The Winning Force

DURMA

AD-S SERIES
PRESS BRAKES



- Perfect Precision
- Deep And Fast Bending
- Efficient
- Winning
- Elegant Design

durmazlar

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^2, 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.

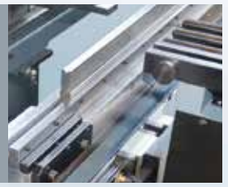
Present Durmazlar machines with **DURMA** name to the world.



1
High technology, modern production lines



2
Top quality components



3
High quality machines designed in R&D Centre

durmazlar

The Winning Force

Feel The Force and Performance

Our Machines are shaped with our superior experience and state of art technology, special designed as well as excellent combined component its the fastest , most reliable and prices press brakes on its category.

With its rigid body structure, robust back gauge and high standard components it ensures long lasting and precision applications.

Therefore with *DURMA* press brakes you can always achieve perfect result.

Fast, Precise and Perfect Bending

- Precise bending result at fast speed
- Minimalized tool change and adjustment time
- Maximized speed and safety





AD-S Series Press Brake



Perfect and Fast Bending

Perfect components for precision

With Easy to use control unit, stabile body structure, perfect design, low operating cost, different tool usage options, maximum safety standards, DURMA press brake is the best in the world in its segment.

High Capacity | **Robust Body** | **Perfect Precision** | **Winning** | **Ergonomic**

Why *DURMA* Press Brakes

- Better and faster bending
- Stronger and rigid body structure
- High sensitivity and repeatability
- High tegnology excellent equipment
- Low service cost
- Reliability

Fast, Efficient, Modern

AD-S Series press brakes, designed with high technology to increase efficiency on precise part bending.

Quality approved components.
Stress relieved for long life and precise bending.



General Specifications

- High sensitivity, Stress relieved steel construction body, long life Mono Block Frame
- Automatic calibration and first start up
- *DURMA* designed and copyrighted guiding system
- Ball Screw and linear guide integrated perfect back gauge system
- Durable, long life and sensitive bending capable special hardened top tools
- Suitable for segmented tools special and fast tool holding system
- Sensitive solutions on Long and deep bending
- High accuracy linear scales
- CE safety standards
- Best quality world wide accepted hydraulic and electric components

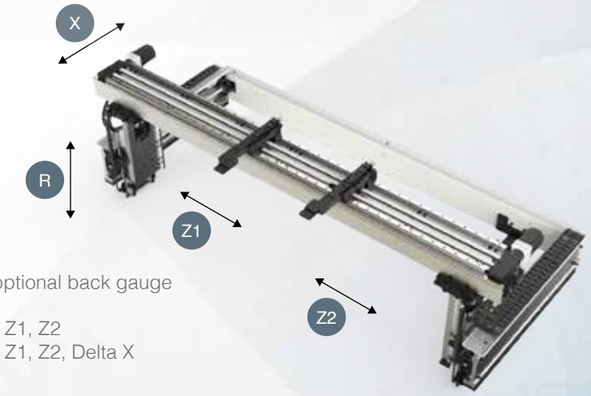
Strong Back Gauge Systems

- Precise
- Reliable
- Strong

- Fast and high accuracy
- Safe movement
- Resistance to crash
- Maintenance free
- Adjustment availability at every point



CNC back gauge
X - R
Z manuel



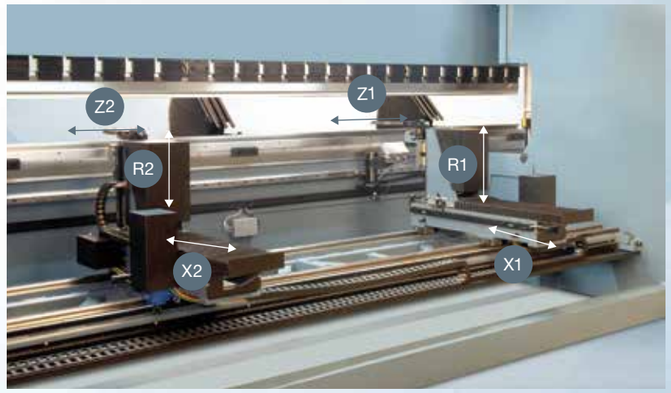
CNC optional back gauge
X - R
X - R - Z1, Z2
X - R - Z1, Z2, Delta X

Why *DURMA* Back Gauge ?

