

Laser Cutting Machine

Series

HD-F
HD-FN
HD-FO
HD-FA



Easy
to Use

High Quality
Cutting

Low Energy
Consumption

Faster

Efficient

Winning

Ergonomic



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

With three production plants covering a total of 1,614,600 sq ft and a workforce of 1,000 employees, we are dedicated to delivering high-quality manufacturing solutions that offer 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

FIBER LASER

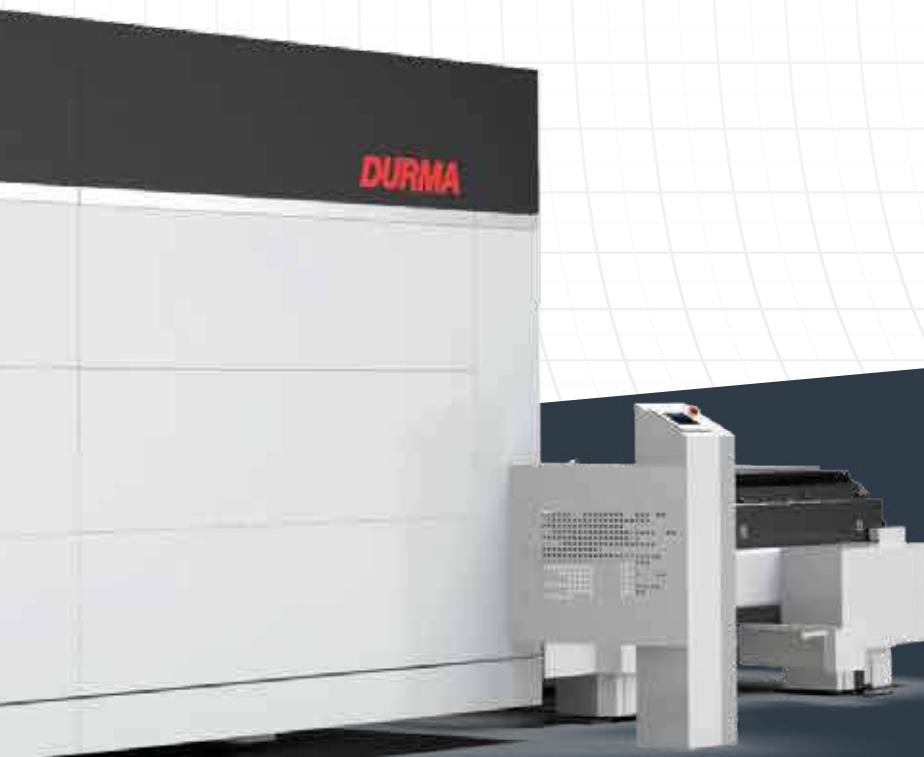
- Low operating cost and energy consumption
- Globally recognized high performance components
- Precise cuts and high durability
- High profit margin



*Production is **More Effective Now.***

Fiber Lasers Provide Innovative Solutions

- Perfect results on variety of material
- Efficient and precise cuts on thick and thin material
- Low investment and operating costs
- Modern and compact design
- Fast service with remote control



FIBER LASER

Fiber Laser Technologies

Fiber lasers outshine with its fast cutting and energy efficiency abilities when especially its compared to CO2 lasers. Easy use, maintenance and service have been achieved by the high technology of Fiber Lasers. Globally recognized efficient components used in DURMA Fiber Lasers add value to your company.

DURMA Fiber Laser is unrivaled with its rigid body structure, perfect filtration system, compact design, efficiency and user - friendliness.

■ Rack and Pinion Motion System

Axes motion is achieved by rack and pinion design. There are not any intermediate load transmitting elements between the motor and the pinion which otherwise could cause precision losses. High precision helical racks with low clearance make it possible to achieve very high acceleration (synchronized 91.86 ft/s^2), speed (synchronized 557.74 ft/min.) and accuracy (0.0012 inch) values.



Fiber Laser Source

Material (Cutting Capacity)*	3 kW	4 kW	6 kW	12 kW	20 kW	30 kW
Mildsteel (S235)	0.625 (0.75) inch	0.75 (0.86) inch	1.18 inch	1.18 inch	1.57(1.95) inch	1.95(2.36) inch
Stainless Steel (304)	0.31 (0.375) inch	0.375(0.5) inch	1 (1.18) inch	1 (1.18) inch	1.57(1.95) inch	1.95(2.36) inch
Aluminium (5083)	0.31 (0.375) inch	0.5 (0.625) inch	1.18 (1.57) inch	1.18 (1.57) inch	1.57(1.95) inch	1.57(1.95) inch
Copper (CU)	0.2 inch	0.25 inch	0.625 inch	0.625 inch	0.625 inch	0.625 inch
Brass (CUZN39 PB3)	0.31 inch	0.375 inch	0.75 inch	0.75 inch	0.75 inch	0.75 inch

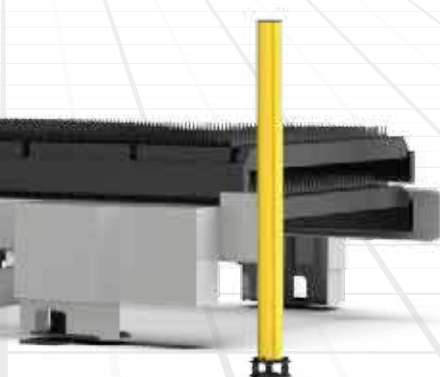
*These are standard cutting parameters.

The values shown in parentheses indicate the thicknesses that can be cut with minimal burr formation using resonators of the specified power. Cutting quality may vary depending on the geometry of the part being cut and the cutting speed. When cutting mild steel, factors such as rust, scale formation, paint, labels, surface height variations, rolling defects, grooves, and other surface imperfections may negatively affect the cutting process. Both the top and bottom surfaces of the material should be clean before cutting.

For shot-blasted steel sheets, cutting quality and cutting speeds may differ from the standard values.

Low Operating Costs

- Low energy consumption
- Low cost per component
- Optimised focal distance for all thickness values
- Maintenance - free operation
- Compact design, fast installation
- Rigid body structure, high durability



FIBER LASER

Laser Cutting Head

The laser beam generated in the resonator is transmitted to the cutting head via the fiber cable. The cutting head focuses the beam received from the fiber cable onto the processing surface. The type of material to be cut, its thickness, and the quality of the cut are related to the structure of the optical system. With a single type of cutting head, it offers a complete solution by cutting all thicknesses within its capacity, depending on the laser power. It performs cutting at high-quality standards even in the most challenging cuts and thicker materials.

The valuable optics such as lenses and collimators inside the high-pressure resistant automatic cutting head are protected from particles generated during the cutting process by a low-cost protective glass. The solid and dustproof body ensures a long service life.

■ Efficient

- Motorized automatic focus position adjustment for faster piercing, piercing thick plates, and cutting materials of different thicknesses.
- Precise distance measurement and quick response.
- Status monitoring with LED indicators.

■ Flexible

- Single focus lens for cutting both thin and thick materials
- Design compatible with high Z-axis dynamics
- Automatic focus position adjustment
- Efficient cutting gas flow

■ User Friendly & Safe

- Thanks to the protective glasses, a dustproof beam path
- LED status indicators
- Collision protection with ceramic part



■ Filter

It provides a healthy work environment by absorbing smoke, dust and small particles generated during cutting. The filter output can be delivered directly to the factory atmosphere. Businesses remain clean, healthy workspaces are provided for operators. The vibrating dust collection filter is fully automatic. It starts automatically when cutting starts. It is a compact unit with filter cartridges, integrated fan motor assembly and jet-pulse cleaning system. The dirt status of the filter can be easily seen on the panel. Cartridges make the blasting process automatically according to its dirt status.



