

The Winning Force

**DURMA**

# AD-R SERIES PRESS BRAKES



- Easy to Use
- Fast
- 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

# 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.



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## Fast, productive and perfect bending

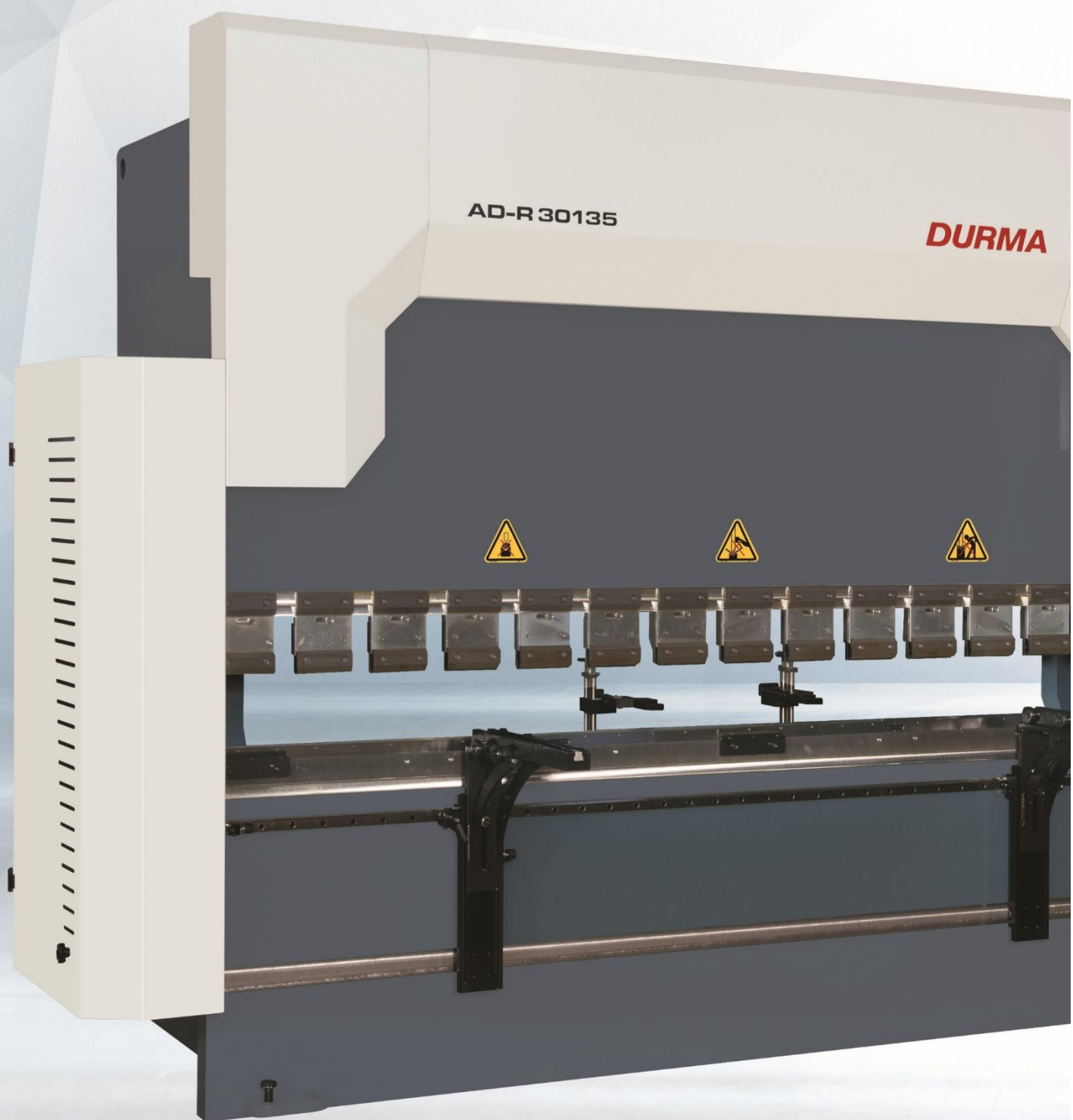
Always precision bending results

Minimum tool exchange and setting time

