



Head Quarter & Ataevler

## Durmazlar has aimed continuous development since 1956

Owes one of the world's most contemporary production plants in the production technology business .3 different plants oriented to different product families, 1000 dedicated employees and 150.000 m2 footprint.

In order to offer solution according to clients' needs and enriching the quantity and quality of its own patent rights; long experienced Engineering Department transformed to Durma Research & Develepment Center has opened in the year 2010. Designed and engineered with modern technics; its products are equipped with proven quality components to precisely fulfill your requirements. We serve "accuracy, speed, flexibility, durability, reliability and advanced technology" with high performance/price ratio. Worldwide Durma distributors and technical support network assures perfect support to our clients.

With its 55 years of experience, its product quality, innovative solutions Durma gives importance and cares you with proactive approach. We thank all our clients to hold us at the top segment of the world brands.



Ataevler



Laser Factory



Başköy Factory

## Durma Punch Presses

Thousands of Durma Punch Presses all around the world is verifying the quality, reliability and stability of machines ; their stres relieved steel construction, modern design, state of art control system,software and quality proven hydraulics are other distinctive characteristics. Auto clamping, strong and flexible turret structure, simple and perfectly designed standardised supplementary equipments and with its user friendly CAD/CAM software; machines offer perfect full package to our clients. Possible software and parameter problems can be check via " Remote diagnostic" function of the control unit Loading and unloading systems can be integrated for efficient and lean operations High performance/price ratio Low maintainence costs Durma Punch Presses are designed and produced for value add operations' for long lifetime.

### RP Series

#### Rotational - Head Punch

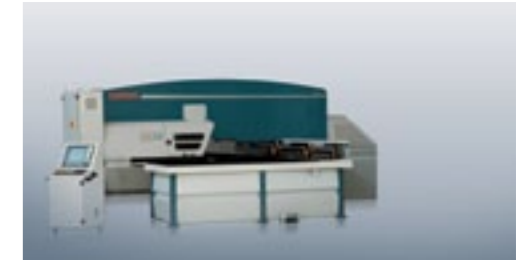
Durable punching operation for cost effective processes



### TP Series

#### Turret Punch

Flexible and strong punching processes for each sheet formats



## RP SERIES

*Single rotational head machines with versatile C frame construction*

*Stress relieved steel construction*

*Powerful Siemens controller with user friendly CAD-CAM Software*

*Fast and simple operation*

*High quality and well known hydraulic and electronic components*



# RP Series Features



## Control System

Siemens Sinumerik 840 DSL control system is applied for punching with strategic alliance with Siemens. Controls and screen are mounted on a mobile control panel. The control system and other hardware are mounted in a separate cabinet. Machining can be started with just a few steps. Network (ethernet) connection is available as well as programming on the control panel. UPS system prevents the control unit from the voltage fluctuations and cuts.

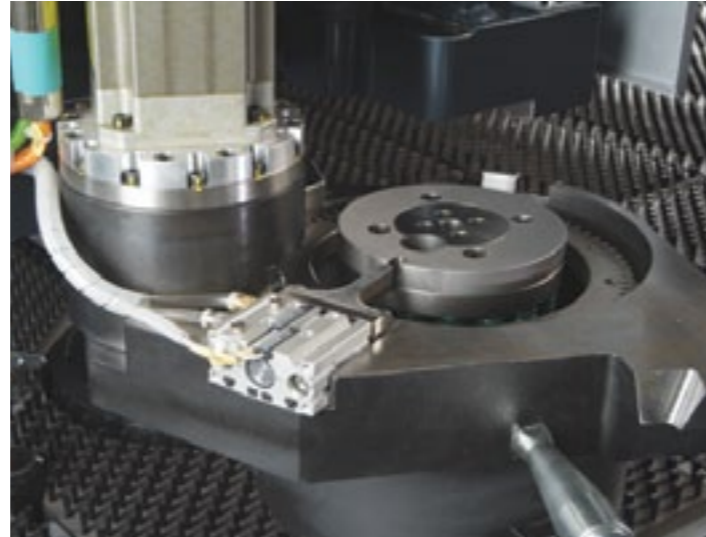
Integrated online help messages answer all questions at the location they arise. The diagnostic concept provides visual depictions of any function faults. Remote diagnostics is a matter of course over Internet for diagnostics for machine controller.

