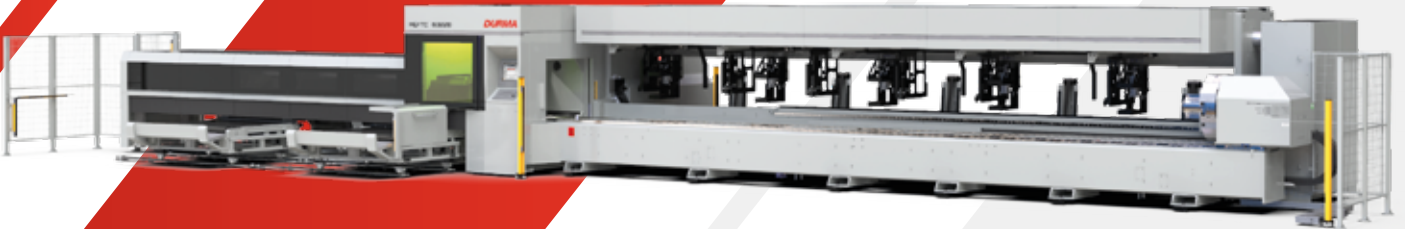


Tube & Profile Laser Cutting Machine

Series

HD-TC COMPACT
HD-TC
HD-TC MEGA



Easy To
Use

High Quality
Cutting

Low energy
Consumption

Faster

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

In our three production plants with a total of 1,614,586 sq. ft. 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.



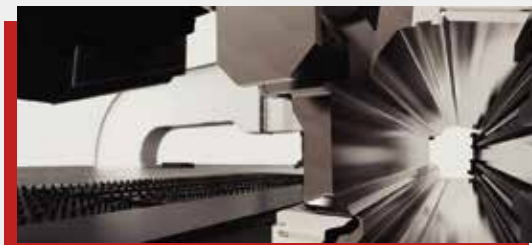
1

High technology,
modern production
lines



2

Top quality
components



3

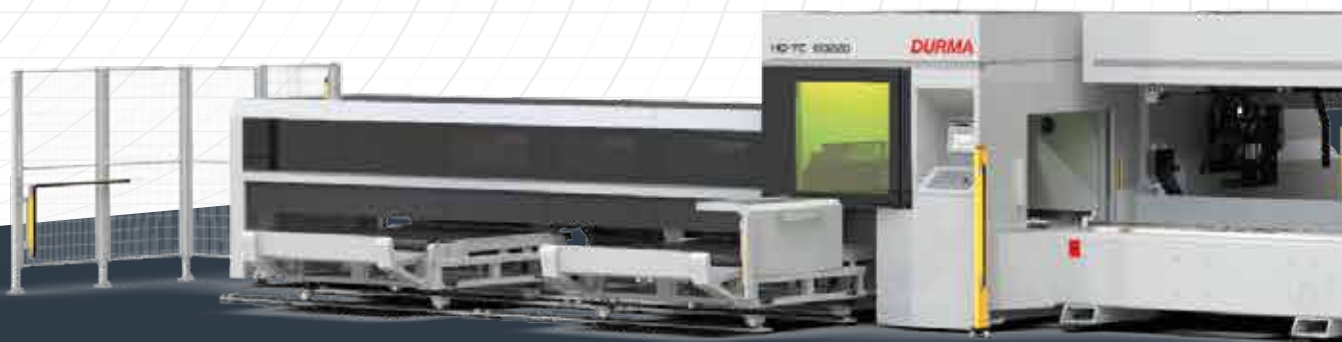
High quality
machines designed
in R&D Centre

HD-TC

HD-TC Tube & Profile Laser Cutting Machines

DURMA HD-TC Tube & Profile Laser Cutting Machines are 'high-speed' 2D & 3D cutting systems used for cutting tube and profile materials.

The moving axes operate via maintenance-free, dynamic and high-performance AC servo motors. Suction system is used to vacuum the dust generated during laser cutting to the dust collection filter. Automatic pipe and profile loading system is designed in accordance with the principle of reducing the material preparation time and automatic pipe and profile unloading system to collect the cut materials without stopping the machine. Thanks to the compact layout of the machine, all pipe and profile loading / cutting / unloading actions are performed with less space and less processing.



