



Super-hard Tools 超硬工具磨床
GRINDING MACHINE

Catalog
Ver. 2.0



北京迪蒙精锐科技有限公司
BEIJING DMJR TECHNOLOGY CO.,LTD.

Brief introduction

公司简介

北京迪蒙精锐科技有限公司是由北京市电加工研究所及其主要科技人员共同出资设立，是集研发、生产、销售、服务为一体的企业。公司致力于精密金刚石/立方氮化硼工具加工技术的创新与市场拓展，主要产品有机械磨床、电火花磨床以及超硬工具制品。

公司已为客户提供了围绕超硬刀具加工技术的多套解决方案，包括机械磨削技术、放电磨削技术、可视化在线测量技术、工具电极在线修整技术等，并成功应用在我们的产品与服务中。

公司以“精益求精，锐意进取”为企业精神，以先进技术为核心、视质量为生命，将不断开拓创新，竭诚为客户提供系统化解决方案、高质量的产品与无微不至的服务。

Beijing DMJR Technology Co.,Ltd. was funded by Beijing Institute of Electro-discharge Machining and its main research staffs, integrating technical development , manufacture, production sale and service in one. The company devote to product innovations and market developments of precision machining technology for industry diamond and CBN tools. The main products include grinding machine, erosion machine and super-hard material tools.

The company had provided multitude solutions around the machining technologies of super-hard tools for customers, including the mechanical grinding technology, electric discharge grinding technology, on-line inspection and measure technology, tool electrode on-line dressing technology etc, which had been applied in products and customer services successfully.

“Stick to perfection, Striving for success” is our enterprise spirit. We will continually develop the advanced technologies, depend on the outstanding product qualities, insist on innovation, provide the systematized solutions, high quality products and meticulous services for customers.





Highlights in history 发展历程

- 2018** 推出BDM-901D CNC聚晶金刚石V-CUT刀自动磨床，公司正式迁址北京市中关村科技园平谷园。
Launched BDM-901D CNC automatic Grinding Machine for PCD v-cut cutter. Company moves to Pinggu park of Beijing Zhongguancun Science and Technology Park.
- 2016** 北京市电加工研究所投资成立北京迪蒙精锐科技有限公司。
Beijing Institute of Electro-discharge Machining invests to establish Beijing DMJR Technology Co.,Ltd.
- 2015** 主持起草数控电火花超硬刀具磨床行BDM业标准。
Presented to draft out the industry standards of super-hard tools EDM machine.
- 2014** 推出BDM-902N新型超硬刀具磨床，成功应用在加工直径800mm金刚石木工锯片。
Launched BDM-902N new type super-hard tools grinder, applied in processing 800mm diamond circular saws successfully.
- 2013** 开发出AC4060NC数控刀磨装置，实现了螺旋刀铣刀、多刃铰刀等超硬刀具的半自动加工。
Developed AC4060NC numerical control tools grinding device, achieved helix milling cutters and multi-teeth reamers semi-automatic processing.
- 2012** 研制出BDM-902精密超硬刀具机械磨床。
Developed BDM-902 precise super-hard tools grinder.
- 2010** 完成了超硬工模具技术实验室建设项目。
Accomplished the project of "Technical Developing Laboratory of Super-hard Dies and Tools".
- 2009** “精密数控电火花超硬刀具磨床”项目获得科技部与北京市中小企业创新基金的资助。
The project of "Precise Super-hard Tools CNC EDM Grinder" was financed by Beijing Minor enterprises Innovation Fund.
- 2008** 推出BDM-904金刚石立方氮化硼砂轮整形机床。
Launched BDM-904 diamond/CBN grinding wheel dressing machine.
- 2007** 研制出BDM-903精密数控电火花超硬刀具磨床，成功实现金刚石锯片、雕刻刀的数控放电加工。
Developed BDM-903 precise super-hard tools CNC EDM machine, applied to diamond circular saws, diamond engraving cutters processing successfully.
- 2002** 北京市电加工研究所投资成立北京迪蒙特佳工模具技术有限公司。
Beijing Institute of Electro-discharge Machining invested to establish Beijing Dmbest Tool & Die Tech. Co.,Ltd..
- 1999** “PCD聚晶金刚石工业性实验”项目签字仪式在研究所举行。
The project of "PCD Industrial Experiment " was held the signing ceremony.
- 1993** 研究所隆重举行北京市精密超硬材料工模具科研中试基地签字仪式。
Performed the signing ceremony of Beijing Precise Super-hard Material of Dies and Tools Test Base.
- 1992** 研究所注册成立北京市迪蒙机电新技术公司。
Beijing Institute of Electro-discharge Machining registered to establish Beijing DIMENG mechanical and electrical new technology company.
- 1990** 成功研制出国内第一台超硬刀具刃磨机床——BDM-901工具磨床。
Developed the first super-hard tools grinder BDM-901 tools grinder in China.
- 1978** 北京市电加工研究所成立。
Beijing Institute of Electro-discharge Machining established.



