

# **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*

# Durma Profile Bending Machines

*Robust machine frame is rugged steel construction, machined after the welding for rigidity.  
Precise bending by large shaft diameters and bearings also minimizes deflection  
Longlife of machine by strong frame and world class components  
Short cycle times by high drive torque and speed  
Minimised straight edge by hydraulic adjustments  
Low energy and maintenance costs by Friction free planetary swing guides  
Powerful guide rolls*

## PBM Series

*Motorised Profile Bending Machines*



## PBH Series

*Hydraulic Profile Bending Machines*





### PBM 30 - 50

#### *Standard Equipment*

CE  
1 set standard hardened and ground rolls  
Mechanic side supports  
Horizontal & Vertical working feature  
Foot pedal with Emergency button  
Bottom rolls driven by motor & gearbox  
Cast iron body

#### *Optionals*

Special support for angle irons  
Bar twist device  
Digital readout  
Mono phase motor  
Special rolls ( Pipe,profile, angle iron )
















### PBH 45

#### *Standard Equipment*

CE  
1 set standard hardened and ground rolls made by special steel  
Mechanic side supports  
Horizontal & Vertical working feature  
Movable command panel separate from the machine  
All rolls driven by motor & gearbox  
Top roll hydraulic movement up and down  
Top roll with digital readout  
Brake motor  
Cast iron body

#### *Optionals*

Special support for angle irons  
Special rolls ( Pipe,profile, angle iron )  
NC control

Profile Type		PBM 30		PBM 50		PBH 45		Notes
		Dimensions	Min. Internal Dia.	Dimensions	Min. Internal Dia.	Dimensions	Min. Internal Dia.	
1		30x30 10x10	650 200	35x35 20x20	1200 400	35x35 15x15	600 300	○
2		50x10 20x6	700 300	60x10 30x10	800 350	60x10 20x10	600 300	○
3		80x15 30x6	700 500	100x15 50x10	750 500	80x15 50x20	600 450	○
4		50x6 20x3	600 400	60x7 30x4	900 500	50x6 20x3	650 300	○●
5		50x6 20x3	600 400	60x7 30x4	900 500	50x6 20x3	650 300	○●
6		50x6 20x3	700 400	60x7 30x4	1000 500	50x6 20x3	800 300	○●
7		40x5 30x4	500 350	50x5 40x4	850 500	50x6 30x3	600 400	○▲
8		40x5 30x4	600 400	50x5 40x4	1200 800	50x6 30x3	900 600	○▲
9		40x40x3	*	60x60x3	*	45x45x3	*	○●
10		50x30x3	*	50x40x3	*	60x30x3	*	○●
11		Ø30 Ø10	650 200	Ø35 Ø15	800 300	Ø35 Ø20	600 300	●
12		Ø1 1/2"x3.2 Ø1/4"x2	800 300	Ø1 1/2"x3.2 Ø3/8"x2	650 350	Ø2"x2.9 Ø1/2"x2	1000 350	●
13		Ø60x1.5 Ø20x1.5	1000 550	Ø70x2 Ø30x2	1200 500	Ø60x2 Ø30x2	1000 450	●
14		UPN 50	450	UPN 60	600	UPN 80 UPN 30	800 400	●
15		UPN 50	550	UPN 60	750	UPN 80 UPN 30	1200 600	●
Shaft Diameters	mm	Ø30		Ø50		Ø45		
Roll Diameters	mm	Ø150		Ø165		Ø162		
Motor Power	KW	0.75		1.5		1.5+0.75		
Bending speed	m/min.	3.6		3.6		3.9		
LxWxH	mm	800x700x1200		930x730x1400		1000x700x1380		
Weight	kg	200		385		600		

- Standard Rolls
- Special Rolls
- ▲ Special Apparatus

\* Can be changed according to deformation.

-All datas given according to 240 N/mm yield point



## PBH 60

### Standard Equipment

CE  
 Digital readout ( X,Y axis)  
 Rolls are planetary gear box and motor driven  
 1 set standard hardened and ground rolls made by special steel  
 3 axis hardened side supports  
 Side supports are suitable for angle iron bending  
 3 axis side supports Front-Back ;Up-Down;;Left-Right manual adjustable (Z,U,C axis)  
 Movable command panel separate from the machine  
 Horizontal working feature  
 Stress relieved steel construction body  
 Electrical and hydraulic protection against overloads

### Optionals

Hydraulic Z axis  
 Full hydraulic 3 axis side supports ( Z,U,C axis)  
 Digital readout ( Z,U,C) Axis  
 NC control system  
 CNC control system  
 Variable turning speed  
 Tie Bar For Rolls  
 Special rolls ( Pipe,profile, angle iron )