■ Chiller

It is a device that provides cooling for the resonator and the optics in the cutting head. It features a water-based cooling system. Thanks to the dual-chamber system, cooling water at different temperatures is delivered to the optics and the laser power supply according to their needs.



■ Higher Acceleration on Z-Axis

In modern laser cutting processes, the vertical (Z-axis) movement capability of the cutting head is one of the most critical factors determining overall processing quality and productivity. Our belt-driven Z-axis architecture has been developed as an advanced alternative to conventional ball screw systems, which are limited by high mechanical inertia and friction. It combines high dynamic performance with superior operational efficiency.

Technical Advantages and Dynamic Performance

- Low Inertia and High Acceleration
- Vibration Damping and Acoustic Comfort
- Lubrication-Free Operation
- Precise Positioning and Fast Dynamic Response



FIBER LASER

■ Shuttle Table

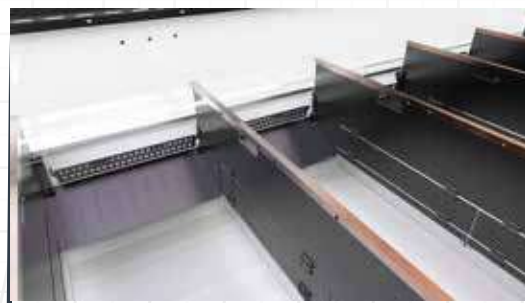
Servo controlled shuttle table system applied to HD-F 3015 (Standard) and HD-F 4020 (Option) series machines reduces the changeover times by 40%.

The shuttle table is fully automatic and maintenance free on all machines. Hydraulic oil is not used and changing the table is fast, soft and has low energy cost.



■ Multi Chambers High Efficient Suction System

With the multi chambers high efficient system offers the ability to make an equal amount of suction during the cutting operation of the whole machine cutting area.



■ Scrap Conveyor

The scrap collection system on the 3015 model is designed as two separate compartments running along the cutting table. In the standard configuration, these compartments are equipped with scrap collection drawers. As an optional feature, the drawers can be replaced with two integrated conveyor systems, one installed in each compartment.

This system enables scrap parts to be removed from the working area as quickly as possible without interrupting the cutting process. In addition, the conveyor system running along the entire length of the 3015 machine is equipped with jam detection and reverse-operation functions, helping to prevent potential part blockages and ensuring continuous operation.



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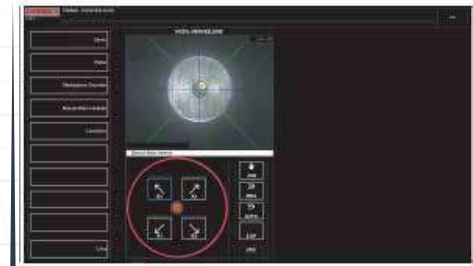
■ Automatic Nozzle Changer (Option)

Automatic nozzle change feature consists of 25 stations. Before starting cutting, the cutting head replaces the existing nozzle with the one that is suitable for cutting, cleans and calibrates and starts cutting. It also monitors nozzle life.



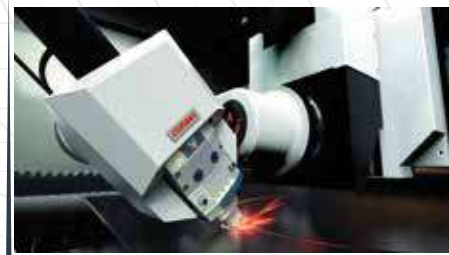
■ Durma Auto Nozzle Centering (Option)

Durma Auto Nozzle Centering is the process of bringing the laser beam to the nozzle center in order to obtain smooth and quality cuts. For this purpose, a camera is placed on the machine. With this camera, the real time position of the laser beam is detected. If the beam is not on the nozzle center then it is automatically adjusted to the center with the 'Durma Auto Nozzle Centering' application.



■ Bevel Head $\pm 45^\circ$ (Option)

Bevel Head for vertical and bevel cuts from 0° to 45° . Optimal results provided through the combination of 5 axis interpolation and software. Positive and negative bevel angles in one part.



■ D-MIX GAS (O2-N2) (Option)

Cutting mildsteel metal is typically done using high-power lasers with a mix gas. This process is performed using a gas mixture consisting of nitrogen and oxygen.

Using a mix gas offers several advantages

- Better cutting results
- Reduction of burrs by 40-70% in medium and thicker mildsteel



FIBER LASER

Control Panel

The controller has a Durma operator interface and a complete cutting database for all standard pipe cutting applications. The database includes the cutting parameters for standard tubes and profiles (steel, stainless steel, aluminium) for common thickness ranges. Based on these reference values the operator can easily improve the cutting quality for different types of materials.



Durma Cloud

Durma Cloud ensures that machines are accessible and inspectable. It stores machine data and allows for its reuse. Advantages include preventive maintenance, calculation of operating vs. downtime and efficiency, real-time status of your machine, remote monitoring without having to visit the machine, generating reports on cut parts, obtaining historical reports by date range, and reviewing error messages and causes. An additional optional feature is cloud file transfer, allowing users to send nested cutting files directly to the machine via the internet. The operator only needs to select the program and press start.



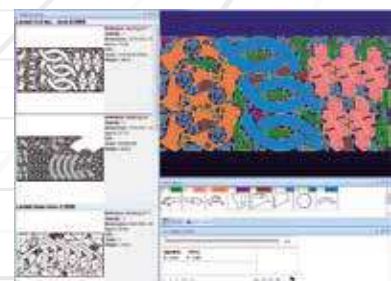
CAD/CAM Software

D-WISE / LANTEK

These are CAD/CAM software specifically designed to automate CNC programming for sheet metal laser cutting machines. They create the most efficient nestings for sheet processing and prepare cutting programs.

- Advanced optimizations
- Fastest cutting and idle motion path calculations to protect the cutting head ceramic parts and prevent sheet deformation
- Real font styles: Fonts supported by the operating system can be directly applied to the material being cut.
- Cutting direction can be clockwise or counterclockwise.
- Advanced corner applications provide perfect corners and high-quality cuts.
- Common Cutting: This feature is especially useful for thick plates and reduces the need for piercing during cutting.

D.WISE



Production is *More Effective Now.*

■ Durma Cloud

Durma Cloud ensures that machines are accessible and inspectable. It stores machine data and allows for its reuse. Advantages include preventive maintenance, calculation of operating vs. downtime and efficiency, real-time status of your machine, remote monitoring without having to visit the machine, generating reports on cut parts, obtaining historical reports by date range, and reviewing error messages and causes.



■ Durma Cloud + File Transfer

An additional optional feature is cloud file transfer, allowing users to send nested cutting files directly to the machine via the internet. The operator only needs to select the program and press start.

■ D-Mobile

Integrated with the Durma Cloud Web application, D-Mobile is a mobile application that you can instantly monitor the data from your machines via mobile phone with its user-friendly interface and comprehensive features.