BDM-901D是一款手动高效万能工具磨床，适用于机夹刀片、线路板切刀、木工锯片、雕刻刀、车刀、镗刀等刀具的加工，加工的材料包括聚晶金刚石、立方氮化硼、陶瓷、硬质合金、高速钢材料等，既可用作成品刀具的制造，也可用作刀具的修磨。

BDM-901D is a manual high-efficient universal grinding machine suitable for processing inserts, circuit board cutter, wood circular saws, engraving cutters, turning cutters, boring cutters etc. Processed materials include PCD, CBN, ceramics, carbide, HSS. The machine is used for tools production and/or tools regrinding.



加工刀具实例
Tool Examples

Characteristics, technical data and configuration

BDM-901D 特点, 技术数据与配置

机床

- 低振动、高强度灰铸铁床身。
- 7个直线轴, 3个旋转轴。
- 5.5kW大功率电主轴。
- 立轴升降结构。
- 影像系统包含CCD、光学镜筒、工控机, 可在线监视加工状况, 检测工件尺寸。
- 配备光栅尺、编码器与数显表, 可精确显示工件位置。

参数

- | | |
|------------|------------------|
| • 砂轮主轴仰角 | -5°-25° |
| • 刀尖圆角半径 | R0.1-R6mm |
| • 砂轮主轴转速 | 1000-3000转/分 |
| • 砂轮主轴摆动频率 | 30次/分 |
| • 砂轮主轴摆动距离 | 0-40mm |
| • 砂轮主轴电机功率 | 5.5kW |
| • 金刚石砂轮尺寸 | Φ150×Φ40×40mm |
| • 检测系统测量精度 | <0.01mm |
| • 影像放大倍数 | 10-65倍 |
| • 光学镜筒物距 | 300mm |
| • 显示器尺寸 | 17" |
| • 显示器分辨率 | 1280×1024 |
| • 光栅尺长度 | 120mm |
| • 光栅尺分辨率 | 0.001mm |
| • 编码器线数 | 2500线 |
| • 编码器分辨率 | 0.036° |
| • 机床总功率 | 6kW |
| • 机床外形尺寸 | 1230×1330×1700mm |
| • 机床净重 | 约1300kg |

标准配置

- 主机
- 电源与控制系统
- 冷却系统
- 在线监测系统
- 位置显示系统
- 机床灯与LED环形灯
- 快速安装夹具
- 砂轮修整器
- 标准附件
- 技术文档

Machine

- Low-vibration, high-strength grey cast iron machine base.
- 7 linear axes, 3 rotation axes.
- 5.5kW high-power electric spindle.
- Pivot up and down structure.
- The on-line inspection, optical tube and industrial PC system with CCD camera for measurement and inspection during grinding process.
- Equip with optical scale, encoder and digital display meter for accurate positioning display.