The most important feature to achieve perfect bending is the stability and the design of the back gauge, which allows an impeccable and correct product to be produced.

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.

Special designed finger blocks with steps to achieve maximum stability can also be supplied for every kind of bending solution.



CNC optional back gauge
X1 - X2, R1 - R2, Z1 - Z2

Tool Holders and Tools

Bending performance is increased by using high quality European clamping system and easiness to use. Narrow table designed for European style tool holder and Z bending.

DURMA is your solution partner with various tool options.



European Clamping System



European Type Bottom Tool (4V Die)



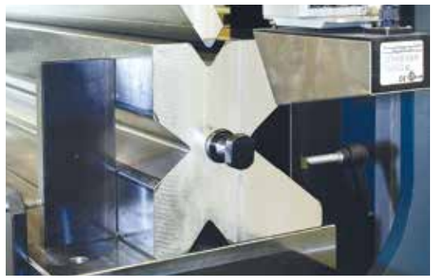
Quick Release Clamping



Wila Bottom Tool Clamping



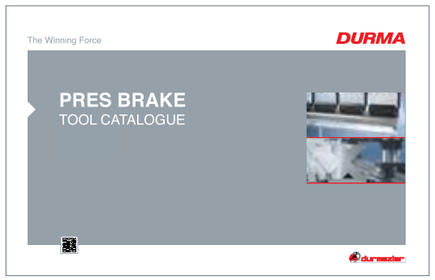
Wila Top Tool Clamping



DURMA Bottom Tool Multi V



DURMA Top Tool



Safe and Accurate Bends with Top Quality Equipments

Crowning System

Manual or CNC-controlled motorized crowning system simplifies bending by adjusting each point of the bending parts to acquire straight bends. The need for shimming is eliminated.



Linear Guide Front Sheet Supports

Rugged support arms with tilting stops are mounted on a linear guide rail system. This allows “finger-tip” lateral
adjustment as required by the bend length of the part. They are also equipped with side gauges for the fast, easy, and accurate feeding of parts small or large.



Linear Guide Front Sheet Supports

CE Safety Systems

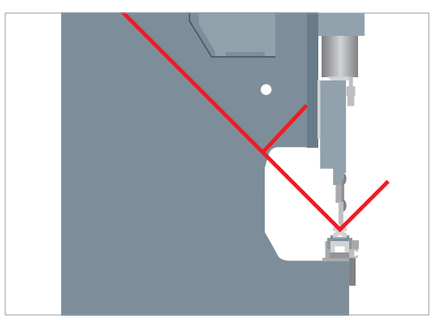
Our machines are designed in accordance with Ce-Norms to ensure your safety with hydraulic, electric, appropriate height covers and laser light curtains. CE safety in tandem machines are also provided with light barriers.



Ce Laser Safety System

Stable Top Beam Movement

By using long and planar guiding surfaces, all the disadvantages of point guiding are eliminated 100%. Free bending space: guiding system that eliminates bending between frame has been moved to the out-side of the frame.



90 Degree Endless Bend

Now Bending is More Easier

ModEva 19T



19" colours Touch Screen
On-screen finger profile drawing
Automatic bend listing
Very simple and convenient data transfer
Higher productivity thanks to easy and rapid
Multi-simulation capability
Simulation criteria for better sheet management
Windows XPe for multitasking and file management
EC safety-cycle management
Ethernet for easy communication

Modeva RA Premium

Full 3D simulation
Multiple view points while working
3D collision detection
Rapid solution computation
Importing 3D models (MetaBEND, IGES)
Automatic Tool Shape Selection
Video-like bend simulation.
Almost unlimited quantity of programs and se-
quences

