hexagonal milling with driven tool

**[3]** Sliding stop – NEF 400

- Sector / material: Machine construction / 42CrMo4
- Workpiece dimensions: ø 52 x 80 mm
- Machining time: 2.8 min
- Highlight: Interpolating face machining

**[4]** Intermediate adapter – NEF 400

- Sector / material: Machine construction / Aluminium
- Workpiece dimensions: ø 110 x 120 mm
- Machining time: 6.8 min
- Highlight: Complete machining with driven tools

**[5]** Tappet – NEF 600

- Sector / material: Hydraulics / 42CrMo4
- Workpiece dimensions: ø 68 x 350 mm
- Machining time: 8.3 min
- Highlight: Chatter-free surfaces thanks to the ‘Alternating Speed’ technology cycle

**[6]** Sleeve – NEF 600

- Sector / material: Hydraulics / Ck 45
- Workpiece dimensions: ø 70 x 140 mm
- Machining time: 13.8 min
- Highlight: Turning of complex internal and external profiles
Machining between centres with driven tools on an NEF 600.
Save up to 30% energy – energy efficiency measures in DMG MORI machines.

**Efficient – optimised design**
- Optimal drive design
- Drives capable of recovery
- Controlled accumulators*
- Minimised friction
  * Optional

**Efficient – intelligent control system**
- Process optimisation
- DMG MORI AUTOshutdown

**Energy saving**
- Smart technology already saves up to 20% of energy costs as standard over the entire life cycle of your DMG MORI machine tool.
- DMG MORI AUTOshutdown:
  Intelligent standby controls to avoid unnecessary energy consumption when idle.
Design
FEM-optimised design with high static and low moving masses.

Linear guides
Negligible friction effects thanks to the consistent use of ball guide technology.

Servo technology / frequency control*
Frequency-controlled coolant and hydraulic pumps instead of fixed displacement pumps with regulator technology.

* Optional

Drives
Energy recovery during the braking phases of spindles and feed drives.

Motor
Use of the latest drive motors with up to 93% efficiency.

DMG MORI AUTOshutdown
Machine tools switch to standby mode when idle.
### Highlights

- **Machine and technology**
- **Technology and options**
- **Applications and parts**
- **Control technology**
- **Technical data**

**APP Menu:** Central access to all available applications

---

**ERGOnline® control panel with 21.5" multi-touch screen and SIEMENS.**

**STANDARD**
Standard interface for all new high-tech machines from DMG MORI.

**CONTINUOUS**
Consistent administration, documentation and visualisation of order, process and machine data.

**COMPATIBLE**
Compatible with common PPS and ERP systems. Can be networked with CAD / CAM products. Can be extended with future CELOS apps.
**CELOS** – From the idea to the finished product.

CELOS by DMG MORI enables consistent administration, documentation and visualisation of order, process and machine data. CELOS can be extended with apps and is also compatible with your company’s existing infrastructures and programmes.

**CELOS APPs facilitate quick and easy operation: three examples »**

**JOB MANAGER**
*Systematic planning, administration and preparation of orders.*

- Machine-related creation and configuration of new orders
- Structured saving of all production-related data and documents
- Easy visualisation of orders, including NC program, equipment, etc.

**JOB ASSISTANT**
*Defining and processing orders.*

- Menu-guided set-up of the machine and conversational processing of production orders
- Reliable error prevention thanks to work instructions with compulsory acceptance function

**CAD-CAM VIEW**
*Visualise workpieces and optimise program data.*

- Direct remote access to external CAD / CAM workstations
- Central master data as basis for component visualisation
- Immediate change options for machining steps, NC programs and CAM strategies, directly in the control system
DMG MORI ERGOline® Control with SIEMENS and ShopTurn 3G.

**Highlights**

- **Up to 60% reduction in programming time**
  thanks to simple and graphical programming, even of complex components

- **3D workpiece simulation**

- **Absolute flexibility between DIN and shop floor programming**
  thanks to the combination of ShopTurn cycles with DIN

- **Quick, easy and clearly structured tool management**

- **Full ShopMill functionality**
DMG MORI ERGoline® Control with HEIDENHAIN CNC PILOT 640.

**Highlights**

- Up to 80% time saved thanks to automatic route sheet generation
  - Independent route sheet generation
  - Automatic tool selection
  - Automatic cutting data calculation
  - Generation of a structured and clear Smart.Turn program

- **Smart.Turn**
  - Import filter for HEIDENHAIN 4290 programs
  - Easy to combine UNIT and DIN / ISO code
  - DXF import of raw and finished part contours*

- **Tool management**
  - 20% less set-up time thanks to new tool management and automatic control parameter adjustment

- **9-block menu navigation** for intuitive and quick one-handed control

- **HEROS 5**, a range of new, modern interfaces, e.g. USB, network etc.

