

AD-S

Hydraulic Press Brakes

Series



Perfect
Precision



Deep And
Fast Bending



Efficient



Winning



Elegant
Design



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 1.615.000 ft², 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

AD-S

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



Production is *More Effective Now.*

AD-S Series Hydraulic Press Brake



Perfect and Fast Bending

Perfect components for precision

With Easy to use control unit, stable 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.



Why DURMA Press Brakes

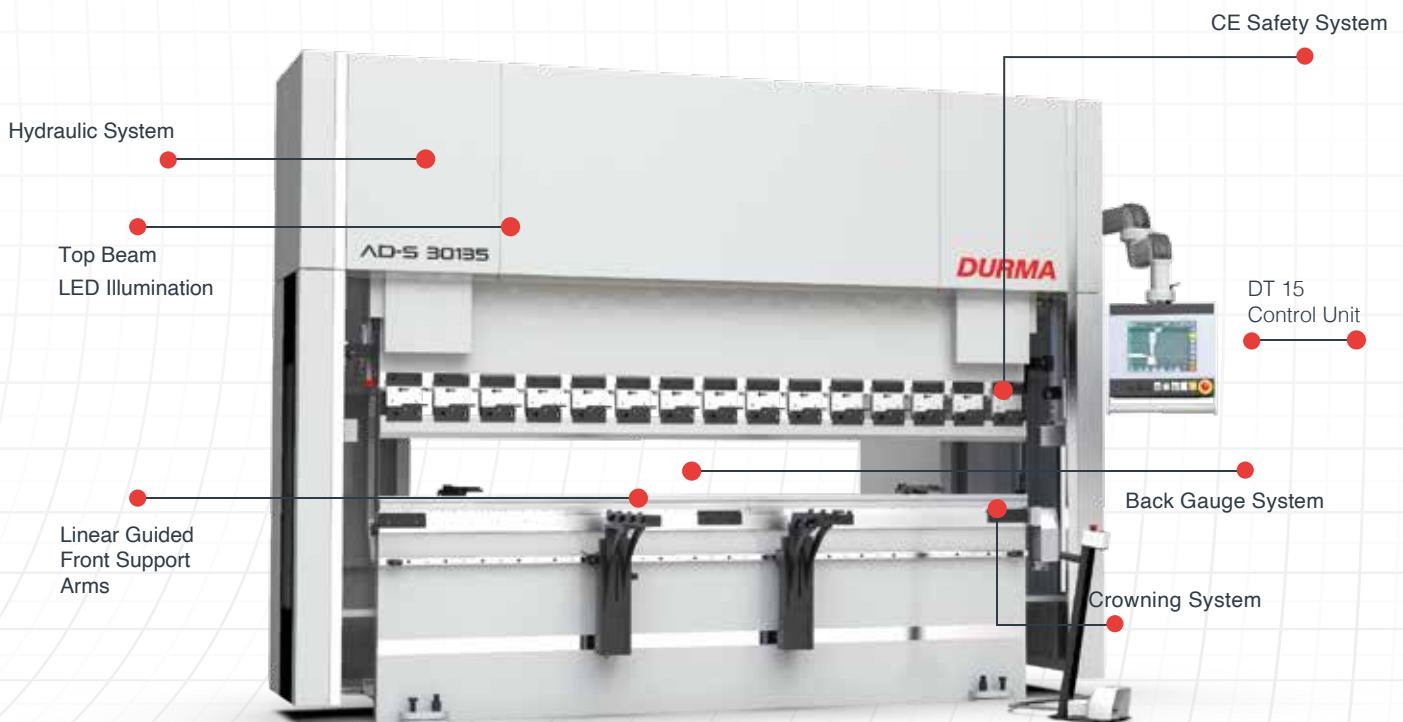
- Better and faster bending
- Stronger and rigid body structure
- High sensitivity and repeatability
- High technology excellent equipment
- Low service cost
- Reliability



AD-S

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.



