

The Winning Force

***DURMA***

# AD-S SERIES PRESS BRAKES



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



# **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<sup>2</sup>, 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



# 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

Minimum tool change and adjustment time

Maximum speed and safety



# AD-S Series Press Brake



# Perfect and Fast Bending

## Perfect components for precision

With Easy to use control unit, stabile body type, perfect design, low operation 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
- Latest technology
- 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

Precision

Reliable

Strong

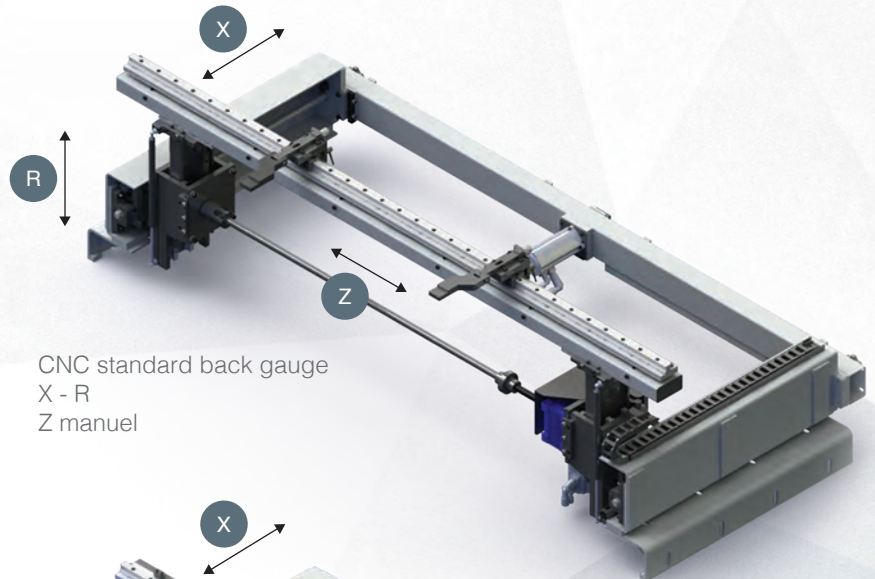
- Fast and high accuracy
- Safe movement
- Resistance to crash
- Maintenance free
- Adjustment availability at every point

## Why *DURMA* Back Gauge ?

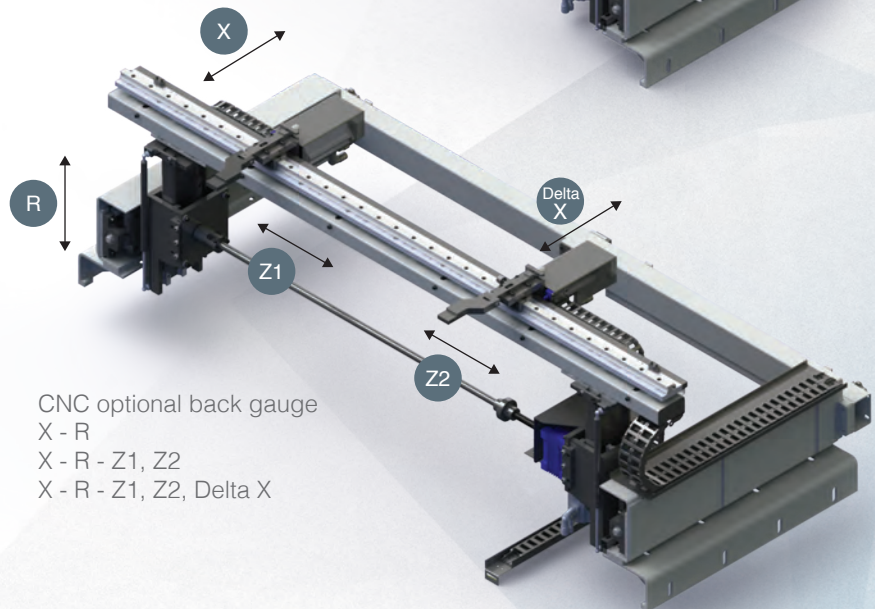
Most important feature to achieve perfect bending is the stability and the design of the back gauge, which allows an impeccable and correct product to be produced.