DA-66T



2D graphical touch screen programming mode
3D visualisation in simulation and production
17" high resolution colour TFT
Full Windows application suite
Delem modusys compatibility
USB, peripheral interfacing
User specific application support within the controllers
multitasking environment
Sensor bending & correction interface
Profile - TL - software

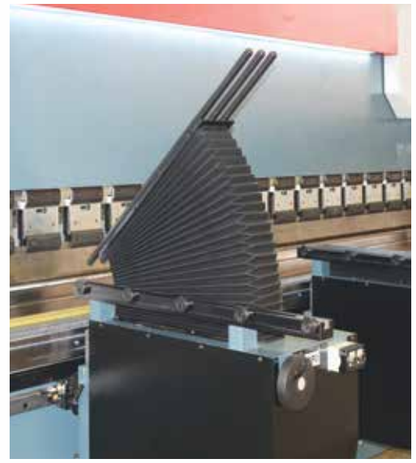
DA-69T

Higher grade of efficiency
3D and 2D graphical touch screen programming mode
17" high resolution colour TFT
Delem modusys compatability
Sensor bending correction interface
1 GB memory capacity
Integrated OEM-Panel
1280x1024 pixels, 16-bit colour
3D graphics acceleration
Profile - T - 3D software

System of DURMA Angle Measurement



Automotic AP3 - AP4 Sheet Follower



Robotic System of Applications



Standard & Optional Equipment

Standard Equipment

Y1, Y2, X, R - 4- Axis
Control Unit - CNC ModEva19T
CE Manuel F. AKAS II M FPSC-B-C + Safety Cages with switch
CE F.AKAS BVLT Light barrier and safety cages (For Tandem Press Brakes)
Servo motor back gauge & linear guided & ballscrew system (X-R)
CNC controlled motorized Crowning
European style tool clamping system
Sliding front arms (With T-Slot and stopper)
World standards special design hydraulic block and valves
World standard electric equipment

Optional Equipment

Control Unit - ModEva Premium, 69T ve 66T
CE with FIESSLER AKAS-LC II AKAS - 3M Motorized + FPSC (SAFETY PLC)
Motorized FIESSLER AKAS-3PM (distance of mute until 3)
Z1, Z2 Axis
X1, X2 Axis
R1, R2 Axises
Delta X Axis ± 125 stroke
X Axis = 1000 mm – light barrier back protection
AP3-AP4 Automatic system of sheet follower – Motorized elevation adjustment
(There is a motorized elevation adjusment of 220 tons or more.)
System of laser angle measurement
Quick release clamping system
Hydraulic and pneumatic tool clamping systems
Bottom and top tools
Bottom tool separation system
Parking area
Central lubrication system
Oil cooler
Additional back gauge finger and sliding front support arms
Special packing for overseas shipments
DBEND 3D bending simulation program

