

The Winning Force

DURMA

AD-R SERIES

Press Brakes



- Easy to use
- Fast
- Productive
- Winning
- Ergonomic



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 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

2
Top quality
components

3
High quality
machines designed
in R&D Centre

The Winning Force

With simple programmable features the high speed AD-R Series press brake adds value to your business with low energy consumption, precision bending and maintenance-free structure. This series can be used safely for many years and simplifies the operators work load.

With DURMA press brakes, you always get great results.

Fast, productive and perfect bending

Always precision bending results

Minimized tool exchange and setting time

Maximized speed and security



AD-R Series Press Brakes



Advance Your Standards

World leader in its category

Perfectly equipped for sensitive bending,
energy efficient solutions

With its easy to use control units, rigid body frame, perfect design, high efficiency, multiple tool usage solutions, top level CE safety standards and with its suitable price range, AD-R is the World leader in its category.



**Easy to
Use**

Ergonomic

Efficient

Fast

**Reliable
Brand**

Why DURMA Press Brakes

- Better and faster bending
- Stronger and rigid body structure
- High sensitivity and repeatability
- Latest technology
- Low service cost
- Reliability

Gain More Power

With its Performance and Price ratio it is the best CNC Press Brake in the World

AD-R series press brakes give excellent results of various type business types. It provides a convenient workspace for bends in many different sizes with a longer daylight.



General Specifications

- High sensitivity, Stress relieved steel construction body, long life Mono Block Frame
- DURMA designed and copyrighted guiding system
- Ball Screw and linear guide integrated perfect back gauge system
- Durable, long life and sensitive bending capability with 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
- Environmentally friendly ,efficient and perfect bending combinations

Strong Back Gauge System

- Precise
- Reliable
- Strong

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



Standard back gauge (X CNC, R manual)



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.

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)



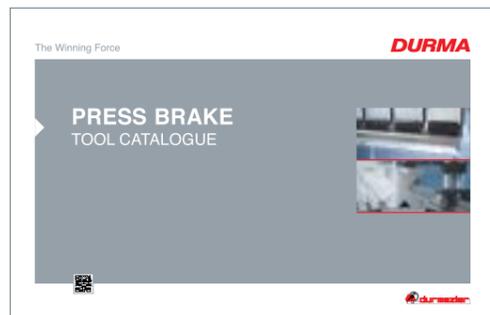
Quick Release Clamping



DURMA Multi V Bottom Tool



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

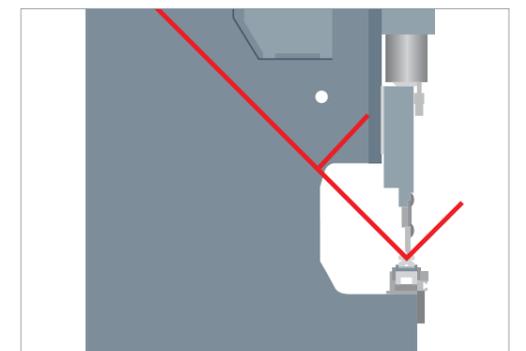


CE Lazer Güvenlik Sistemi

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

DT-15 Control Unit



-  Create profile with touch screen
-  Online service via Internet connection
-  Diagnostic mode
-  Easy programming page
-  Automatic bend calculation and listing
-  Tool programming and library



D-Bend offline software

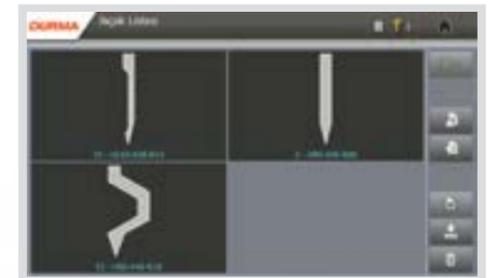
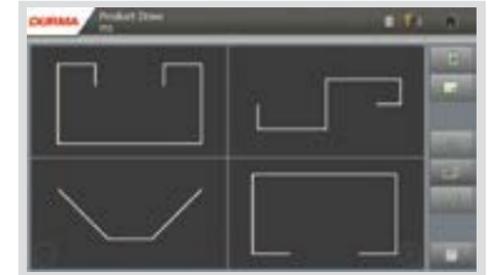
D-Bend Offline software allows you to simulate your bending at your desk in your office.

You can create your tools and it provides the opportunity to make new programs without interrupting production. D-Bend verifies your bend sequence. Creates verified part drawings for Laser, punch, and plasma machines.

Everything is Under Control with User-Friendly

InterfaceDA-66T

- Automatic bend listing
- Storing your programs
- Easy bend functioning
- 2D color graphics display and multiple simulation
- Linux operating system
- D-Bend offline software
- Tandem compatible
- Multiple language options
- Ergonomic panel design
- USB port, back-up 10" TFT color touch screen



Optional Control Units

ModEva 19T

- 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
- 15" color Touch Schreen



DA-58T

- 2D graphical touch screen programming
- 15" high resolution colour TFT
- Bend sequence calculation
- Crowning control
- Servo and frequency inverter control
- Advanced Y-axis control algorithms for closed-loop as well as open-loop valves
- USB, peripheral interfacing



Standard & Optional Equipment

Standard Equipments

Y1, Y2, X=650mm (AL - double gait)
 Control Unit - CNC DT15 Touch screen 2D graphic (Remote Control)
 Back gauge - motorised & linear guide & ball bearing system
 Manually adjustable R axes
 European Clamping system
 Sliding sheet support Arms with T-Channel and Tilting stop
 Special designed – world-class hydraulics blocks & valves
 World-class electrical equipment
 Manuel crowning