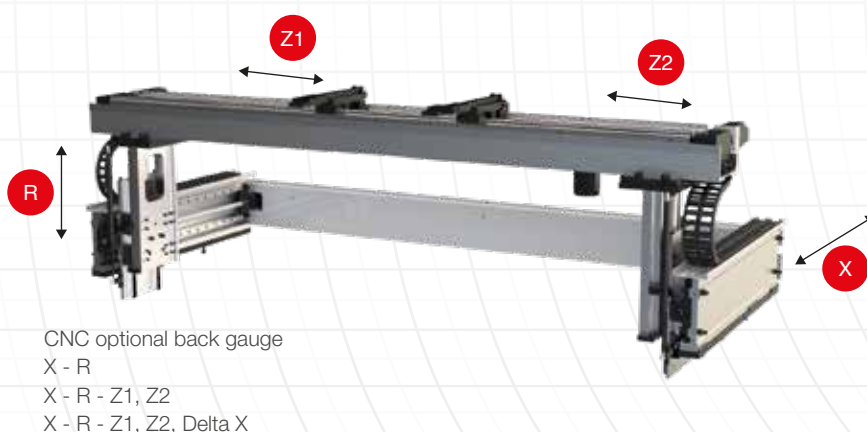
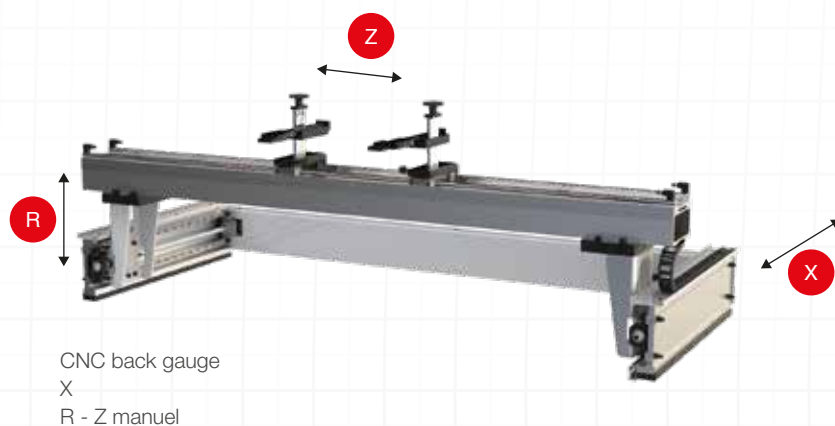
General Specifications

- 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 SYSTEM

- Precise
- Reliable
- Strong

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

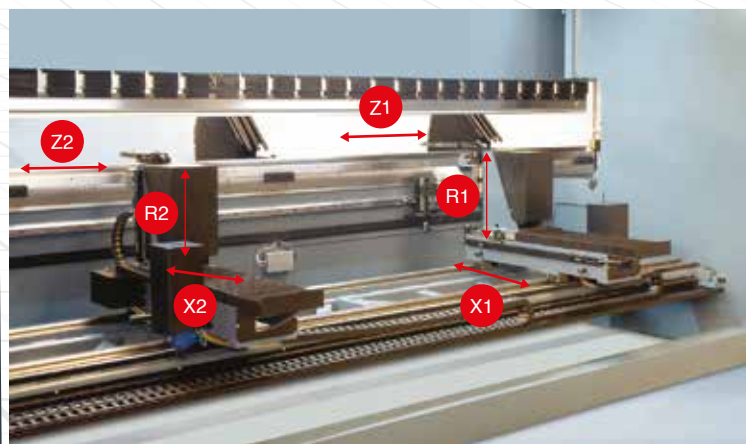


Why DURMA Back Gauge ?

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 **double ballscrew** back gauge system movement is also supported with **double 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

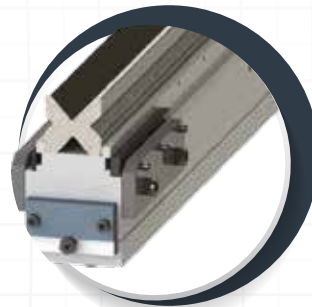
TOOL HOLDERS AND TOOLS

Bending performance 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.