Production is *More Effective Now.*

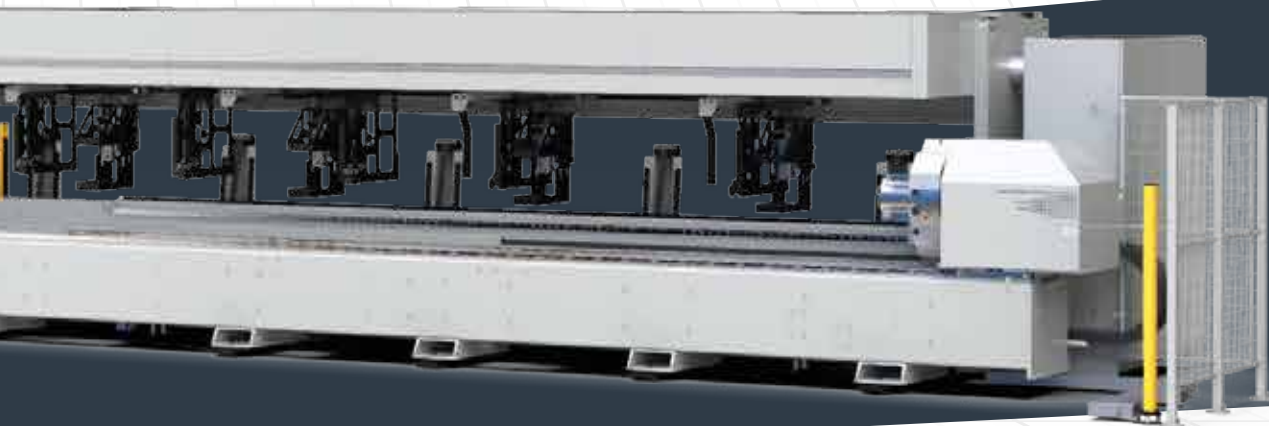
➤ Friendly

➤ Ergonomic

➤ Efficient

➤ Fast

➤ Reliable
Brand



HD-TC

HD-TC 60220

Tube & Profile Laser Cutting Machine

- Both – sides (front & back) unloading system
- $\varnothing$ 8" 5/8 mm profile diameter,
- 6" 5/16 x 6" 5/16 mm square tube dimension,
- 7" 7/8 x 3" 15/16 mm rectangular tube dimension, maximum cutting sizes

■ Low Operating Costs

- Low energy consumption
- Low cost per part
- Maintenance-free operation
- Modular design, quick commissioning
- Compact, robust, and easy to use
- Wide product range



■ Control Unit

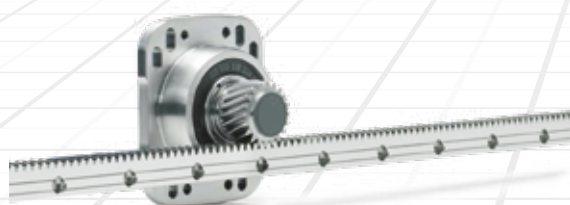
The controller has a Durma operator interface and a complete cutting database for all standard pipe cutting applications.

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



■ Rack and Pinion Motion System

Axes motions achieved by rack and pinion design. There are low backlash gears between the motor and the pinion which otherwise could cause precision losses. High precision two-day, hardened helical racks with low clearance make it possible to achieved very high acceleration (32.8 ft/s^2), speed (5.5 ft/s) and accuracy (0.002 inch) values.



Production is *More Effective Now.*

■ CAD/CAM Software

D-WISE / LANTEK

- The laser power is controlled as a function of the path, velocity, time and travel.
- Close-loop working.
- Optional functions.
- 6 MB expanded user memory, external memory option.
- Advanced optimisation: tools optimisation.
- Fast tool way collision protection. Toolway optimisation to prevent damage from possible deformed material.
- Writings supported by your operating system can be applied directly on the material to be cut.
- Cutting direction, clockwise or opposite is supported.
- Advanced corner applications provide perfect corners and soft cutting.
- Fillets, cooling, slowing down, circulation.
- Shared Cuttings: Reduces the need of marking holes during cutting
- Automatic entry point
- Fully automatic cutting
- Z-Axis control

■ Chiller

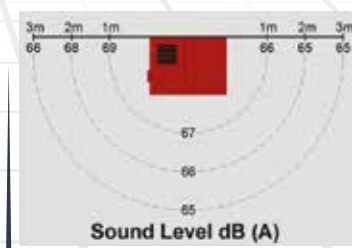
The cooler is a device that provides cooling of the laser power source, optics in the cutting head.

Thanks to the dual circuit system, cooling water is sent at different temperatures, which are needed for optics and laser power supply.



■ Filter

It provides a healthy working environment by absorbing smoke, dust and small particles formed during cutting. The vibrating dust collection filter is fully automatic. It runs automatically when cutting is started. Filter cartridges are a compact unit with integrated fan motor assembly and jet-pulse (back blow) cleaning system.



Low noise level



Easy access to filters and dust bins

HD-TC

■ Automatic Loading System

Profiles taken from bundle one by one to the chain, system moves the profile up and grippers clamp the profile and move it to the chuck axis and chuck holds the profile.



■ Profile Transfer System

Profile transfer system ensures that profiles are taken to cutting line with right position.



■ Chain Transfer System

Chain transfer system is used with the principle of loading stainless steel aluminium brass etc. tubes without scratching.