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

DURMA
Solution Center

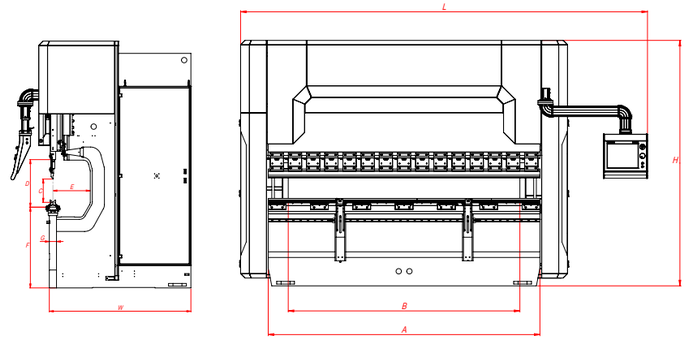

Service Agreements


Software


Training


Flexible Solution

AD-S Series Technical Details



AD-S Series	Bending Force	Bending Length	Distance Between Columns	Stroke	Daylight	Throat Depth	Throat Depth	Table Width	Working Speed	
									Y Rapid Speed	Y Working Speed
	Ton	mm	mm	mm	mm	mm	mm	mm	mm/sn.	mm/sn.
		A	B	C	D	E	F	G		
AD-S 1260	60	1250	1050	265	530	450	900	104	200	10
AD-S 2060	60	2050	1700	265	530	450	900	104	200	10
AD-S 25100	100	2550	2200	265	530	450	900	104	180	10
AD-S 30100	100	3050	2600	265	530	450	900	104/180	180	10
AD-S 30135	135	3050	2600	265	530	450	900	104/180	160	10
AD-S 30175	175	3050	2600	265	530	450	900	104/240	160	10
AD-S 30220	220	3050	2600	265	530	450	900	104/240	140	10
AD-S 30320	320	3050	2600	365	630	450	900	154/300	160	10
AD-S 37175	175	3700	3100	265	530	450	900	104/240	140	10
AD-S 37220	220	3700	3100	265	530	450	900	104/240	160	10
AD-S 40175	175	4050	3600	265	530	450	900	104/240	160	10
AD-S 40220	220	4050	3600	265	530	450	900	104/240	160	10
AD-S 40320	320	4050	3600	365	630	450	900	154/300	160	10
AD-S 40400	400	4050	3400	365	630	510	1050	154/300	140	8
AD-S 40600	600	4050	3100	365	700	510	990	154/300	80	7
AD-S 60220	220	6050	5100	265	530	450	1050	154/300	140	10
AD-S 60320	320	6050	5100	365	630	450	1100	154/300	140	10
AD-S 60400	400	6050	5100	365	630	510	1220	154/300	120	8
AD-S 60600	600	6050	5100	365	700	510	990	154/300	80	7
AD-S 60800	800	6050	5100	400	700	610	800	400	70	6
AD-S 70800	800	7050	5100	400	700	610	800	400	80	7
AD-S 701000	1000	7050	5100	500	800	610	800	400	70	5
AD-S 701250	1250	7050	5100	500	800	610	900	400	70	7
AD-S 80800	800	8050	6400	400	700	610	800	400	80	7
AD-S 801000	1000	8050	6400	500	800	610	800	400	70	5
AD-S 801250	1250	8050	6400	500	800	610	900	500	70	7
AD-S 801600	1600	8100	6400	500	1000	610	900	500	70	6
AD-S 802000	2000	8100	6400	600	1000	750	950	500	70	6

