

IW

Iron Worker

VN

Coner Worker

Series



Reliable

Efficient

Ergonomic

High Capacity

Low Investment Cost



As a total supplier for sheet metal manufacturing with almost 70 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 1.615,000 ft², we dedicate 1,000 employees to delivering high quality manufacturing solutions at the best performance-to-price ratio in the market.



PRODUCTION IS
MORE EFFECTIVE NOW

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.

Durmazlar offers it's machines to the world markets under the Durma brand.



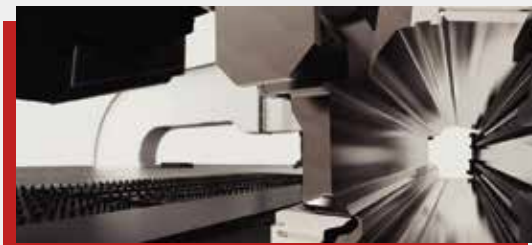
1

High technology,
modern production
lines



2

Top quality
components



3

High quality
machines designed
in R&D Centre

IW-VN

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!



Production is *More Effective Now.*

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.



■ **String Away Stripper**

■ **Press Brake Attachment**

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

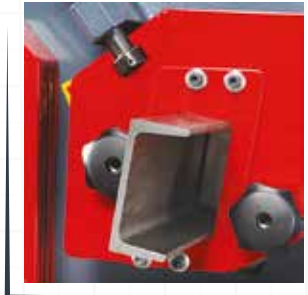
Bar shearing station consists of square bar shearing, round bar shearing, touch and cut electrical back gauge. Also optional U Blade and optional I&T blades are available upon request.



■ Square Bar Shearing



■ Round Bar Shearing



■ Optional U Blade



■ Optional I&T Blades

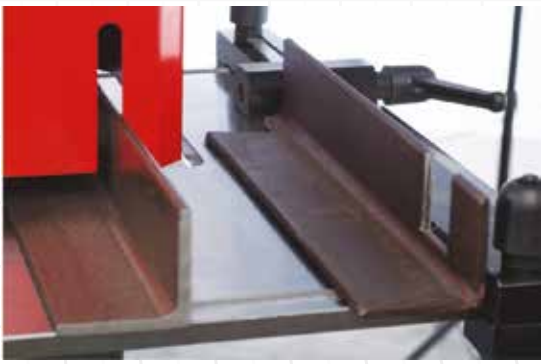


■ Touch and Cut Electrical Back Gauge

Production is *More Effective Now.*

■ Notching Stations

This station comes standard with rectangular notching blades which allow side notching, therefore allowing notching 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.



■ Rectengual Notcher



■ Triangular Notcher Option

IW-VN

IW 45 "It is meant to be everlasting"

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.

- **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 1/2⁴ and 2⁴ 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