Maximum 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

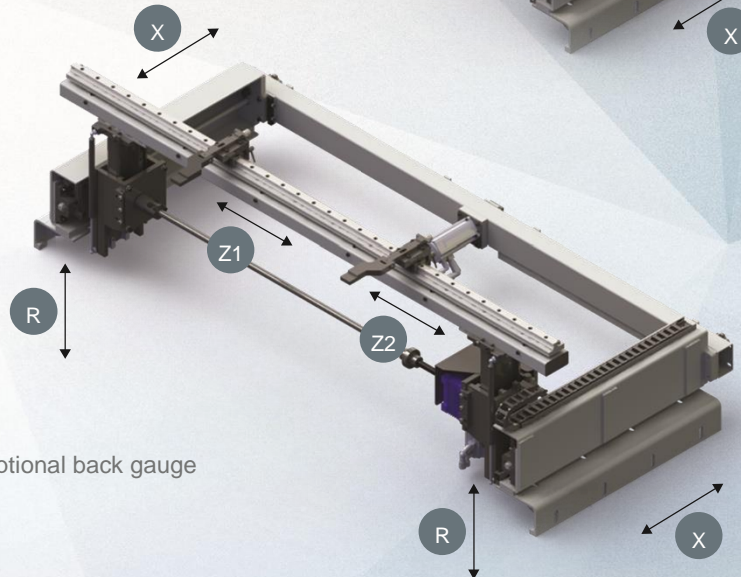
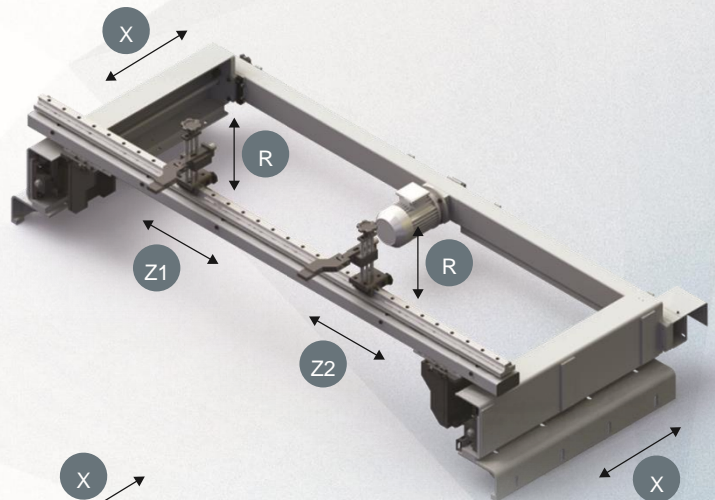
Reliable

Strong

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



Standard back gauge  
(X CNC, R manual)



CNC optional back gauge  
R  
Z1, Z2

## 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.

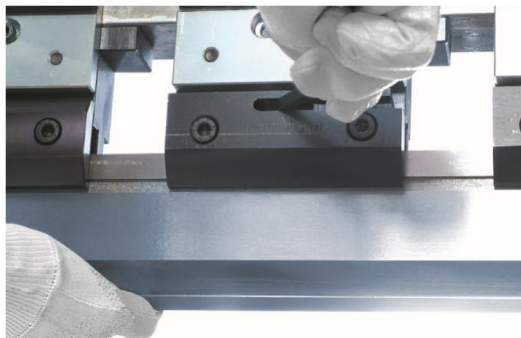
*DURMA* is your solution partner with various tool options.