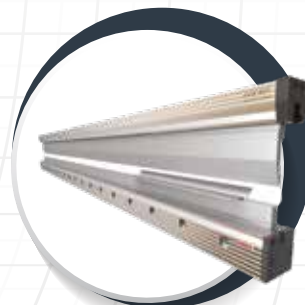
European
Clamping System



European Type
Bottom Tool (4V Die)



Quick
Release Clamping



DURMA Hydraulic
Holder



DURMA Top
Tool Holder

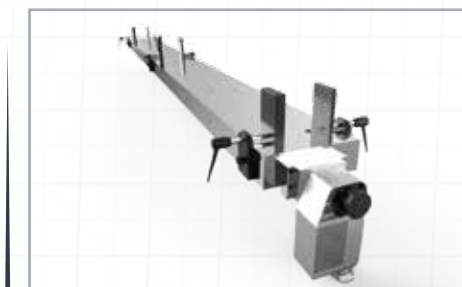


DURMA Multi
V Bottom Tool

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

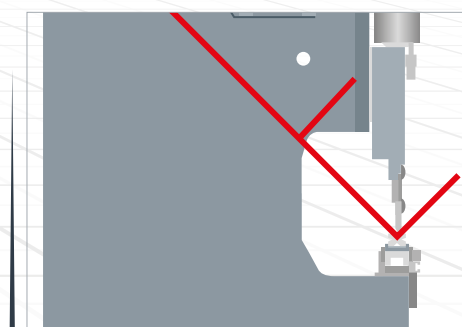
Our machines are designed in accordance with CE-Norms to ensure your safety with hydraulic, electric, appropriate height covers and laser light curtains. CE safety in tandem machines are also provided with light barriers.



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

BENDING IS MORE EASIER NOW

■ SKY 22 (Optional)



- 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
- Robot integration compatible

■ DT 15 (Standard)



- Ergonomic panel design
- 15" 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

■ DA-66S (Option)



- 2D graphical touch screen programming mode
- 3D visualisation in simulation and production
- 24" 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

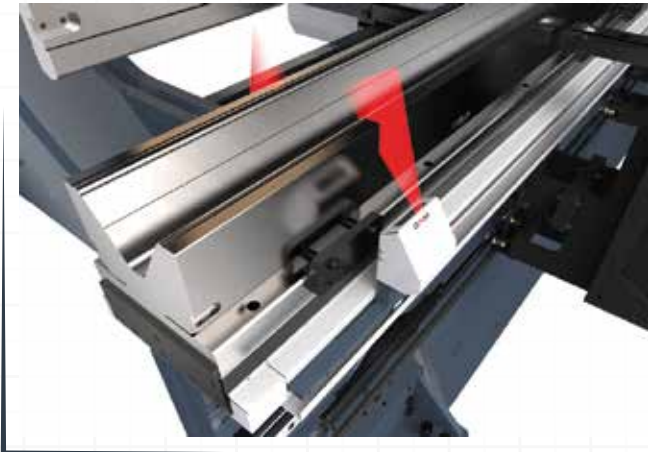
■ DA-69S (Option)



- 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 sequence calculation for 2D/3D
- DXF part & tool import support

