DURMA

Head Quarter & Ataevler

Durmazlar has aimed continous development since 1956

Owes one of the world's most contemporary production plants in the production technology business .3 different plants oriented to different product families, 1000 dedicated employees and 150.000 m2 footprint.

In order to offer solution according to clients' needs and enriching the quantity and quality of its own patent rights; long experienced Engineering Department transformed to Durma Research & Develepment Center has opened in the year 2010. Designed and engineered with modern technics; its products are equipped with proven quality components to precisely fulfill your requirements. We serve " accuracy, speed, flexibility, durability, reliability and advanced technology" with high performance/price ratio.Worldwide Durma distributors and technical support network assures perfect support to our clients.

With its 55 years of experience, its product quality, innovative solutions Durma gives importance and cares you with proactive approach. We thank all our clients to hold us at the top segment of the world brands.

Laser Factory

Başköy Factory

IW Series

Iron Worker
Combined and convenient metal working solution for variety of processes

P Series

Punch
Cost effective punching solution for every thicknesses

MULTI - P Series

Multi Punch
Multiple punching head and CNC, machine offers productivity and ease of operation.

MULTI - P Line

Multi Punch Line
Multiple punching head and CNC, machine offers productivity and ease of operation for huge sheet punching.

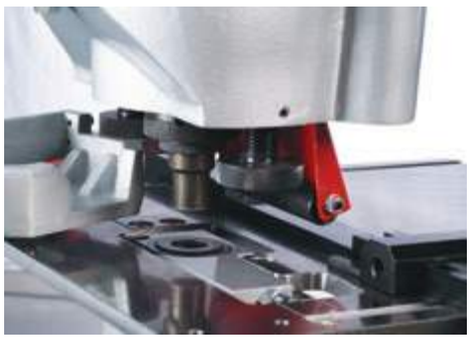
165/300
DURMA

IW SERIES

The DURMA Hydraulic Ironworkers are designed with multi-functions to save labor, time energy and cost. DURMA Ironworkers are well engineered, maximum efficiency and long life is guaranteed by latest manufacturing methods. These universal machines are supplied with Standard tooling including 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 safety while providing precision and easy use.

DURMA Ironworkers stand for reliability, productivity and accuracy.

IW Series Features



Swing Away Stripper

Punching Flat Steel

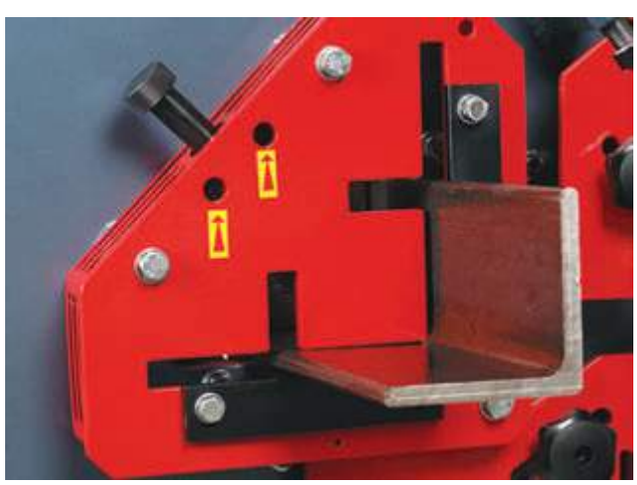
Punching Channel Flangers And Angles

Different Dimension Punch & Dies

Press Brake Attachment

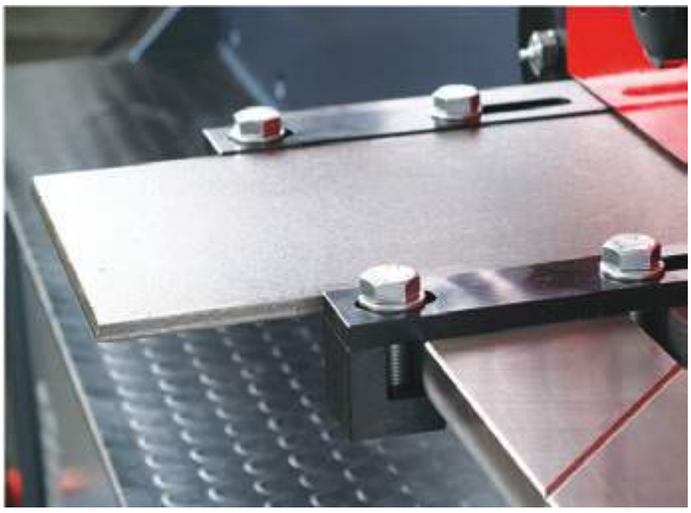
Punching Station

The punch station is designed with versatility in mind. The station of the bolster plate, makes it possible to perform a wide range of punching. This includes the punching of 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 are 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.



