

The Winning Force

**DURMA**

# PBF SERIES PRESS BRAKES



- Easy to Use
- Faster
- Productive
- Winning
- Ergonomic



**DURMA**

The Winning Force





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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



2

Top Quality  
Components



3

High quality  
machines designed  
in R&D Centre

# PBF Series Press Brakes

## Customer-oriented leader

We designed an excellent machine for customers who don't need high stroke and work in three shifts. We support you with low investment costs, efficient, precise, minimum maintenance costs.

With this serie it is more easy to have a press brake to your company.



# The Winning Force

Magic touch to your company

Fast, productive and perfect bendings

Low investment cost

High efficiency

Low energy consumption

Perfectly equipped for precise bendings, economic solution

Developed by the expertise of R&D Center engineers of DURMAZLAR  
PBF Hydraulic Press Brake will gain more power with innovative solutions.



**Easy to  
Use**

**Economic**

**Efficient**

**Fast**

**Reliable  
Brand**

Why *DURMA* Press Brakes

- Better and faster bendings
- Stronger and rigid body structure
- High sensitivity and repeatability
- Low service cost
- Hi-tech perfect equipment
- Increases the value of your company
- Reliable brand

# Gain More Power

## Easy solutions for your investments

With PBF Hydraulic Press Brakes, we provide low investment costs, high productivity and economic without sacrificing quality, PBF ensures and obtains all the solutions for bendings.



## 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 capable special hardened top tools
- Suitable for segmented tools special and fast tool holding system
- Sensitive solutions at long and deep bending
- High accuracy linear scales
- CE safety standards
- Environment friendly, efficient and perfect bending combinations

# Strong Back Gauge System

Precision

Reliable

Robust

- Fast and high precision
- Reliable process
- Adjustable for each point
- Crash-proof
- Maintenance free

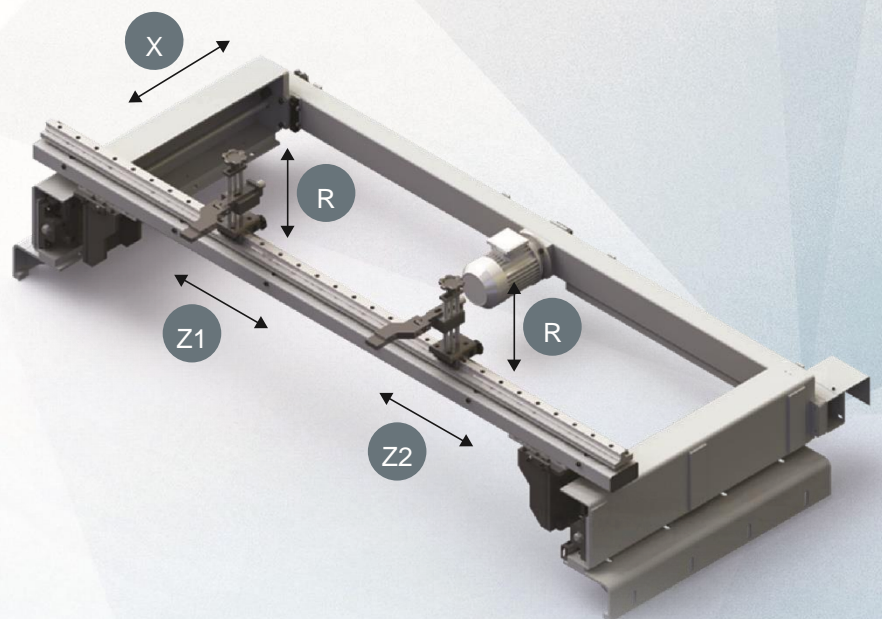


## Why *DURMA* Back Gauge ?

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.



Standard back gauge  
X CNC  
R manuel

# Tool Holders and Tools

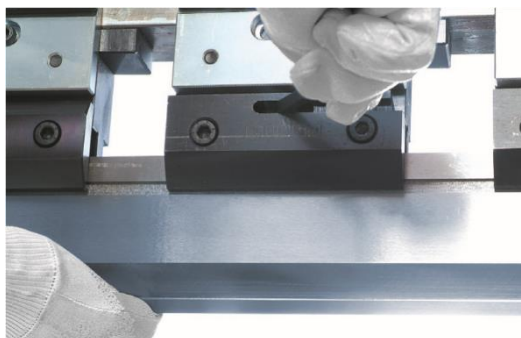
Bending performance increased with high European clamping system and easy to use. Narrow table for Z bending and table designed for European style tool holder. *DURMA* is your solution partner with various tool options.