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

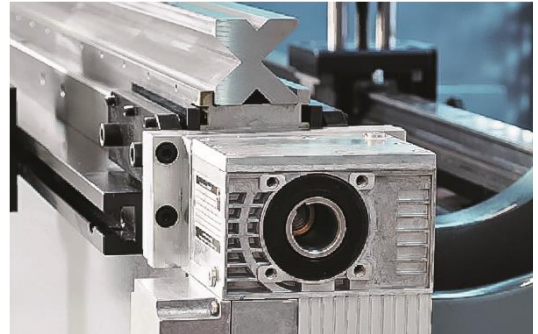
Rugged support arms with tilting stops are mounted on a linear guide rail system. This allows “finger-tip” lateral adjustment as required by the bend length of the part. They are also equipped with side gauges for the fast, easy, and accurate feeding of parts small or large.

## 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

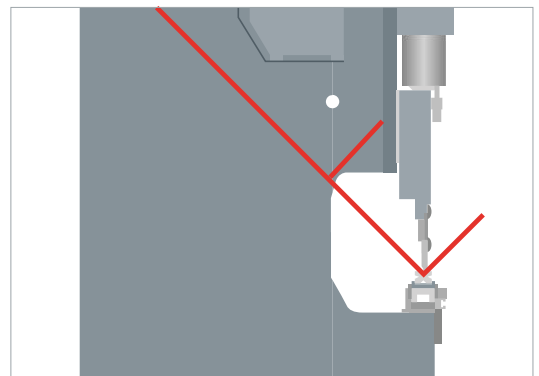
## Stable Top Beam Movement

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.



Linear Guide Front Sheet Supports

Ce Laser Safety System



90 Degree Endless Bend

DURMA Touch

# DT10 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

## All the solutions are a click away with the DT10

### Alarm Help Screen

The alarm help screen helps find a solution for the operator step by step. This module makes the operator's life easier with rapid solutions.

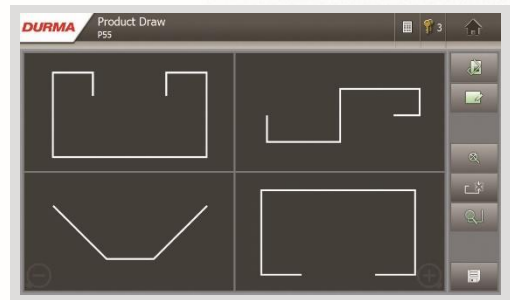
## D-Bend offline software

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 Easy to Use

- 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



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## Optional Control Units

### CybTouch 12

- 2D Touch Screen
- On-screen finger profile drawing
- Easy programming with 12" display interface
- Automatic bend listing (optional)
- Advanced valve optimization programming



### 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



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# Standard & Optional Equipment

## Standard Equipments

Y1, Y2, X - 3 Axes  
Control Unit - DT 10 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

## Optional Equipments

Control Unit - CNC CybTouch 12  
Control Unit - CNC DA 58T  
CE with FIESSLER AKAS-LC II F manual + AKFR control box  
CE F.AKAS (Only Tandem) + steel protection covers  
Motorized R Axes  
Z1 - Z2 axes CNC  
European style top tool  
European style bottom tool  
Bottom tool Durma  
Quick Release Clamping  
Manuel crowning  
CNC controlled Motorized Crowning  
Back gauge 1000 mm - Back protection with Light barrier  
Oil Cooler  
Additional Finger blocks & Sliding front arms  
Overseas special packaging

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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.



