

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 m<sup>2</sup>, 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.



 <p>1 High technology, modern production lines</p>	
 <p>2 Top quality components</p>	 <p>3 High quality machines designed in R&amp;D Centre</p>

# 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



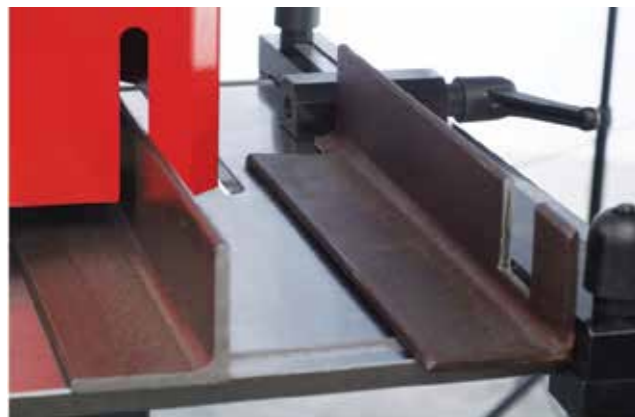
Optional I&T Blades



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=1000mm Y=350mm

### Standard Equipment

#### PUNCHING

Table for punching station  
 Durma punch & die holder  
 1 starting set (Punch & Die)  
 Punch holder up to 28 mm (IW 45)  
 Punch holder up to 40 mm (IW 55/110-55/110 BTD-80/150-80/150-165/300)  
 1m. Electrical backgauge (over 55 tons)  
 1m. 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 1m.)  
 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 Details

Punching Pressure	Punching Capacity (DiameterxThickness)	Throat Depth	Stroke Length	Cycles /Min. (15mm. Stroke)	Cycles /Min. (20mm. 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	
																		Punching
ton	mm	mm	mm	quat.	quat.	mm	mm	mm	mm	inch	mm	mm	mm	mm	mm	mm	mm	
IW 45	45	27x13 18X18	160	21	20	-	450x160	100x3	-	-	-	-	-	200x13	300x10	305	80x80x10	
IW 55/110	55	40x10 20X20	250	60	-	37	550x250	160x2	250x10	500x5	1/2"-2"	120-260	10-Ø25	100-240	200x20	300x15	305	60x60x8
IW 55/110 BTD	55	40x10 20X20	510	60	-	37	550x510	160x2	250x10	500x5	1/2"-2"	120-260	10-Ø25	100-240	200x20	300x15	305	60x60x8
IW 80/150	80	40x14 24X24	300	70	-	38	550x300	160x3	300x10	600x6	1/2"-2"	120-400	14-Ø28	100-320	300x20	450x15	475	80x80x10
IW 80/150 BTD	80	40x14 24X24	510	70	-	38	550x510	160x3	300x10	600x6	1/2"-2"	120-400	14-Ø28	100-320	300x20	450x15	475	80x80x10
IW 110/180 BTD	110	40x20 28X28	610	80	-	28	550x610	160x5	300x10	600x8	1/2"-2"	140-400	14-Ø28	100-320	400x20	600x15	605	100x100x12
IW 165/300 BTD	165	40x30 34X34	610	90	-	31	750x510	160x7	415x12	835x8	1/2"-2"	120-400	14-Ø28	100-320	400x30	750x20	765	120x120x12

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 Thicknes	Triangular Notching Width V90	Triangular Notching Depth	Motor Power	Oil Capacity	Weight	Machine Dimension (LxWxH)	Working Height
Angle Shearing			Bar Shearing				Notching				General Information								
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kw	lit	kg	mm	mm
80x80x8	100x100x10	-	30	30	-	-	-	7	40	50	40x40x7	4	75	75	3	33	870	1460x1400x1620	1010
120x120x10	-	70x70x7	20-40	20-40	120	50	120	10	42	90	42x42x10	6	95	95	5.5	76	1250	1480x1800x1730	1080
120x120x10	-	70x70x7	20-40	20-40	120	50	120	10	42	90	42x42x10	6	95	95	5.5	76	1660	1980x1800x1730	1088
130x130x13	-	70x70x7	45	45	140	60	140	12	52	90	52x52x12	6	125	125	11	76	2250	2025x1780x2700	1195
130x130x13	-	70x70x7	45	45	140	60	140	12	52	90	52x52x12	6	125	125	11	76	2500	2120x2025x1780	1195
152x152x13	-	70x70x7	50	50	160	60	160	13	52	90	52x52x13	6	125	125	15	76	3600	2560x2550x1790	1260
205x205x18	-	70x70x7	60	60	200	80	200	16	58	110	58x58x16	10	125	125	22	150	8000	3230x1100x2280	1110

# P Series

"Concentrated" Punching

If your business needs a punching pioneer, we have got you covered with Durma P Series Ironwoker. 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 40 mm

### 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	Ton	55	80	110
	Punch Capacity (Diameter x Thickness)	mm	Ø40X10	Ø40X14	Ø40x20
			Ø20X20	Ø24X24	Ø28x28
	Throat Depth	mm	510	510	610
	Stroke lenght	mm	60	70	80
	Cycles /Min. (20 mm stroke)	quat.	37	38	28
	Table Size (W x D)	mm	550x510	550x510	550x610
	Working Height up to Die	mm	1100	1195	1275
OPTINOL EQUIPMENTS					
	Largest Hole	mm	Ø160x2	Ø160x3	Ø160x5
	Single Vee Press Brake (W x T)	mm	250x10	300x10	300x10
	Multi-Vee Press Brake (W x T)	mm	500x5	600x6	600x8
	Pipe Notching	inch	1/2" - 2"	1/2" - 2"	1/2" - 2"
	A min-max	mm	120 - 260	120 - 400	140 - 400
	ØD max	mm	(DIN 997) 25	(DIN 997) 28	(DIN 997) 28
	S max	mm	(DIN 997) 10	(DIN 997) 14	(DIN 997) 14
	B min-max	mm	100 - 240	100 - 320	120 - 320
	ØD max	mm	(DIN 997)	(DIN 997)	(DIN 997)
	S max	mm	(DIN 997)	(DIN 997)	(DIN 997)

