The Winning Force

**IW** SERIES
Iron Worker

**VN** SERIES
Coner Notcher

**DLC** SERIES
L Angle Processing Center

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

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 plate, 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 press brake attachment can be performed.

String Away Stripper

Press Brake Attachment

Punching Flat Steel

Different Dimension Punch & Dies

Punching 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.

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.

IW 45

“It is meant to be everlasting”

Small Footprint
Efficient Production
Rigid Body Structure

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 36845 to
Blades for flat steel station
Blades for angle cutting station
Blades for round and square bar cutting station

Optional Equipment

Illuminations (24V-220V)
1 m. Manual backgauge (additional)
Electrical backgauge (over 1 m.)
Gress pump
Special colour
Overseas special packaging

PUNCHING
Pedninghaus, 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

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

<table>
<thead>
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<td>550x160</td>
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<td>120-280</td>
<td>10-025</td>
<td>100-240</td>
<td>200x20</td>
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</tbody>
</table>

### Punching

- **Punching Pressure**: The maximum force applied during punching operations.
- **Throat Depth**: The depth of the punch area where the material is sheared off.
- **Stroke Length**: The length of the stroke for each punching or shearing cycle.
- **Cycle Time (mm. Stroke)**: The time taken for each cycle with a stroke length of 1mm.
- **Cycle Time (2mm. Stroke)**: The time taken for each cycle with a stroke length of 2mm.
- **Single Vee Press Brake (W×T)**: The size of the press brake used for single vee notching.
- **Pipe Notching**: The maximum size of the pipe that can be notched.
- **Maximum S-Maximum Ø (Accor DIN 997)**: The maximum size of the material that can be sheared.

### Flat Shearing

- **Angle Flat Shearing**
- **Angle Frame Trim**

### Bar Shearing

- **Round Bar Shear**
- **Square Bar Shear**
- **U Profile Shear**
- **T Profile Shear**
- **I Profile Shear**

### Notching

- **Material Thickness**
- **Rectangular Notcher (Width)**
- **Rectangular Notcher (Depth)**
- **Triangular Notcher (Width** V90
- **Triangular Notcher (Depth)**

### General Information

- **Motor Power**: The power rating of the motor that drives the machine.
- **Oil Capacity**: The capacity of the oil reservoir for coolant or lubrication.
- **Weight**: The weight of the machine.
- **Machine Dimension (LxWxH)**: The dimensions of the machine.
- **Working Height**: The height at which the machine can work effectively.

### Additional Information

- **Machine Color**: The color of the machine.
- **Machine Size**: The size of the machine.
- **Machine Type**: The type of machine (e.g., hydraulic, mechanical).

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**Note**: The table and diagram provide a comprehensive overview of the technical specifications and dimensions for the Iron Worker Series. The values listed are for reference and may vary depending on the specific model and configuration.
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 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

<table>
<thead>
<tr>
<th>PUNCHING</th>
<th>P65</th>
<th>P80</th>
<th>P110</th>
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<td>Punching Rate</td>
<td>50</td>
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<td>50</td>
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<tr>
<td>Punching Capacity (Diameter x Thickness)</td>
<td>Ø20x10</td>
<td>Ø28x10</td>
<td>Ø40x20</td>
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<tr>
<td>Throat Depth</td>
<td>510</td>
<td>510</td>
<td>510</td>
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<td>Stroke Length</td>
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<td>Punch Rate (PPM at Stroke)</td>
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<td>Table Size (mm x mm)</td>
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<td>500x500</td>
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<tr>
<td>Working Height up to Die</td>
<td>1150</td>
<td>1150</td>
<td>1275</td>
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</table>

OPTICAL EQUIPMENTS

- Illuminations
  - 24V
  - 220V

PIVING

Punching Pressure

Motorpower

Oil Capacity

Gross Weight (Apr.)

Technological Data

Motor Power

Electrical Capacity

Net Weight (Apr.)

Gross Weight (Apr.)

Machine dimensions (Apr.) (L x W x H)

Packaging Dimensions (Apr.) (L x W x H)

NC Series

Technical Specification

<table>
<thead>
<tr>
<th>Feature</th>
<th>P55</th>
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<td>X-Axis Working Dimension (Stroke)</td>
<td>17700 x 330</td>
<td>17700 x 330</td>
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<tr>
<td>Y-Axis Working Dimension (Stroke)</td>
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<td>1000</td>
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<tr>
<td>Movement Speed / Y Axis</td>
<td>m/min</td>
<td>m/min</td>
<td>m/min</td>
</tr>
<tr>
<td>Movement Accuracy</td>
<td>±0.1 mm</td>
<td>±0.1 mm</td>
<td>±0.1 mm</td>
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<tr>
<td>Controller</td>
<td>7 inch Eaton</td>
<td>7 inch Eaton</td>
<td>7 inch Eaton</td>
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</table>
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 hold-down and Siemens control unit.

- Faster Production
- Increased Productivity
- User Friendly Control Unit

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<th>Unit</th>
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<tr>
<td>Max. Length of Sheet, X axis</td>
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<tr>
<td>Max. Width of Sheet, Y axis</td>
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<td>750</td>
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<tr>
<td>Thickness Of Metal Plate</td>
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<td>Positioning Tolerance</td>
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<tr>
<td>Punching Tonnage</td>
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<tr>
<td>Max. Traverse Speed Of X axis</td>
<td>m/min</td>
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<tr>
<td>Max. Traverse Speed Of Y axis</td>
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<td>Height</td>
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<tr>
<td>Weight</td>
<td>kg</td>
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</tbody>
</table>

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 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.

DLC 160 Series

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. Convenient foot switch enables operator to use both hands for work efficiency.

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

### Specifications

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<thead>
<tr>
<th></th>
<th>Unit</th>
<th>Value</th>
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<td>VN</td>
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<tr>
<td>Cutting Capacity</td>
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<tr>
<td>Cutting Length</td>
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<td>Cutting Angle</td>
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<tr>
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<tr>
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<td>Width</td>
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<td>Sound Strength (Loaded)</td>
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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.