■ Automatic Loading Gripper System

Tubes which come from loading unit are transferred to cutting zone and centered automatically.



■ Measuring Profile Length

With servo motor on it measures profile length and send the data to the system.



■ Driver Chuck

With its 4 independent jaws working in a 2+2 configuration, it can grip profiles of different cross-sections. It automatically adjusts the clamping pressure according to the wall thickness of the profile. By measuring the jaw position, it enables fast and reliable clamping.



■ Central Chuck

To achieve precision in cutting, it centers the profile in the position closest to the cutting head. It rotates in synchronization with the driver chuck. The roller jaws, operating in a 2+2 configuration, automatically clamp after the profile arrives. The clamping pressure is automatically adjusted according to the wall thickness of the profile. To prevent collisions, the positions of the rollers are detected by sensors.



■ Profile Support System

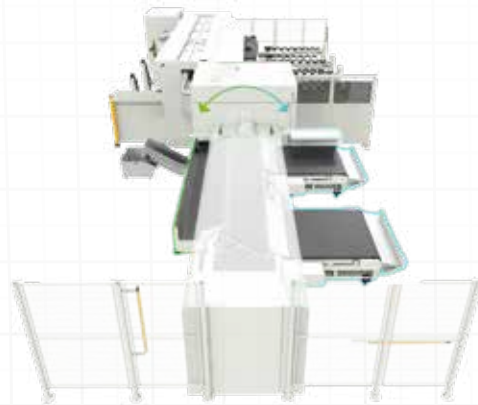
The 4 support arms automatically adjust to the required height with a servo motor according to the profile dimensions during loading, ensuring that the profile is loaded on the same axis as the driver chuck. The VY axis between the 1st and 2nd support arms precisely aligns the profile with the central chuck axis. In addition, the support rollers adaptively support the profile both horizontally and vertically during cutting, eliminating deflection in the profile and minimizing waste, thus enabling high-precision cuts.



HD-TC

■ Automatic Unloading System

The automatic unloading system is designed to sort cut parts into separate locations based on their lengths, and it operates in both directions. It features a conveyor at the front and a discharge bin at the rear. Additionally, the table can move back and forth, allowing short parts to be quickly dropped onto the lower part/scrap conveyor and collected in the part trolley. Depending on user preferences, it is possible to drop the cut parts to either side, with sorting based on length, type, and shape. (It is standard on machines with a 220 mm diameter.)



■ Seam Detection Sensor (Option)

The Seam Detection sensor attached to the HDTC machines detects the stitched surface when the pipe is loaded on the machine and provides the ability to rotate the operator's cut holes at any angle.



■ Centering System with Laser Sensors (Option)

With the newly added laser sensor centering option added to the HDTC machines, it is possible to control the size and irregular structure of the profile during cutting or before cutting with the help of sensors to ensure that the internal contours to be cut are at the right point.



■ Spatter Protection System (Option)

The Spatter Protection system is used to prevent the slag coming out at the cutting edge from sticking to the opposite surface of the profile. The burrs adhering to the inner surface of the profile disrupt both the cutting quality and require additional cleaning of the inner surface of the work pieces. All these problems can be prevented by Spatter Protection system.



■ 3D Bevel Cutting (Option)

To achieve the required angled surfaces in the welding of pipes and profiles, HD-TC machines offer an excellent 3D cutting option. This feature enables high-speed and high-quality bevel cuts from ± 45 for pipes and profiles.



■ Front Chain Loader - Semi Automatic (Option)

8 tubes can be loaded to chain loader at once. Different types of tubes can be loaded at once. (In the order in the part program list) After loading to cutting line, the tube length is measured automatically by measuring system. Zlt allows for the semi-automatic loading of special profiles (L, U).