Parameters

- | | |
|--|------------------|
| • Grinding spindle inclination | -5°-25° |
| • Tip radius | R0.1-R6mm |
| • Grinding spindle speed | 1000-3000rpm |
| • Grinding spindle oscillation frequency | 30 strokes/min |
| • Grinding spindle oscillation size | 0-40mm |
| • Grinding spindle motor power | 5.5kW |
| • Grinding wheel size | Φ150×Φ40×40mm |
| • Inspection system accuracy | <0.01mm |
| • Image magnification | 10-65x |
| • Object distance of optical tube | 300mm |
| • Monitor size | 17" |
| • Monitor resolution | 1280×1024 |
| • Optical scale length | 120mm |
| • Optical scale resolution | 0.001mm |
| • Number of pulses in encoder | 2500 pulses/turn |
| • Encoder resolution | 0.036° |
| • Total power | 6kW |
| • Dimension | 1230×1330×1700mm |
| • Net weight | about 1300kg |

Standard configuration

- Main part of machine
- Power supply and control system
- Coolant system
- On-line inspection system
- Positioning display system
- Machine light and LED ring light
- Quick clamping fixture
- Dressing attachment
- Standard accessories
- Technical documents

BDM-901D CNC聚晶金刚石V-CUT刀自动磨床

Automatic Grinding Machine for PCD v-cut cutter



BDM-901D CNC是BDM-901D工具磨床的数控化升级产品。适用于线路板V-CUT刀、木工锯片等PCD刀具的自动加工。机床具备自动进刀、自动分度、自动检测、磨削压力自动调节、磨削速度自动匹配，以及加工参数自动记忆、加工错误报警等功能。

BDM-901D CNC is a CNC machine which is upgraded product of BDM-901D. The machine is suitable for processing PCD v-cut and PCD saw blade. The major features of the machine includes automatic feeding and dividing, on-line inspecting, automatic adjusting grinding pressing, automatic matching grinding speed, processing parameters memory, and error alarming, etc.



加工刀具实例
Tool Examples

Characteristics, technical data and configuration

BDM-901D CNC特点，技术数据与配置

机床

- 低振动、高强度灰铸铁床身。
- 7个直线轴，4个旋转轴，其中两种数控。
- 5.5kW大功率电主轴。
- 立轴升降结构。
- 数控系统包括专用控制软件、影像系统、伺服控制单元、工控机，上光源、底光源、位置传感器等。
- 配备高精度数控分度夹具与专用连接法兰。

参数

- | | |
|--------------|------------------|
| • 砂轮主轴仰角 | -5°-25° |
| • 砂轮主轴转速 | 1000-3000转/分 |
| • 砂轮主轴摆动频率 | 30次/分 |
| • 砂轮主轴摆动距离 | 0-40mm |
| • 砂轮主轴电机功率 | 5.5kW |
| • 金刚石砂轮尺寸 | Φ150×Φ40×40mm |
| • 影像系统分辨率 | 0.004mm/像素 |
| • 影像放大倍数 | 150倍 |
| • 光学镜筒物距 | 300mm |
| • 显示器尺寸 | 17" |
| • 显示器分辨率 | 1280×1024 |
| • 数控进给轴行程 | 110mm |
| • 数控进给轴位置分辨率 | 0.001mm |
| • 数控分度轴分辨率 | 0.001° |
| • 机床总功率 | 6kW |
| • 机床外形尺寸 | 1230×1330×1700mm |
| • 机床净重 | 约1300kg |

标准配置

- 主机
- 电源与控制系统
- 伺服控制单元
- 冷却系统
- 数字影像系统
- 机床灯、LED环形灯与底光源
- 数控分度夹具
- 砂轮修整器
- 标准附件
- 技术文档

Machine

- Low-vibration, high-strength grey cast iron machine base.
- 7 linear axes and 4 rotation axes including 2 CNC axes.
- 5.5kW high-power electric spindle.
- Pivot up and down structure.
- CNC system including professional software, digital imaging system, servo-control unit, IPC, upper light, bottom light, position sensor etc.
- Equip with high-accuracy CNC division fixture and connecting flange.

Parameters

- | | |
|--|------------------|
| • Grinding spindle inclination | -5°-25° |
| • Grinding spindle speed | 1000-3000rpm |
| • Grinding spindle oscillation frequency | 30 strokes/min |
| • Grinding spindle oscillation size | 0-40mm |
| • Grinding spindle motor power | 5.5kW |
| • Grinding wheel size | Φ150×Φ40×40mm |
| • Imaging system resolution | 0.004mm/ pixel |
| • Image magnification | 150x |
| • Object distance of optical tube | 300mm |
| • Monitor size | 17" |
| • Monitor resolution | 1280×1024 |
| • CNC feeding axe travel | 110mm |
| • CNC feeding axe positioning resolution | 0.001mm |
| • CNC division axe resolution | 0.001° |
| • Total power | 6kW |
| • Dimension | 1230×1330×1700mm |
| • Net weight | about 1300kg |