- **TURNguide user handbook** with context-sensitive assistance on the control system

* Option
NEF 400 / NEF 600

Up to 50% increased productivity thanks to exclusive technology cycles for SIEMENS with ShopTurn 3G.

**Easy Tool Monitoring**
+ Driven tool load monitoring during the machining process in order to avoid damage to the machine, workpiece and equipment

**Alternating speed – for vibration-critical set-ups**
+ Automatic and repeated modification of the spindle speed in order to avoid tool vibration during the machining process

**Multi-thread cycle**
+ This cycle provides an interface for entering the angle, number of threads and contour of the thread

**Technology cycle highlights**
+ Exclusive technology know-how
+ Simply enter the parameters into a graphical dialogue
+ Exclusive context menus with parameters
+ Easy to learn thanks to predefined input screens
  - no programming knowledge required
+ Program generation by the machine operator, no complicated DIN programming
+ Cycle to produce a thread with free contours, e.g. for large power transmission threads or special threads
NEF 400 / NEF 600

Working areas / floor plans

NEF 400  NEF 600

Working area

Front view

Top view
## Technical data

<table>
<thead>
<tr>
<th>Working area</th>
<th>NEF 400</th>
<th>NEF 600</th>
</tr>
</thead>
<tbody>
<tr>
<td>Maximum swing over bed</td>
<td>385</td>
<td>600</td>
</tr>
<tr>
<td>Maximum swing over cross slide</td>
<td>350</td>
<td>490</td>
</tr>
<tr>
<td>Maximum cutting diameter over bed</td>
<td>350</td>
<td>600</td>
</tr>
<tr>
<td>Maximum cutting diameter over cross slide</td>
<td>350</td>
<td>490</td>
</tr>
<tr>
<td>Distance from main spindle to tailstock (without chuck)</td>
<td>902.5</td>
<td>1,454</td>
</tr>
<tr>
<td>Maximum workpiece length with tailstock (machinable)</td>
<td>650</td>
<td>1,190</td>
</tr>
<tr>
<td><strong>Main spindle</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Integrated spindle motor (ISM)</td>
<td>4,500</td>
<td>3,500</td>
</tr>
<tr>
<td>C axis resolution*</td>
<td>0.001</td>
<td>0.001</td>
</tr>
<tr>
<td>Drive performance (40 / 100 % DC)</td>
<td>11.5 / 8</td>
<td>37 / 28</td>
</tr>
<tr>
<td>Torque (40 / 100 % DC)</td>
<td>340 / 240</td>
<td>790 / 590</td>
</tr>
<tr>
<td>Spindle head (flat flange)</td>
<td>170 h5</td>
<td>220 h5</td>
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<tr>
<td>Front bearing diameter</td>
<td>130</td>
<td>160</td>
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<tr>
<td>Spindle bore</td>
<td>87</td>
<td>118</td>
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<tr>
<td>Drawbar inner diameter</td>
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<td>95</td>
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<tr>
<td>Maximum bar capacity</td>
<td>65</td>
<td>92</td>
</tr>
<tr>
<td>Maximum chuck diameter</td>
<td>250</td>
<td>315</td>
</tr>
<tr>
<td><strong>Turret</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Tool holder under VDI / DIN 69880*</td>
<td>12 x VDI30</td>
<td>12 x VDI40</td>
</tr>
<tr>
<td>Number of driven tools*</td>
<td>6</td>
<td>12</td>
</tr>
<tr>
<td>Maximum speed</td>
<td>4,500</td>
<td>4,000</td>
</tr>
<tr>
<td>Drive power (40 % DC)</td>
<td>5.5</td>
<td>7.5</td>
</tr>
<tr>
<td>Torque (40 % DC)</td>
<td>17.5</td>
<td>36</td>
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<tr>
<td><strong>Turret slide</strong></td>
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<td></td>
</tr>
<tr>
<td>Travel X / Y</td>
<td>255 / 800</td>
<td>398 / 1,250</td>
</tr>
<tr>
<td>Rapid traverse speed X / Z</td>
<td>30 / 30</td>
<td>30 / 30</td>
</tr>
<tr>
<td>Feed force X</td>
<td>4.5</td>
<td>6.2</td>
</tr>
<tr>
<td>Feed force Z</td>
<td>6.2</td>
<td>10</td>
</tr>
<tr>
<td><strong>Tailstock</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Stroke (hydraulic)</td>
<td>680</td>
<td>1,150</td>
</tr>
<tr>
<td>Pressure</td>
<td>6.8</td>
<td>12.5</td>
</tr>
<tr>
<td>Centre location</td>
<td>4</td>
<td>5</td>
</tr>
<tr>
<td><strong>Machine weight</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Machine without chip conveyor</td>
<td>3,500</td>
<td>5,500</td>
</tr>
<tr>
<td>Machine with chip conveyor (optional)</td>
<td>3,700</td>
<td>5,700</td>
</tr>
</tbody>
</table>