Angle Shearing Station

Blades are four sided and and easily installed and rotated. An 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.

Square bar Shearing

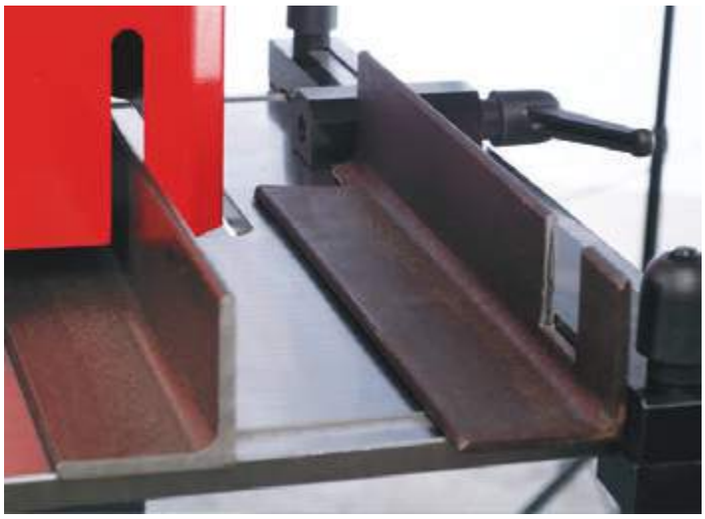
Round bar Shearing

Optional U blade

Optional I & T blades

Touch and cut electrical back gauge

Bar Shearing Stations



Rectangular Notcher

Triangular Notcher Option)

Notching Stations

This station comes standard with rectangular notching blades which allow side notching, therefore allowing notching of unlimited widths. Vee 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 work and ease material handling.

IW 45 & IW 45 M

Durma IW 45 Series Ironworkers are specially designed for high volumes and with its 5 stations enables to make efficient production. 45 tom machines have single cylinder and 5 stations can be operated by one foot pedal.

Punching station has max. Capacity of 27x13 & 18x18

Swing away stripper

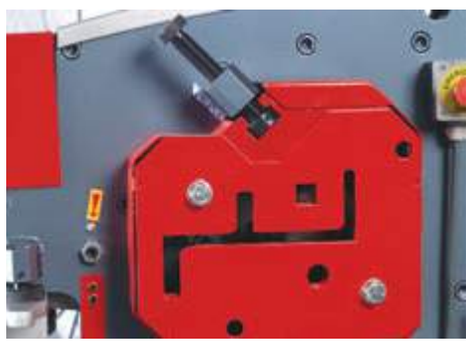
Punching flat steel

Punching Station

200x15 mm. & 300x12 mm. Flat steel cutting capacity

Flat Shearing Station

Angle Shearing Station for IW45



At angle shear station with Z shape apparatus, it is possible to make miter shear on angle bars

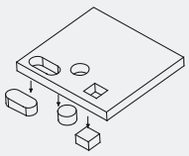
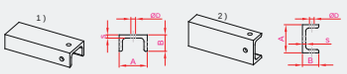
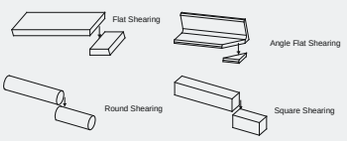
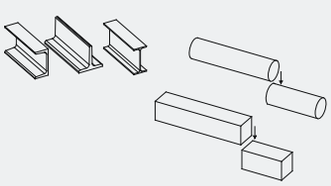
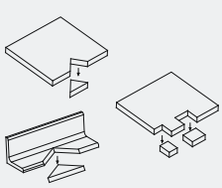
Angle Shearing Station for IW45 M

