

The Winning Force

**DURMA**

# PBF<sub>SERIES</sub> PRESS BRAKES



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



# **DURMA** The Winning Force



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 our clients who do not need high stroke and work in three shifts. We support you with low investment costs, efficient, precise, minimum maintenance costs.

PBF series serves your company and advances your production standards.



# The Winning Force

## The "Magic Touch" for your company

Fast, productive and perfect bendings

High efficiency

Low energy consumption

## Perfectly equipped for precise bendings and economic solutions

Developed by the expertise of R&D Center engineers of DURMAZLAR PBF Hydraulic Press Brake will strengthen your business with innovative solutions.

Easy to Use

Economic

Efficient

Fast

Reliable Brand

## Why *DURMA* Press Brakes

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

# Gain More Power

## Easy solutions for your investments

PBF Hydraulic Press Breaks, featuring low investment cost, high productivity and perfect performance / price ratio, ensures and obtains all solutions for your bending needs.



## 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

Precise

Reliable

Robust

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

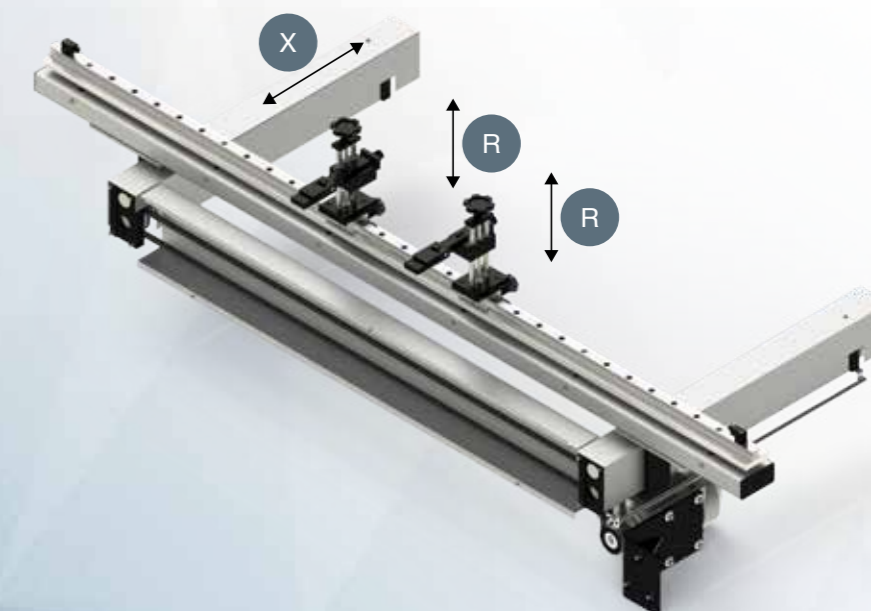


## Why DURMA Back Gauge ?

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



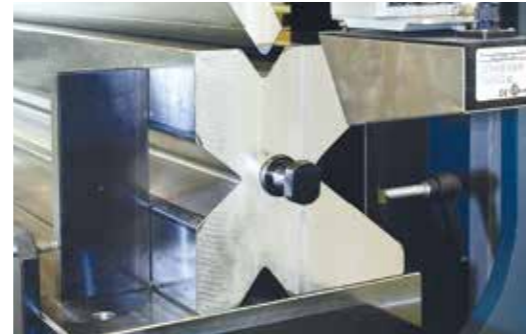
European Clamping System



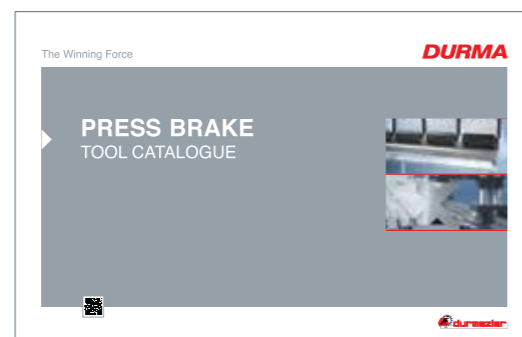
European Type Bottom Tool - 4 V Die



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 by adjusting each point of the bending parts to acquire straight bends. The need for shimming is eliminated.