Production is *More Effective Now.*

■ Durma Angle Measurement System



■ Automatic AP3 - AP4 Sheet Follower



■ Robotic System Applications





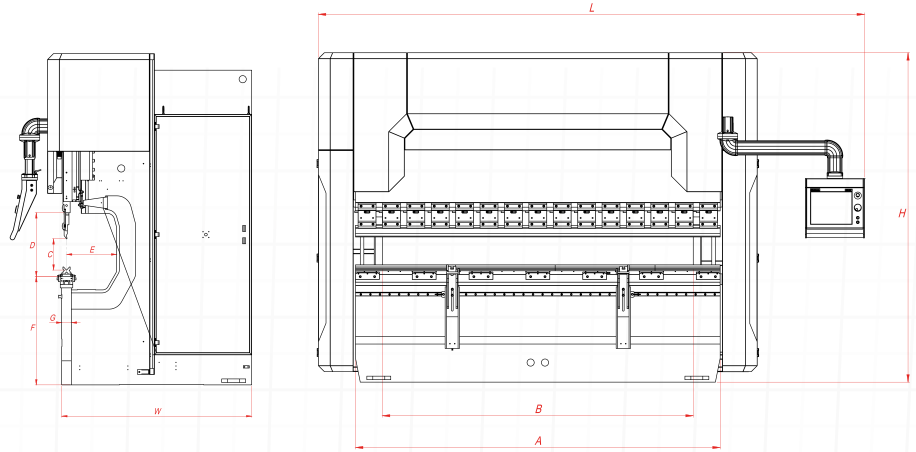
SPECIAL PROJECTS



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)	Y Rapid Speed	Y Working Speed	Y Return Speed	Y Axes Precision	X Axes Working Speed
Unit	US ton	ft A	ft B	inch C	ft D	ft E	ft F	ft. G	inch/sec.	inch/sec.	inch/sec.	inch/sec.	inch/sec.
AD-S 1260	66	4'1.2"	3'5.3"	6.3"	1'3.7"	1'1.8"	2'11.4"	4.1"	7.9"	0.4"	4.3"	0,0004	1'7.7"
AD-S 2060	66	6'8.7"	5'6.9"	10.4"	1'8.9"	1'5.7"	2'11.4"	4.1"	7.9"	0.4"	4.3"	0,0004	1'7.7"
AD-S 25100	110	8'4.4"	7'2.6"	10.4"	1'8.9"	1'5.7"	2'11.4"	4.1"	7.1"	0.4"	4.7"	0,0004	1'7.7"
AD-S 30100	110	10'0.1"	8'6.4"	10.4"	1'8.9"	1'5.7"	2'11.4"	4.1" / 7.1"	7.1"	0.4"	4.7"	0,0004	1'7.7"
AD-S 30135	148,5	10'0.1"	8'6.4"	10.4"	1'8.9"	1'5.7"	2'11.4"	4.1" / 7.1"	6.3"	0.4"	4.7"	0,0004	1'7.7"
AD-S 30175	192,5	10'0.1"	8'6.4"	10.4"	1'8.9"	1'5.7"	2'11.4"	4.1" / 9.4"	6.3"	0.4"	3.9"	0,0004	1'7.7"
AD-S 30220	242	10'0.1"	8'6.4"	10.4"	1'8.9"	1'5.7"	2'11.4"	4.1" / 9.4"	5.5"	0.4"	5.5"	0,0004	1'7.7"
AD-S 30320	352	10'0.1"	8'6.4"	1'2.4"	2'0.8"	1'5.7"	2'11.4"	6.1" / 11.8"	6.3"	0.4"	5.5"	0,0004	1'7.7"
AD-S 37220	242	12'1.7"	10'2"	10.4"	1'8.9"	1'5.7"	2'11.4"	4.1" / 9.4"	6.3"	0.4"	4.7"	0,0004	1'7.7"
AD-S 40175	192,5	13'3.4"	11'9.7"	10.4"	1'8.9"	1'5.7"	2'11.4"	4.1" / 9.4"	6.3"	0.4"	5.5"	0,0004	1'7.7"
AD-S 40220	242	13'3.4"	11'9.7"	10.4"	1'8.9"	1'5.7"	2'11.4"	4.1" / 9.4"	6.3"	0.4"	5.5"	0,0004	1'7.7"
AD-S 40320	352	13'3.4"	11'9.7"	1'2.4"	2'0.8"	1'5.7"	2'11.4"	6.1" / 11.8"	6.3"	0.4"	5.5"	0,0004	1'7.7"
AD-S 40400	440	13'3.4"	11'1.9"	1'2.4"	2'0.8"	1'8.1"	3'5.3"	6.1" / 11.8"	5.5"	0.3"	4.7"	0,0004	1'1.8"
AD-S 60220	242	19'10.2"	16'8.8"	10.4"	1'8.9"	1'5.7"	3'5.3"	6.1" / 11.8"	5.5"	0.4"	4.7"	0,0004	1'1.8"
AD-S 60400	440	19'10.2"	16'8.8"	1'2.4"	2'0.8"	1'8.1"	4'	6.1" / 11.8"	4.7"	0.3"	3.9"	0,0004	1'1.8"

