

The Winning Force

DURMA

IW SERIES
Iron Worker



VN SERIES
Coner Notcher



DLC SERIES
L Angle Processing Center



- Reliable
- Efficient
- Ergonomic
- High Capacity
- Low Investment Cost



DURMA The Winning Force






As a total supplier for sheet metal manufacturing with almost 60 years of experience, Durma understands and recognizes the challenges, requirements and expectations of the industry. We strive to satisfy the ever higher demands of our customers by continuously improving our products and processes while researching and implementing the latest technologies.

In our three production plants with a total of 150.000 m², we dedicate 1,000 employees to delivering high quality manufacturing solutions at the best performance-to-price ratio in the market.

From the innovations developed at our Research & Development Center to the technical support given by our worldwide distributors, we all have one common mission: to be your preferred partner.

Present Durmazlar machines with **DURMA** name to the world.



| | | |
|---|---|---|
|  | 1 High technology, modern production lines |  |
| 2 Top quality components |  | 3 High quality machines designed in R&D Centre |

Productive, Reliable, Accurate

The *DURMA* Hydraulic Ironworkers are designed with high speed hydraulics which allows higher production, save labor force and lower cost. Latest manufacturing methods applied guarantees longer lifetime and better efficiency.

These universal machines features standard toolings such as; repetition support tables at punch, shear and notch stations and with easily adjusted hold downs at all five work stations. Each work station is equipped with specially designed hold downs to ensure maximum safety and precision.

“Productive, Reliable and Accurate” that is what describes *DURMA* IW series best!

Easy to Use

Reliable Brand

Efficient

Ergonomic



Punching Precision at its Finest!

Precise punching result at fast speed

Minimum tool change and adjustment time

Reliable Brand

DURMA IW SERIES IRONWORKERS

Designed with multi-functionality in mind to save labor force, time, energy and cost, *DURMA* ironworkers set the industry standard for reliability, productivity and accuracy.

Dual cylinder ironworkers are available in 55, 80, 100, 110, 150 165, 180 and 300-ton models.



IW Series Features

Punching Station

Punching station is designed versatility in mind. The station of bolster plater, makes it possible to perform a wide range of punching. This includes the punching flat bar, flange, angle and channel. The station comes standard with quick change punch and die holders, as well as a swing away stripper. Also included x & y coordinate gauge stops. This feature is useful for repetitive work. At punch station different punching diameter, pipe notching and bending with pres brake attachment can be performed.



String Away Stripper



Press Brake Attachment



Punching Flat Steel



Different Dimension Punch & Dies



Puching Channels Flangers and Angles

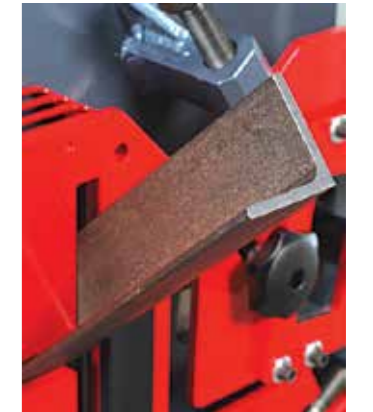


Different Dimension Punch & Dies

IW Series Features

Angle Shearing Station

Blades are four sided and easily installed and rotated. Easy adjustable hold down provides for proper clamping of the material while it is being sheared.



Flat Shearing Station

An easily adjustable hold down ensures proper clamping of the plate. An entry feed table has adjustable guides and stops to make sure the material is accurately placed under the cutting blades. The blades are manufactured in such a way that allows cutting of a wide range of material thickness at a low rake angle and without the need for adjustment.



IW Series Features

Bar Shearing Stations

Bar shearing station consists of square bar shearing, round bar shearing, touch and cut electrical back gauge. Also optional U Blade and optional I&T blades are available upon request.