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.

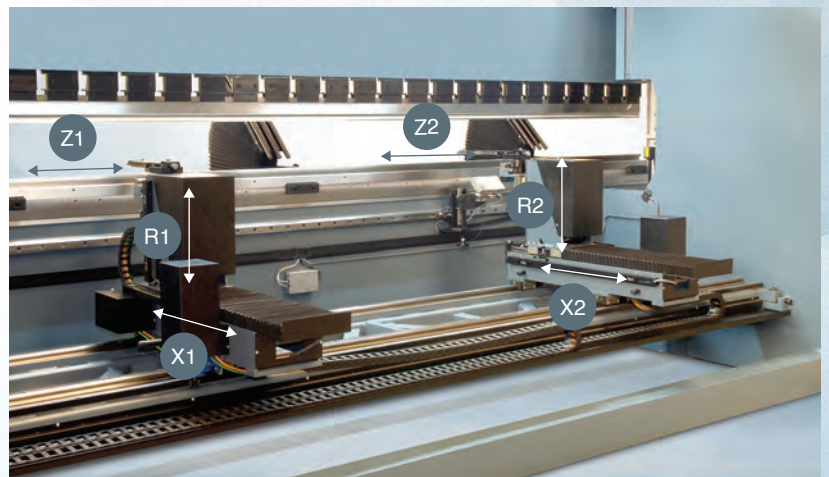
Special designed finger blocks with steps to achieve maximum stability can also be supplied for every kind of bending solution.



CNC standard back gauge  
X - R  
Z manuel



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



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

# Tool Holders and Tools

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

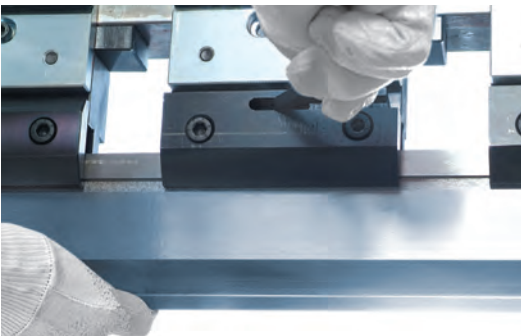
*DURMA* is your solution partner with various tool options.



European Clamping System



European Type Bottom Tool (4V Die)