Standard configuration

- Main part of machine
- Power supply and control system
- servo-control unit,
- Coolant system
- Digital imaging system
- Machine light , LED ring light and bottom light
- CNC division fixture
- Dressing attachment
- Standard accessories
- Technical documents



BDM-902精密超硬刀具机械磨床具备恒压进给、快速进退刀、磨削过程在线监视、刀具尺寸在线测量、金刚石砂轮在线修整等功能，适用于聚晶金刚石、立方氮化硼、陶瓷、硬质合金、高速钢等材料切削刀具的高效、精密加工，机床主要零部件全部选用国际业界著名企业的产品，包括日本NSK精密轴承，瑞士SCHNEEBERGER导轨，意大利MOTOVARIO减速机，意大利CAMOZZI气动器件、西班牙FAGOR光栅等，与我公司研制的专用刀具夹具配套使用，不仅可实现各种切削刀具的高效加工，还可完成尺寸精度 $\pm 3\mu\text{m}$ 、表面粗糙度Ra0.5铰刀、铣刀的精密加工。

BDM-902 is a manual high- accuracy, high-efficient universal grinding machine, with many advanced functions such as constant pressure feeding, fast feeding and withdrawing, on-line measurement and inspection, on-line wheel dressing. The machine is suitable for grinding PCD, CBN, ceramics, carbide, HSS tools. The key components are all from famous brand including NSK bearing, SCHNEEBERGER guiding, MOTOVARIO decelerating motor, CAMOZZI pneumatic components, FAGOR optical scale etc. Equipped with our special fixtures, the machine is not only successfully used in any kinds of tools high-efficient grinding, but also applied in machining high-accuracy milling cutter and reamer with $\pm 3\mu\text{m}$ dimensional accuracy and Ra0.5 surface roughness.



加工刀具实例 Tool Examples

Characteristics, technical data and configuration

BDM-902特点，技术数据与配置

机床

- 低振动、高强度灰铸铁床身。
- 气动恒压进给、快速进退刀。
- 精密轴承，高强度直线导轨，滚珠丝杠。
- 高精度机械主轴。
- 集成砂轮修整器。
- 集成在线影像监测系统。
- 集成刀具位置显示系统。

参数

• 砂轮主轴移动行程 (X)	430mm
• 砂轮主轴升降距离 (Y)	120mm
• 砂轮主轴仰角	-5-25 °
• 砂轮主轴摆动距离	0-50mm
• 砂轮主轴摆动频率	0-45次/分
• 砂轮主轴转速	1000-4500转/分钟
• 砂轮主轴电机功率	2.2kW
• 拖板进给行程 (Z)	120mm
• 工作台迴转角度	0-240 °
• 工作台移动距离	60×60mm
• 磨削压力	0-400N
• 影像放大倍数	10-65倍
• 光学镜筒移动范围 (WUV)	50×150×150mm
• 光学镜筒物距	300mm
• 光栅尺分辨率	0.001mm
• 编码器分辨率	0.018°
• 机床总功率	4kW
• 机床主机外形尺寸	1780X1850X1450mm
• 机床净重	约2800kg

标准配置

- 主机
- 电源与控制系统
- 冷却系统
- 在线监测系统
- 位置显示系统
- 机床灯与LED环形灯
- 快速安装夹具
- 立轴电动锁紧装置
- 标准附件
- 技术文档

Machine

- Low-vibration, high-strength grey cast iron machine base.
- Pneumatic constant pressure feeding, fast feeding and withdrawing.
- Precise bearing, high strength linear guiding, ball screw.
- High precise mechanical spindle.
- Integrated dressing of the grinding wheels.
- Integrated on-line inspection and measurement system.
- Integrated the tool position display system.