## PBH 80 - 100

### Standard Equipment

CE  
 Hydraulic Z axis  
 Digital readout ( X,Y axis)  
 All rolls driven by planetary gear box and hydramotor  
 1 set standard hardened and ground rolls made by special steel  
 3 axis side supports Z Front-Back;Hydraulic ;U :Up-Down&C : Left-Right manual  
 Side supports are suitable for angle iron bending  
 Movable command panel separate from the machine  
 Horizontal working feature  
 Stress relieved steel construction body  
 Electrical and hydraulic protection against overloads

### Optionals

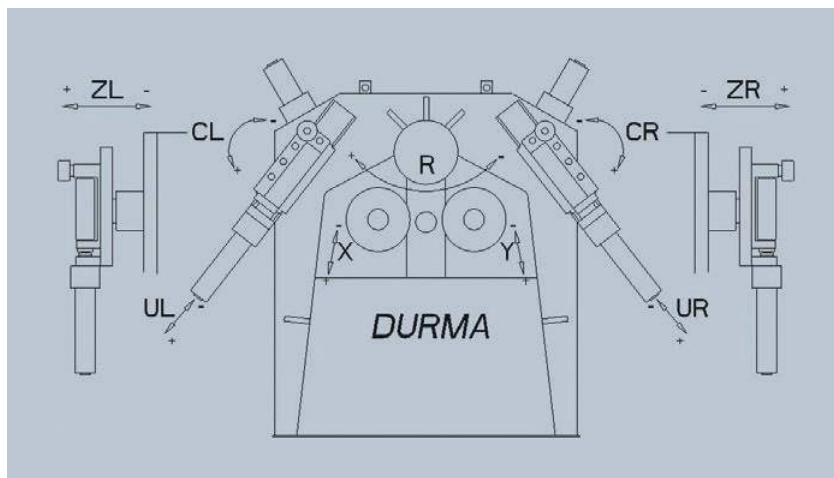
Full hydraulic 3 axis side supports ( standard Z +U,C axis)  
 Digital readout ( Z,U,C) Axis  
 NC control system  
 CNC control system  
 Variable turning speed  
 Tie Bar For Rolls  
 Special rolls ( Pipe,profile, angle iron )

Profile Type		PBH 60		PBH 80		PBH 100		PBH 125		Notes
		Dimensions	Min. Internal Dia.	Dimensions	Min. Internal Dia.	Dimensions	Min. Internal Dia.	Dimensions	Min. Internal Dia.	
1		40x40 20x20	500 300	50x50 30x30	500 350	60x60 30x30	700 400	75x75 35x35	750 500	○
2		70x10 30x10	600 250	80x20 30x10	500 350	100x25 40x10	1500 400	120x25 50x10	1300 500	○
3		90x25 50x5	500 250	120x30 50x10	650 300	180x35 60x10	900 400	200x40 100x10	1200 500	○
4		60x7 20x3	600 250	80x9 30x4	1000 300	120x13 30x4	1200 400	130x14 30x4	1300 500	○
5		60x7 20x3	600 250	80x9 30x4	1000 300	100x11 30x4	1000 400	120x13 30x4	1200 500	○
6		60x7 20x3	800 250	80x9 30x4	1300 300	100x11 30x4	1300 400	100x12 30x4	1200 500	○
7		50x5 30x3	500 250	80x8 30x3	800 450	100x12 40x4	1400 700	120x12 50x5	1300 700	○●
8		50x5 30x4	1000 350	80x8 30x3	1200 450	100x10 40x4	1600 700	100x10 50x5	1200 700	○
9		60x60x4	*	70x70x4	*	80x80x5	*	100x100x6	*	○●
10		80x40x3	*	80x40x4	*	100x50x6	*	140x40x3	*	○●
11		Ø40 Ø20	500 300	Ø50 Ø20	500 350	Ø70 Ø30	800 400	Ø85 Ø40	850 500	○●
12		Ø2"x3,9 Ø1/2"x2,7	600 250	Ø3"x4 Ø3/4"x2,6	1000 300	Ø4"x4,5 Ø1"x3,2	1600 450	Ø5"x5 Ø11/4"x3,2	1500 500	●
13		Ø60x2 Ø20x1	600 250	Ø100x2,5 Ø20x1	1300 300	Ø120x2,5 Ø30x2	1400 400	Ø140x3 Ø40x2	1500 500	●
14		UPN 80 UPN 30	550 250	UPN 120 UPN 30	850 300	UPN 160 UPN 30	800 400	UPN 220 UPN 40	1000 500	○●
15		UPN 80 UPN 30	800 250	UPN 120 UPN 30	1000 450	UPN 160 UPN 30	1000 400	UPN 220 UPN 40	1200 500	○●
16								UPN 100 UPN 50	8000 2000	●▲
17		IPN 80	600	IPN 120	600	IPN 180 IPN 80	1000 500	IPN 200 IPN 80	1000 500	○●
18								IPN 120 IPN 60	2500 1000	●▲
19						HEA 120 HEB 100	1000 1200	HEA 140 HEB 120	1200 1300	○●
20								HEA 120 HEB 100	4000 3000	●▲
Shaft Diameters		mm	Ø60		Ø85		Ø110-100		Ø140-120	
Roll Diameters		mm	Ø177		Ø247		Ø315		Ø380	
Motor Power		KW	2.2+1.5		7.5		11		15	
Bending speed		m/min.	5		6,5		7,5		7,5	
LxWxH		mm	1160x1000x1175		1580x1200x1410		1750x1340x1650		1850x1550x1685	
Weight		kg	950		2350		3360		4600	