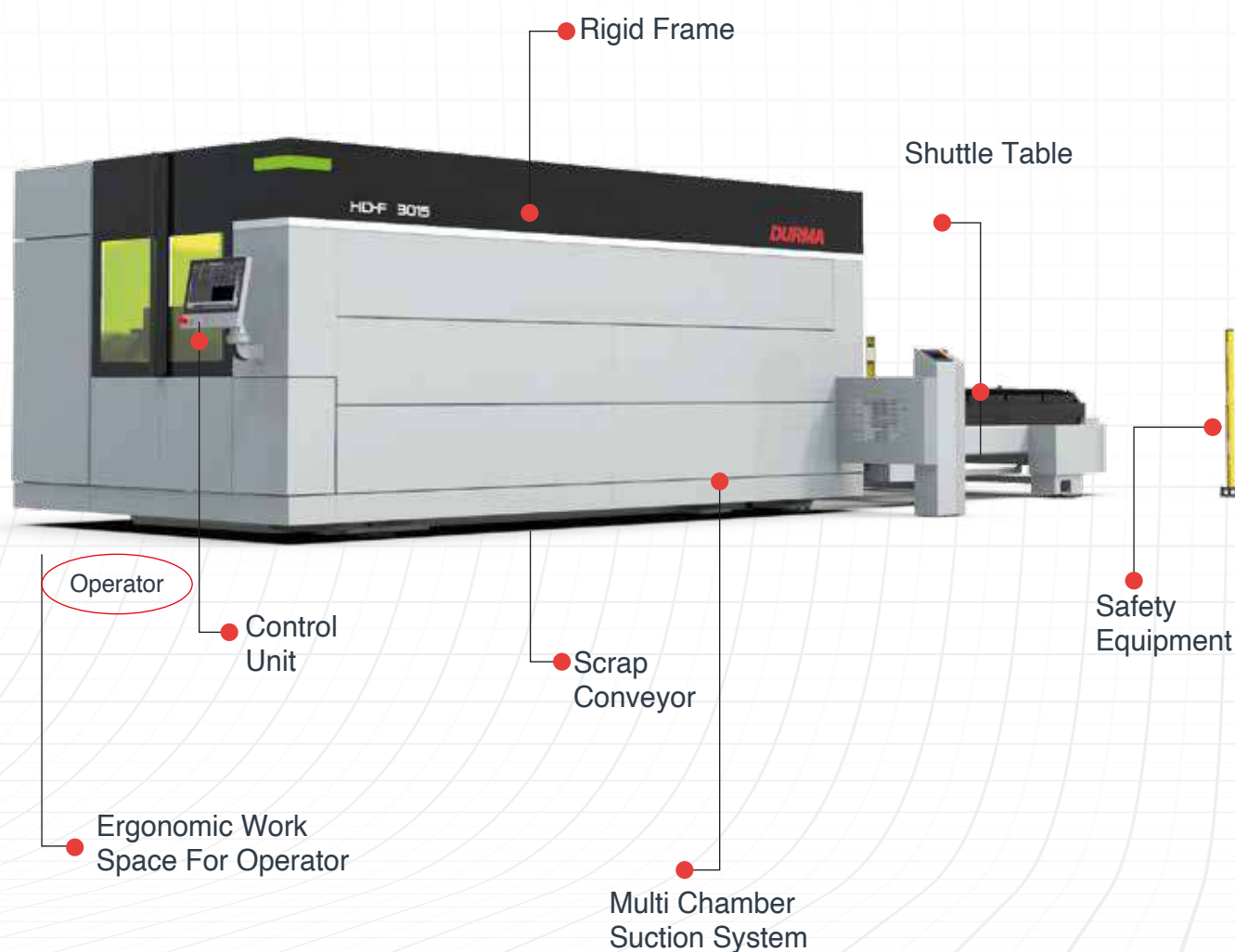


■ Stay informed with instant notifications

Don't miss significant events in the production process. You can instantly intervene in your machine thanks to the notifications such as "last piece in cut", "machine stopped" and "feedrate is running at a value lower than 100%" that you can receive instantly via the D-Mobile application on your smart devices.

FIBER LASER

Experience the Difference with Dynamic DURMA Lasers



Production is *More Effective Now.*

HD-F VI

➤ User Friendly ➤ Ergonomic ➤ Efficient ➤ Fast ➤ Reliable Brand



	3015 VI	4020 VI	6020 VI	6025 VI	
X Axis	10'	13' 5"	20'	20'	
Y Axis	5'	6' 8"	6' 8"	8' 5"	
Z Axis	6.3"	6.5"	6.5"	6.5"	inch
Max. Sheet Size	10' x 5'	13' 5" x 6' 8"	20' x 6' 8'	20' x 8' 4'	
Max. Sheet Weight (Single Table)	98.3	98.3	98.3	98.3	lbs/ft ²
HD-F 3015					
Max. Speed X Axis	393				ft/min.
Max. Speed Y Axis	393				ft/min.
Max.Synchronized Speed (X-Y)	557				ft/min.
Max. Synchronized Acceleration (X-Y)	91				ft/s ²
Positioning Accuracy	±0.002				inch
Repeatability	±0.002				inch

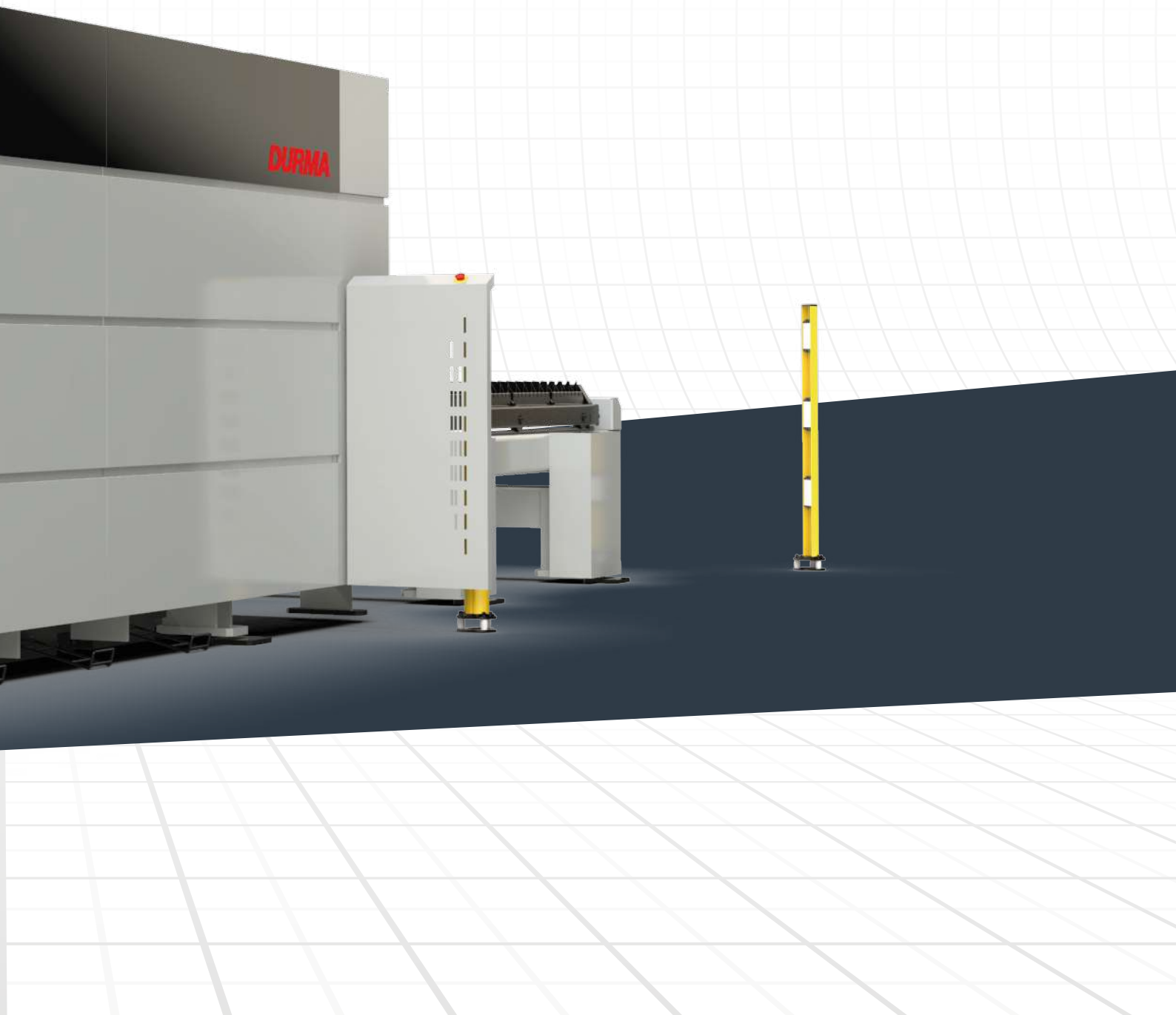
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HD-FN