Square Bar Shearing



Round Bar Shearing



Optional U Blade



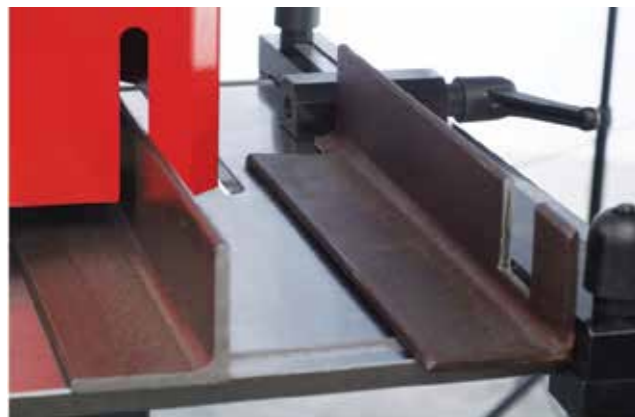
Optional I&T Blades



Touch and Cut Electrical Back Gauge

Notching Stations

This station comes standard with rectangular notching blades which allow side notching, therefore allowing nothing of unlimited widths. V-Notching blades can easily be installed and are available as an option. Other optional devices include tube notching. It is also possible to convert this station to a punching or bending station. A large feed and worktable with gauging stops helps speed up repetitive type of work and ease material handling.



Rectangular Notcher



Triangular Notcher Option

IW 45 "It is meant to be everlasting"

Small Footprint

Efficient Production

Rigid Body Structure

"Durma IW 45 is capable of operating when high volume of work is required. 5 stations enable to make the production more efficient and it can be operated by one foot pedal. It is capable of punching, flat shearing, angle shearing, bar shearing and notching that makes it the perfect fit to serve you for your metalworking needs!"



PUNCHING

Pedinghaus, Mubea, Kingsland punch&die holder
 Bending equipment (top tool + single Vee + Toolholder)
 40-80 NPU punching equipment
 "Pipe Notching Equipment (between 1/2" and 2" any diameter) without punch & die
 For pipe notching punch and dies (each set)
 NC control with table x=39,37 inch Y=13,78 inch

Standard Equipment

PUNCHING

Table for punching station
 Durma punch & die holder
 1 starting set (Punch & Die)
 Punch holder up to 1,1 inch (IW 45)
 Punch holder up to 1,57 inch (IW 55/110-55/110 BTD-80/150-80/150-165/300)
 39,37 inch Electrical backgauge (over 55 tons)
 39,37 inch Manual backgauge for 36&45 to
 Blades for flat steel station
 Blades for angle cutting station
 Blades for round and square bar cutting station

Optional Equipment

Illmunations (24V-220V)
 1 m. Manual backgauge (additional)
 Electrical backgauge (over 39,37 inch)
 Gress pump
 Special colour
 Overseas special packaging

FLAT SHEARING

Spare blades for flat shearing

ANGLE SHEARING

Spare blades for angle shearing

BAR SHEARING

Spare blades for bar shearing

NOTCHING

Triangular notching system with blades
 Spare blades for triangular notching
 Spare blades for rectangular notching