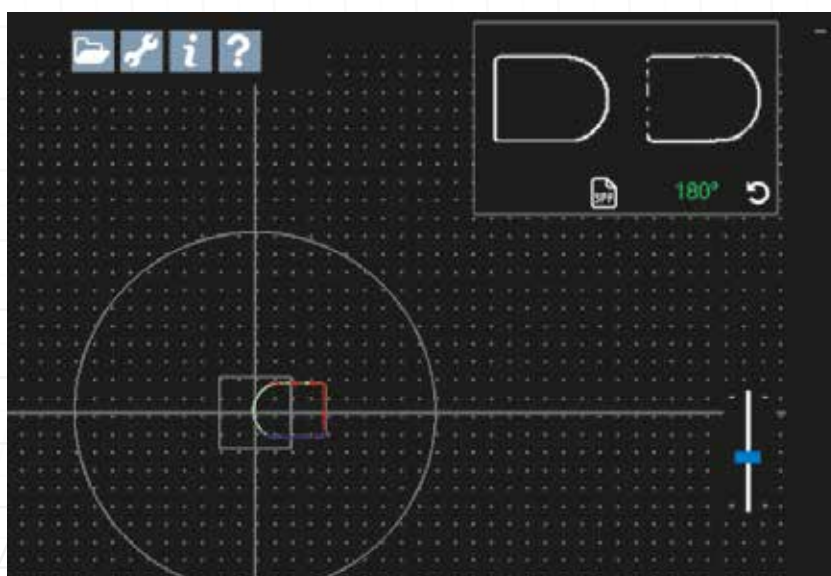
HD-TC

PROFILE ANGLE DETECTION SYSTEM *(Option)*

Automatic loading of non-symmetrical profiles is a common problem for many customers. We eliminated this problem with Durma Smart Profile Detection System. Automatically loading of all profiles is now much easier and smoother.

Durma profile cutting fiber laser, simplifies fully automatic laser profile cutting.

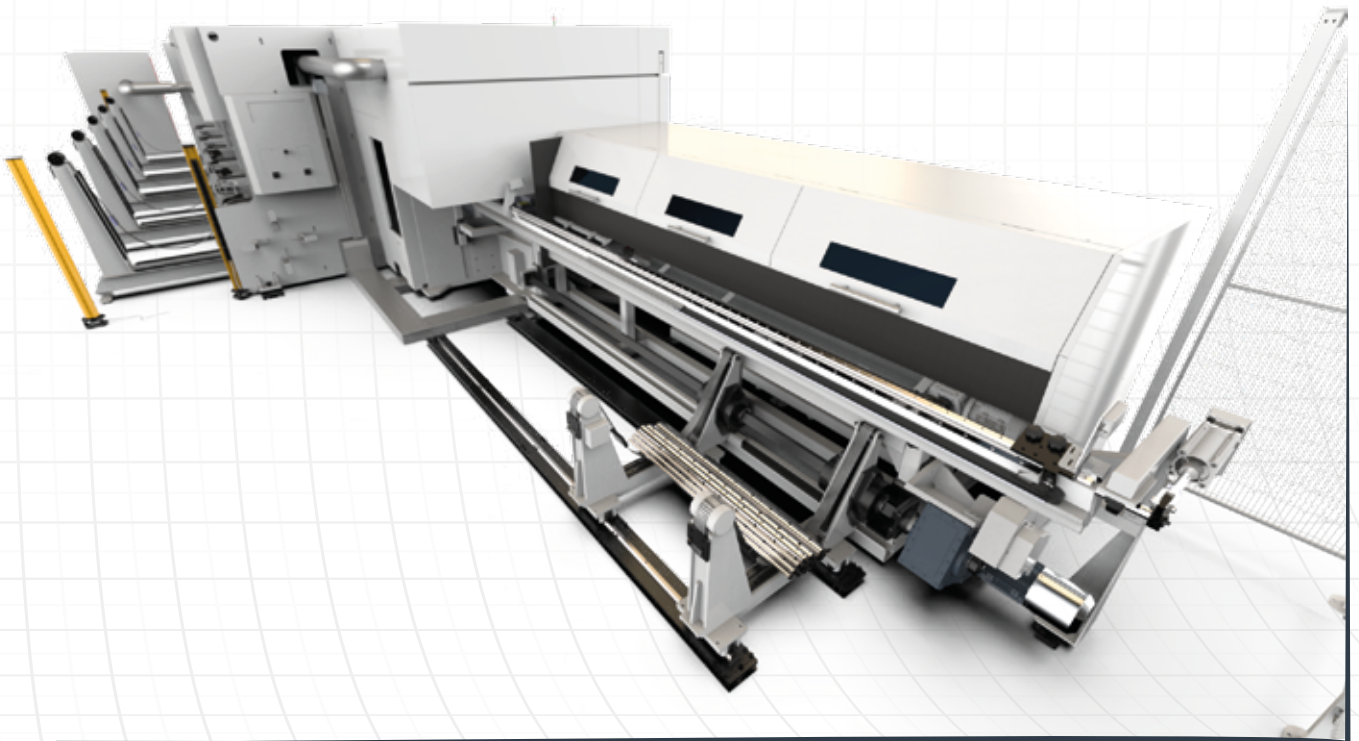
You can now easily load specially shaped profiles automatically, which was previously not possible due to the special geometries of the profiles.



Production is *More Effective Now.*

Full Automatic Loading & Stacking (*Option*)

Your profiles are ready for packaging after the cutting process. With its advanced Automatic Unloading and Stacking System, Durma ensures that the profiles you cut on the machine are stacked precisely according to their dimensions and without deformation, thus preventing potential time losses and additional labor costs.



