

**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 150.000 m<sup>2</sup>, 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.





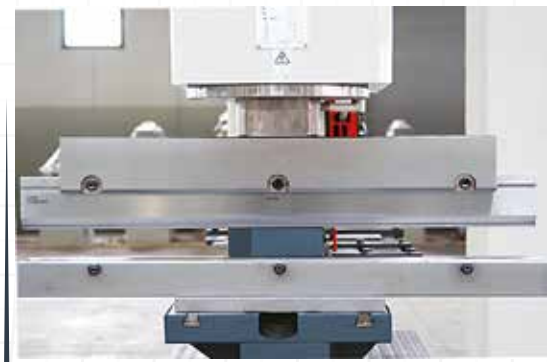
## IW Series Features

### ■ 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

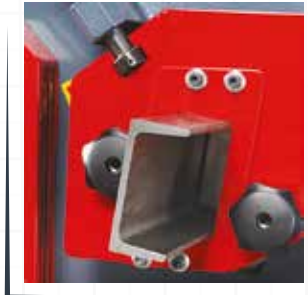
Bar shearing station consists of square bar shearing, round bar shearing, touch and cut electrical back gauge. Also optional U Blade and optional I&T blades are available upon request.



■ Square Bar Shearing



■ Round Bar Shearing



■ Optional U Blade



■ Optional I&T Blades



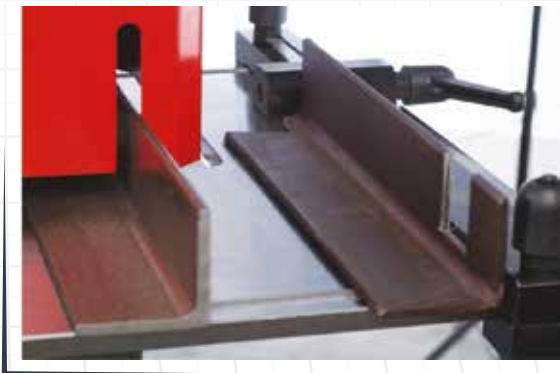
■ Touch and Cut Electrical Back Gauge



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### ■ 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 1/2" 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

## 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 LTD	IW 80/150 LTD	IW 110/180 LTD
<b>PUNCHING</b>					
Punching Pressure	ton	45	55	80	110
Punch Capacity (Diameter x Thickness)	mm	Ø27x13	Ø40x10	Ø40x14	Ø40x20
		Ø18x18	Ø20x20	Ø24x24	Ø28x28
Throat Depth	mm	160	510	510	610
Stroke length (Stroke)	mm	21	60	70	80
Cycles /Min. (20 mm stroke)	quat.	20	37	38	28
Table Size (W x D)	mm	450x160	550x510	550x510	550x610
Working Height up to Die	mm	1010	1088	1195	1260
<b>OPTIONAL EQUIPMENTS</b>					
Largest Hole	mm	Ø100	Ø160	Ø160	Ø160
Single Vee Press Brake (W x T)	mm	-	300x10	300x10	300x10
Multi-Vee Press Brake (W x T)	mm	-	600x6	600x6	600x8
Pipe Notching	mm	-	1/2" - 2"	1/2" - 2"	1/2" - 2"
A min-max	mm	-	120 - 260	120 - 400	140 - 400
ØD max	mm	-	(DIN 997) 25	(DIN 997) 28	(DIN 997) 28
S max	mm	-	(DIN 997) 10	(DIN 997) 14	(DIN 997) 14
B min-max	mm	-	100 - 240	100 - 320	120 - 320
ØD max	mm	-	(DIN 997)	(DIN 997)	(DIN 997)
S max	mm	-	(DIN 997)	(DIN 997)	(DIN 997)
<b>FLAT SHEARING</b>					
Flat Bar (max. thickness)	mm	200x13	200x20	300x20	400x20
Flat Bar (max. width)	mm	300x10	300x15	450x15	600x15
Blade Length	mm	305	305	475	605
Angle Flange Trim	mm	80	60	80	100
Working Height	mm	1010	890	1032	1085
<b>ANGLE SHEARING</b>					
At 90° Shearing	mm	80x80x8	120x120x10	130x130x13	152x152x13
At 45° Miter Shearing	mm	-	70x70x7	70x70x7	70x70x7
Working Height	mm	1020	1100	1250	1305
<b>BAR SHEARING</b>					
Round Bar Shear	mm	30	16-40	45	50
Square Bar Shear	mm	30	16-40	45	50
Working Height	mm	1040	1060	1310	1380
<b>OPTIONAL EQUIPMENTS</b>					
U - Profil Shear	mm	100	120	140	160
T - Profil Shear	mm	40	50	60	60
I - Profil Shear	mm	100	120	140	160
<b>NOTCHING</b>					
Material thickness	mm	7	10	12	13
Rectangular Notcher (width)	mm	40	42	52	52
Rectangular Notcher (depth)	mm	50	90	90	90
Vee-Notcher (Side x Side x T)	mm	40x40x7	42x42x10	52x52x12	52x52x13
<b>OPTIONAL EQUIPMENTS</b>					
Triangular notching material thickness	mm	4	6	6	6
Triangular notching width V90	mm	75	95	125	125
Triangular notching depth	mm	75	95	125	125
<b>TECHNICAL DATA</b>					
Motorpower	KW	3	5.5	11	11
Oil Capacity	lt	33	76	76	76
Net Weight (Apr.)	kg	790	1365	2680	3730
Gross Weight (Apr.)	kg	810	1385	2700	3750
Machine dimensions (Apr.) (L x W x H)	mm	1460x1400x1620	1980x1800x1730	2120x2025x1780	2560x2550x1790
Packing Dimensions (Apr.) (L x W x H)	mm	1450x1480x700	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	mm	6 - 4
Cutting Lenght	mm	200 x 200
Cutting Angle	mm	30° - 140°
Stroke Per Min.	mm/m	28
Motor Power	kw	4
Working Power Pressure	bar	210 3045 PSI
Oil Capacity	lt	50
Height	mm	1300
Width	mm	1050
Lenght	mm	900
Weight	kg	950
Sound Strenght (Unloaded)	dBA	66
Sound Strenght (Loaded)	dBA	77








# Product Groups

# DURMA



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

 Durma International  
 durmainternational  
 durmaint  
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 Durmazlar



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