Price & Performance Advantage in Laser Cutting



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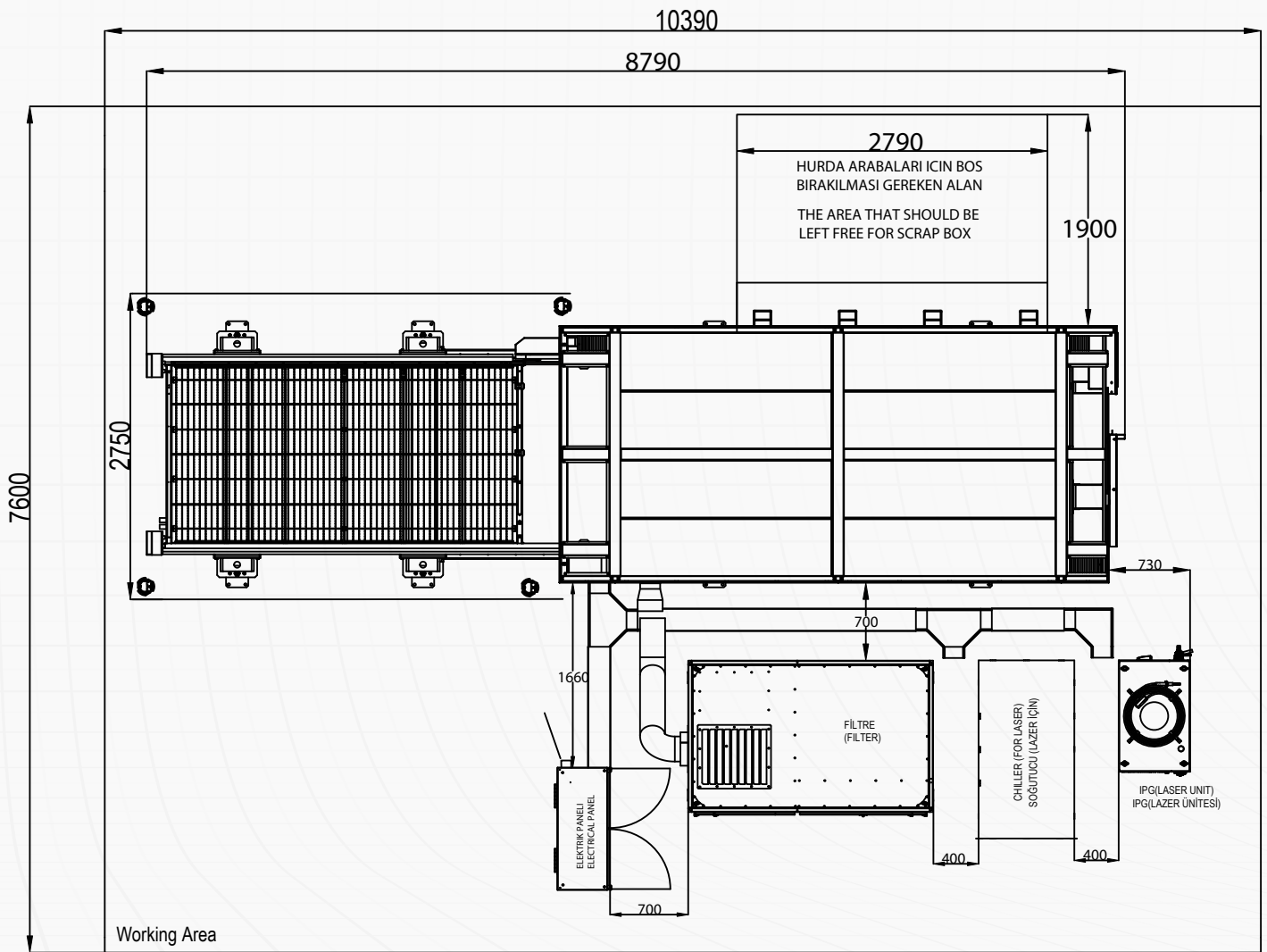
FIBER LASER

- Effective Price and Performance
- Suitable for Increasing Competition
- Laser power up to 20 kW
- High Sensitivity
- Easy to Use and User Friendly
- Easy to Programmable
- Low Operating Cost

	3015	4020	6020	
X Axis	10'	13' 5"	20'	
Y Axis	5'	6' 9"	6' 9"	
Z Axis	4.9 (10.6)	4.9 (10.6)	4.9 (10.6)	inch
Max. Sheet Size	10' x 5'	13' 4" x 6' 8"	20' x 6' 8"	
Max. Sheet Weight (Single Table)	49.4 (3...12kW) 81.6 (15-20kW)	49.4 (3...12kW) 81.6 (15-20kW)	49.4(3...12kW) 81.6 (15-20kW)	lbs/ft ²
HD-FN 3015				
Max. Speed X Axis	328			ft/min.
Max. Speed Y Axis	328			ft/min.
Max.Synchronized Speed (X-Y)	462			ft/min.
Max. Synchronized Acceleration (X-Y)	45			ft/s ²
Positioning Accuracy	±0.002			inch
Repeatability	±0.002			inch