HD-TC

HD-TC 60250 COMPACT



Capacity		
Max. Pipe Diameter	Ø9.84	inch
Max. Square Profile Dimension	6.3 x 6.3	inch
Max. Rectangular Profile Dimension	7.87 x 5.90	inch
Min. Pipe Diameter	Ø0.63	inch
Max. Material Length	19.68	ft
Min. Length of Remaining Material	3.74 (If last part can be cut with one chuck, otherwise 10.03 inch)	inch
Unloading Length	9.84 / 19.68	ft
Automatic Unloading Unit	Part Box / Conveyor (Option)	
Max. Material Weight	38.97	lbs/ft
Max. Total Workpiece Weight	771.61	lbs
Material Length Range for Semi Auto Loading	19.02 / 20.01	ft
Semi Automatic Loading Unit	Option (19.68)	
Profile Types Can Be Cut	Round, Square, Rectangular, Elliptic	
Open Profile Types Can Be Cut **	L, U, H	
Max. Open Profile Dimension	6.3 x 6.3	inch
Min. Length of Remain Part for Open Type Tubes	3' 9.3"(If last part can be cut with one chuck, otherwise 0' 10.8")	inch
Dynamics		
X Axis	131.23	ft/min
Y Axis	308.4	ft/min
Z Axis	98.42	ft/min
A Axis	510	%s
Accuracy ***		
Positioning Accuracy	±0.008	inch
Positioning Variation	±0.002	inch
Tube Center Search with Capacitive Sensor	Yes	
Control Unit		
CNC	Durma CNC Aurora	

** A slim-type head must be used for H-profile cutting.

***The values given represent the cumulative positional accuracy of the machine's axes. Cutting accuracy varies depending on errors in the profile's diameter or edge dimensions, radius, warping, or the use of a nozzle of the wrong size. The warping of the profile directly affects the cutting tolerance, and this effect varies depending on the profile dimensions. The laser centring option is recommended to achieve precise cutting.

**** The 'lead-in' distance in the final cut may alter the scrap material length. This should be taken into account when nesting.

■ HD-TC 60170



Capacity		
Max. Pipe Diameter	Ø6.69	inch
Max. Square Profile Dimension	4.72 x 4.72	inch
Max. Rectangular Profile Dimension	5.90 x 3.93	inch
Min. Pipe Diameter	Ø0.78 (Ø0.47 optional)*	inch
Max. Material Length	21.32	ft
Min. Material Length for Automatic Loading	9.84	ft
Min. Length of Remaining Material	5.11 (4.33 optional)	inch
Unloading Length	Max. 14.76 / Max. 19.68	ft
Max. Material Weight	25.2	lbs/ft
Max. Total Workpiece Weight	462.97	lbs
Max. Bundle Weight	6613.86	lbs
Profile Types Can Be Cut	Round, Square, Rectangular, Elliptic	
Open Profile Types Can Be Cut **	L, U	
Max. Open Profile Dimension	4.72	inch
Height of Chuck Center	3.77	ft
Dynamics		
X Axis	196.85	ft/min
Y Axis	196.85	ft/min
Z Axis	98.42	ft/min
A Axis	840	°/s
Accuracy ***		
Positioning Accuracy	±0.008	inch
Positioning Variation	±0.002	inch
Tube Center Search with Capacitive Sensor	Yes	

*Pipes and profiles smaller than Ø20 can only be loaded manually.

** Open-section profiles can only be loaded manually or using a semi-automatic chain loading system. A slim-type head must be used for H-profile cutting.

***The values provided represent the cumulative positional accuracy of the machine's axes. Cutting accuracy varies depending on the profile's diameter or edge dimensions, radius, warping, or the use of a nozzle of the wrong size. The profile's warping directly affects the cutting tolerance, and this effect varies depending on the profile's dimensions. The laser centring option is recommended to achieve precise cutting.

HD-TC

HD-TC 60220



Capacity		
Max. Pipe Diameter	Ø8.66	inch
Max. Square Profile Dimension	6.3 x 6.3	inch
Max. Rectangular Profile Dimension	7.87 x 3.93	inch
Min. Pipe Diameter	Ø0.78 (Ø0.47 optional)*	inch
Max. Material Length	21.32	ft
Min. Material Length for Automatic Loading	9.84	ft
Min. Length of Remaining Material	6.3 (5.51 optional)	inch
Unloading Length	Max. 14.76 / Max. 19.68	ft
Max. Material Weight	34.94	lbs/ft
Max. Total Workpiece Weight	793.66	lbs
Max. Bundle Weight	6613.86	lbs
Profile Types Can Be Cut	Round, Square, Rectangular, Elliptic	
Open Profile Types Can Be Cut **	L, U, H	
Max. Open Profile Dimension	3.93 (bigger size optional)	inch
Height of Chuck Center	3.77	ft
Dynamics		
X Axis	196.85	ft/min
Y Axis	196.85	ft/min
Z Axis	98.42	ft/min
A Axis	840	°/s
Accuracy ***		
Positioning Accuracy	±0.008	inch
Positioning Variation	±0.002	inch
Tube Center Search with Capacitive Sensor	Yes	

*Pipes and profiles smaller than Ø20 can only be loaded manually.