This station allows to cut special bars with special blades such as round, square, channels and many other special profiles

Bar Shearing Station

In this station standard rectangular notching and with special blade triangular notching can be performed

Notching Station

	IW		IW 36	IW 45	IW 45 - M
PUNCHING	Punching Pressure	ton	36	45	45
	Punch Capacity(Diameter x Thickness)	mm	Ø27x10 Ø16x16	Ø27x13 Ø18x18	Ø27x13 Ø18x18
	Throat Depth	mm	160	160	160
	Stroke lenght	mm	28	21	21
	Cycles /Min. (15 mm stroke)	quat.	24	20	20
	Cycles /Min. (20 mm stroke)	quat.	-	-	-
	Table Size (W x D)	mm	450x220	450x160	450x160
	Largest Hole	mm	-	Ø100x3	Ø100x3
	Single Vee Press Brake (W x T)	mm	-	-	-
	Multi-Vee Press Brake (W x T)	mm	-	-	-
	Pipe Notching	inch	-	-	-
	1) A min-max for NPU	mm	-	-	-
	Maximum S - Maximum ØD (Accor DIN 997)	mm	-	-	-
	2) A min-max for NPU	mm	-	-	-
	Maximum S - Maximum ØD (Accor DIN 997)	mm	-	-	-
FLAT SHEARING	Flat Bar (max. thickness)	mm	200x13	200x13	200x13
	Flat Bar (max. width)	mm	350x6	300x10	300x10
	Blade Length	mm	356	305	305
	Angle Flange Trim	mm	80x80x10	80x80x10	80x80x10
	Round Bar Shear	mm	30	-	-
	Square Bar Shear	mm	25	-	-
ANGLE SHEARING	At 90° Shearing	mm	80x80x10	80x80x8	80x80x8
	At 90° Shearing width slight deformation	mm	-	100x100x10	-
	At 45° Miter Shearing	mm	50x50x6	-	60x60x6
BAR SHEARING	Round Bar Shear	mm	-	30	25
	Square Bar Shear	mm	-	30	22
	Round Bar Shear	mm	35	-	-
	Square Bar Shear	mm	30	-	-
	U - Profil Shear	mm	-	100	100
	T - Profil Shear	mm	-	40	40
	I - Profil Shear	mm	-	100	100
NOTCHING	Material thickness	mm	-	7	7
	Rectangular Notcher (width)	mm	-	40	40
	Rectangular Notcher (depth)	mm	-	50	50
	Vee-Notcher (Side x Side x T)	mm	-	40x40x7	40x40x7
	Triangular notching material tickness	mm	-	4	4
	Triangular notching width V90	mm	-	75	75
	Triangular notching depth	mm	-	75	75
GENERAL INFORMATION	Motorpower	kw	3	3	3
	Oil Capacity	lt	33	33	33
	Weight	kg	630	890	970
	Machine dimensions (L x W x H)	mm	1200x1470x1390	1460x1400x1620	1460x1580x1450
	Working Height	mm	990	1010	1010