Y Return Speed	Y Axes Precision	X Axes Working Speed	X Axes Precision	X Axes Dimensions			R Axes Working Speed	R Axes Working Distance	R Axes Precision	Z Axes Working Speed	Z Axes Working Distance	Motor Power	Oil Tank Capacity	Length	Width	Height	Weight Approx.
				650	750	1000											
mm/sn.		mm/sn.		mm	mm	mm	mm/s	mm		mm/s	mm	kw	lt	mm	mm	mm	kg
110	0,01	500	0,05	S	-	O	350	250	0,1	1000	490	7,5	100	2300	1550	2850	4700
110	0,01	500	0,05	S	-	O	350	250	0,1	1000	1100	7,5	100	3200	1550	2850	5600
120	0,01	500	0,05	S	-	O	350	250	0,1	1000	1580	11	100	3800	1670	2850	7800
120	0,01	500	0,05	S	-	O	350	250	0,1	1000	1990	11	100	4200	1670	2850	8500
120	0,01	500	0,05	S	-	O	350	250	0,1	1000	1990	15	150	4200	1680	2850	9580
100	0,01	500	0,05	S	-	O	350	250	0,1	1000	1990	18,5	250	4250	1700	2850	10900
140	0,01	500	0,05	S	-	O	350	250	0,1	1000	1990	22	250	4250	1770	3000	12600
140	0,01	500	0,05	S	-	O	350	250	0,1	1000	1990	37	250	4300	1820	3330	17100
100	0,01	500	0,05	S	-	O	350	250	0,1	1000	2375	18,5	250	4950	1700	3000	11750
120	0,01	500	0,05	S	-	O	350	250	0,1	1000	2375	22	250	4950	1770	3000	14440
140	0,01	500	0,05	S	-	O	350	250	0,1	1000	2910	18,5	250	5250	1700	2850	12780
140	0,01	500	0,05	S	-	O	350	250	0,1	1000	2910	22	250	5250	1770	3000	14750
140	0,01	500	0,05	S	-	O	350	250	0,1	1000	2910	37	250	5300	1910	3330	20000
120	0,01	350	0,05	-	S	O	300	250	0,1	1000	2670	37	500	5750	2110	3640	27760
80	0,01	350	0,05	-	S	O	300	250	0,1	1000		45	500	5650	2250	3935	40500
120	0,01	350	0,05	-	S	O	300	250	0,1	1000	4400	22	250	7500	1770	3350	20800
120	0,01	350	0,05	-	S	O	300	250	0,1	1000	4400	37	250	7500	1910	3550	29000
100	0,01	350	0,05	-	S	O	300	250	0,1	1000	4400	37	500	7500	2110	3810	34600
80	0,01	350	0,05	-	S	O	300	250	0,1	1000	4400	45	500	7600	2650	3950	44000
80	0,01	300	0,05	-	S	O	250	250	0,1	1000	4400	55	750	8050	3200	4250	72000
70	0,01	300	0,05	-	S	O	250	250	0,1	1000	4400	55	750	8700	3200	4250	79500
60	0,01	300	0,05	-	S	O	250	250	0,1	1000	4400	55	1000	8800	3250	5900	95500
70	0,01	300	0,05	-	S	O	250	250	0,1	1000	4400	90	1250	8800	3250	6400	110000
70	0,01	300	0,05	-	S	O	250	250	0,1	1000		55	750	9800	3200	4250	85000
60	0,01	300	0,05	-	S	O	250	250	0,1	1000		55	750	10000	3250	5900	102000
70	0,01	300	0,05	-	S	O	250	250	0,1	1000		90	1250	10000	3250	6400	135000
70	0,01	300	0,05	-	-	O	250	250	0,1	1000		90	1250	10100	3500	6000	163000
60	0,01	300	0,05	-	-	S	250	250	0,1	1000		110	2000	10500	4350	7000	249000

S: Standart

O: Opsiyon

Machines set according to optimum values.

Special projects




AD-S 641000
DURMA










DURMA
AD-S 1202000



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

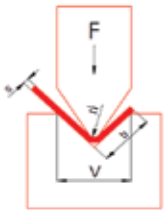


CORNER NOTCHER

DURMA

Today, Tomorrow, Forever...

V	b	r_i	s(mm)																					
			0.5	0.8	1	1.2	1.5	1.8	2	2.5	3	3.5	4	4.5	5	6	7	8	9	10	12	15	18	20
6	5	1	2,5	6,5	10																			
8	6	1,3	2	5	8	11																		
10	7	1,7	1,5	4	6	9	13																	
12	9	2		3	5	7	11	16																
15	12	2,7			4	6	9	13	16															
20	15	3,3				4	7	10	12	19														
26	18	4,2					4	7,5	9	14	21													
30	22	5						6,5	8	12	19	24												
32	23	5,4							7,5	11,6	17	23	30											
37	25	5,8								10	14,5	20	26	33										
42	29	6,7									13	17	23	29	33,5									
45	32	7,5										16	21	27	33	48								
50	36	8,3											19	24	30	43	58							
60	43	10												20	25	36	49	64						
70	50	11,5													21	31	42	55	69					
80	57	13,5														27	37	48	60	75				
90	64	15															32	42	54	66	95			
100	71	17																38	48	60	86	134		
130	93	22																	37	46	66	103	149	
180	130	30																		33	48	75	107	153
200	145	33																			43	67	83	119
250	180	42																				54	77	92



$$F = \frac{1{,}42 \times L \times Rm \times s^2}{1000 \times V} (Ton)$$

F: Bending Force (Ton) L: Length (mm) Ri: Inside Radius (mm) Rm: Material Tensile Strength (daN/mm²) V: Channel Width (mm) B: Minimum Sheet Bending Side (mm) S: Thickness (mm)

AD-S SERIES
PRESS BRAKES

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

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