Production is *More Effective Now.*

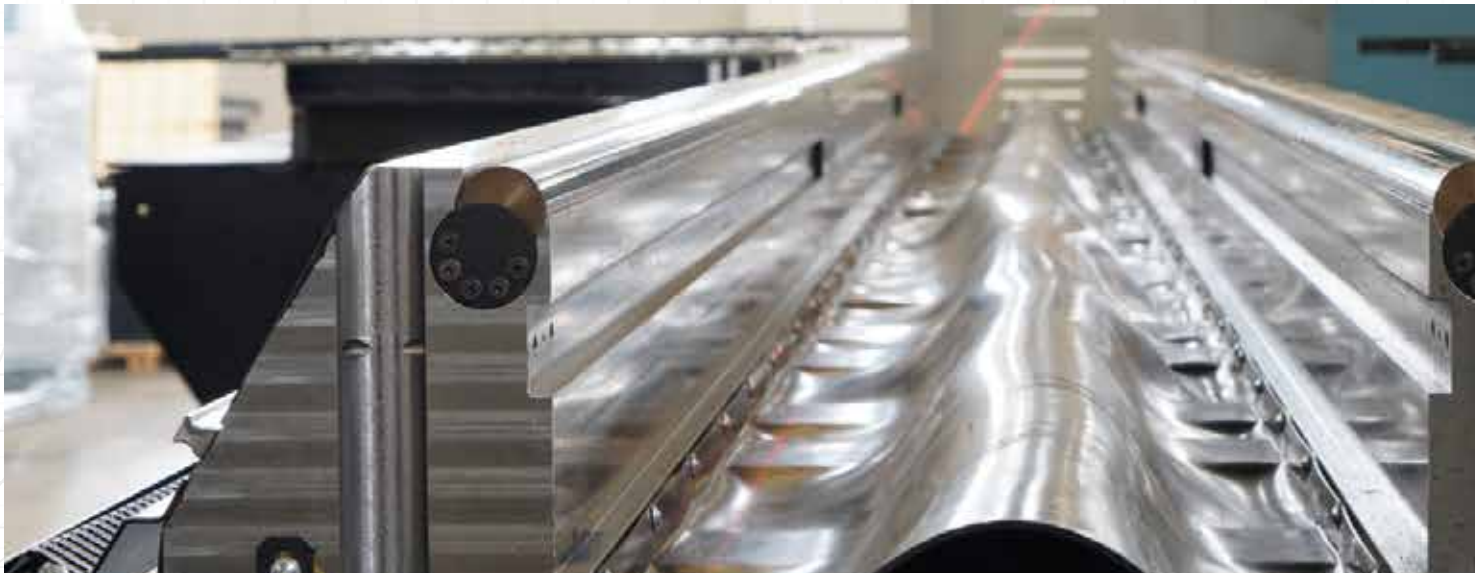


X Axes Precision	X Axis Dimentions			R Axes Working Speed	R Axes Working Distance	R Axes Precision	Z Axes Working Speed	Z Axes Working Distance	Motor Power Consumption Ratio	Oil Tank Capacity	Length	Width	Height	Weight Approx.
	25,6	29,5	39,4											
inch	inch	inch	inch	ft.	inch	inch	inch/sec.	ft	hp	gal	ft	ft	ft	lbs
0,002	S	-	O	1'1.8"	9.8"	0,0004	3'3.4"	1'7.3"	10,1	26,4	7'6.6"	5'1"	7'8.5"	10360
0,002	S	-	O	1'1.8"	9.8"	0,0004	3'3.4"	3'7.3"	10,1	26,4	10'6"	5'1"	9'4.2"	12345
0,002	S	-	O	1'1.8"	9.8"	0,0004	3'3.4"	5'2.2"	14,7	26,4	12'5.6"	5'5.7"	9'4.2"	17195
0,002	S	-	O	1'1.8"	9.8"	0,0004	3'3.4"	6'6.3"	14,7	26,4	13'9.4"	5'5.7"	9'4.2"	18740
0,002	S	-	O	1'1.8"	9.8"	0,0004	3'3.4"	6'6.3"	20,1	39,6	13'9.4"	5'6.1"	9'4.2"	21120
0,002	S	-	O	1'1.8"	9.8"	0,0004	3'3.4"	6'6.3"	24,8	66	13'11.3"	5'6.9"	9'4.2"	24030
0,002	S	-	O	1'1.8"	9.8"	0,0004	3'3.4"	6'6.3"	29,5	66	13'11.3"	5'9.7"	9'10.1"	27780
0,002	S	-	O	1'1.8"	9.8"	0,0004	3'3.4"	6'6.3"	49,6	66	14'1.3"	5'11.7"	10'11.1"	37700
0,002	S	-	O	1'1.8"	9.8"	0,0004	3'3.4"	7'9.5"	29,5	66	16'2.9"	5'9.7"	9'10.1"	31835
0,002	S	-	O	1'1.8"	9.8"	0,0004	3'3.4"	9'6.6"	24,8	66	17'2.7"	5'6.9"	9'4.2"	28175
0,002	S	-	O	1'1.8"	9.8"	0,0004	3'3.4"	9'6.6"	29,5	66	17'2.7"	5'9.7"	9'10.1"	32520
0,002	S	-	O	1'1.8"	9.8"	0,0004	3'3.4"	9'6.6"	49,6	66	17'4.7"	6'3.2"	10'11.1"	44090
0,002	-	S	O	11.8"	9.8"	0,0004	3'3.4"	8'9.1"	49,6	132,1	18'10.4"	6'11.1"	11'11.3"	61200