Optional Equipments

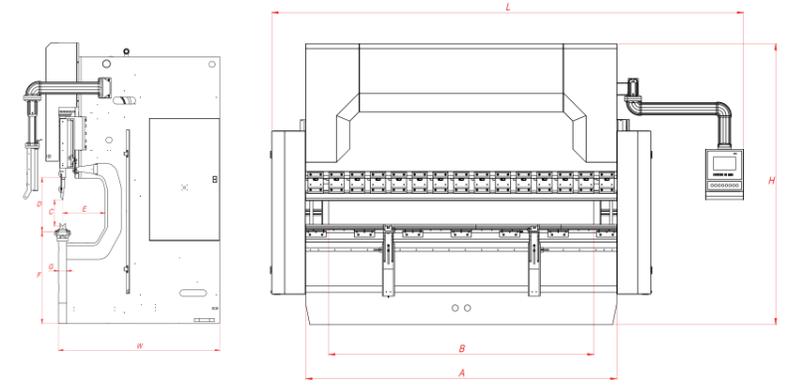
Control Unit - CNC ModEva 19T 3D Colour Graphic
 Control Unit - CNC DA 58T
 CE with FIESSLER AKAS-LC II F manual + AKFR control box
 CE BLVT safety – only for tandem machines
 Motorized R Axes
 Z1 - Z2 axes CNC
 DBEND 3D CAD/CAM Importing & Similation Program
 European style top tool
 European style bottom tool
 Bottom tool Durma
 Quick Release Clamping
 CNC controlled Motorized Crowning
 Back gauge 1000 mm - Back protection with Light barrier
 Oil Cooler
 Additional Finger blocks & Sliding front arms
 Overseas special packaging

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.



AD-R Serisi Teknik Detaylar



AD-R Series	Bending Force (Ton)	Bending Length (mm)	Distance Between Columns (mm)	Stroke (mm)	Daylight (mm)	Throat Depth (mm)	Optional Throat Depth	Table Height (mm)	Table Width (mm)	Working Speed	
										Y Rapid Speed (mm/sec)	Y Working Speed (mm/sec)
		A	B	C	D	E		F	G		
AD-R 1260	60	1250	1050	160	400	350		900	104	200	10
AD-R 2060	60	2050	1700	160	400	350		900	104	200	10
AD-R 25100	100	2550	2200	265	530	410		900	104	180	10
AD-R 30100	100	3050	2600	265	530	410	*	900	104	180	10
AD-R 30135	135	3050	2600	265	530	410	*	900	104	160	10
AD-R 30175	175	3050	2600	265	530	410	*	900	104	160	10
AD-R 30220	220	3050	2600	265	530	410	*	900	104	140	10
AD-R 30320	320	3050	2600	365	630	410	*	900	154	160	10
AD-R 37175	175	3700	3100	265	530	410	*	900	104	140	10
AD-R 37220	220	3700	3100	265	530	410	*	900	104	160	10
AD-R 40175	175	4050	3600	265	530	410	*	900	104	160	10
AD-R 40220	220	4050	3600	265	530	410	*	900	104	160	10
AD-R 40320	320	4050	3600	365	630	410	*	900	154	160	10
AD-R 40400	400	4050	3400	365	630	510	**	1050	154	140	8
AD-R 60220	220	6050	5100	265	530	410	*	1100	154	140	10
AD-R 60320	320	6050	5100	365	630	410	*	1100	154	140	10
AD-R 60400	400	6050	5100	365	630	510	**	1220	154	120	8

* 750 mm throat depth
 ** 750 - 1000 - 1250 mm throat depth
 *** 500mm/sec. backgauge speed on AL.
 Machines set according to optimum values.

Y Return Speed (mm/sec)	X Axes Working Speed (mm/sec)***	R Axes Working Distance (Manual)	R Axes Working Distance (Motorized)	X Axes Distance			Motor Power	Length (mm)	Width (mm)	Height (mm)	Weight Approx. (kg)
				650	750	1000					
								L	W	H	
110	500	140	250	S	-	O	7,5	2300	1250	2350	3350
110	500	140	250	S	-	O	7,5	3200	1250	2350	4000
120	500	140	250	S	-	O	11	3800	1670	2750	7400
120	500	140	250	S	-	O	11	4200	1670	2750	8000
120	500	140	250	S	-	O	15	4200	1680	2750	9170
100	500	140	250	S	-	O	18,5	4250	1700	2750	10520
140	500	140	250	S	-	O	22	4250	1770	2900	12250
140	500	140	250	S	-	O	37	4300	1820	3230	16500
100	500	140	250	S	-	O	18,5	4950	1700	2900	11250
120	500	140	250	S	-	O	22	4950	1770	2900	14100
140	500	140	250	S	-	O	18,5	5250	1700	2750	12850
140	500	140	250	S	-	O	22	5250	1770	2900	15000
140	500	140	250	S	-	O	37	5300	1910	3230	20040
120	350	140	250	-	S	O	37	5750	2110	3540	25000
120	350	140	250	-	S	O	22	7500	1770	3250	21760
120	350	140	250	-	S	O	37	7500	1910	3450	28000
100	350	140	250	-	S	O	37	7500	2110	3710	34200

S : Standard
 O : Option

DURMA

DURMA



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

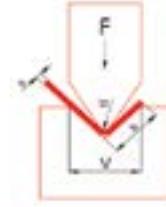


CORNER NOTCHER

DURMA

Today, Tomorrow and Forever With You...

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-R SERIES Press Brakes

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