Iron Worker Series Technical Specification

| Punching Pressure | Punching Capacity (DiameterxThickness) | | Throat Depth | | Stroke Length | | Cycles /Min. (0,59 inch. Stroke) | | Cycles /Min. (0,79 inch. Stroke) | | Table Size (WxD) | | Largest Hole | | Single Vee Press Brake (W xT) | | Multi-Vee Press Brake (W xT) | | Pipe Notching | | 1) A min-max for NPU | | Maximum S-Maximum øD(Accor DIN 997) | | 2) A min-max for NPU | | Flat Bar (max. thickness) | | Flat Bar (max. width) | | Blade Length | | Angle Frame Trim | | | | | |
|-------------------|--|------------------------|--------------|------|---------------|-------|----------------------------------|-----------|----------------------------------|------------|------------------|------------|--------------|------------|-------------------------------|------------|------------------------------|----------------|---------------|------|----------------------|------|-------------------------------------|------|----------------------|------|---------------------------|------|-----------------------|------|--------------|------|------------------|---|---|---|--|--|
| | ton | inch | inch | inch | quat. | quat. | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | inch | | | | | |
| IW 45 | 45 | 1,06x50 0,71x0,71 | 6,30 | 0,83 | 20 | - | 17,72x6,30 | 3,93x0,12 | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | - | | |
| IW 55/110 | 55 | 1,57x0,39 0,78x0,78 | 9,84 | 2,36 | - | 37 | 21,65x9,84 | 6,30x0,08 | 9,85x0,39 | 19,68x0,19 | 1/2" -2" | 4,72-10,23 | 0,39x1 | 3,93x9,45 | 7,87x0,78 | 11,81x0,59 | 12 | 2,36x2,36x0,31 | | | | | | | | | | | | | | | | | | | | |
| IW 55/110 LTD | 55 | 1,57x0,39 0,78x0,78 | 20 | 2,36 | - | 37 | 21,65x20 | 6,30x0,08 | 9,85x0,39 | 19,68x0,19 | 1/2" -2" | 4,72-10,23 | 0,39x1 | 3,93x9,45 | 7,87x0,78 | 11,81x0,59 | 12 | 2,36x2,36x0,31 | | | | | | | | | | | | | | | | | | | | |
| IW 80/150 | 80 | 1,57x0,55 0,94x0,94 | 11,81 | 2,75 | - | 38 | 21,65x11,81 | 6,30x0,12 | 11,81x0,39 | 23,62x0,23 | 1/2" -2" | 4,72-15,74 | 0,55x1,10 | 3,93x12,54 | 11,81x0,78 | 17,72x0,59 | 18,70 | 3,15x3,15x0,39 | | | | | | | | | | | | | | | | | | | | |
| IW 80/150 LTD | 80 | 1,57x0,55 0,94x0,94 | 20 | 2,75 | - | 38 | 21,65x20 | 6,30x0,12 | 11,81x0,39 | 23,62x0,23 | 1/2" -2" | 4,72-15,74 | 0,55x1,10 | 3,93x12,54 | 11,81x0,78 | 17,72x0,59 | 18,70 | 3,15x3,15x0,39 | | | | | | | | | | | | | | | | | | | | |
| IW 110/180 LTD | 110 | 1,57x0,78 1,10x1,10 | 24 | 3,15 | - | 28 | 21,65x24 | 6,30x0,19 | 11,81x0,39 | 23,62x0,31 | 1/2" -2" | 5,51-15,74 | 0,55x1,10 | 3,93x12,54 | 15,74x0,78 | 23,62x0,59 | 23,81 | 3,03x3,93x0,47 | | | | | | | | | | | | | | | | | | | | |
| IW 165/300 LTD | 165 | 1,57x1,18 1,33x1,33 | 24 | 3,54 | - | 31 | 29,53x20 | 6,30x0,27 | 16,33x0,47 | 32,87x0,31 | 1/2" -2" | 4,72-15,74 | 0,55x0,10 | 3,93x12,54 | 15,74x1,18 | 29,53x0,78 | 30,11 | 4,72x4,72x0,47 | | | | | | | | | | | | | | | | | | | | |

| Angle Shearing | | Bar Shearing | | Notching | | | | General Information | | | | | | | | | | | |
|-----------------|--|-----------------------|-----------------|------------------|-----------------|-----------------|-----------------|---------------------|-----------------------------|-----------------------------|---------------------------|--|-------------------------------|---------------------------|-------------|--------------|--------------------|---------------------------|----------------|
| At 90° Shearing | At 90° Shearing width slight deformation | At 45° Miter Shearing | Round Bar Shear | Square Bar Shear | U Profile Shear | T Profile Shear | I Profile Shear | Material Thickness | Rectangular Notcher (Width) | Rectangular Notcher (Depth) | Vee-Notcher (SidexSidexT) | Triangular Notching Material Thickness | Triangular Notching Width V90 | Triangular Notching Depth | Motor Power | Oil Capacity | Weight | Machine Dimension (LxWxH) | Working Height |
| 4,72x4,72x0,31 | 3,93x3,93x0,39 | - | 1,18 | 1,18 | - | - | - | 0,28 1,57 | 0,97 | 1,57x1,57x0,28 | 0,16 | 2,95 | 2,95 | 4 | 8,72 | 1914 | 57,48x55,12x63,78 | 39,76 | |
| 4,72x4,72x0,39 | - | 2,75x2,75x0,28 | 0,78x1,57 | 0,78x1,57 | 4,72 | 0,97 | 4,72 | 0,39 1,65 | 3,54 | 1,65x1,65x0,39 | 0,24 | 3,74 | 3,74 | 7,3 | 20 | 2750 | 58,27x70,87x68,11 | 42,52 | |
| 4,72x4,72x0,39 | - | 2,75x2,75x0,28 | 0,78x1,57 | 0,78x1,57 | 4,72 | 0,97 | 4,72 | 0,39 1,65 | 3,54 | 1,65x1,65x0,39 | 0,24 | 3,74 | 3,74 | 7,3 | 20 | 3652 | 77,95x70,87x68,11 | 42,83 | |
| 5,11x5,11x0,5 | - | 2,75x2,75x0,28 | 1,77 | 1,77 | 5,51 | 2,36 | 5,51 | 0,47 2,05 | 3,54 | 2,05x2,05x0,47 | 0,24 | 4,92 | 4,92 | 14,5 | 20 | 4950 | 79,72x70,07x106,3 | 47,05 | |
| 5,11x5,11x0,5 | - | 2,75x2,75x0,28 | 1,77 | 1,77 | 5,51 | 2,36 | 5,51 | 0,47 2,05 | 3,54 | 2,05x2,05x0,47 | 0,24 | 4,92 | 4,92 | 14,5 | 20 | 5500 | 2120x2025x1780 | 47,05 | |
| 5,98x5,98x0,5 | - | 2,75x2,75x0,28 | 1,97 | 1,97 | 6,3 | 2,36 | 6,3 | 0,5 2,05 | 3,54 | 2,05x2,05x0,5 | 0,24 | 4,92 | 4,92 | 20 | 20 | 7820 | 83,46x79,72x70,07 | 49,61 | |
| 8,07x8,07x0,71 | - | 2,75x2,75x0,28 | 2,36 | 2,36 | 7,87 | 3,15 | 7,87 | 0,63 2,28 | 4,33 | 2,28x2,28x0,62 | 0,39 | 4,92 | 4,92 | 29 | 39,62 | 17600 | 127,16x43,30x89,76 | 43,70 | |

