

DURMA

AD-S SERIES HYDRAULIC PRESS BRAKES



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



DURMA





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.



1

High technology,
modern production
lines

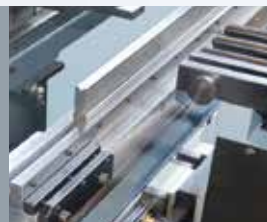


3

High quality
machines designed
in R&D Centre

2

Top quality
components



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 Hydraulic 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 technology excellent equipment
- Low service cost
- Reliability

Fast, Efficient, Modern

AD-S Series hydraulic 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

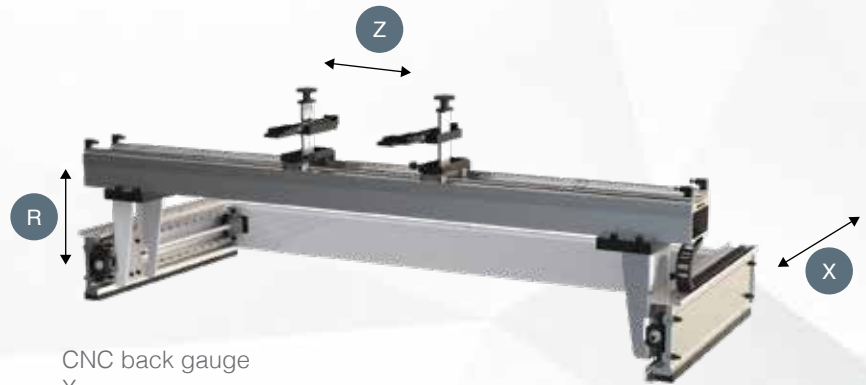
- High sensitivity, Stress relieved steel construction body, long life Mono Block Frame
- Automatic calibration and first start up
- *DURMA* designed and copyrighted guiding system
- Ball Screw and linear guide integrated perfect back gauge system
- Durable, long life and sensitive bending capable special 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



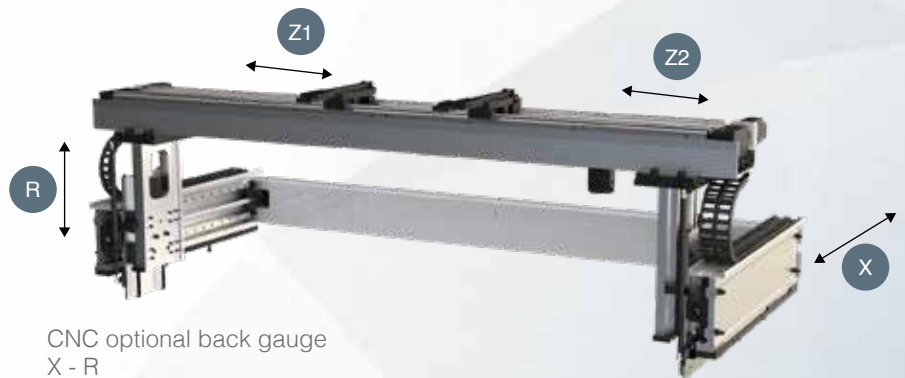
Strong Back Gauge Systems

- 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



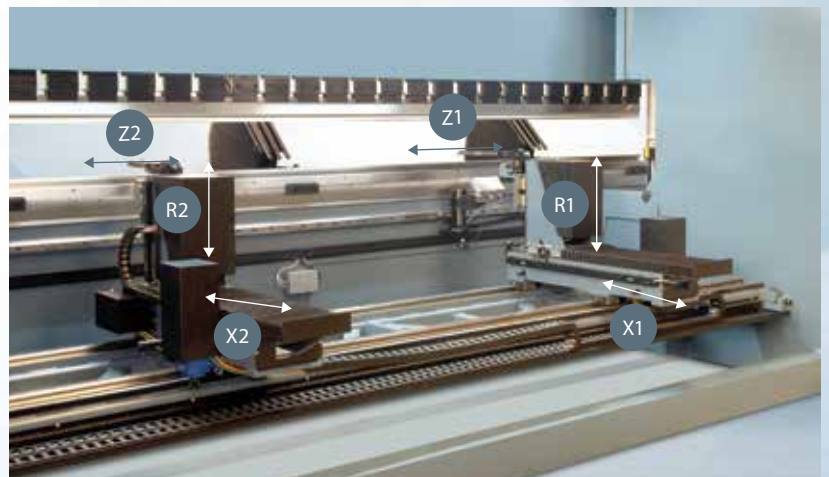
CNC optional back gauge
X - R
X - R - Z1, Z2
X - R - Z1, Z2, Delta X