STANDARD & OPTIONAL EQUIPMENT

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

Iron Worker Series Technical Details

Model		IW 45	IW 55/110 BTD	IW 80/150 BTD	IW 110/180 BTD	
PUNCHING						
Punching Pressure		ustons	60	60	88	121
	Punch Capacity (Diameter x Thickness)	inch	Ø1,06 x 50	Ø1,57 x 0,39	Ø1,57 x 0,55	Ø1,57 x 0,79
			Ø0,71 x 0,71	Ø0,79x0,79	Ø0,94 x 0,94	Ø1,1 x 1,1
	Throat Depth	inch	0,71 x 0,71	9,8	20	24
	Stroke length (Stroke)	inch	0,83	2,36	2,75	3,15
	Cycles /Min. (20 mm stroke)	quat.	20	37	38	28
	Table Size (W x D)	inch	17,72 x 6,30	21,65 x 20,07	21,65 x 20,07	21,65 x 24
	Working Height up to Die	ft	3' 3,7"	3' 6,8"	3' 11"	4' 1,6"
OPTIONAL EQUIPMENTS						
Largest Hole		inch	Ø3,93	Ø6,3	Ø6,3	Ø6,3
	Single Vee Press Brake (W x T)	inch	-	11,8 x 0,4	11,8 x 0,4	11,8 x 0,4
	Multi-Vee Press Brake (W x T)	inch	-	23,6 x 0,24	23,6 x 0,24	23,6 x 0,3
	Pipe Notching	inch	-	1/2" - 2"	1/2" - 2"	1/2" - 2"
	A min-max	inch	-	4,7 - 10,2	4,7 - 15,7	4,7 - 15,7
	ØD max	inch	-	(DIN 997) 9,8	(DIN 997) 11,1	(DIN 997) 11,1
	S max	inch	-	(DIN 997) 0,4	(DIN 997) 0,55	(DIN 997) 0,55
	B min-max	inch	-	3,94 - 9,4	3,94 - 12,6	3,94 - 12,6
	ØD max	inch	-	(DIN 997)	(DIN 997)	(DIN 997)
	S max	inch	-	(DIN 997)	(DIN 997)	(DIN 997)
FLAT SHEARING						
	Flat Bar (max. thickness)	inch	7,87 x 0,5	7,87 x 0,8	11,8 x 0,8	15,7 x 0,8
	Flat Bar (max. width)	inch	11,8 x 0,4	11,8 x 0,59	17,7 x 0,59	23,6 x 0,59
	Blade Length	ft	1	1	1' 6,7"	1' 11,8"
	Angle Flange Trim	inch	3,15	2,36	3,15	3,94
	Working Height	ft	3' 3,8"	2' 11"	3' 4,63"	3' 6,7"
ANGLE SHEARING						
	At 90° Shearing	inch	3,15x3,15x0,3	4,72x4,72x0,4	5,12x5,12x0,5	5,98x5,98x0,5
	At 45° Miter Shearing	inch	-	2,76x2,76x0,27	2,76x2,76x0,27	2,76x2,76x0,27
	Working Height	ft	3'4,16"	3'7,3"	4'1,2"	4'3,4"
BAR SHEARING						
	Round Bar Shear	inch	0,18	0,63-1,57	1,77	1,97
	Square Bar Shear	inch	0,18	0,63-1,57	1,77	1,97
	Working Height	ft	3' 4,94"	3' 5,7"	4' 3,57"	4' 6,3"
OPTIONAL EQUIPMENTS						
	U - Profil Shear	inch	3,93	4,72	5,5	6,3
	T - Profil Shear	inch	1,57	1,97	2,36	2,36
	I - Profil Shear	inch	3,93	4,72	5,5	6,3
NOTCHING						
	Material thickness	inch	0,27	0,39	0,47	0,51
	Rectangular Notcher (width)	inch	1,57	1,65	2,05	2,05
	Rectangular Notcher (depth)	inch	1,97	3,54	3,54	3,54
	Vee-Notcher (Side x Side x T)	inch	1,57x1,57x0,27	1,65x1,65x0,4	2,05x2,05x0,47	2,05x2,05x0,51
	OPTIONAL EQUIPMENTS					
	Triangular notching material thickness	inch	0,16	0,24	0,24	0,24
	Triangular notching width V90	inch	2,95	3,74	4,92	4,92
	Triangular notching depth	inch	2,95	3,74	4,92	4,92
TECHNICAL DATA						
Motorpower		hp	4	5,5	11	11
Oil Capacity		gal	8,7	76	76	76
Net Weight (Apr.)		lbs	1741,6	1365	2680	3730
Gross Weight (Apr.)		lbs	1785,7	1385	2700	3750
Machine dimensions (Apr.) (L x W x H)		ft	4' 9,5"x4' 7,1"x5' 3,8"	1980x1800x1730	2120x2025x1780	2560x2550x1790
Packing Dimensions (Apr.) (L x W x H)		ft	4' 9,1"x4'10,2"x2'3,5"	1980x1840x820	2190x2090x820	2540x2280x820

Production is *More Effective Now.*

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.



IW-VN

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**

VN	Unit	2006
Cutting Capacity	inch	0,24-0,16
Cutting Lenght	inch	7,87 x 7,87
Cutting Angle	degree	30° - 140°
Stroke Per Min.	quat.	28
Motor Power	hp	5,43
Working Power Pressure	psi	210/3045 PSI
Oil Capacity	gal	13,20
Height	ft	4' 3,2"
Width	ft	3' 5,3"
Lenght	ft	2' 11,4"
Weight	lbs	2094
Sound Strenght (Unloaded)	dBA	66
Sound Strenght (Loaded)	dBA	77z








Product Groups

DURMA



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

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