The control ensures that optimal acceleration values can be attained at every stage of machining, depending on the actual masses that need to be moved.



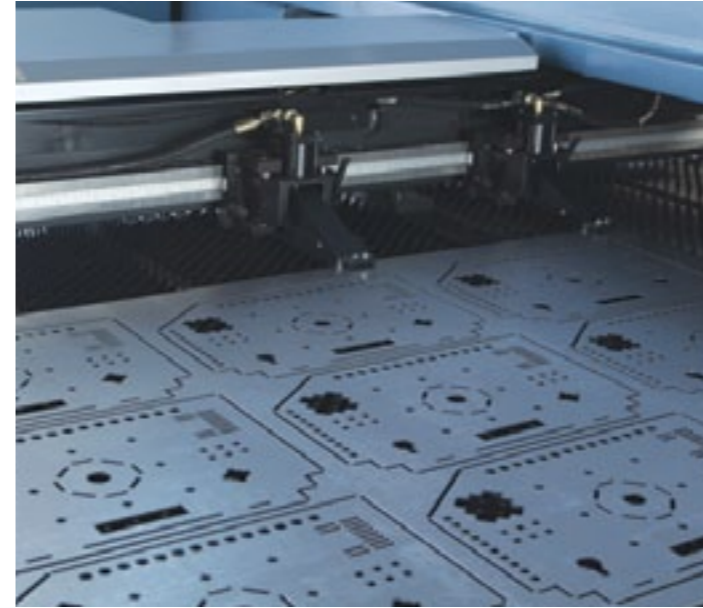
## Multi Tooling

Durma rotation punch press machine top and bottom tools work synchronize to obtain all required angular pitch can be  $\pm 0,02^\circ$ . Upper and lower index groups have no mechanical connections which means they can be perfectly aligned, even defect into the tools can be adjusted. It has a wide tooling usage capacity with 3, 6, 8, 10 tools multi tool selection.



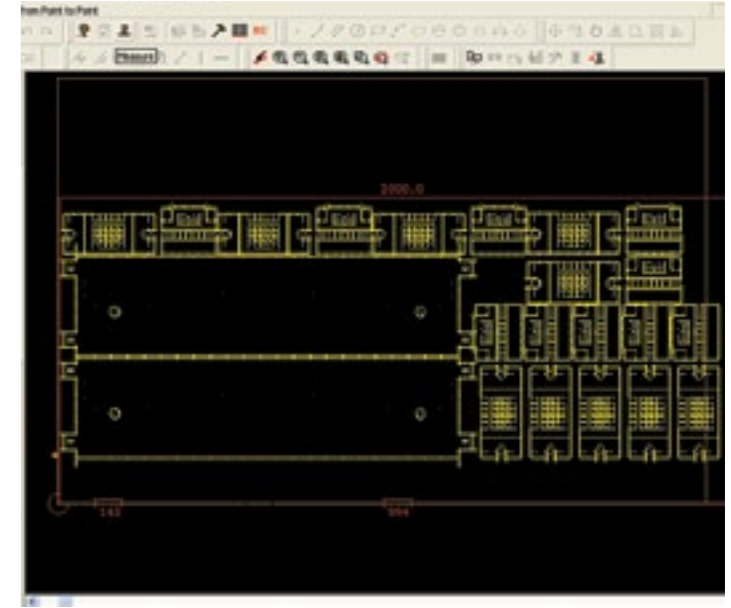
## Rotational Head

High rotational speed 40 rpm makes the machine fast. By using zero backlash Harmonic Drive Gear system for index position punching. Automatic reposition in the X axis enables to punch longer than 2 meters and eliminate the death area on the sheet.