P Series

"Concentrated" Punching

If your business needs a punching pioneer, we have got you covered with Durma P Series Ironworker. It is a specialized punching machine that answers to your needs precisely.

Concentrated in Punching

Efficient Production

Rigid Body Structure

Standard & Optional Equipment

Standard Equipment

Table for punching station
Durma Punch & Die Holder
1 Starting Set (Punch & Die)
Punch holder up to 1,57 inch

Optional Equipments







Illuminations (24V - 220V)
Special Colour
Overseas special packaging

PUNCHING

Pedinghaus, Mubea
Kingsland Punch & Die Holder
Bending Equipment
40-80 NPU punching equipment
NC Control



Technical Specifications

| PUNCHING | | | P55 | P80 | P110 |
|---|---------------------------------------|-----------|----------------|----------------|----------------|
| | Punching Pressure | U.S. Tons | 60 | 88 | 121 |
|  | Punch Capacity (Diameter x Thickness) | inch | 1,57x0,39 | 1,57x0,55 | 1,57x0,78 |
| | | | 0,78x0,78 | 0,94x0,94 | 1,10x1,10 |
| | Throat Depth | inch | 20 | 20 | 24 |
| | Stroke lenght | inch | 2,36 | 2,76 | 3,15 |
| | Cycles /Min. (0,79 inch stroke) | quat. | 37 | 38 | 28 |
| | Table Size (W x D) | inch | 21,65x20 | 21,65x20 | 21,65x24 |
| | Working Height up to Die | inch | 43,30 | 47,05 | 50,19 |
| OPTINOL EQUIPMENTS | | inch | | | |
| | Largest Hole | inch | 6,30x0,08 | 6,30x0,12 | 6,30x0,19 |
|  | Single Vee Press Brake (W x T) | inch | 9,85x0,39 | 11,81x0,39 | 11,81x0,39 |
|  | Multi-Vee Press Brake (W x T) | inch | 19,68x0,19 | 23,62x0,24 | 23,62x0,31 |
|  | Pipe Notching | inch | 1/2" - 2" | 1/2" - 2" | 1/2" - 2" |
|  | A min-max | inch | 4,72x10,23 | 4,72x15,74 | 5,51x15,74 |
| | ØD max | inch | (DIN 997) 1 | (DIN 997) 1,1 | (DIN 997) 1,1 |
| | S max | inch | (DIN 997) 0,39 | (DIN 997) 0,55 | (DIN 997) 0,55 |
|  | B min-max | inch | 3,93-9,45 | 3,93-12,54 | 4,72-12,54 |
| | ØD max | inch | (DIN 997) | (DIN 997) | (DIN 997) |
| | S max | inch | (DIN 997) | (DIN 997) | (DIN 997) |

| TECNICAL DATA | | | | | |
|---------------------------------------|------|--|-------------------|-------------------|-------------------|
| Motorpower | hp | | 7,3 | 14,5 | 20 |
| Oil Capacity | gl | | 20 | 20 | 20 |
| Net Weight (Apr.) | lbs | | 51,97 | 1900 | 2630 |
| Gross Weight (Apr.) | lbs | | 52,76 | 1920 | 2650 |
| Machine dimensions (Apr.) (L x W x H) | inch | | 52,76x36,61x72,83 | 59,84x36,61x78,74 | 66,53x36,61x85,83 |
| Packing Dimensions (Apr.) (L x W x H) | inch | | 54,33x43,31x78,74 | 62,99x43,31x80,71 | 66,93x43,31x88,19 |