European Clamping System



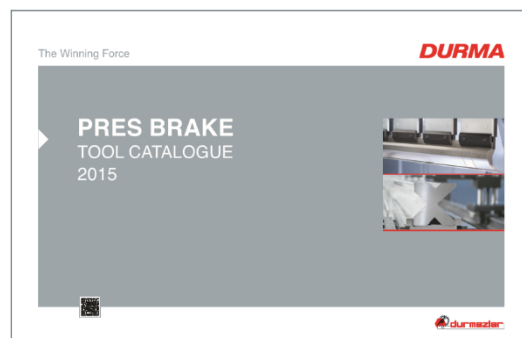
European Type Bottom Tool - 4 V Die



Quick Release Clamping



*DURMA* Multi V Bottom Tool





# Safe and Accurate Bends with Top Quality Equipments

## Crowning System

Manual or CNC-controlled motorized crowning system simplifies bending, which forces every point of the bending parts to acquire straight bends. The need for shimming is eliminated.

CNC Crowning System

## Linear Guide Front Sheet Supports

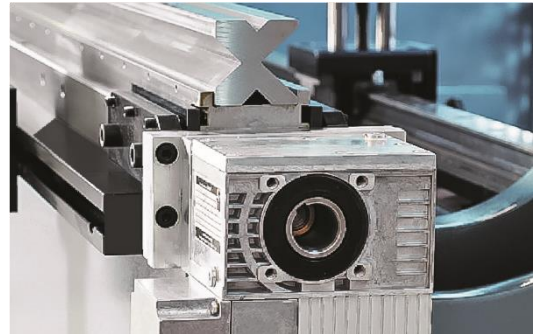
Rugged support arms with disappearing stops are mounted on a linear guide rail system. This allows “finger-tip” lateral adjustment as required by the bend length of the part. They are also equipped with side gauges for the fast, easy, and accurate feeding of parts small or large.

## 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 curtain. CE safety in tandem machine is provided with light barriers

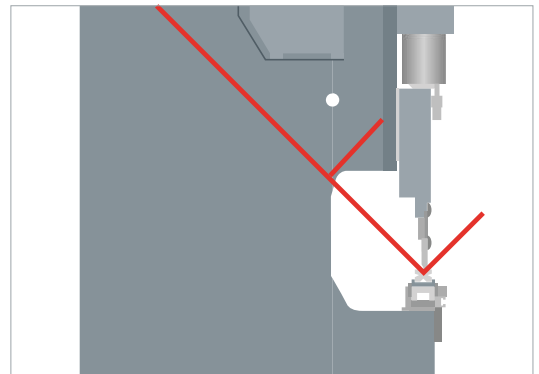
## Stable Top Beam Movement

By using long and planar guiding surface, all disadvantages of point guiding eliminated %100 free bending space:guiding system that eliminates bending between frame has been moved to the outside of the frame.



Linear Guide Front Sheet Supports

CE Laser Safety System



90 Degree Endless Bend

DURMA Touch

# DT10 Control Unit



Everything is Under Control  
With User-Friendly Interface...



Create profile with touch screen



Online service via Internet connection



Diagnostic mode



Easy programming page



Automatic bend calculation and listing



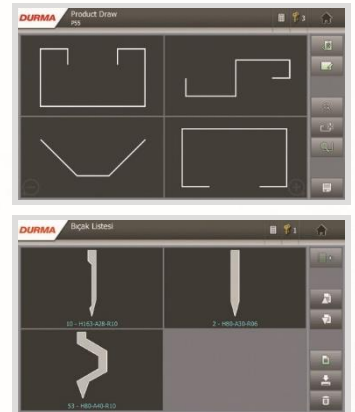
Tool programming and library

- Automatic bend listing
- Archiving your bendings
- 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



## D-Bend offline software

D-Bend Offline software allows you to simulate your bendings at your desk in your office. You can create your tools. It provides the opportunity to make new programs without interrupting production. In addition to the errors that occur when you start your process yet you will find the opportunity to pre-intervention. D-Bend verifies your unfolding. Creates verified part drawings for Laser, punch, and plasma machines.



All the solutions are a  
click away with the DT10

Alarm Help Screen

Alarm help screen is finding a solution for the operator step by step. This module makes the operator's life easier with rapid solutions.