- Standard Rolls
- Special Rolls
- ▲ Special Apparatus

- All datas given according to 240 N/mm yield point

\* Can be changed according to deformation.





## **PBH 125 - 360**

### **Standard Equipment**

CE

Digital readout ( X,Y axis)

All rolls driven by planetary gear box and hydramotor ( PBH 125 )

All rolls 3 different planetary gear box and hydramotor driven ( PBH 180 to 360)

Full hydraulic 3 axis ( Z,U,C) side supports

Movable command panel seperate from the machine

Horizontal working feature ( PBH 125 can also be operated in vertical position)

Stress relieved stell construction body

Electrical and hydraulic protection against overloads

1 set standard hardened and ground rolls made by special steel

### **Optionals**

Digital readout ( Z,U,C) Axis





















NC control system

CNC control system

Adjustable turning speed

Special aparatus to prevent deformation on U-I-H bending

Special rolls ( Pipe,profile, angle iron )

Profile Type		PBH 180		PBH 240		PBH 300		PBH 360		Notes Notlar
		Dimensions	Min. Internal Dia.	Dimensions	Min. Internal Dia.	Dimensions	Min. Internal Dia.	Dimensions	Min. Internal Dia.	
1		90x90	1300	110x110	1500	150x150	2200	240x240	2500	○
2		150x30	1000	175x40	1200	250x60	2000	400x60	2800	○
3		250x40	1000	350x50	900	450x70	1000	650x100	1800	○
4		150x15	1400	160x20	1500	200x28	2000	200x28	1600	○●
5		150x15	1300	160x20	1500	200x28	2000	200x28	1500	○●
6		130x15	1800	150x20	2000	200x20	2800	200x28	2300	○●
7		150x15	1200	160x20	1600	200x28	2300	200x28	1800	○●
8		130x15	1400	150x20	1600	200x20	2300	200x28	2000	○●
9		120x120x8	*	150x150x8	*	200x200x10	*	400x400x15	*	○●
10		180x70x8	*	200x75x8	*	200x150x10	*	500x300x10	*	○●
11		Ø100	1000	Ø130	1600	Ø170	1800	Ø260	2000	○●
12		Ø170x6	2800	Ø220x8	2800	Ø300x10	4000	Ø500x15	16500	○●
13		UPN 300	1400	UPN 360	1400	UPN 500	2250	UPN 1000	4000	○●
14		UPN 300	1700	UPN 360	1600	UPN 500	2600	UPN 1000	4000	○●
15		UPN 160	10000	UPN 200	12000	UPN 260	10000	UNP 400	40000	●▲
16		IPN 300	1400	IPN 360	1500	IPN 500	2000	IPN 1000	5000	○●
17		IPN 160	4000	IPN 200	5000	IPN 300	13000	IPN 550	2000	●▲
18		HEA 180 HEB 120	1200 1200	HEA 240 HEB 200	1500 1500	HEA 320 HEB 280	2500 2000	HEA 1000 HEB 1000	6000 8000	○●
19		HEA 120	4000	HEA 180	4500	HEA 220	10000	HEA 550	40000	●▲
20		HEB 120	3000	HEB 160	3200	HEB 200	6000	HEB 500	30000	●▲
Shaft Diameters		mm	Ø180-160		Ø220-240		Ø280-300		Ø360 - 340	
Roll Diameters		mm	Ø460		Ø550		Ø740		Ø800	
Motor Power		kW	18,5		37		70		77	
Bending speed		m/min.	6		6		5		5	
LxWxH		mm	2500x2000x1900		2900x2300x2150		3850x3100x2800		4600x3750x3350	
Weight		kg	8600		16000		24000		45000	

- Standard Rolls
- Special Rolls
- ▲ Special Apparatus

\* Can be changed according to deformation.

- All datas given according to 240 N/mm yield point



PBH 300