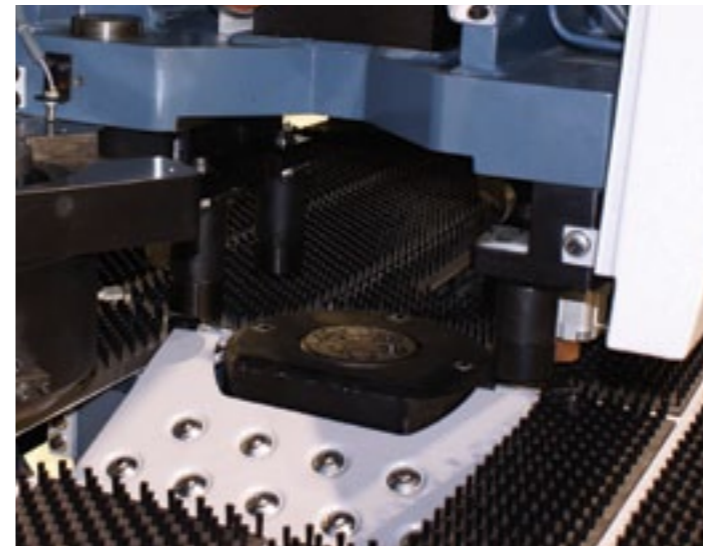
## Auto Clamps

Automatic clamps (standard with RP9) position according to the CAM program, sheet remove sensors at clamps detects the sheet hold, in case any possible release machine stops to protect working environment.



## Cadcam Software

Programming time minimized by using fast and easy CAD-CAM software (cncKAD) metalix or LanTek. By choosing the effective position of the tool automatically to use maximum area of the sheet, additional reposition and work strips is eliminated.



## Workchute

Discharges processed small workpieces without interruption or small manual manipulation. (standart with RP9)



DURMA Punch Press is equipped with infra-red barrier system according to CE conformity.

RP Series	Unit	RP6	RP9
Maximum tonnage	ton	30	20
X axis movement	mm	2000 + R	2000 + R
Y axis movement with multiple tool	mm	1250	1250
Y axis movement with single tool	mm	1285	1285
Max. Cutting thickness	mm	6	6
Automatic positioning range *	mm	10000	10000
Speed of Y axis	m/min	50	75
Speed of X axis	m/min	60	96
Speed of C axis index	rpm	40	40
Lateral speed Y + X	m/min	75	120
Max. Hit rate (1 mm pitch, 1mm thickness)	1/min	600	850
Max. Hit rate (25 mm pitch, 1mm thickness)	1/min	280	320
Max. Hit rate : Marking	Stroke/min	900	1250
Accuracy for positioning	mm	± 0.1	± 0.1
Max. weight of sheet	kg	100	120
Hard disk	Gbyte	40	40
RAM	Mb EDO	256	256
Network system	-	Windows XP	Windows XP
LCD colorscreen Super VGA	-	12.1"	12.1"
Working height	mm	980	980
Table width	mm	2400 x 3600	2400 x 3600
Machine sizes	mm	3600 x 4100 x 2450	3600 x 4100 x 2450
Motor	kw	11	7,5
Oil tank	lt	200	200
Weight approx.	kg	11600	12000
Main cylinder stroke	mm	20	30
Maximum punching diameter ( for Multitool )	mm	24	24
Number of Clamps	pcs.	2	2
Holding force of clamps	kg	850	1000
Automatic Clamp Positioning	-	-	Standard
Table type	-	Brush	Brush

## RP

### STANDARD EQUIPMENTS

Command pedal  
 CAD-CAM software & Activator  
 Control unit, Siemens Sinumerik 840 D SL Windows XP operating system  
 Remote diagnostic function  
 Programming on the control panel  
 Automatic clamp positioning ( RP9)  
 Sheet set switches on clamps ( RP9)  
 Network, Ethernet communication.  
 standart 6multi tool with punch and dies  
 6 pieces Durma tool and guide( gap 0.3 mm )  
 round Ø8  
 round Ø10  
 round Ø20  
 rectangle 4 x 20  
 square 7  
 square 17  
 Automatic tool lubrication  
 Alignment Tools for Index Stations (D Station)  
 Movable scrap box  
 UPS for control panel  
 USB driver  
 Brush table  
 Control panel  
 Oil Cooler  
 Reposition on X axis  
 Web cam for service  
 Manuel nesting

### OPTIONAL EQUIPMENTS

Light barriers for CE  
 Additional clamps  
 Special table  
 Tools, Tool holders, reducers  
 CAD-CAM SW Second activator (dongle)  
 SW for Autonesting & Wheel tools  
 Additional table  
 Air condition for electrical box  
 Additional oil cooler  
 Warning lamp  
 Sheet deformation alert switch  
 Workchute for RP9  
 Automatic lubrication for the machine  
 UPS for machine ( 30KvA - 10 min )  
 Transformator  
 Auto Nesting and wheel soft