** Open-section profiles can only be loaded manually or using a semi-automatic chain loading system. A slim-type head must be used for H-profile cutting.

***The values provided represent the cumulative positional accuracy of the machine's axes. Cutting accuracy varies depending on the profile's diameter or edge dimensions, radius, warping, or the use of a nozzle of the wrong size. The profile's warping directly affects the cutting tolerance, and this effect varies depending on the profile's dimensions. The laser centring option is recommended to achieve precise cutting.

■ HD-TC 80220



Kapasite		
Max. Pipe Diameter	Ø8.66	inch
Max. Square Profile Dimension	6.3 x 6.3	inch
Max. Rectangular Profile Dimension	7.87 x 3.93	inch
Min. Pipe Diameter	Ø0.78 (Ø0.47 optional)*	inch
Max. Material Length	27.88	ft
Min. Material Length for Automatic Loading	9.84	ft
Min. Length of Remaining Material	6.3 (5.51 optional)	inch
Unloading Length	Max. 14.76 / Max. 19.68	ft
Max. Material Weight	34.94	lbs/ft
Max. Total Workpiece Weight	793.66	lbs
Max. Bundle Weight	8818.49	lbs
Profile Types Can Be Cut	Round, Square, Rectangular, Elliptic	
Open Profile Types Can Be Cut **	L, U, H	
Max. Open Profile Dimension	3.93 (bigger size optional)	inch
Height of Chuck Center	3.77	ft
Dinamik		
X Axis	196.85	ft/min
Y Axis	196.85	ft/min
Z Axis	98.42	ft/min
A Axis	840	°/s
Hassasiyet		
Positioning Accuracy	±0.008	inch
Positioning Variation	±0.002	inch
Tube Center Search with Capacitive Sensor	Yes	

*Pipes and profiles smaller than Ø20 can only be loaded manually.

** Open-section profiles can only be loaded manually or using a semi-automatic chain loading system. A slim-type head must be used for H-profile cutting.

***The values provided represent the cumulative positional accuracy of the machine's axes. Cutting accuracy varies depending on the profile's diameter or edge dimensions, radius, warping, or the use of a nozzle of the wrong size. The profile's warping directly affects the cutting tolerance, and this effect varies depending on the profile's dimensions. The laser centring option is recommended to achieve precise cutting.

HD-TC

HD-TC 60350 MEGA



Capacity		
Max. Pipe Diameter	Ø13.78	inch
Max. Square Profile Dimension	9.84 x 9.84	inch
Max. Rectangular Profile Dimension	11.81 x 7.87	inch
Min. Pipe Diameter	Ø0.78	inch
Max. Material Length	21.32	ft
Min. Length of Remaining Material	0	inch
Unloading Length	19.68	ft
Automatic Unloading Unit	Standard (Chain Unloader)	
Max. Material Weight	84	lbs/ft
Max. Total Workpiece Weight	1763.69	lbs
Material Length Range for Semi Auto Loading	14.76 - 21.32	ft
Semi Automatic Loading Unit	Standard Chain Loader	
Profile Types Can Be Cut	Round, Square, Rectangular, Elliptic	
Open Profile Types Can Be Cut **	L, U, I	
Max. Open Profile Dimension	9.84 x 9.84	inch
Height of Chuck Center	4.59	ft
Dynamics		
X Axis	262.46	ft/min
Y Axis	98.42	ft/min
Z Axis	98.42	ft/min
A Axis	320	°/s
Accuracy ***		
Positioning Accuracy	±0.008	mm
Positioning Variation	±0.002	mm
Tube Center Search with Capacitive Sensor	Yes	
Control Unit		
CNC	Durma CNC Aurora	

** A slim-type head must be used for H-profile cutting.

***The values given represent the cumulative positional accuracy of the machine's axes. Cutting accuracy varies depending on errors in the profile's diameter or edge dimensions, radius, warping, or the use of a nozzle of the wrong size. The warping of the profile directly affects the cutting tolerance, and this effect varies depending on the profile dimensions. The laser centring option is recommended to achieve precise cutting.

**** The 'lead-in' distance in the final cut may alter the scrap material length. This should be taken into account when nesting.