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HD-FN 3015



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HD-FO FIBER LASER



*Production is **More Effective Now.***

➤ User
Friendly

➤ Ergonomic

➤ Efficient

➤ Fast

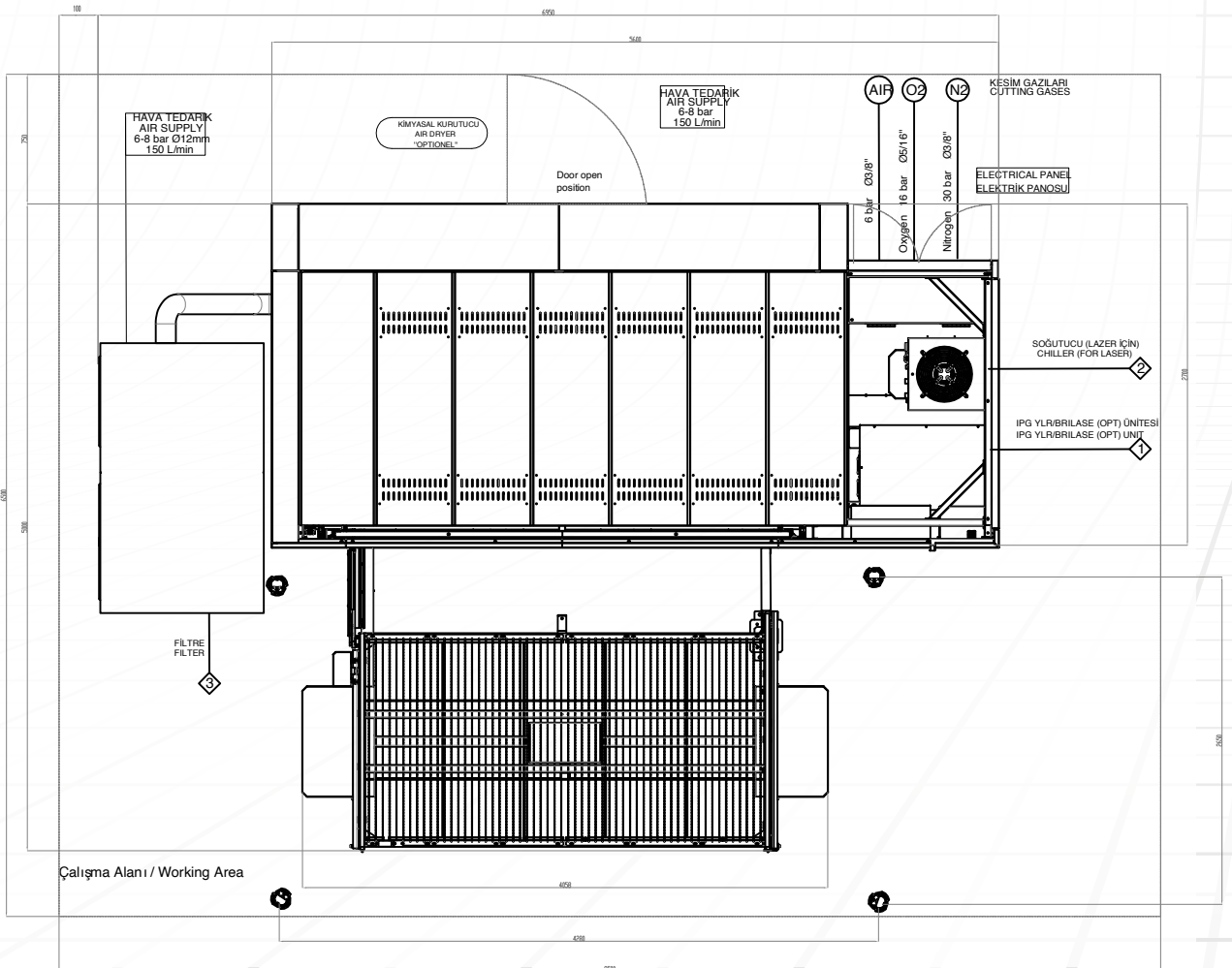
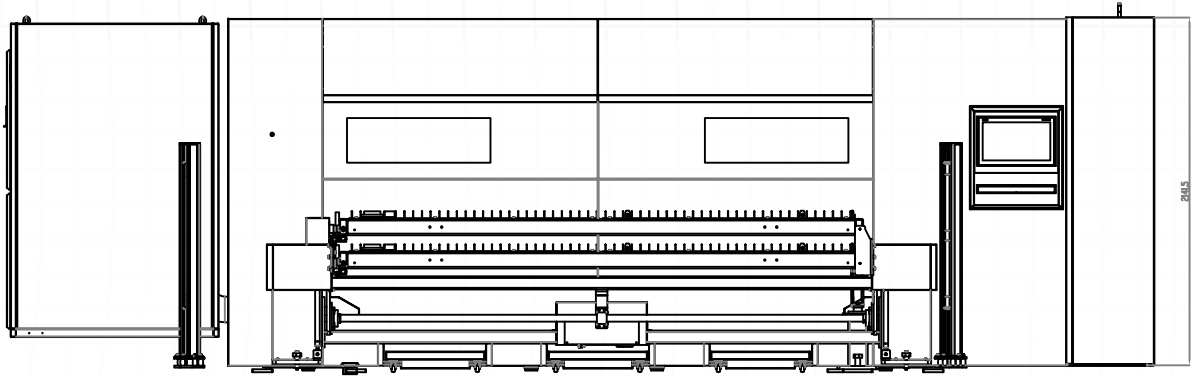
➤ Reliable
Brand



FIBER LASER

SPECIFICALLY DESIGNED ACCORDING TO LAYOUT

- User Friendly
- Low Operating Costs
- Quick Opening Front Door
- Easy Access To Cutting Area Compact Bridge
- Design
- Fast Packing & Delivery



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HD-FO FIBER LASER

HD-FO Technical Specifications		
X Axis	5'	
Y Axis	10'	
Z Axis	5.5"	inch
Max. Sheet Size	10' x 5'	
"Max. Sheet Weight (For Each Table)"	1609	lbs
Dynamic		
Max. Speed X Axis	295	ft/min.
Max. Speed Y Axis	295	ft/min.
Max. Speed Z Axis	98	ft/min.
Max.Synchronized Speed (X-Y)	416	ft/min.
Max. Synchronized Acceleration (X-Y)	45	ft/s2
Positioning Accuracy	± 0.002	inch
Repeatability	± 0.002	inch

FIBER LASER

■ MANUAL CUTTING TABLE

The machine is designed especially for customers who have layout problems. Sheet loading and unloading is extremely easy in cases where no shuttle table is needed.



■ COMPACT, MODERN AND ERGONOMIC LAYOUT

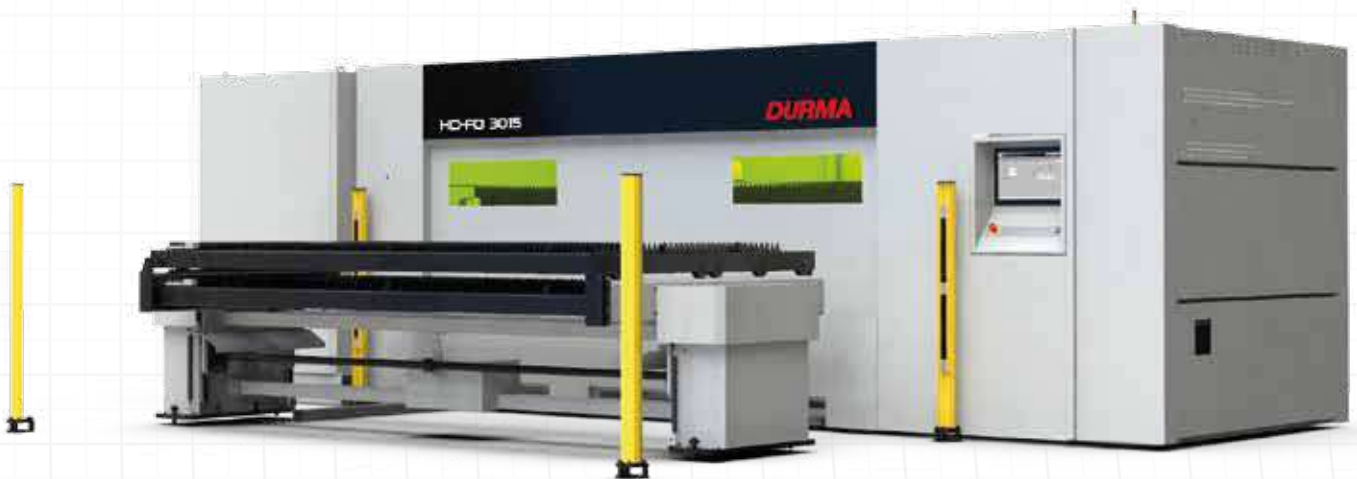
Thanks to the compact layout of the machine, sheet loading, cutting and unloading operations are performed by using less space and less operations.



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■ **PNEUMATIC SHUTTLE TABLE (Option)**

The machine is designed especially for customers who have layout problems. Sheet loading and unloading is extremely easy in cases where no shuttle table is needed.