Quick Release Clamping



Wila Bottom Tool Clamping



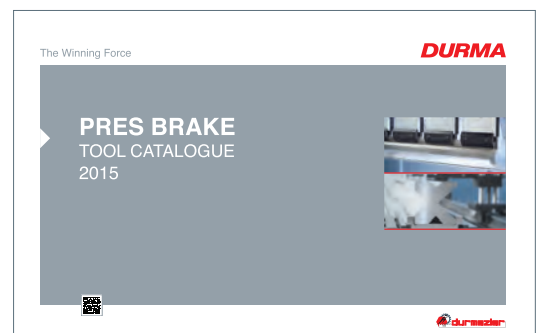
Wila Top Tool Clamping



*DURMA* Bottom Tool Multi V



*DURMA* Top Tool

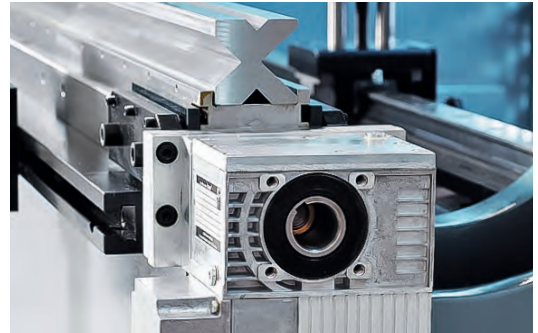




# Safe and Accurate Bends with Top Quality Equipments

## 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.



CNC Crowning System

## 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

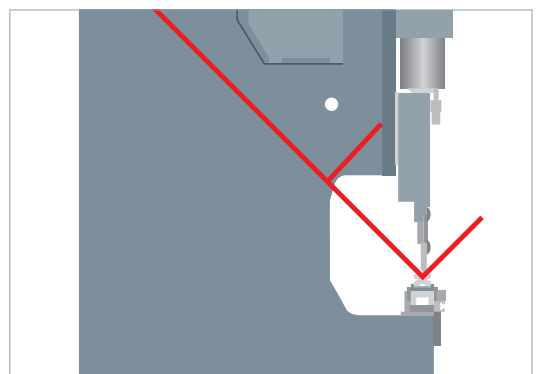
Our machines are designed in accordance with Ce-Norms to ensure your safety with hydraulic, electric, appropriate height covers and laser light curtains. CE safety in tandem machines are also provided with light barriers



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

## ModEva 15T



- 15" color 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

### Bundled Offline Software

PC-ModEva software allows you to prepare your programs, calculate offers and check feasibility of the parts on your desktop computer. No time is wasted on the machine.

## DA-66T



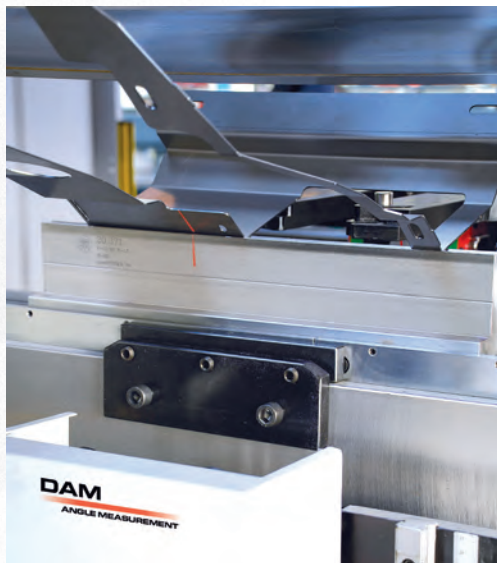
- 2D graphical touch screen programming mode
- 3D visualisation in simulation and production
- 17" high resolution colour TFT
- Full Windows application suite
- Delem Modusys compatibility
- USB, peripheral interfacing
- User specific application support within the controllers multitasking environment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

## Modeva Premium

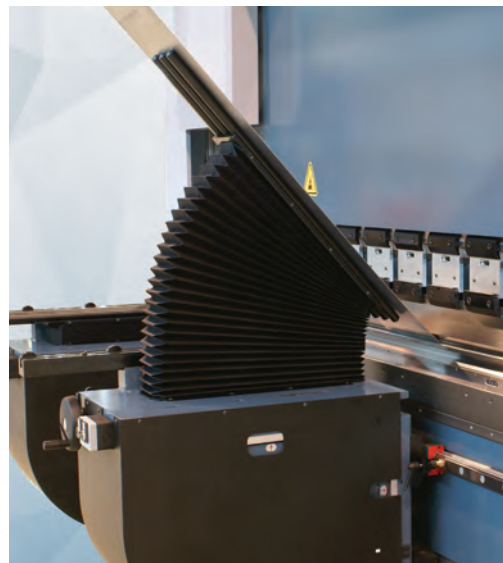
## DA-69T



## ANGLE MEASUREMENT



## AP3 - AP4 SHEET FOLLOWER



## ROBOTIC SOLUTIONS



# Standard & Optional Equipment

## Standard Equipment

Y1, Y2, X, R - 4- axis  
Control Unit - CNC ModEva15T or 66T  
CE Manuel F. AKAS II M FPSC-B-C + safety covers with switch  
CE F.AKAS BLVT light barrier and safety covers ( for tandem press brakes)  
Servo motor back gauge & linear guided & ballscrew system (X-R)  
CNC 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 or 69T  
FIESSLER AKAS-LC II AKAS-3 M Motorized + FPSC (safety PLC)  
CE BLVT safety – only for tandem machines  
Z1, Z2 axis  
X1, X2 axis  
R1, R2 axis  
R1 R2 axis on back gauge fingers  
Delta X axis, +250mm stroke  
X axis = 1000 mm – light barrier back protection  
AP3-AP4 sheet following system  
Motorized height adjustable laser angle measurement system  
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



