

DURMA

VS SERIES

VARIABLE RAKE CNC SHEAR



- Perfect Cutting
- Fast Speed
- Powerful
- Accurate
- Efficient



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



3

High quality
machines designed
in R&D Centre

2

Top quality
components



VS Series

Variable Rake CNC Shear

Well equipped for precision cuttings (± 0.05 cutting precision)

High technology VS variable rake shears, with **0° 30' - 2°** precise rake adjustment, cut fast and efficiently. Easy to use and good quality cutting feature are suitable for every job. By entering all cutting parameters you can have precise and perfect cutting. High efficient and maximum security VS shears will differentiate you with its precise cutting.



Advance Your Standards

Precision and high quality cuts with automatic gap adjustment

In world standards equipped with high-tech products VS Series Shears offer you exact solutions. We have reduced the cutting angle to achieve straight precision and minimum twist tolerance.

Easy to Use

Economic

Efficient

Faster

Reliable Brand



Why *DURMA* Shears

- Better and faster cuttings
- Automatic blade gap adjustment
- Stronger and rigid body structure
- High sensitivity and repeatability
- High-tech excellent equipments
- Low service cost
- Adds value to your company
- Reliable brand

Gain More Power

Performance and Productivity

The *DURMA* VS series CNC variable rake shear is one of the most advanced production shears available today. From 0,25 up to 1 inch shearing capability these highly developed machines yield the most flexibility you can hope to get in a modern shearing machine.



General Specifications

- Robust design & powerful body for perfect cutting
- Hardened and ground blades for long life and precise
- CE standards security
- The combination of economic and perfect cutting performance
- Blade clearance and cutting angle automatically adjusted by CNC controller
- User friendly CNC touch screen control unit
- VS shears provide flexible use for narrow or wide, thin or thick sheet metal cutting.
- Automatic swing up back gauge for more comfortable use
- Sheet support arms
- Front feeding and conveyor systems
- Front support arms T-Slots for easy cutting and feeding material
- Ball Transfer table

Standard & Optional Equipment

Standard Equipments

CE-Norm
Heavy duty steel construction & Stress relieved frame
User friendly CNC Touchscreen control unit D-Touch 7
Automatically adjusted rake angle by CNC
Adjusted cutting length by CNC
Ball integrated front tables
Ball screw back gauge, 40 inch
Flip-up finger guards 40 inch
Squaring arm with scale T-Slot (L=60 inch)
Support arms T-Slot & Tilting stop (L=40 inch)
Illumination & Shadow line
Throat depth with 14 inch
Automatically pressure adjusted solid holddowns
Top and bottom blades with four sides

Optional Equipments

Laser Cutting Line
Light curtains for finger protection
Pneumatic sheet support *DURMA I*
Pneumatic sheet support *DURMA IV*
Hydraulic anti-twisting
Special throat depth
Back gauge 50 inch
X1, X2 axis
Oil coolant
Oil heater
Central lubrication manual
Central lubrication motorized
Adjustable angle stop 0-180°
Add. Support arms
Special blades
Temperature measurement
Overseas special packaging

D-Touch 7 Control Unit



Fast data input



Easy connection USB port



Ethernet RJ-45 10/100M



Easy programming

Cuttings are easier with D-Touch 7

With easy to use interface D-Touch 7 enables perfect cutting in seconds by endless programming and material entrance feature.

- Wide, colored, touch-screen (LCD 7" 800x480)
- Quick data entry
- Easy connection
- USB input
- Ethernet: RJ-45 10/100M
- Windows CE Unlimited program and steps
- Unlimited material type

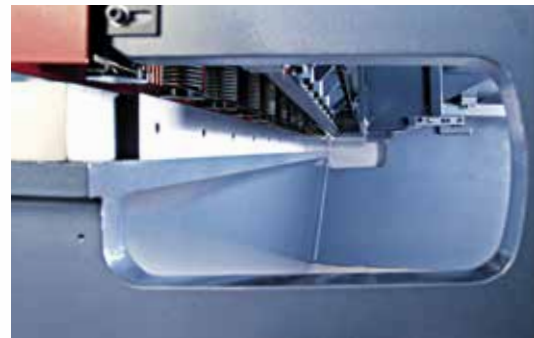


VS Series General Features

With choice of standards and optional equipment VS Series add to value your business by offering proper solutions for your needs. With the high-tech features high efficiency, high precision, high performance criteria VS Series have proved that it is user-friendly and the best of in this sector.