0,002	-	S	O	11.8"	9.8"	0,0004	3'3.4"	14'5.2"	29,5	66	24'7.3"	5'9.7"	10'11.9"	45855
0,002	-	S	O	11.8"	9.8"	0,0004	3'3.4"	14'5.2"	49,6	132,1	24'7.3"	6'11.1"	12'6"	76280

S : Standard

O : Optional

AD-S



Production is *More Effective Now.*



STANDARD & OPTIONAL EQUIPMENT

Standard Equipment

Control Unit - DT 15
Y1, Y2, X - 3 Axis CNC Control
Manual F. AKAS FPBS Security System
Servo Motor Backgauge - Linear Guided & Ballscrew System (X)
Manual Crowning System
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 - SKY 22 / DA-66S / DA-69S
Manual F. AKAS FPSC Security System
F.AKAS LC-5 Security System
Motorized F. AKAS - 5P FPSC (Safety PLC)
CE F.AKAS BLVT Light Barrier and Safety Cages (For Tandem Press Brakes)
Motorized X, R Axis Backgauge System
Motorized X, R, Z1, Z2 Axis Backgauge System
Motorized X1, X2, R1, R2, Z1, Z2 Axis Backgauge System
Delta X-Axis +/- 4.92" stroke
X-Axis = 40" - Light Barrier Back Protection
"AP3-AP4 Automatic Sheet Follower System - Motorized Elevation Adjustment
(There is a motorized elevation adjustment for 242 US tons or more.)"
CNC Control Motorized Crowning System
Durma Laser Angle Measurement (DAM)
DBEND 3D Bending Simulation Program
Quick Release Clamping System
Hydraulic and Pneumatic Tool Clamping Systems
Parking Area for Support Arms
Central Lubrication System (Manual / Automatic)
Oil Cooler / Oil Heater
Additional Backgauge Finger and Sliding Front Support Arms
Robot Integration
Special Packing for Overseas Shipments