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

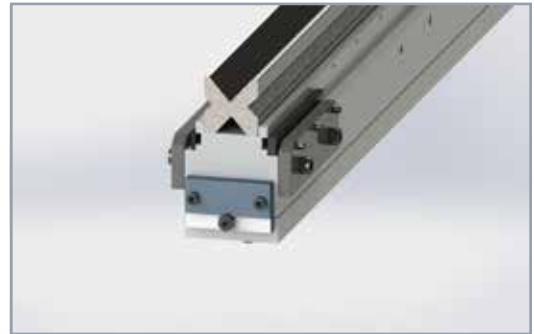
Tool Holders and Tools

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)



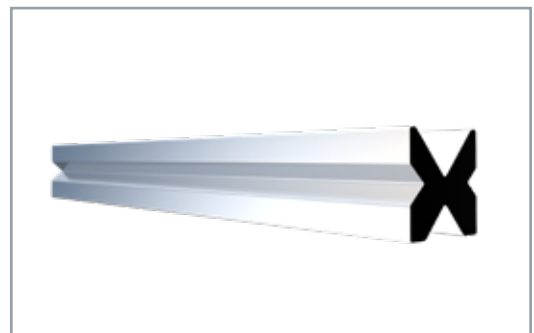
Quick Release Clamping



DURMA Hydraulic Clamping System



DURMA Top Tool Clamping System & Tool



DURMA Bottom Tool Multi V

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

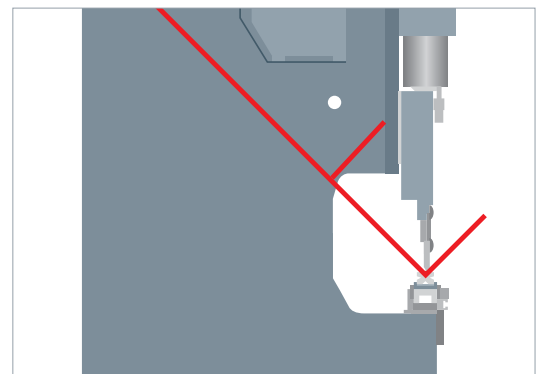
Our machines are designed in accordance with Ce-Norms to ensure your safety with hydraulic, electric, appropriate height covers and laser light curtains. CE safety in tandem machines are also provided with light barriers.



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 outside of the frame.



90 Degree Endless Bend

Now Bending is More Easier

DT 15



- Ergonomic panel design
- 19" color touchscreen
- Manual profiling on the touchscreen
- Diagnostic mode
- Easy programming mode
- Automatic bend sorting
- Multi-language option
- Tool programming and library
- D-Bend offline software
- Tandem compatible
- Internet service facility

SKY 22



- 21.5 " TFT color touch screen with USB port and backup
- Automatic bending order
- Perfect control of electrical servo systems
- Archiving user bendings
- 2D/3D color graphics display and multi-simulation
- Windows 10 operating system
- D-Bend offline software
- Tandem applications
- Network interface
- X1-X2-R1-R2-Z1-Z2 and AP3-AP4 part support system
- DURMA laser angle measurement system compatible
- 2D / 3D part & tool import