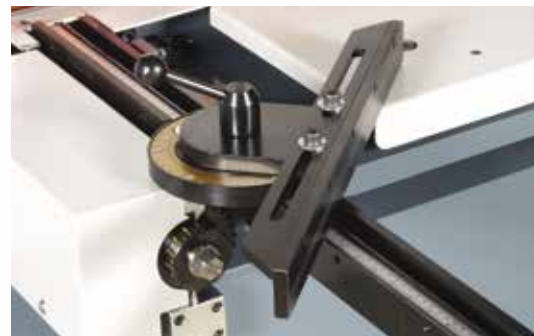
Flip-up Finger Guard
Ball Transfer Table
Hydraulic Holddowns



Special Throat Depth



Light Curtains For Finger Guard



Adjustable Angle Stop 0-180°



Conveyor System



Thin Sheet Support System

Robust Back Gauge System

Precision

Robust

Min. Deformation



- Fast and high accuracy
- Reliable movement
- Adjustment at any point
- Resistance to crash
- Maintenance free
- Better and fast cutting
- Easy and secure usage
- High precision and repeatability

Why *DURMA* Back Gauge?

One of the most important factor for cutting capacity is the design of back gauge and stability.

Quality cutting is possible with perfect product, stability and precision back gauge.

The high speed **ballscrew** back gauge system movement is also supported with **linear guides**, which helps the back gauge achieve long life, greater sensitivity and strengthens against any collisions.