■ **EASY ACCESS TO CUTTING AREA WITH BACK DOOR**

Rear door for use when cutting is required. This rear door is also used during machine maintenance



FIBER LASER

HD-FA 5 AXIS LASER



Production is *More Effective Now.*

➤ User
Friendly

➤ Ergonomic

➤ Efficient

➤ Fast

➤ Reliable
Brand



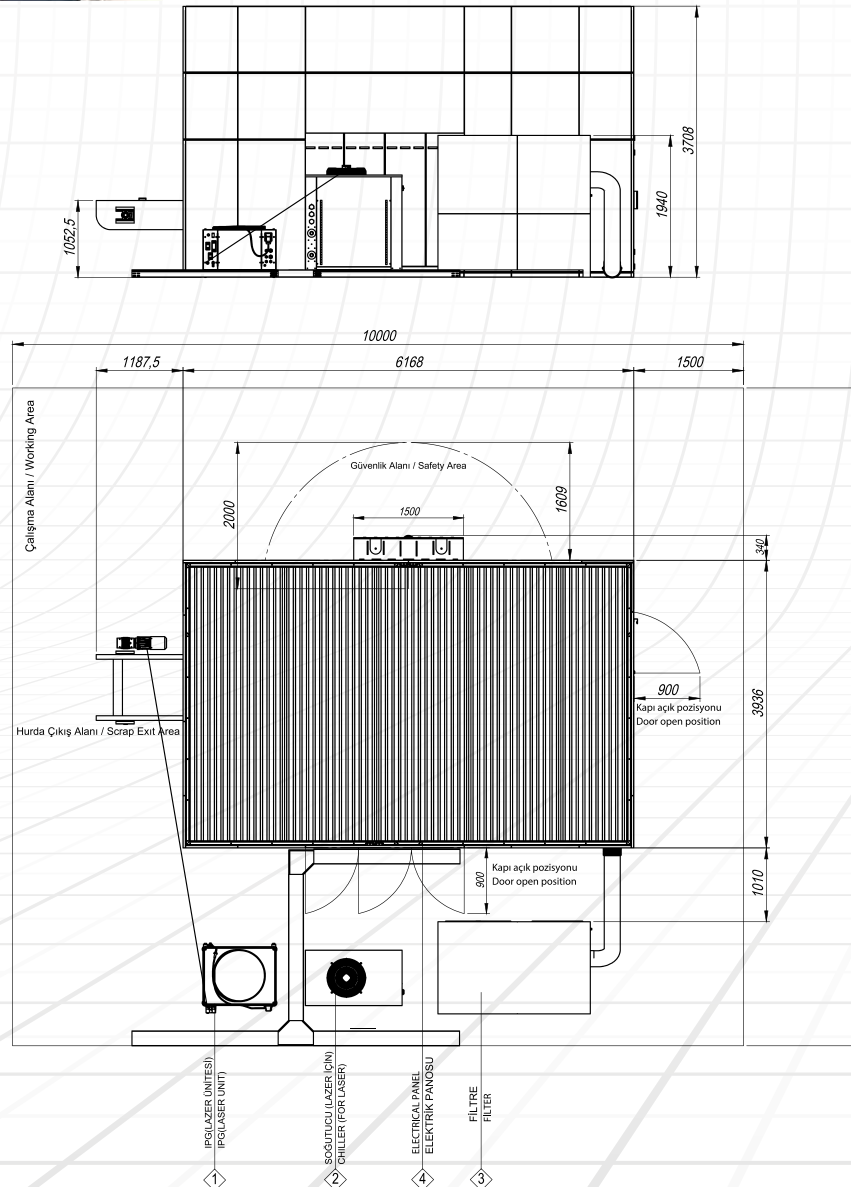
FIBER LASER

THE 5 AXIS FIBER LASER SYSTEM

DURMA 5 axis fiber laser system will be your best partner for automotive and any other high-sense and 3D complex part production. +%25 increased processing space due to same concept machines. For gratify cutting performance, strong machine frame and rotary table provide best quality.



- Modern and Compact Design
- Easy to use Fixture
- Globally High Performance Components
- High Quality 3D Cutting
- Low Energy Consumption
- Faster, Reliable, Efficient



HD-FA Technical Specifications

X Axis Stroke	10'	
Y Axis Stroke	5'	
Z Axis Stroke	25,6	inch
B Axis	±135	°
C Axis	±360	°xn
Max. Synchronous Speed	567	ft/min.
Max. Synchronous Acceleration	56	ft/s2
Positional Accuracy	±0.003	inch
Repeatability	±0.003	inch

Machine Dimensions

Machine Size	20' 3" x 12' 11" h= 12' 2"	
Working Area	29' 6" x 32' 9" (Secure Area)	
Rotary Table's Door Length	13'1 "	
Machine Weight	35274	lbs

Cutting Thickness

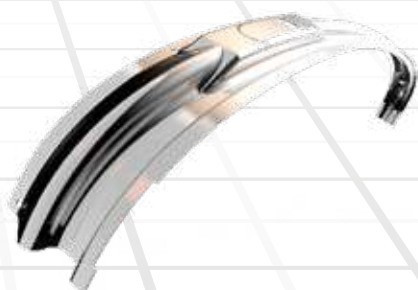
Material (Cutting Capacity)*	3 kW	4 kW
Mildsteel (S235)	0.625 inch	0.75 inch
Stainless Steel (304)	0,31 inch	0.375 inch
Aluminium (5083)	0,31 inch	0.5 inch
Copper (CU)	0,31 inch	0.375 inch
Brass (CUZN39 PB3)	0,20 inch	0.25 inch

Cutting Head

Type	3D	
Focus	Automatic	

*Standard cutting parameters.

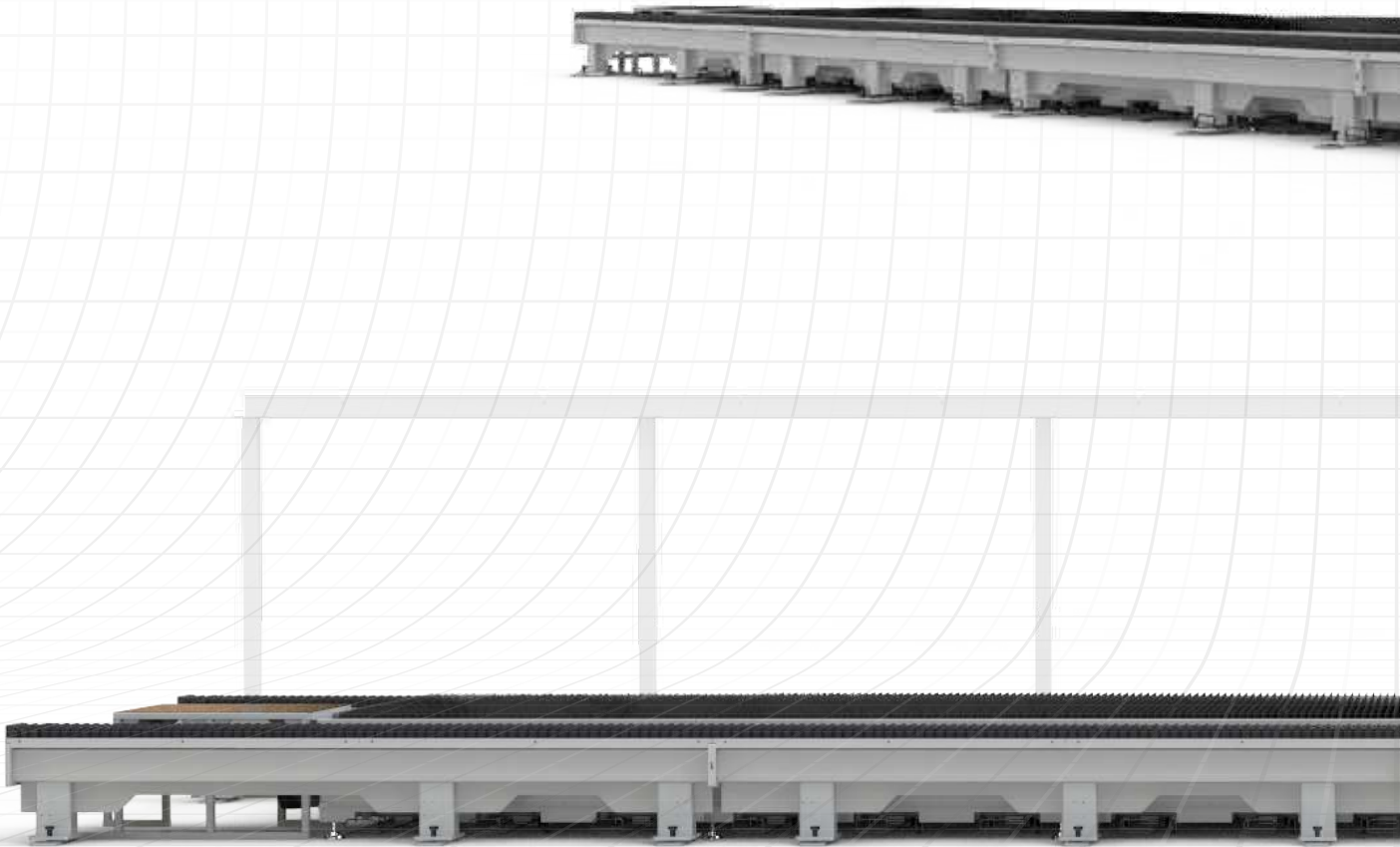
Factors such as rust, shell formation, paint, label, pitch shifts on the surface, rolling defects, rusts on the surface of the material, affect the black sheet cutting negatively. The top and bottom surfaces of the material to be cut must be clean. The cutting quality and cutting speeds of sandblasted sheets vary.