DA-66T



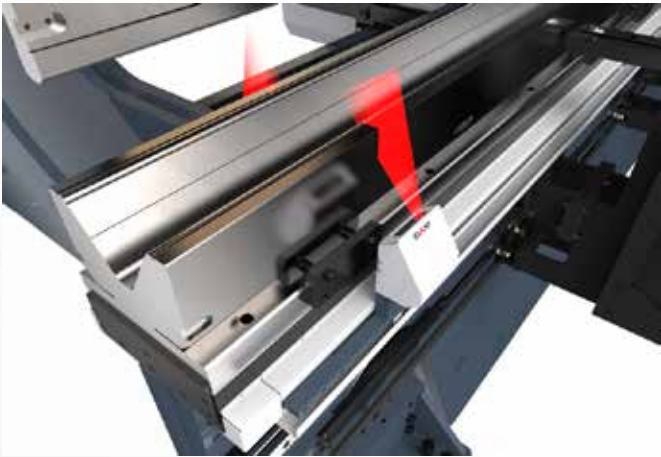
- 2D graphical touch screen programming mode
- 3D visualisation in simulation and production
- 17" high resolution colour TFT
- Full Windows application suite
- Delem modusys compatibility
- USB, peripheral interfacing
- User specific application support within the controllers multitasking environment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

DA-69S



- 24" TFT screen, 1920 x3080 pixels, 32 bit colour,
- Real-time Linux embedded OS
- Full touch screen control
- Storage capacity 2 GB
- Network connectivity
- Delem modusys compatible
- Tandem operation
- 2D/3D real-scale product programming and visualisation
- Automatic bending calculation 2D/ 3D
- DXF part & tool import support

System of DURMA Angle Measurement



Automatic AP3 - AP4 Sheet Follower



Robotic System of Applications



Standard & Optional Equipment

Standard Equipment

Y1, Y2, X - 3 Axis
Control Unit - DT 15
Manuel F. AKAS FPSC Security system
CE F.AKAS BVLTLight barrier and safety cages (For Tandem Press Brakes)
Servo motor back gauge & linear guided & ballscrew system (X)
Manual Crowning system
European style tool clamping system
Sliding front arms
World standards special design hydraulic block and valves
World standard electric equipment

Optional Equipment

Control Unit - SKY 22
Control Unit - Delem 66T
Control Unit - Delem 69S
F.AKAS - LC 5 Security system
Motorlu F.AKAS-3P FPSC Security system
X Axis = 1000 mm – light barrier back protection
Motorised crowning system
Motorised X, R axis back gauge
Motorised X, R, Z1, Z2 axis back gauge
Motorised X1, X2, R1, R2, Z1, Z2 axis back gauge
Delta X Axis \pm 125 stroke
AP3-AP4 Automatic system of sheet follower – Motorized elevation adjustment
(There is a motorized elevation adjustment of 220 tons or more.)
Durma Laser angle measurement (DAM)
Laser bending line
DBEND 3D bending simulation program
Quick release clamping system
Hydraulic and pneumatic tool clamping systems
Parking area
Robot Integration
Central lubrication system manuel/automatic
Oil cooler - oil heater
Additional back gauge finger and sliding front support arms
Special packing for overseas shipments