## 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



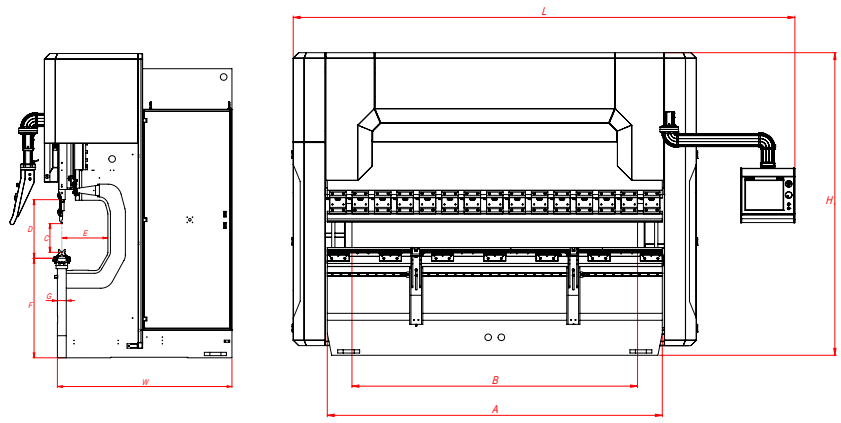
Flexible Solution

## AD-S Series Technical Details

| AD-S Series | Bending Force | Bending Length | Distance Between Columns | Stroke | Daylight | Throat Depth | Table Height | Table Width | Working Speed |                 |
|-------------|---------------|----------------|--------------------------|--------|----------|--------------|--------------|-------------|---------------|-----------------|
|             |               |                |                          |        |          |              |              |             | Y Rapid Speed | Y Working Speed |
|             | Ton           | mm             | mm                       | mm     | mm       | mm           | mm           | mm          | mm/sec        | mm/sec          |
|             |               | A              | B                        | C      | D        | E            | F            | G           |               |                 |
| AD-S 1260   | 60            | 1250           | 1050                     | 265    | 530      | 350          | 900          | 104         | 200           | 10              |
| AD-S 2060   | 60            | 2050           | 1700                     | 265    | 530      | 410          | 900          | 104         | 200           | 10              |
| AD-S 25100  | 100           | 2550           | 2200                     | 265    | 530      | 410          | 900          | 104         | 180           | 10              |
| AD-S 30100  | 100           | 3050           | 2600                     | 265    | 530      | 410          | 900          | 104         | 180           | 10              |
| AD-S 30135  | 135           | 3050           | 2600                     | 265    | 530      | 410          | 900          | 104         | 160           | 10              |
| AD-S 30175  | 175           | 3050           | 2600                     | 265    | 530      | 410          | 900          | 104         | 160           | 10              |
| AD-S 30220  | 220           | 3050           | 2600                     | 265    | 530      | 410          | 900          | 104         | 140           | 10              |
| AD-S 30320  | 320           | 3050           | 2600                     | 265    | 530      | 410          | 900          | 154         | 160           | 10              |
| AD-S 37175  | 175           | 3700           | 3100                     | 265    | 530      | 410          | 900          | 104         | 140           | 10              |
| AD-S 37220  | 220           | 3700           | 3100                     | 265    | 530      | 410          | 900          | 104         | 160           | 10              |
| AD-S 40175  | 175           | 4050           | 3600                     | 265    | 530      | 410          | 900          | 104         | 160           | 10              |
| AD-S 40220  | 220           | 4050           | 3600                     | 265    | 530      | 410          | 900          | 104         | 160           | 10              |
| AD-S 40320  | 320           | 4050           | 3600                     | 365    | 630      | 410          | 900          | 154         | 160           | 10              |
| AD-S 40400  | 400           | 4050           | 3400                     | 365    | 630      | 510          | 1040         | 300         | 140           | 8               |
| AD-S 40600  | 600           | 4050           | 3100                     | 365    | 700      | 510          | 990          | 300         | 80            | 7               |
| AD-S 60220  | 220           | 6050           | 5100                     | 265    | 530      | 410          | 1100         | 154         | 140           | 10              |
| AD-S 60320  | 320           | 6050           | 5100                     | 365    | 630      | 410          | 1100         | 154         | 140           | 10              |
| AD-S 60400  | 400           | 6050           | 5100                     | 365    | 630      | 510          | 1220         | 300         | 120           | 8               |
| AD-S 60600  | 600           | 6050           | 5100                     | 365    | 700      | 510          | 990          | 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                     | 600    | 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                     | 400    | 1000     | 610          | 900          | 500         | 70            | 6               |
| AD-S 802000 | 2000          | 8100           | 6400                     | 600    | 1000     | 750          | 950          | 700         | 70            | 6               |