FIBER LASER

SPECIAL APPLICATIONS

Turkey's Biggest and Fastest Laser



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HD-F 20030

Cutting Length 65' 7.4"

Cutting Width 9' 10.1"

Power 20 kW

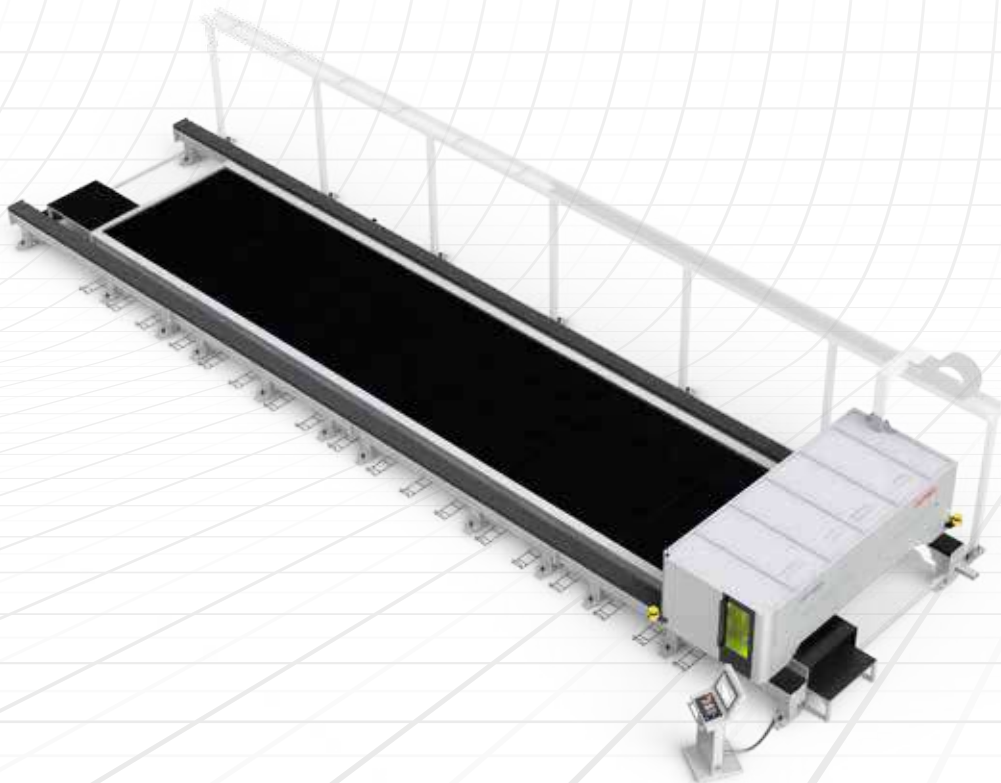
Bevel +/- 45° Cutting Option



FIBER LASER

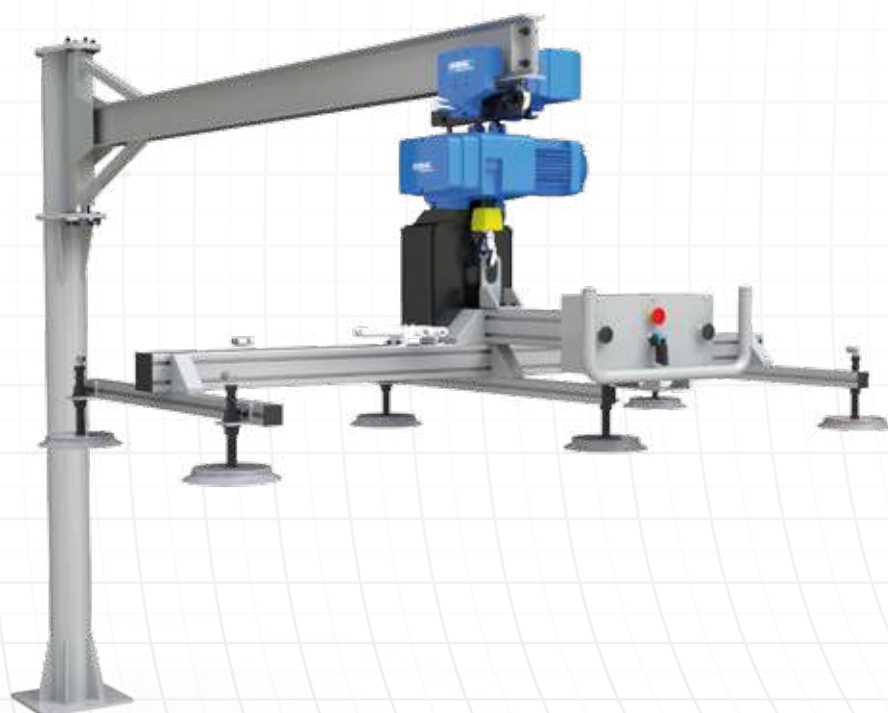
HD-F 20030

HD-F 20030 Technical Data		
X Axis	66'	inch
Y Axis	10'	inch
Z Axis	6.49"	inch
Max. sheet size	66'x10'	inch
Max. Speed X Axis	196	ft/min
Max. Speed Y Axis	196	ft/min
Max. Speed Z Axis	98	ft/min
Max.Synchronized Speed (X-Y)	278	ft/min
Max. Synchronized Acceleration (X-Y)	45	ft/s2
Positioning Accuracy	±0.002	inch



Automatic Loading – Unloading Units Solutions For Your Process

- Manual loading-unloading systems
- Semi automatic loading-unloading systems
- Automatic loading-unloading systems



M-LOADER 3015 / 4020			
Technical Data	3015	4020	
Sheet Length (Max.)	10'	1' 7,6" - 13' 1,4"	inch
Sheet Width (Max.)	5'	1' 7,6" - 6' 6,7"	inch
Sheet Thickness	0,375	0,25	inch
Max. Loading Capacity	794	992	lbs
Vacuum Pad Qty.	6	8	pcs.
Rotation angle (Max.)	260	260	°
Consumption Values			
Electricity	0.67	0.67	hp
Compressed Air	1.76	1.76	cfm
Compressed Air	101	101	psi

FIBER LASER



D-LOADER 3015 / 4020

Technical Data	3015	4020	
Sheet Length (Max.)	1' 7.6" - 10'	1' 7.6" - 13' 1.4"	
Sheet Width (Max.)	1' 7.6" - 5'	1' 7.6" - 6' 6.7"	
Sheet Thickness	0.02 - 1.00	0.02 - 1.00	inch
Max. Loading Capacity	1980	3530	lbs
Vacuum Pad Qty.	12	18	pcs.
Total Cycle Time	"60-75 (depends on loading height)"	"60-85 (depends on loading height)"	sec.
Working Area	13' 9" x 13' 5" h= 7' 5"	18' 1" x 17' 8" h= 8' 11"	
Rotation angle (Max.)	90	90	°
Electricity	4.02	5.36	hp
Compressed Air	3.53	5.89	cfm
Compressed Air	101	101	psi