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



Service Agreements



Software



Training

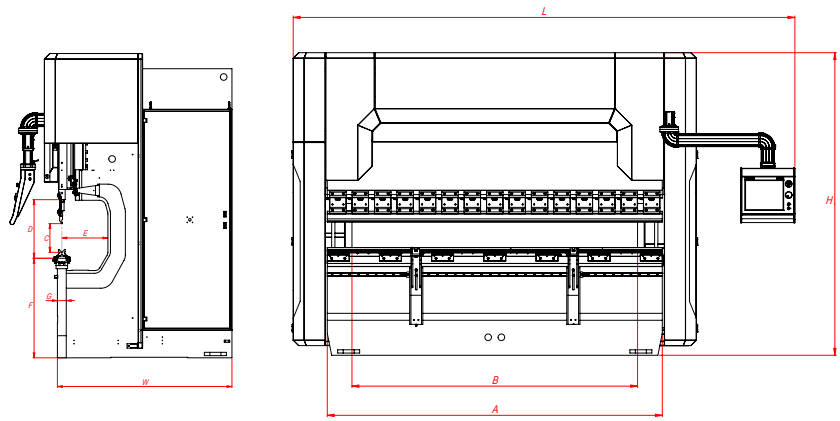


Flexible Solution

AD-S Series Technical Details

| AD-S Series | Bending Force | Bending Length | Distance Between Columns | | Stroke | Daylight | Throat Depth | Table Height | Table Width (Narrow / Wide) | Working Speed | | Y Return Speed | Y Axis Precision | X Axis Working Speed |
|-------------|---------------|----------------|--------------------------|-----|--------|----------|--------------|--------------|------------------------------|---------------|-----------------|----------------|------------------|----------------------|
| | | | | | | | | | | Y Rapid Speed | Y Working Speed | | | |
| | | | | | | | | | | Ton | mm | | | |
| | A | B | C | D | E | F | G | | | | | | | |
| AD-S 1260 | 60 | 1250 | 1050 | 160 | 400 | 350 | 900 | 104 | 200 | 10 | 110 | 0,01 | 500 | |
| AD-S 2060 | 60 | 2050 | 1700 | 265 | 530 | 450 | 900 | 104 | 200 | 10 | 110 | 0,01 | 500 | |
| AD-S 25100 | 100 | 2550 | 2200 | 265 | 530 | 450 | 900 | 104 | 180 | 10 | 120 | 0,01 | 500 | |
| AD-S 30100 | 100 | 3050 | 2600 | 265 | 530 | 450 | 900 | 104/180 | 180 | 10 | 120 | 0,01 | 500 | |
| AD-S 30135 | 135 | 3050 | 2600 | 265 | 530 | 450 | 900 | 104/180 | 160 | 10 | 120 | 0,01 | 500 | |
| AD-S 30175 | 175 | 3050 | 2600 | 265 | 530 | 450 | 900 | 104/240 | 160 | 10 | 100 | 0,01 | 500 | |
| AD-S 30220 | 220 | 3050 | 2600 | 265 | 530 | 450 | 900 | 104/240 | 140 | 10 | 140 | 0,01 | 500 | |
| AD-S 30320 | 320 | 3050 | 2600 | 365 | 630 | 450 | 900 | 154/300 | 160 | 10 | 140 | 0,01 | 500 | |
| AD-S 37175 | 175 | 3700 | 3100 | 265 | 530 | 450 | 900 | 104/240 | 140 | 10 | 100 | 0,01 | 500 | |
| AD-S 37220 | 220 | 3700 | 3100 | 265 | 530 | 450 | 900 | 104/240 | 160 | 10 | 120 | 0,01 | 500 | |
| AD-S 40175 | 175 | 4050 | 3600 | 265 | 530 | 450 | 900 | 104/240 | 160 | 10 | 140 | 0,01 | 500 | |
| AD-S 40220 | 220 | 4050 | 3600 | 265 | 530 | 450 | 900 | 104/240 | 160 | 10 | 140 | 0,01 | 500 | |
| AD-S 40320 | 320 | 4050 | 3600 | 365 | 630 | 450 | 900 | 154/300 | 160 | 10 | 140 | 0,01 | 500 | |
| AD-S 40400 | 400 | 4050 | 3400 | 365 | 630 | 510 | 1050 | 154/300 | 140 | 8 | 120 | 0,01 | 350 | |
| AD-S 60220 | 220 | 6050 | 5100 | 265 | 530 | 450 | 1050 | 154/300 | 140 | 10 | 120 | 0,01 | 350 | |
| AD-S 60400 | 400 | 6050 | 5100 | 365 | 630 | 510 | 1220 | 154/300 | 120 | 8 | 100 | 0,01 | 350 | |

Machines set according to optimum values.