IW 55/110	IW 55/110 BTD	IW 80/150	IW 80/150 BTD	IW 110/180 BTD	IW 165/300 BTD
55	55	80	80	110	165
Ø40x10	Ø40x10	Ø40x14	Ø40x14	Ø40x20	Ø40x30
Ø20x20	Ø20x20	Ø24x24	Ø24x24	Ø28x28	Ø34x34
250	510	300	510	610	610
60	60	70	70	80	90
-	-	-	-	-	-
37	37	38	38	28	31
550x250	550x510	550x300	550x510	550x610	750x510
Ø160x2	Ø160x2	Ø160x3	Ø160x3	Ø160x5	Ø160x7
250x10	250x10	300x10	300x10	300x10	415x12
500x5	500x5	600x6	600x6	600x8	835x8
”1/2”” - 2””	”1/2”” - 2””	”1/2”” - 2””	”1/2”” - 2””	”1/2”” - 2””	”1/2”” - 2””
120 - 260	120 - 260	120 - 400	120 - 400	140 - 400	120-400
10 - Ø25	10 - Ø25	14 -Ø28	14 - Ø28	14 - Ø28	14 - Ø28
100 - 240	100 - 240	100 - 320	100 - 320	120 - 320	120 - 320
10 - Ø25	10 - Ø25	14 -Ø28	14 - Ø28	14 - Ø28	14 - Ø28
200x20	200x20	300x20	300x20	400x20	400x30
300x15	300x15	450x15	450x15	600x15	750x20
305	305	475	475	605	765
60x60x8	60x60x8	80x80x10	80x80x10	100x100x12	120x120x12
-	-	-	-	-	-
-	-	-	-	-	-
120x120x10	120x120x10	130x130x13	130x130x13	152x152x13	205x205x18
-	-	-	-	-	-
70x70x7	70x70x7	70x70x7	70x70x7	70x70x7	70x70x7
20-40	20-40	45	45	50	60
20-40	20-40	45	45	50	60
<20	<20	-	-	-	-
<20	<20	-	-	-	-
120	120	140	140	160	200
50	50	60	60	60	80
120	120	140	140	160	200
10	10	12	12	13	16
42	42	52	52	52	58
90	90	90	90	90	110
42x42x10	42x42x10	52x52x12	52x52x12	52x52x13	58x58x16
6	6	6	6	6	10
95	95	125	125	125	125
95	95	125	125	125	125
5,5	5.5	11	11	11	15
76	76	76	76	76	150
1270	1680	2260	2530	3580	8070
1480x1800x1730	1980x1800x1730	2025x1780x2700	2120x2025x1780	2560x2550x1790	3230x1100x2280
1080	1088	1195	1195	1260	1110

IW

STANDARD EQUIPMENTS

PUNCHING

Table for punching station

Durma punch&die holder

1 starting set (Punch & Die)

Punch holder up to 28 mm (IW 45-45M)

Punch holder up to 40 mm (IW 55/110-55/110 BTD- 80/150-80/150

BTD-110/180 BTD)

1m. Electrical back gauge (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

Rectangular notcher complete with down holder

Table for notching station

OPTIONAL EQUIPMENTS

Illmunations (24V-220V)

1 m. Manual Back gauge (additional)

Electrical Back gauge(over 1 m.)

Gress pump

Special Colour

Overseas special packaging

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) witouth

punch&die"

For pipe notching punch and dies (each set)

NC control with table x=1000mm Y=350mm

FLAT SHEARING

Spare blades for flat shearing

ANGLE SHEARING

Spare blades for angle shearing

BAR SHEARING

Spare blades for bar shearing

U,I,T profile blades

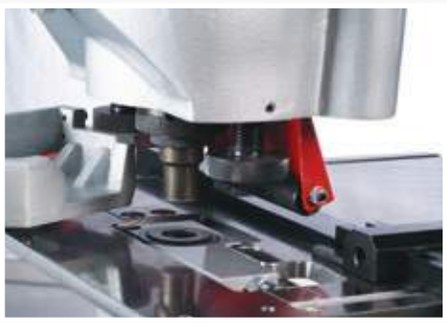
NOTCHING

Triangular notching system with blades

Spare blades for triangular notching

Spare blades for rectangular notching

P SERIES



The punching station comes standard with quick change punch and die holders, as well as a swing away stripper

Punching channel flanges and angles

Punching flat steel

Different dimension Punch & Dies

STANDARD EQUIPMENTS

Table for punching station
Durma punch&die holder
1 starting set (Punch & Die)
Punch holder up to 28 mm (IW 45-45M)
Punch holder up to 40 mm (IW 55/110-55/110 BTD- 80/150-80/150 BTD-110/180 BTD)

OPTIONAL EQUIPMENTS

Illmunations (24V-220V)
Special Colour
Overseas special packaging
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) witouth
punch&die"
For pipe notching punch and dies (each set)
NC control with table x=1000mm Y=350mm

MULTI P

Multi P		Unit	80
Max Lenght of sheet, X Axis		mm	1500
Max Widht 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 Lenght		mm	70
Lenght	A	mm	3755
Table Widht	B	mm	1310
Width	C	mm	2930
Working Height	D	mm	1220
Height	E	mm	2240
Weight		kg	11150

STANDARD EQUIPMENTS

- Triable Punching Unit
- Hydraulic Holddown
- Siemens Control Unit

MULTI P LINE

Automatic Light Pole Punching line with loading and unloading.