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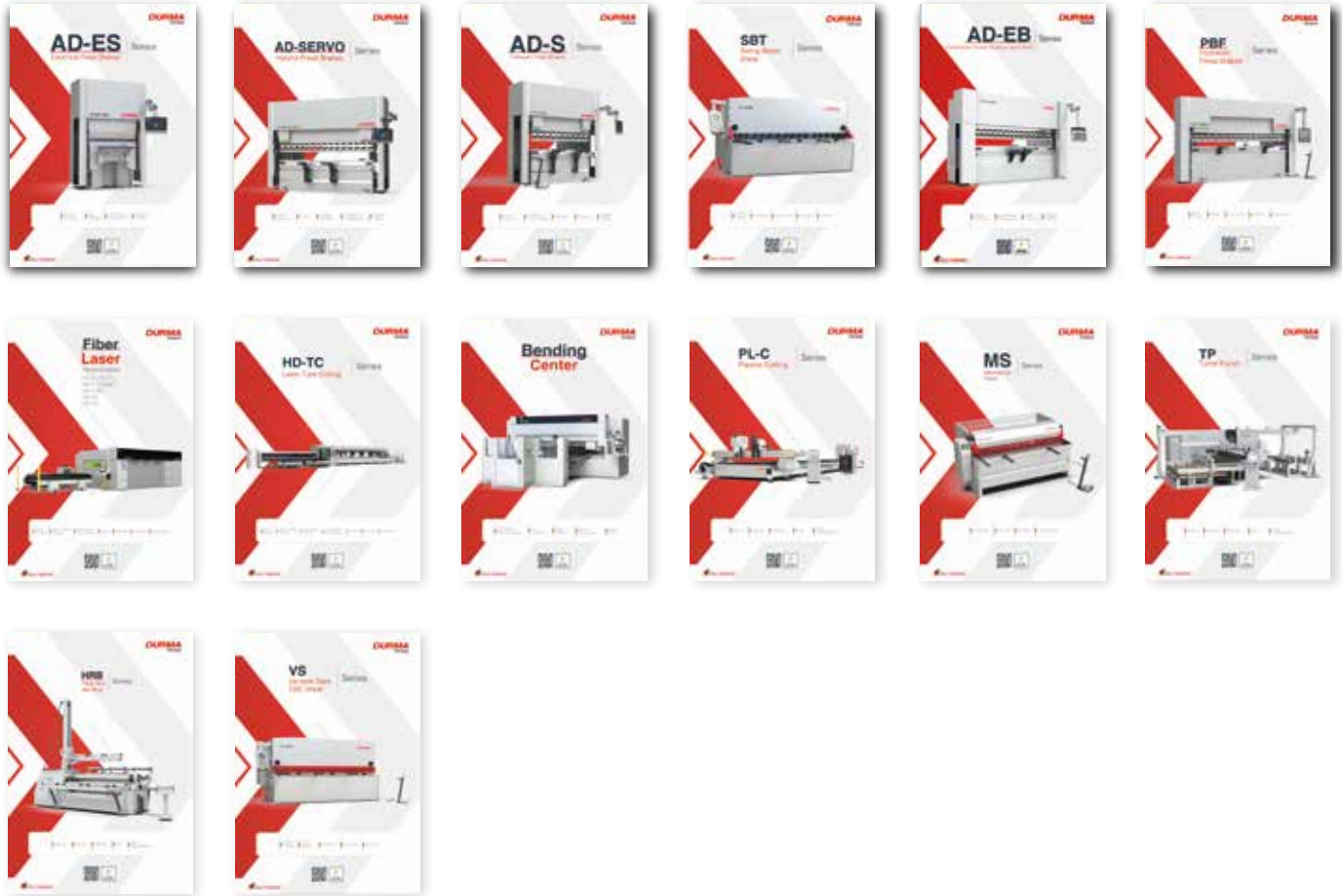
FAST ON SERVICE AND SPARE PARTS

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.



Product Groups

DURMA



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

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