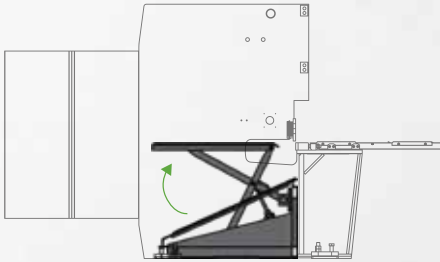


Ballscrew back gauge

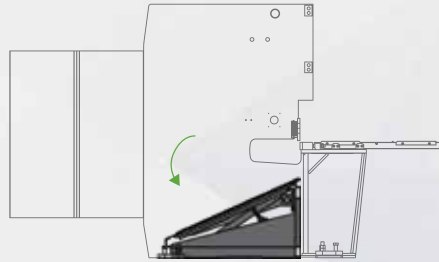
Sheet Support Systems

Pneumatic Thin Sheet Support System

DURMA I



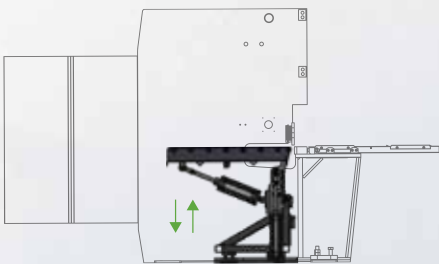
Step 1



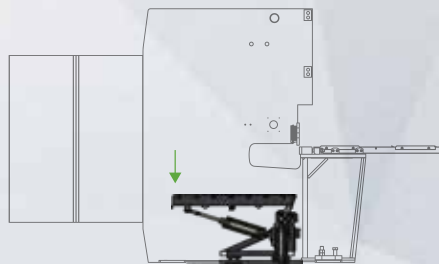
Step 2

Pneumatic Thin Sheet Support System

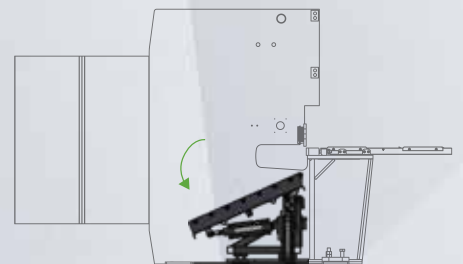
DURMA IV



Step 1



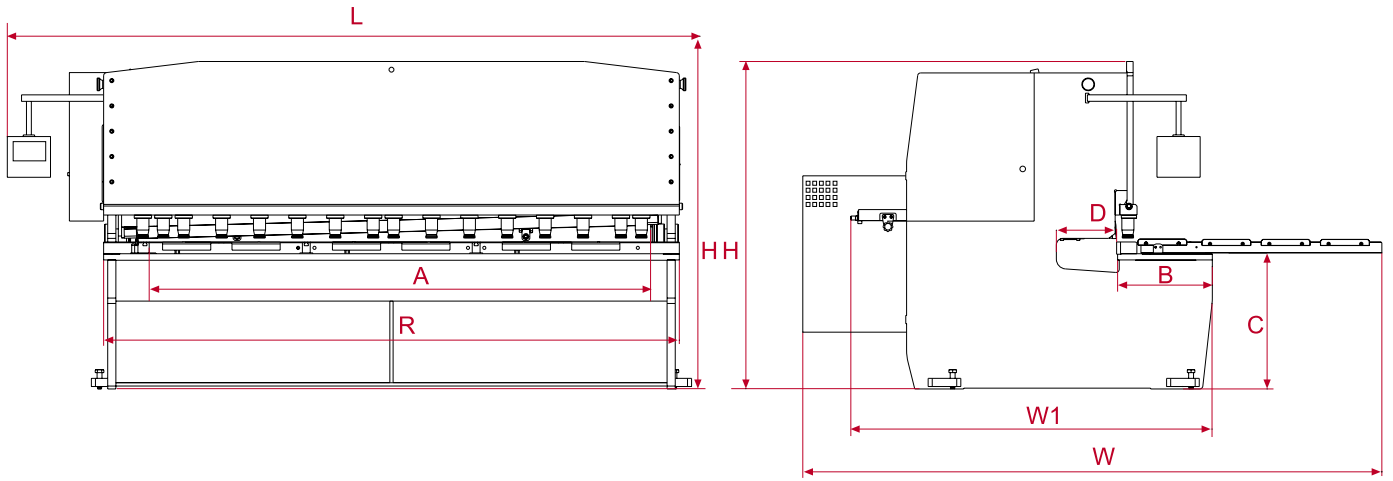
Step 2



Step 3

VS Series Technical Details

VS Series	Cutting Length	Cutting Capacity		Stroke per min.	Cutting Angle		Number of Holddowns	Holddown Force		Back Gauge Range
		MS (65 ksi)	SS (100 ksi)	Minimum - Maximum	Minimum	Maximum		Minimum	Maximum	
	inch	inch	inch	1/min.	°	°	lbf	lbf	inch	
	A									
3006	121	0,25	0,16	12 - 20	0° 30'	2°	16	9000	45000	39
3010	121	0,40	0,30	10 - 20	0° 30'	2°	16	9000	4500	39
3013	121	0,50	0,40	9 - 17	0° 30'	2° 30'	17	18000	9000	39
3016	121	0,63	0,47	7 - 12	0° 30'	2° 30'	14	25000	123500	39
3020	121	0,80	0,60	6 - 12	0° 30'	2° 30'	14	38500	186500	39
4006	161	0,25	0,16	10 - 20	0° 30'	2°	20	9000	45000	39
4013	161	0,50	0,40	7 - 13	0° 30'	2° 30'	20	22500	108000	39
4016	161	0,63	0,60	5 - 9	0° 30'	2° 30'	17	112500	225000	39
4020	161	0,80	0,60	4 - 8	0° 30'	2° 30'	21	112500	225000	39
6006	239	0,25	0,16	6 - 10	0° 30'	2°	29	22500	45000	39
6013	239	0,50	0,40	5 - 10	0° 30'	2° 30'	29	65500	130500	39
6016	239	0,63	0,47	4 - 10	0° 30'	2° 30'	29	65500	130500	39
6020	239	0,80	0,60	3 - 6	0° 30'	3° 15'	29	108000	225000	39
6025	240	0,98	0,75	3 - 6	0° 30'	3° 25'	30	337500	565000	39
8010	319	0,40	0,30	3 - 6	0° 30'	2°	40	90000	135000	39
10013	398	0,50	0,40	3 - 6	0° 30'	2° 12'	52	135000	182000	59