Consultancy



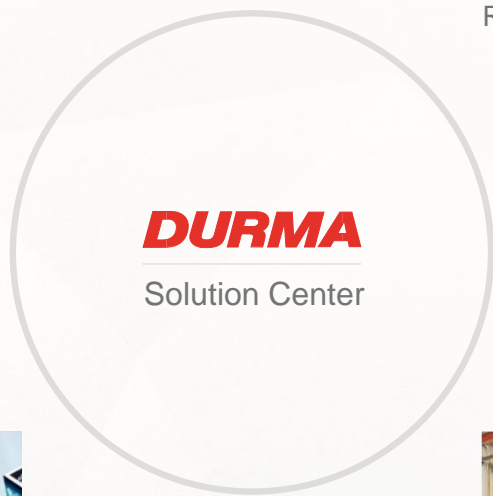
Spare Parts



R&D Center



After Sales Service



Service Agreements



Software



Training



Flexible Solution

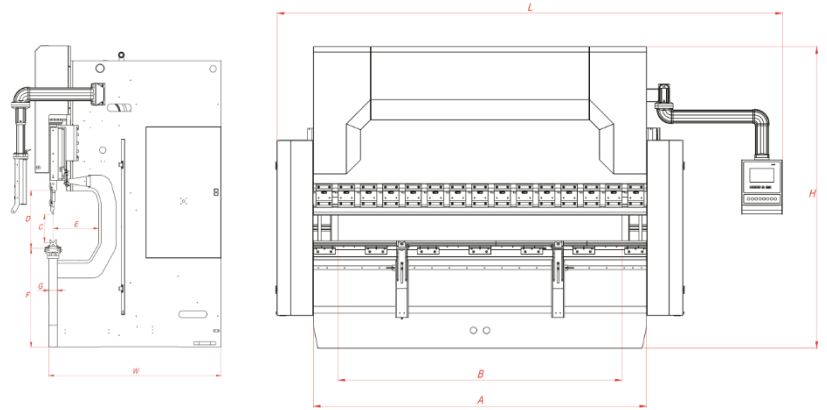
# AD-R Series Technical Details

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	2050	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	**	1040	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 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	250	140	250	-	S	-	7,5	2300	1200	2350	3100
110	250	140	250	S	-	O	7,5	3200	1200	2350	3550
120	250	140	250	S	-	O	11	3800	1670	2750	8650
120	250	140	250	S	-	O	11	4200	1670	2750	9250
120	250	140	250	S	-	O	15	4200	1680	2750	10250
100	250	140	250	S	-	O	18,5	4250	1700	2750	11250
140	250	140	250	S	-	O	22	4250	1770	2900	12250
140	250	140	250	S	-	O	37	4300	1820	3230	17250
100	250	140	250	S	-	O	18,5	4950	1700	2900	13000

120	250	140	250	S	-	O	22	4950	1770	2900	14100
140	250	140	250	S	-	O	18,5	5250	1700	2750	12850
140	250	140	250	S	-	O	22	5250	1770	2900	14750
140	250	140	250	S	S	O	37	5300	1910	3230	20750
120	250	140	250	-	S	O	37	5750	2110	3540	26750
120	250	140	250	-	S	O	22	7500	1770	3250	20590
120	250	140	250	-	S	O	37	7500	1910	3450	28250
100	250	140	250			O	37	7500	2110	3710	35750

S :

Standard

O : Option

**DURMA**



FIBER LASER



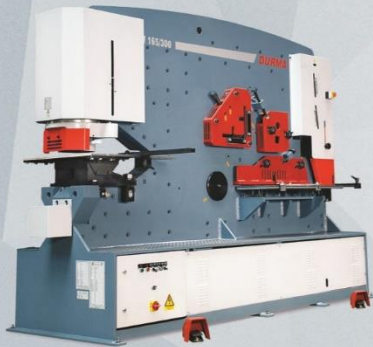
PUNCH



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																						
8	6	1,3																						
10	7	1,7																						
12	9	2																						
15	12	2,7																						
20	15	3,3																						
26	18	4,2																						
30	22	5																						
32	23	5,4																						
37	25	5,8																						
42	29	6,7																						
45	32	7,5																						
50	36	8,3																						
60	43	10																						
70	50	11,5																						
80	57	13,5																						
90	64	15																						
100	71	17																						
130	93	22																						
180	130	30																						
200	145	33																						
250	180	42																						

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

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)

## AD-R SERIES PRESS BRAKES

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