■ HD-TC 80350 MEGA



Capacity		
Max. Pipe Diameter	Ø13.78	inch
Max. Square Profile Dimension	1' 1.8" x 1' 1.8"	inch
Max. Rectangular Profile Dimension	1' 1.8" x 1' 1.8"	inch
Min. Pipe Diameter	Ø0.78	inch
Max. Material Length	27.88	ft
Min. Length of Remaining Material	0	inch
Unloading Length	26.24	ft
Automatic Unloading Unit	Standard (Chain Unloader)	
Max. Material Weight	84	lbs/ft
Max. Total Workpiece Weight	2314.85	lbs
Material Lenght Range for Semi Auto Loading	13.12 - 27.88	ft
Semi Automatic Laoding Unit	Standard Chain Loader	
Profile Types Can Be Cut	Round, Square, Rectangular, Eliptic	
Open Profile Types Can Be Cut **	L, U, H	
Max. Open Profile Dimension	1' 1.8" x 1' 1.8"	inch
Height of Chuck Center	4.59	ft
Dynamics		
X Axis	262.46	ft/min
Y Axis	98.42	ft/min
Z Axis	98.42	ft/min
A Axis	320	°/s
Accuracy ***		
Positioning Accuracy	±0.008	mm
Positioning Variation	±0.002	mm
Tube Center Search with Capacitive Sensor	Yes	
Control Unit		
CNC	Durma CNC Aurora	

** A slim-type head must be used for H-profile cutting.

***The values given represent the cumulative positional accuracy of the machine's axes. Cutting accuracy varies depending on errors in the profile's diameter or edge dimensions, radius, warping, or the use of a nozzle of the wrong size. The warping of the profile directly affects the cutting tolerance, and this effect varies depending on the profile dimensions. The laser centring option is recommended to achieve precise cutting.

**** The 'lead-in' distance in the final cut may alter the scrap material length. This should be taken into account when nesting.

HD-TC

HD-TC 120350 MEGA



Capacity		
Max. Pipe Diameter	Ø13.78	inch
Max. Square Profile Dimension	1' 1.8" x 1' 1.8"	inch
Max. Rectangular Profile Dimension	1' 1.8" x 1' 1.8"	inch
Min. Pipe Diameter	Ø0.78	inch
Max. Material Length	41.01	ft
Min. Length of Remaining Material	0	inch
Unloading Length	41.01	ft
Automatic Unloading Unit	Standard (Chain Unloader)	
Max. Material Weight	84	lbs/ft
Max. Total Workpiece Weight	3306.93	lbs
Material Length Range for Semi Auto Loading	14.76 - 41.01	ft
Semi Automatic Loading Unit	Standard Chain Loader	
Profile Types Can Be Cut	Round, Square, Rectangular, Elliptic	
Open Profile Types Can Be Cut **	L, U, I	
Max. Open Profile Dimension	1' 1.8" x 1' 1.8"	inch
Height of Chuck Center	4.59	ft
Dynamics		
X Axis	262.46	m/ft
Y Axis	98.42	m/ft
Z Axis	98.42	m/ft
A Axis	320	°/s
Accuracy ***		
Positioning Accuracy	±0.008	inch
Positioning Variation	±0.002	inch
Tube Center Search with Capacitive Sensor	Yes	
Control Unit		
CNC	Durma CNC Aurora	

** A slim-type head must be used for H-profile cutting.

***The values given represent the cumulative positional accuracy of the machine's axes. Cutting accuracy varies depending on errors in the profile's diameter or edge dimensions, radius, warping, or the use of a nozzle of the wrong size. The warping of the profile directly affects the cutting tolerance, and this effect varies depending on the profile dimensions. The laser centring option is recommended to achieve precise cutting.

**** The 'lead-in' distance in the final cut may alter the scrap material length. This should be taken into account when nesting.

■ HD-TC 120500 MEGA



Capacity		
Max. Pipe Diameter	Ø19.68	inch
Max. Square Profile Dimension	14.96 x 14.96	inch
Max. Rectangular Profile Dimension	1' 3.7" x 1' 1.8"	inch
Min. Pipe Diameter	Ø1.57	inch
Max. Material Length	39.37	ft
Min. Length of Remaining Material	0 (3 chuck)	inch
Unloading Length	39.37	ft
Automatic Unloading Unit	Standard (Chain Unlaoder)	
Max. Material Weight	117.59	lbs/ft
Max. Total Workpiece Weight	4629.70	lbs
Material Lenght Range for Semi Auto Loading	14.76 - 39' 4.4"	ft
Semi Automatic Laoding Unit	Standard Chain Loader	
Profile Types Can Be Cut	Round, square, rectangular, eliptic	
Open Profile Types Can Be Cut **	L,U,H	
Max. Open Profile Dimension	14.96 x 14.96	inch
Height of Chuck Center	4.59	ft
Dynamics		
X Axis	164.04	ft/min
Y Axis	164.04	ft/min
Z Axis	98.42	ft/min
A Axis	150	°/s
Accuracy ***		
Positioning Accuracy	±0.008	inch
Positioning Variation	±0.002	inch
Tube Center Search with Capacitive Sensor	Yes	
Control Unit		
CNC	Durma CNC Aurora	

** A slim-type head must be used for H-profile cutting.

***The values given represent the cumulative positional accuracy of the machine's axes. Cutting accuracy varies depending on errors in the profile's diameter or edge dimensions, radius, warping, or the use of a nozzle of the wrong size. The warping of the profile directly affects the cutting tolerance, and this effect varies depending on the profile dimensions. The laser centring option is recommended to achieve precise cutting.