Back Gauge Speed	Motor Power	Oil Capacity	Throat Depth	Front Arms	Table Height	Table Width	Table Length	Length	Width	Total Width	Height	Weight
inch/sec.	kW	gallon	inch	Unit	inch	inch	inch	inch	inch	inch	inch	~pound
			D		C	B	R	L	W1	W	H	
8	11	33,0	14	3	32,3	19,4	129,1	161,4	80,7	143,7	76,8	17600
8	22	47,6	14	3	32,3	21,3	132,3	149,6	80,7	139,8	84,6	20500
8	30	79,3	14	3	32,9	22,0	133,1	165,4	82,7	140,2	96,5	28500
8	45	118,9	14	3	33,1	21,8	134,6	162,6	87,0	150,4	101,2	40000
8	45	132,1	14	3	33,1	22,8	136,2	161,4	90,6	145,7	104,3	47500
8	11	33,0	14	4	32,3	19,4	173,2	202,8	82,7	139,8	80,7	23000
8	30	87,2	14	4	32,9	23,2	173,2	204,7	84,6	140,2	100,4	40000
8	45	105,7	14	4	39,4	24,8	172,6	231,9	82,7	142,7	116,1	54000
8	45	132,1	14	4	39,4	24,8	173,4	232,3	86,6	148,6	116,1	67000
8	22	52,8	14	6	35,4	24,8	250,8	287,4	84,6	133,9	108,3	56500
8	37	105,7	14	6	37,4	25,6	251,0	291,3	86,6	145,7	114,2	75000
8	45	145,3	14	6	37,4	25,6	251,0	291,3	86,6	149,2	116,1	86800
8	45	145,3	14	6	37,4	31,5	259,6	318,9	110,2	161,4	139,0	134500
8	55	198,2	14	6	39,4	35,4	265,7	309,1	114,2	167,3	133,9	159000
8	30	145,3	20	7	48,0	33,5	336,4	358,3	131,9	165,4	129,1	192000
8	45	171,7	30	9	47,6	33,9	418,5	452,8	133,9	166,9	149,6	325000

Special Projects

CNC Front Feeding



Sheet Support + Belt Conveyor + Stacker + Scrap Container



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



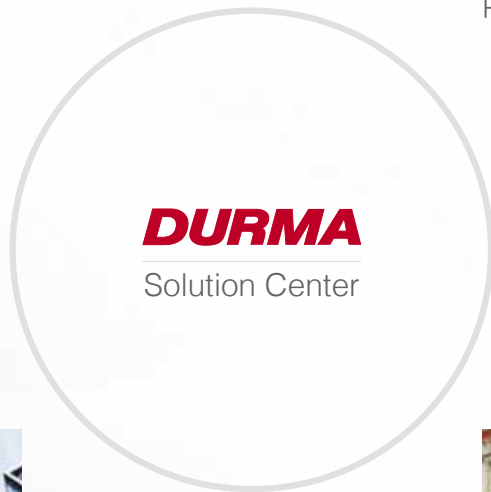
Spare Parts



R&D Center



After Sales Service



Service Agreements



Software

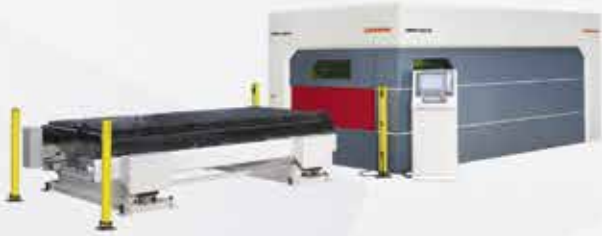


Training



Flexible Solution

DURMA



FIBER LASER



PUNCH



PLASMA



L ANGLE PROCESSING CENTER



IRON WORKER



POWER OPERATED SHEAR



PRESS BRAKE



VARIABLE RAKE SHEAR



ROLL BENDING



PROFILE BENDING



BANDSAW



CORNER NOTCHER

DURMA

VS SERIES
VARIABLE RAKE CNC SHEAR

Durmazlar Makina San. Tic. A.Ş. has right to change catalogue values and machine technical details without notice.

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