- COMPACT DESIGN
- Space-Saving
- Easy Integration
- Cost-Effective Solution
- Low Maintenance Cost

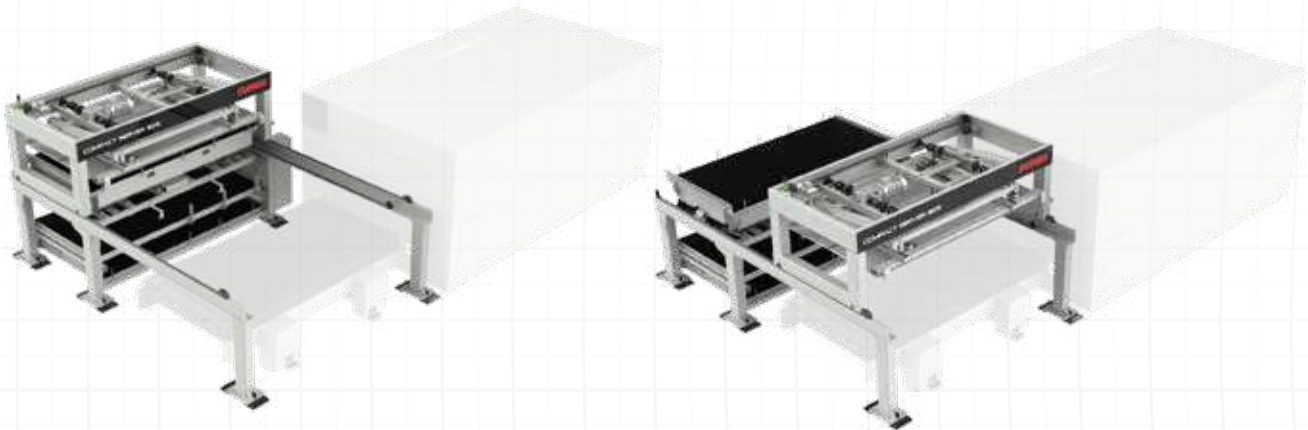


COMPACT SERVER (H Type)

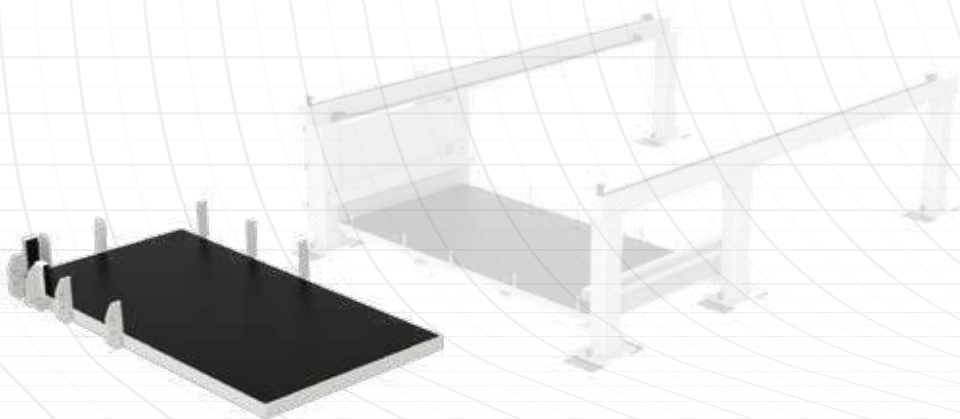
Technical Data	3015	4020	
Min. Sheet Size	2' 8" x 2' 8"	2' 8" x 2' 8"	
Length	3' 4", 5', 6' 8", 8' 2", 10'	3' 4", 5', 6' 8", 8' 2", 10' 11' 6", 13' 4"	
Width	3' 4", 4' 1" - 5"	3' 4", 4' 1" - 5", - 6' 8"	
Thickness	0.02" - 1"	0.02" - 1"	inch
Max. Sheet Size	10' x 5'	13' 5" x 6' 8"	
Max. Sheet Load	11,023	14,330	lbs
Max. Sheet Stack Height	9.84	9.84	inch
Cycle Time	60	70	sec.
Unloading Station Max. Stack Height	3.35	3.35	inch
Unloading Station Max. Stack Weight	6,613	8,818	lbs
Double Sheet Dedector	yes	yes	
Sheet Separation System	yes	yes	

*Production is **More Effective Now.***

AUTOMATIC FORK MOVEMENT OPTION



ADDITIONAL SHELF OPTION



Operational Continuity and High Production Capacity

Enhances production capacity with uninterrupted loading and unloading operations. The machine can continue operating while the unloading process is in progress

FIBER LASER



DURMA RAPID SERVER 3015 / 4020 (H Type)				
Technical Data	3015	4020	6020	
Min. Sheet Size	3' 4" - 3' 4"	3' 4" - 3' 4"	3' 4" - 3' 4"	
Length	3' 4" - 5' - 6' 8" - 8' 2" - 10'	3' 4"- 5', 6' 8"- 8' 2"- 10' - 11' 6"- 13' 4"	3' 4"- 5' - 6' 8" - 8' 2" - 10' - 11' 6" - 13' 4" - 19' 8"	
Width	3' 4" - 4' 1" - 5'	3' 4" - 4' 1" - 5' - 6' 8"	3' 4" - 4' 1" - 5' - 6' 8"	
Thickness	0.02 - 1	0.02 - 1	0.02 - 1	inch
Max. Sheet Size	10' x 5'	13' 4" x 6' 8"	20' x 6' 8"	
Max. Loadable Sheet Loading Weight	11,000 lbs	13,220	19,840	lbs
Max. Sheet Loading Height	9,8	9,8	9,8	inch
Cycle Time	50	60	80	sec.
Dual Sheet Sensor	yes	yes	yes	
Sheet Separation System	yes	yes	yes	

Production is *More Effective Now.*



DURMA RAPID TOWER 3015 / 4020 / 6020 (H Type)

Technical Specifications	3015	4020	6020	
Min. Sheet Size	3' 4" - 3' 4"	3' 4" - 3' 4"	3' 4" - 3' 4"	
Length	3' 4" - 5' - 6' 8" - 8' 2" - 10'	3' 4" - 5', 6' 8" - 8' 2" - 10' - 11' 6" - 13' 4"	3' 4" - 5' - 6' 8" - 8' 2" - 10' - 11' 6" - 13' 4" - 19' 8"	
Width	3' 4" - 4' 1" - 5'	3' 4" - 4' 1" - 5' - 6' 8"	3' 4" - 4' 1" - 5' - 6' 8"	
Thickness	0,02 - 1	0,02 - 1	0,02 - 1	inch
Max. Sheet Size	10' x 5'	13' 4" x 6' 8"	20' x 6' 8"	
Max. Sheet Metal Loading Weight That Can Be Loaded On The Pallet	6,614	8,818	11,023	lbs
Pallet Numbers	10	10	10	pcs.
Total Loadable Sheet Weight	66,138	88,184	110,231	lbs
Max. Sheet Loading Height	3,35	3.35	3.35	inch
Cycle Time	50	60	80	sec.
Dual Sheet Sensor	yes	yes	yes	
Sheet Separation System	yes	yes	yes	
Electric Power	30.8	50.9	53.6	hp
Compressed Air	49.4	49.4	49.4	cfm
Compressed Air	101	101	101	psi

FIBER LASER

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Industrial Machines



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Product Groups

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