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SPECIAL APPLICATIONS



Industrial Machines



Steel Service Center



Damper Trailer



Lighting and Energy Poles



Production is *More Effective Now.*

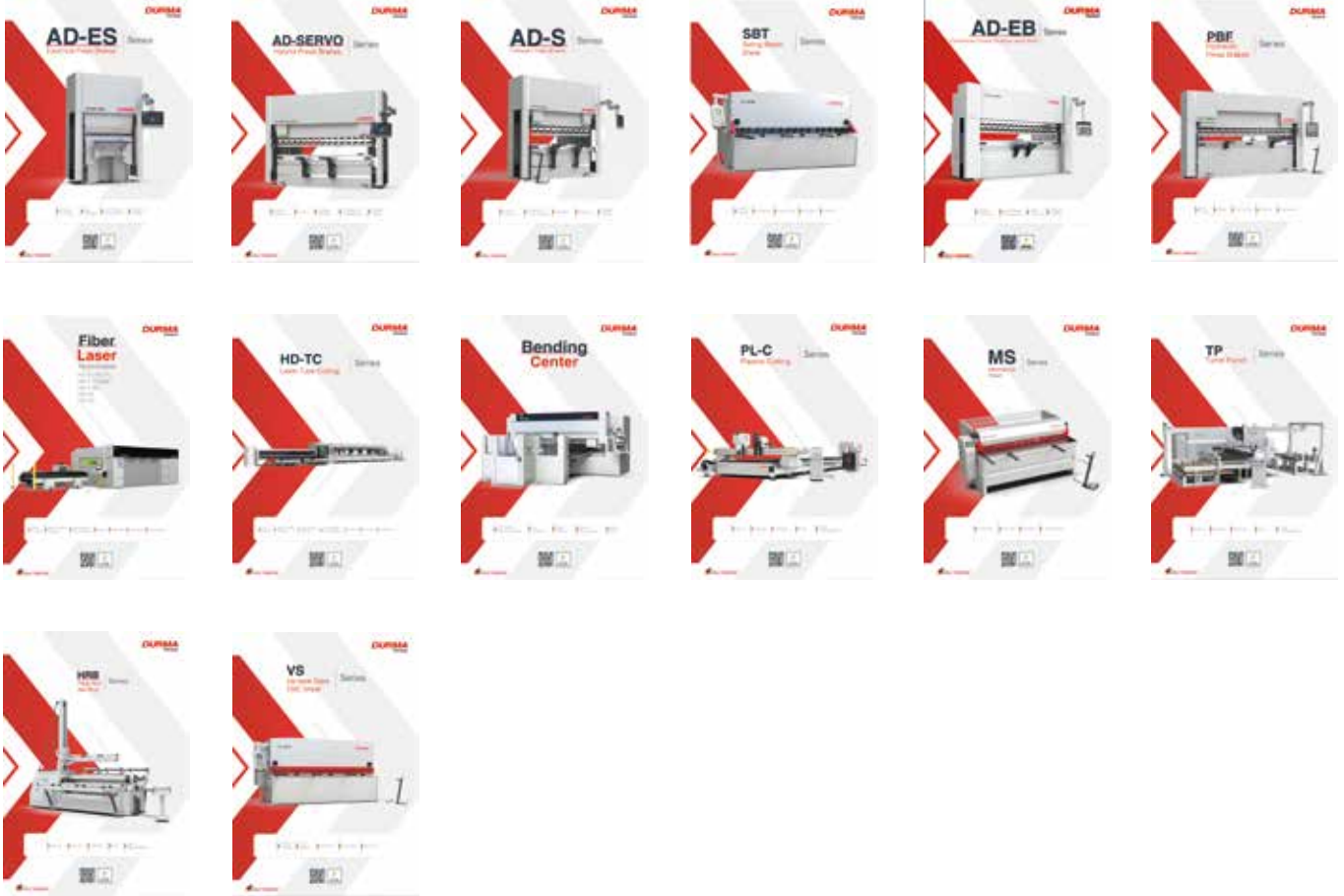
FAST ON SERVICE AND SPARE PARTS

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.



Product Groups

DURMA



f Durma International
@ durmainternational
X durmaint
▶ durmamachines
in Durmazlar



EN 2026/07/V05



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