Parameters

• Grinding spindle travel	430mm
• Grinding spindle height adjustment	120mm
• Grinding spindle inclination	-5-25 °
• Grinding spindle oscillation size	0-50mm
• Grinding spindle oscillation frequency	0-45 strokes/min
• Grinding spindle speed	1000-4500rpm
• Grinding spindle motor power	2.2kW
• Slider feeding size	120mm
• Worktable swiveling angle	0-240 °
• Worktable travel	60×60mm
• Contact pressure	0-400N
• Image magnification	10-65x
• Optical tube travel (WUV)	50×150×150mm
• Object distance of optical tube	300mm
• Optical scale resolution	0.001mm
• Encoder resolution	0.018°
• Total power	4kW
• Dimension	1780X1850X1450mm
• Net weight	about 2800kg

Standard configuration

- Main part of machine
- Power supply and control system
- Coolant system
- On-line inspection system
- Positioning display system
- Machine light and LED ring light
- Quick clamping fixture
- Pivot electric locking device
- Standard accessories
- Technical documents



BDM-903是一款盘状电极放电加工机床，适用于PCD、CBN、硬质合金、高速钢工具的磨削加工。机床具备三个数控轴，无论在木工刀具，还是在金属切削刀具加工中，都有非常出色的表现。机床控制单元集成了增爆回路、超精细加工回路以及丰富的放电参数数据库，可实现表面粗糙度Ra0.2、尺寸精度 $\pm 0.005\text{mm}$ 的精密加工。

BDM-903 is a disk erosion machine for complete machining PCD, CBN, carbide, HSS tools. With 3 CNC controlled axes, the machine always has excellent performance whether in wood tools or metal tools processing. Thanks to the high-efficient increasing explosion module, super-fine machining module and the professional technical data base in the control unit, BDM-903 is able to respond to high-precision tools machining requirements such as roughness Ra0.2, dimension accuracy $\pm 0.005\text{mm}$.



加工刀具实例 Tool Examples

Characteristics, technical data and configuration

BDM-903 特点, 技术数据与配置

机床

- 三轴三联动CNC控制。
- 盘状工具电极在线自动车削, $Ra \leq 0.8\mu m$ 。
- 360° 迴转工作台。
- 精密数控分度夹具, U轴。
- 高效增爆放电模块, 超精细放电模块、放电参数专家数据库。
- 自动灭火装置。
- 全封闭结构、排烟装置。
- 天然石材绝缘保护。

参数

• 电极主轴移动行程 (X)	350mm
• 电极主轴移动行程 (Y)	330mm
• 电极主轴仰角	-22-22°
• 电极主轴转速	1000~2800转/分钟
• 电极主轴电机功率	0.75kW
• 工作台尺寸	Φ250mm
• 工作台迴转角度	0-360°
• 工作台升降距离	110mm
• X、Y轴分辨率	0.001mm
• U轴分辨率	0.001°
• 脉冲电压	200V
• 最大加工电流	20A
• 工作液箱容积	80l
• 工作液泵功率	0.75kW
• 机床总功率	6kW
• 机床主机外形尺寸	1800X1690X2100mm
• 机床净重	约2100kg

标准配置

- 主机
- 脉冲电源与控制系统
- 工作液箱
- 自动灭火器
- 手控盒
- 操作面板 (人机界面)
- 机床灯
- 刀具夹具装置 (U轴)
- 电极在线车削装置 (含车刀)
- 标准附件
- 技术文档

Machine

- 3 axes CNC linkage.
- Disk electrode on-line dressing, $Ra \leq 0.8\mu m$.
- 360° rotation worktable.
- CNC precise constant dividing attachment, U axes.
- High-efficient increasing explosion module,, super-fine machining module and professional technical data base.
- Auto fire extinguisher.
- Fully protected structure, auto smoke exhaust device.
- Granite insulation.

Parameters

• Electrode spindle travel(X axes)	350mm
• Electrode spindle travel(Y axes)	330mm
• Electrode spindle inclination	-22-22°
• Electrode spindle speed	1000~2800rpm
• Electrode spindle motor power	0.75kW
• Worktable size	Φ250mm
• Worktable swiveling angle	0-360°
• Worktable height adjustment	110mm
• X and Y axes resolution	0.001mm
• U axes resolution	0.001°
• Pulse voltage	200V
• Working current	max.20A
• Working liquid volume	80l
• Working liquid pump power	0.75kW
• Total power	6kW
• Dimension	1800X1690X2100mm
• Net weight	about 2100kg