NC Series

| Technical Specification | | |
|-----------------------------------|----------------------|------------|
| Table Dimension | inch | 68,9x32,87 |
| X Axis Working Dimension (Stroke) | inch | 39,37 |
| Y Axis Working Dimension (Stroke) | inch | 13,78 |
| Movement Speed Of X Axis | m/min. | 0-14 |
| Movement Speed Of Y Axis | m/min. | 0-10 |
| Positioning Accuracy | inch | ± 0,0039 |
| Controller | Hmi-plc 7 Inch Eaton | |



Multi P 80

It is designed for businesses that require greater volume of work and desire a more productive machine. It is equipped with triable punching unit, hydraulic holddown and Siemens control unit.

Faster Production

Increased Productivity

User Friendly Control Unit

| | | |
|-------------------------------|-----------|-----------|
| Multi P | U.S. Tons | 88 |
| Max. Length of Sheet X axis | inch | 59,06 |
| Max. Width of Sheet, Y axis | inch | 29,53 |
| Thickness Of Metal Plate | inch | 0,06-0,78 |
| Positioning Tolerance | inch/min | 0.0039 |
| Punching Tonnage | U.S. Tons | 88 |
| Max. Traverse Speed Of X axis | m/min | 25 |
| Max. Traverse Speed Of Y axis | m/min | 25 |
| Cycles/Min (0,79 inch Stroke) | quat. | 38 |
| Stroke Length | inch | 2,76 |
| Length | inch | 147,83 |
| Table Width | inch | 51,57 |
| Width | inch | 115,35 |
| Working Height | inch | 48,03 |
| Height | inch | 88,19 |
| Weight | lbs | 24580 |



Multi P Line

DURMA Multi P Line is a complete solution partner for punching Lighting Pole punching. Automatic lighting pole punching line is designed to increase efficiency and speed.

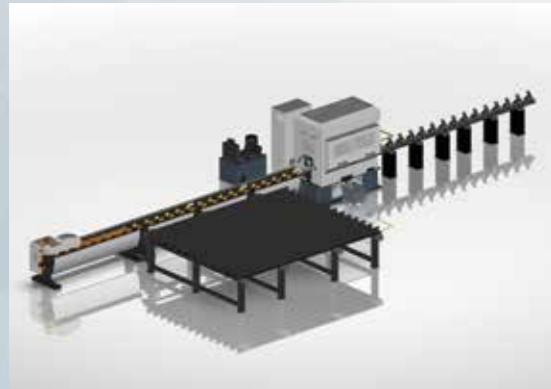
- Faster Loading & Unloading
- More Efficient
- Time Saving
- Complete Solution



DLC 160

L Angle Processing Center

DURMA L Angle series has been designed to be a time saver. Less installation time, less adjustment duration and less tool changing process. On L profiles; marking (labeling), punching and cutting can be performed automatically without requiring additional processing.



DLC 160 Technical Specification

| | | |
|-------------------------------|----------|-----------------|
| DLC | Unit | 160 |
| Max. L Profile Size | | 6,5"x6.5"x0.75" |
| Min. L Profile Size | | 1.6"x1.6"x0.15" |
| Main Motor Power | kW | 15 |
| Cooling Motor Power | kW | 1.1 |
| Max. Pressure | bar | 265 |
| Max. Shear Tonnage | kN | 3000 |
| Max. Punching Tonnage | kN | 1000 |
| Max. Standart Tool Diameter | inch | 1,25" |
| Number of Shot Per Minute | | 30 |
| Max. Marking Tonnage | kN | 200 |
| Number of Cassette Unit | | 8 |
| Number of Characters | | 12 |
| Number of Cutting Per Minute | | 20 |
| Number of Punching per Minute | | 32 |
| Number of Marking per Minute | | 42 |
| Speed of feeding table | inch/min | 4 |



DLC 160 Series

Automatic Feeding

Material feeding process can be done with hydraulic driven clamps that squeeze the edge of the L profile and shift them on the automatic feeding table.