TECNICAL DATA				
Motorpower	KW	5,5	11	15
Oil Capacity	lt	76	76	76
Net Weight (Apr.)	kg	1320	1900	2630
Gross Weight (Apr.)	kg	1340	1920	2650
Machine dimensions (Apr.) (L x W x H)	mm	1340x930x1850	1520x930x2000	1690x930x2180
Packing Dimensions (Apr.) (L x W x H)	mm	1380x1100x2000	1600x1100x2050	1700x1100x2240

## NC Series

Technical Specification		
Table Dimension	mm	1750x835
X Axis Working Dimension (Stroke)	mm	1000
Y Axis Working Dimension (Stroke)	mm	350
Movement Speed Of X Axis	m/min.	0-14
Movement Speed Of Y Axis	m/min.	0-10
Positioning Accuracy	mm	± 0,1 mm
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	Unit	80
Max. Length of Sheet X axis	mm	1500
Max. Width of Sheet, Y axis	mm	750
Thickness Of Metal Plate	mm	2-20
Positioning Tolerance	mm/m	0.1
Punching Tonnage	ton	80
Max. Traverse Speed Of X axis	m/min	25
Max. Traverse Speed Of Y axis	m/min	25
Cycles/Min (20 mm Stroke)	quat.	38
Stroke Length	mm	70
Length	mm	3755
Table Width	mm	1310
Width	mm	2930
Working Height	mm	1220
Height	mm	2240
Weight	kg	11150



# 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

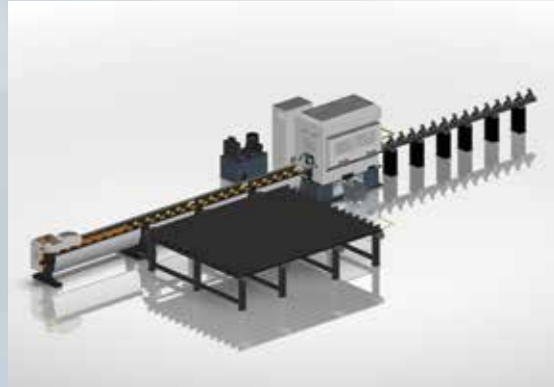




# DLC 160

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 Details

DLC	Unit	160
Max. L Profile Size		160x160x19
Min. L Profile Size		40x40x4
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	mm	32
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	m/min	100

## 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

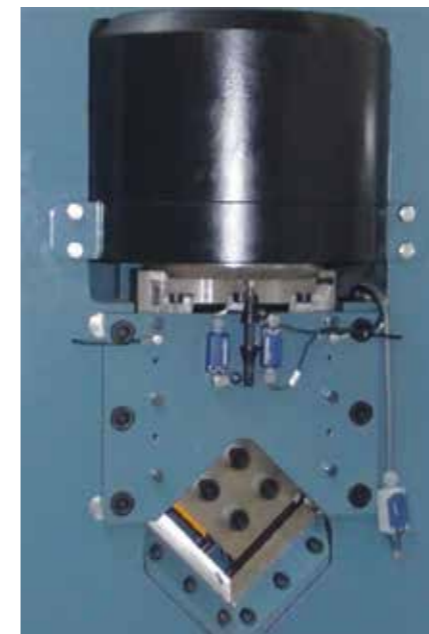
Punching stations can move/work independently one to another by triple punch-matrix groups. Positioning has been made very sensitive with servomotor-ball screw mechanism.



### 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	mm	6 - 4
Cutting Lenght	mm	200 x 200
Cutting Angle	mm	30° - 140°
Stroke Per Min.	mm/m	28
Motor Power	kw	4
Working Power Pressure	bar	210 3045 PSI
Oil Capacity	lt	50
Height	mm	1300
Width	mm	1050
Lenght	mm	900
Weight	kg	950
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**

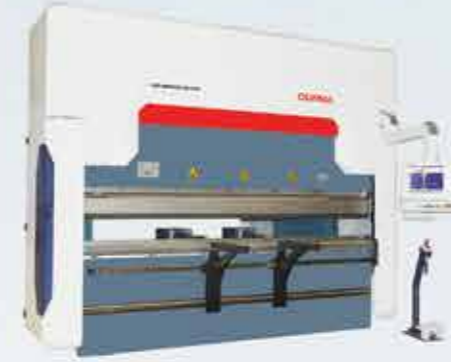
**DURMA**



PANEL BENDER



PUNCH



PRESS BRAKE



VARIABLE RAKE SHEAR



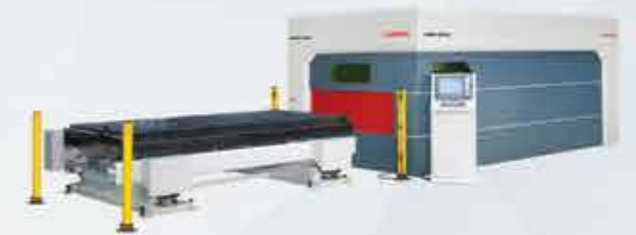
PLASMA



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