Manual Crowning System

### Easy Changeable 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.



Front Support Arms with T-Slot

### CE Safety Systems

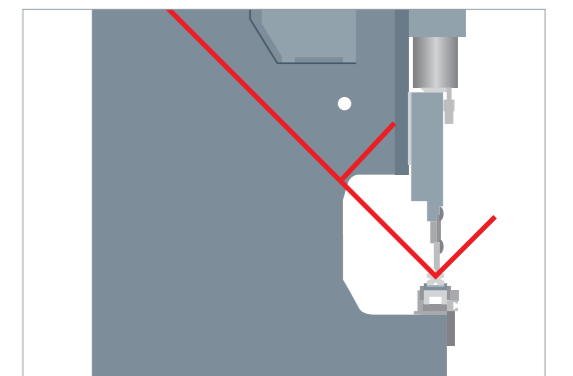
Our machines are designed in accordance with Ce-Norms to ensure your safety with hydraulic, electric, appropriate height covers and laser light curtains. CE safety in tandem machines are also provided with light barriers.



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



# 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



## 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.

## 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 unfoldment. Creates verified part drawings for Laser, punch, and plasma machines.

## 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



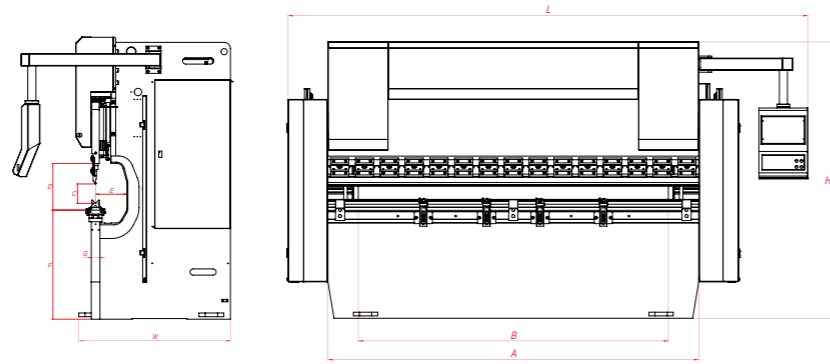
Software



Training



Flexible Solution



## PBF Series Technical Details

			PBF 2560	PBF 30120	PBF 30200
Bending Force	Ton		60	120	200
Bending Length	mm	A	2550	3050	3050
Distance Between Columns	mm	B	2150	2550	2550
Stroke	mm	C	160	180	210
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		250	250	250
X Axes Travel	mm		620	620	620
Motor Power	kW		5,5	11	15
Length	mm	L	3250	3750	3750
Width	mm	W	1200	1230	1390
Height	mm	H	2350	2400	2500
Weight Approx.	kg		4250	5900	8160

## Standard & Optional Equipment

### Standard Equipment

Y1, Y2, X - 3 Axis  
 Control Unit - DT 10 Touch screen 2D graphic (Remote Control)  
 Back gauge: motorized & linear guide & ballscrew  
 European clamping system  
 European clamping system top tool  
 European style bottom tool holder  
 Support arms with T-Slot  
 Safety side covers (Non CE)  
 World known electrical equipments

### Optional Equipment

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

**DURMA**



PANEL BENDER



PUNCH



PRESS BRAKE



VARIABLE RAKE SHEAR



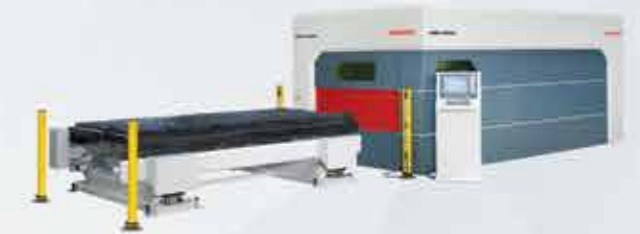
PLASMA



L ANGLE PROCESSING CENTER



TUBE LASER CUTTING



FIBER LASER



IRON WORKER



POWER OPERATED SHEAR



ROLL BENDING



PROFILE BENDING



CORNER NOTCHER

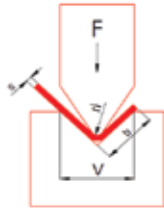
**DURMA**



# DURMA

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) Ri: Inside Radius (mm) Rm: 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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