DLC 160 Series

Punching Stations

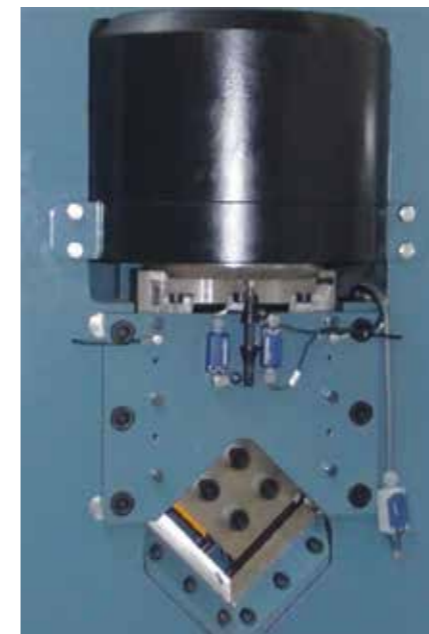
Punching stations can move/work independently one to another by triple punch-matrix groups. Positioning has been made very sensitive with servomotor-ball screw mechanism.



Shearing, Punching and Marking

DLC series feature shearing, punching and marking abilities that makes it a real time saver. On L profiles marking, punching and cutting can be done automatically without requiring additional processing.

Marking station is consisted of variant types of modules, trays (cassette) and controlled automatically and independently. The cassette holder is able to configure and the client can be installed in 8 different tapes.



VN Series Corner notcher

Durma Corner notcher have strong body structure and it is composed with high quality components. Convinient foot switch enables operator to use both hands for work efficiency.

- Small Footprint
- High Quality Components
- Long Durability
- Convinient Foot Switch

Specifications

| VN | Unit | 2006 |
|---------------------------|--------|-------------|
| Cutting Capacity | inch | 0,24-0,16 |
| Cutting Lenght | inch | 7,87 x 7,87 |
| Cutting Angle | degree | 30° - 140° |
| Stroke Per Min. | quat. | 28 |
| Motor Power | kw | 5,43 |
| Working Power Pressure | bar | 210/3045 |
| Oil Capacity | lt | 13,20 |
| Height | inch | 51,18 |
| Width | inch | 41,34 |
| Lenght | inch | 35,43 |
| Weight | lbs | 2094 |
| Sound Strenght (Unloaded) | dBA | 66 |
| Sound Strenght (Loaded) | dBA | 77 |



Fast on Service and Spare Parts

DURMA provides the best level of service and spare parts with qualified personnel and spare parts in stock. Our experienced and professional service personnel are always ready at your service. Our professional training and application enriched courses will give you an advantage to use our machinery.



Consultancy



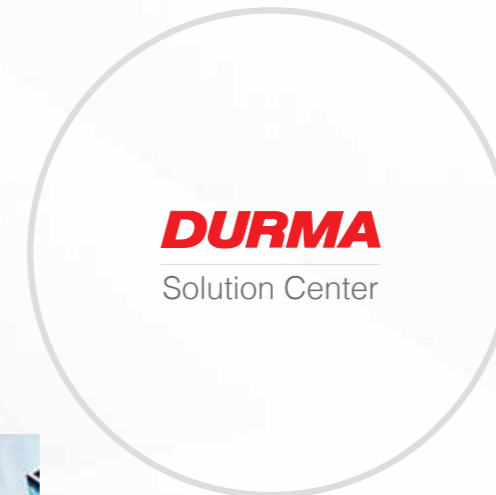
Spare Parts



R&D Center



After Sales Service



Service Agreements



Software



Training



Flexible Solution

DURMA

DURMA



PANEL BENDER



PUNCH



PRESS BRAKE



VARIABLE RAKE SHEAR



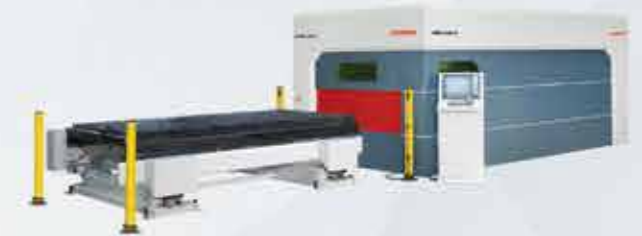
PLASMA



L ANGLE PROCESSING CENTER



TUBE LASER CUTTING



FIBER LASER



IRON WORKER



POWER OPERATED SHEAR



ROLL BENDING



PROFILE BENDING



CORNER NOTCHER

DURMA

Today, Tomorrow, Forever...

IW SERIES
Iron Worker

VN SERIES
Coner Notcher

DLC SERIES
L Angle Processing Center

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