Machines set according to optimum values.



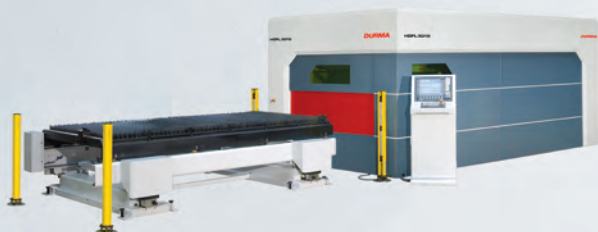


| Y Return Speed | X Axes Working Speed | R Axes Working Speed | R Axes Working Distance | X Axes Distance |     |      | Motor Power | Length | Width | Height | Weight Approx. |
|----------------|----------------------|----------------------|-------------------------|-----------------|-----|------|-------------|--------|-------|--------|----------------|
|                |                      |                      |                         | 650             | 750 | 1000 |             |        |       |        |                |
| mm/sec         | mm/sec               | mm                   | mm                      |                 |     |      | kW          | mm     | mm    | mm     | kg             |
|                |                      |                      |                         |                 |     |      |             | L      | W     | H      |                |
| 110            | 500                  | 350                  | 250                     | -               | S   | -    | 7,5         | 2300   | 1200  | 2350   | 3100           |
| 110            | 500                  | 350                  | 250                     | S               | -   | O    | 7,5         | 3200   | 1200  | 2350   | 3550           |
| 120            | 500                  | 350                  | 250                     | S               | -   | O    | 11          | 3800   | 1670  | 2750   | 8900           |
| 120            | 500                  | 350                  | 250                     | S               | -   | O    | 11          | 4200   | 1670  | 2750   | 9500           |
| 120            | 500                  | 350                  | 250                     | S               | -   | O    | 15          | 4200   | 1680  | 2750   | 10500          |
| 100            | 500                  | 350                  | 250                     | S               | -   | O    | 18,5        | 4250   | 1700  | 2750   | 11500          |
| 140            | 500                  | 350                  | 250                     | S               | -   | O    | 22          | 4250   | 1770  | 2900   | 12500          |
| 140            | 500                  | 350                  | 250                     | S               | -   | O    | 37          | 4300   | 1820  | 3230   | 17500          |
| 100            | 500                  | 350                  | 250                     | S               | -   | O    | 18,5        | 4950   | 1700  | 2900   | 13000          |
| 120            | 500                  | 350                  | 250                     | S               | -   | O    | 22          | 4950   | 1770  | 2900   | 14360          |
| 140            | 500                  | 350                  | 250                     | S               | -   | O    | 18,5        | 5250   | 1700  | 2750   | 13100          |
| 140            | 500                  | 350                  | 250                     | S               | -   | O    | 22          | 5250   | 1770  | 2900   | 15000          |
| 140            | 500                  | 350                  | 250                     | -               | S   | O    | 37          | 5300   | 1910  | 3230   | 21000          |
| 120            | 350                  | 300                  | 250                     | -               | S   | O    | 37          | 5750   | 2110  | 3540   | 27000          |