# 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



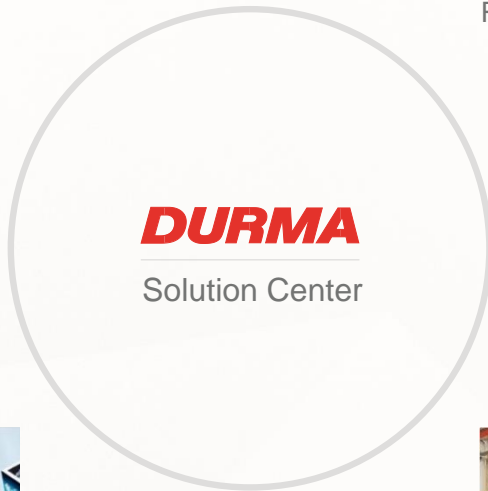
Spare Parts



R&D Center



After Sales Service



Service Agreements



Software



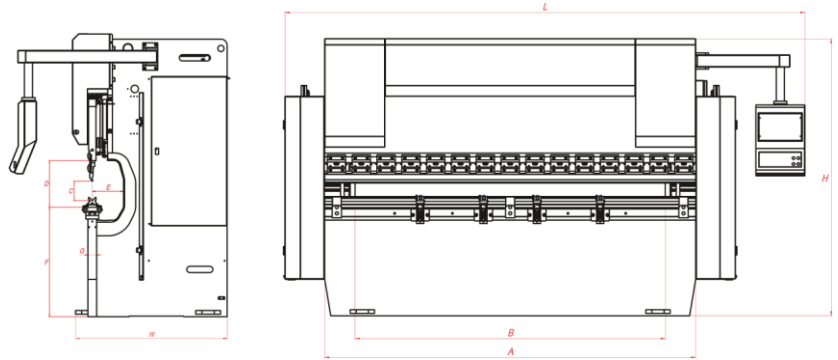
Training



Flexible Solution

# PBF Series Technical Details

		<b>PBF 2560</b>	<b>PBF 30120</b>	<b>PBF 30220</b>
Bending Force (Ton)		60	120	220
Bending Length (mm)	A	2550	3050	3050
Distance Between Columns (mm)	B	2150	2550	2550
Stroke (mm)	C	160	180	220
Daylight (mm)	D	350	375	445
Throat Depth (mm)	E	250	250	250
Y Axes Rapid Speed (mm/sec)		120	100	100
Y Axes Working Speed (mm/sec)		9	9	7
Y Axes Return Speed (mm/sec)		70	77	73
Table Height (mm)	F	813	878	858
Table Width (mm)	G	104	104	104
X Axes Working Speed (mm/sec)		80	80	80
X Axes Travel (mm)		620	620	620
Motor Power (kW)		7,5	11	15
Length (mm)	L	4455	4910	4950
Width (mm)	W	1100	1230	1390
Height (mm)	H	2235	2275	2430
Weight Approx. (kg)		4000	5900	7950



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# Standard & Optional Equipment

## Standard Equipment

Y1, Y2, X - 3 Axes  
Control Unit - DT 10 Touch screen 2D graphic (Remote Control)  
Manual adjustable R axes  
Back gauge: motorized & linear guide & ballscrew  
European clamping system  
European style bottom tool holder  
Support arms with T-Slot  
Safety side covers (Non CE)  
Special designed and World known hydraulic block and valves  
World known electrical equipments

## Optional Equipment

Motorized R Axes  
D-Bend offline software (3D importer)  
CE with Manuel F.AKAS II M FPSC-B-C (SAFETY PLC)  
Bottom tool *DURMA* Multi V  
European clamping system top tool  
European style bottom tool  
Quick release clamping  
Manuel crowning  
Motorized crowning  
Additional finger blocks  
Additional support arms with T-Slot  
Oil coolant  
Overseas special packing

**DURMA**



FIBER LASER



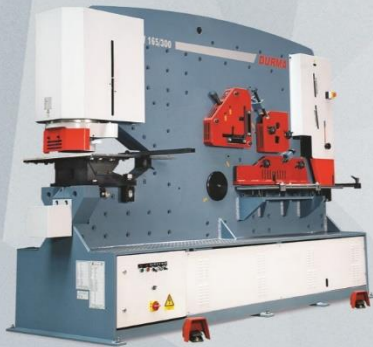
PUNCH



PLASMA



L ANGLE PROCESSING CENTER



IRON WORKER



POWER OPERATED SHEAR

**DURMA**



PRESS BRAKE



VARIABLE RAKE SHEAR



ROLL BENDING



PROFILE BENDING



BANDSAW

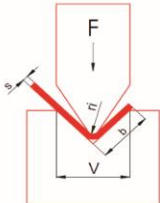


CORNER NOTCHER



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



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

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)

## PBF SERIES PRESS BRAKES

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