* Optional machine V3: driven tools and C axis
Options

<table>
<thead>
<tr>
<th>Machine options</th>
<th>NEF 400</th>
<th>NEF 600</th>
</tr>
</thead>
<tbody>
<tr>
<td>Machine in V3 configuration:</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Turret for driven tools and C axis on the main spindle</td>
<td>*</td>
<td>*</td>
</tr>
<tr>
<td>Differential pressure clamping for the main spindle</td>
<td>*</td>
<td>*</td>
</tr>
<tr>
<td>Tool measurement device</td>
<td>*</td>
<td>*</td>
</tr>
<tr>
<td>Semi-hollow clamping device ø 67 mm</td>
<td>*</td>
<td>–</td>
</tr>
<tr>
<td>Semi-hollow clamping device ø 95 mm</td>
<td>–</td>
<td>*</td>
</tr>
<tr>
<td>Hollow clamping device ø 67 mm</td>
<td>*</td>
<td>–</td>
</tr>
<tr>
<td>Hollow clamping device ø 95 mm</td>
<td>–</td>
<td>*</td>
</tr>
<tr>
<td>Chip conveyor</td>
<td>–</td>
<td>–</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Bar machining / automation</th>
<th>NEF 400</th>
<th>NEF 600</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bar machining package with parts catcher</td>
<td>*</td>
<td>*</td>
</tr>
<tr>
<td>Hydraulic hollow clamping device, quad-colour signal light and connection slot for a bar feed or bar loading magazine</td>
<td>*</td>
<td>*</td>
</tr>
<tr>
<td>Parts catcher</td>
<td>*</td>
<td>*</td>
</tr>
<tr>
<td>Short bar loading magazine</td>
<td>*</td>
<td>*</td>
</tr>
<tr>
<td>Automatic sliding cover</td>
<td>*</td>
<td>*</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Shaft machining</th>
<th>NEF 400</th>
<th>NEF 600</th>
</tr>
</thead>
<tbody>
<tr>
<td>Steady rest clamping range up to 101 mm</td>
<td>–</td>
<td>*</td>
</tr>
<tr>
<td>Steady rest clamping range up to 152 mm</td>
<td>–</td>
<td>*</td>
</tr>
<tr>
<td>Steady rest clamping range up to 200 mm</td>
<td>–</td>
<td>*</td>
</tr>
<tr>
<td>Differential pressure tailstock</td>
<td>*</td>
<td>*</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Clamping in for the main spindle</th>
<th>NEF 400</th>
<th>NEF 600</th>
</tr>
</thead>
<tbody>
<tr>
<td>210 mm diameter chuck including accessories and chuck jaws</td>
<td>*</td>
<td>–</td>
</tr>
<tr>
<td>215 mm diameter chuck including accessories and chuck jaws</td>
<td>*</td>
<td>–</td>
</tr>
<tr>
<td>250 mm diameter chuck including accessories and chuck jaws</td>
<td>*</td>
<td>*</td>
</tr>
<tr>
<td>315 mm diameter chuck including accessories and chuck jaws</td>
<td>–</td>
<td>*</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Control system</th>
<th>NEF 400</th>
<th>NEF 600</th>
</tr>
</thead>
<tbody>
<tr>
<td>DMG MORI ERGOline® control panel with 19” monitor</td>
<td>*</td>
<td>*</td>
</tr>
<tr>
<td>SIEMENS 840D solutionline Operate with ShopTurn 3G</td>
<td>*</td>
<td>*</td>
</tr>
<tr>
<td>HEIDENHAIN CNC PILOT 640</td>
<td>*</td>
<td>*</td>
</tr>
</tbody>
</table>

* Standard, e Option, – Not available
DMG / MORI SEIKI Europe AG
Lagerstrasse 14, CH-8600 Dübendorf
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info@dmgmori.com, www.dmgmori.com