| X Axis Precision | X Axis Distances | | | R Axis Working Speed | R Axis Working Distance | R Axis Precision | Z Axis Working Speed | Z Axis Working Distance | Motor Power | Oil Tank Capacity | Length | Width | Height | Weight Approx. |
|------------------|------------------|-----|------|----------------------|-------------------------|------------------|----------------------|-------------------------|-------------|-------------------|--------|-------|--------|----------------|
| | 650 | 750 | 1000 | | | | | | | | | | | |
| mm | mm | mm | mm | mm/sec. | mm | mm | mm/sec. | mm | kW | lt | mm | mm | mm | kg |
| | | | | | | | | | | | L | W | H | |
| 0,05 | S | - | O | 350 | 250 | 0,1 | 1000 | 490 | 7,5 | 100 | 2300 | 1550 | 2350 | 4700 |
| 0,05 | S | - | O | 350 | 250 | 0,1 | 1000 | 1100 | 7,5 | 100 | 3200 | 1550 | 2850 | 5600 |
| 0,05 | S | - | O | 350 | 250 | 0,1 | 1000 | 1580 | 11 | 100 | 3800 | 1670 | 2850 | 7800 |
| 0,05 | S | - | O | 350 | 250 | 0,1 | 1000 | 1990 | 11 | 100 | 4200 | 1670 | 2850 | 8500 |
| 0,05 | S | - | O | 350 | 250 | 0,1 | 1000 | 1990 | 15 | 150 | 4200 | 1680 | 2850 | 9580 |
| 0,05 | S | - | O | 350 | 250 | 0,1 | 1000 | 1990 | 18,5 | 250 | 4250 | 1700 | 2850 | 10900 |
| 0,05 | S | - | O | 350 | 250 | 0,1 | 1000 | 1990 | 22 | 250 | 4250 | 1770 | 3000 | 12600 |
| 0,05 | S | - | O | 350 | 250 | 0,1 | 1000 | 1990 | 37 | 250 | 4300 | 1820 | 3330 | 17100 |
| 0,05 | S | - | O | 350 | 250 | 0,1 | 1000 | 2375 | 18,5 | 250 | 4950 | 1700 | 3000 | 11750 |
| 0,05 | S | - | O | 350 | 250 | 0,1 | 1000 | 2375 | 22 | 250 | 4950 | 1770 | 3000 | 14440 |
| 0,05 | S | - | O | 350 | 250 | 0,1 | 1000 | 2910 | 18,5 | 250 | 5250 | 1700 | 2850 | 12780 |
| 0,05 | S | - | O | 350 | 250 | 0,1 | 1000 | 2910 | 22 | 250 | 5250 | 1770 | 3000 | 14750 |
| 0,05 | S | - | O | 350 | 250 | 0,1 | 1000 | 2910 | 37 | 250 | 5300 | 1910 | 3330 | 20000 |
| 0,05 | - | S | O | 300 | 250 | 0,1 | 1000 | 2670 | 37 | 500 | 5750 | 2110 | 3640 | 27760 |
| 0,05 | - | S | O | 300 | 250 | 0,1 | 1000 | 4400 | 22 | 250 | 7500 | 1770 | 3350 | 20800 |
| 0,05 | - | S | O | 300 | 250 | 0,1 | 1000 | 4400 | 37 | 250 | 7500 | 2110 | 3810 | 34600 |

S : Standard

O : Optional

Special projects









DURMA



PANEL BENDER



PUNCH



PLASMA



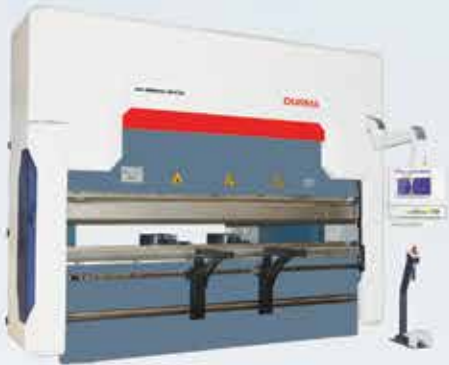
L ANGLE PROCESSING CENTER



IRON WORKER



POWER OPERATED SHEAR



PRESS BRAKE



VARIABLE RAKE SHEAR



TUBE LASER CUTTING



FIBER LASER



ROLL BENDING



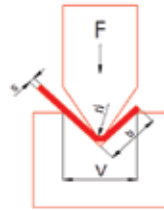
PROFILE BENDING



CORNER NOTCHER

DURMA

| 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 |



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

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

Durmazlar Makina San. ve Tic. A.Ş.
OSB 75. Yıl Bulvarı Nilüfer-Bursa / Türkiye
T: +90 224 219 18 00
F: +90 224 242 75 80
info@durmazlar.com.tr

www.durmazlar.com.tr



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