Standard configuration

- The mechanical part
- Pulse power supply and control system
- Working liquid tank
- Auto fire extinguisher
- Remote control box
- Control panel (human-computer interface)
- Machine lights
- Tool chucking device(U axes)
- Electrode on-line dressing device (including turning tool)
- Standard accessories
- Technical documents

Numerical control grinding attachment 数控夹具



安装在机床工作台上，两轴两联动PLC控制，用于铣刀、铰刀、钻头、圆柄刀具自动刃磨加工。

- ER40/ER50夹头，刀柄尺寸 $\Phi 3-\Phi 26\text{mm}/\Phi 6-\Phi 34\text{mm}$
- 同心度 0.004mm
- 直线轴行程 60mm ，分辨率 0.001mm
- 旋转轴分辨率 0.001°

Mounting onto the cross worktable, 2 axes PLC linkage, to clamp rotary tools such as end-mills, reamers, deep hole drills etc.

- ER40/ER50 collets, $\Phi 3-\Phi 26\text{mm}/\Phi 6-\Phi 34\text{mm}$.
- Concentricity on clamping taper 0.004mm .
- Linear axis travel 60mm , resolution 0.001mm .
- Rotation axis resolution 0.001° .

Rotation grinding attachment 旋转夹具



安装在机床工作台上，变频调速控制，用于圆柱体、圆锥体磨削加工。

- ER40/ER50夹头，刀柄尺寸 $\Phi 3-\Phi 26\text{mm}/\Phi 6-\Phi 34\text{mm}$
- 同心度 0.004mm
- 转速调节：0-28转/分（低速夹具），0-200转/分（高速夹具）
- 可正反转

Mounting onto the cross worktable, frequency control of motor speed, used for cylinder tools or cone tools grinding.

- ER40/ER50 collets, $\Phi 3-\Phi 26\text{mm}/\Phi 6-\Phi 34\text{mm}$.
- Concentricity on clamping taper 0.004mm .
- Rotation speed adjustment: 0-28rpm (low speed attachment), 0-200rpm (high speed attachment).
- Clockwise or anti-clockwise adjustment.

Dividing attachment 分度夹具



安装在机床工作台上，用于线路板切刀、木工锯片等磨削加工。

- ER40/ER50夹头，刀柄尺寸 $\Phi 3-\Phi 26\text{mm}/\Phi 6-\Phi 34\text{mm}$ 。
- 同心度 0.004mm
- 分度精度 0.2°
- 有24等分、30等分、40等分、60等分等供选择

Mounting onto the cross worktable, used for grinding circuit board cutter, wood circular saws.

- ER40/ER50 collets, $\Phi 3-\Phi 26\text{mm}/\Phi 6-\Phi 34\text{mm}$.
- Concentricity on clamping taper 0.004mm .
- Division accuracy 0.2° .
- 24 division, 30 division, 40 division, 60 division for choice.

Universal quick-clamping attachment 万向夹具



安装在机床工作台上，用于圆柱形、圆锥形过渡圆弧或后角大于25° 刀具的磨削。

- 刀柄尺寸6-20mm
- 两轴-20° -20° 倾斜
- 一轴360° 转动

Mounting onto the cross worktable, used for grinding conical relief, cylindrical relief, or a combination of both, also for grinding the tool with ≥ 25 degree relief angle.

- Arbor size 6-20mm.
- Two axes inclination, angle from -20° to 20° .
- One axes rotation.

CCD measurement and inspection device CCD检测装置



用于检测刀具形状和尺寸，有计算机软件检测和分划板检测两种型式可供选择。

- 测量刀尖圆弧尺寸R0.1-R6mm
- 放大倍数14-70倍
- 物距300mm
- 显示器尺寸17"
- 计算机软件检测装置，可测量线性尺寸、角度、圆弧半径等，还可绘图

Used for measuring or inspecting the shape and dimension of tools. There are two types for choice: PC software, precision scale.

- Tip radius R0.1-R6mm.
- Magnification 14-70x.
- Object distance 300mm.
- Display size 17".
- For computer measuring device, linear dimension, angle, arc radius etc can be measured, and drawing is enable.

Other accessories 其它附件



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