| 80             | 350                  | 300                  | 250                     | -               | S   | O    | 45          | 5650   | 3250  | 3835   | 40500          |
| 120            | 350                  | 300                  | 250                     | -               | S   | O    | 22          | 7500   | 1770  | 3250   | 20840          |
| 120            | 350                  | 300                  | 250                     | -               | S   | O    | 37          | 7500   | 1910  | 3450   | 28500          |
| 100            | 350                  | 300                  | 250                     | -               | S   | O    | 37          | 7500   | 2110  | 3710   | 36000          |
| 80             | 350                  | 300                  | 250                     | -               | S   | O    | 45          | 7600   | 2650  | 3850   | 54000          |
| 80             | 350                  | 300                  | 250                     | -               | S   | O    | 55          | 8050   | 3200  | 4250   | 72000          |
| 70             | 350                  | 300                  | 250                     | -               | S   | O    | 55          | 8700   | 3200  | 4250   | 79500          |
| 60             | 300                  | 250                  | 250                     | -               | -   | S    | 55          | 8800   | 3250  | 5900   | 95500          |
| 70             | 300                  | 250                  | 250                     | -               | -   | S    | 90          | 8800   | 3250  | 6400   | 110000         |
| 70             | 300                  | 300                  | 250                     | -               | S   | O    | 55          | 9800   | 3200  | 4250   | 85000          |
| 60             | 300                  | 250                  | 250                     | -               | -   | S    | 55          | 10000  | 3250  | 5900   | 102000         |
| 70             | 300                  | 250                  | 250                     | -               | -   | S    | 90          | 10000  | 3250  | 6400   | 135000         |
| 70             | 300                  | 250                  | 250                     | -               | -   | S    | 90          | 10100  | 3500  | 7000   | 163000         |
| 60             | 300                  | 250                  | 250                     | -               | -   | S    | 110         | 10500  | 4350  | 8100   | 249000         |

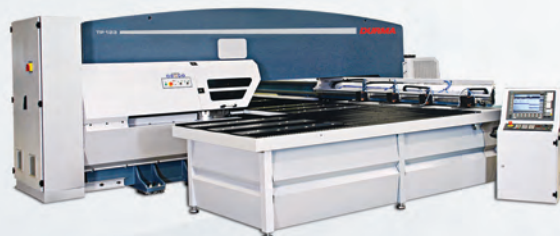
S : Standard

O : Option

# DURMA



FIBER LASER



PUNCH



PLASMA



L ANGLE PROCESSING CENTER



IRON WORKER



POWER OPERATED SHEAR





PRESS BRAKE



VARIABLE RAKE SHEAR



ROLL BENDING



PROFILE BENDING



BANDSAW

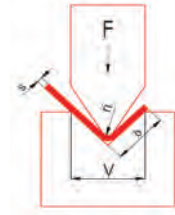


CORNER NOTCHER

# DURMA

Today Tomorrow and Forever With You...

| V   | b   | r <sub>i</sub> | 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  |    |



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

F: Bending Force (Ton) L: Length(mm) r<sub>i</sub>: Inside Radius (mm) R<sub>m</sub>: Material Tensile Strength (daN/mm<sup>2</sup>) V: Channel Width (mm) b: Minimum Sheet Bending Side (mm) s: Thickness (mm)

## AD-S SERIES PRESS BRAKES

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