

Productive, Reliable, Accurate

The *DURMA* Hydraulic Ironworkers are designed with high speed hydraulics which allows higher production, save labor force and lower cost. Latest manufacturing methods applied guarantees longer lifetime and better efficiency.

These universal machines features standard toolings such as; repetition support tables at punch, shear and notch stations and with easily adjusted hold downs at all five work stations. Each work station is equipped with specially designed hold downs to ensure maximum safety and precision.

"Productive, Reliable and Accurate" that is what describes *DURMA* IW series best!

**Easy to
Use**

**Reliable
Brand**

Efficient

Ergonomic



Punching Precision at its Finest!

Precise punching result at fast speed

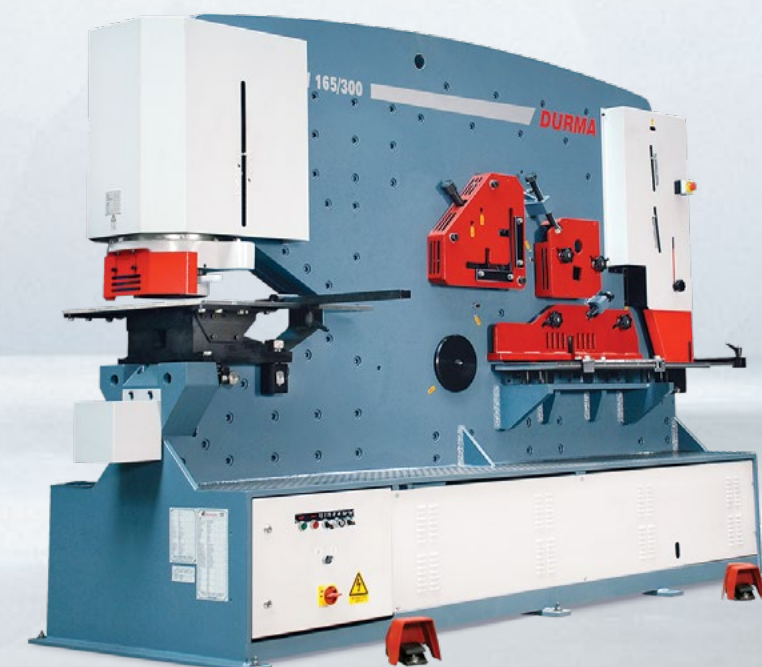
Minimum tool change and adjustment time

Reliable Brand

DURMA IW SERIES IRONWORKERS

Designed with multi-functionality in mind to save labor force, time, energy and cost, *DURMA* ironworkers set the industry standard for reliability, productivity and accuracy.

Dual cylinder ironworkers are available in 55, 80, 100, 110, 150 165, 180 and 300-ton models.



IW Series Features

Punching Station

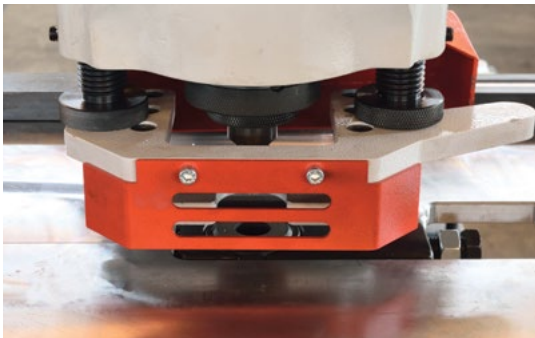
Punching station is designed versatility in mind. The station of bolster plater, makes it possible to perform a wide range of punching. This includes the punching flat bar, flange, angle and channel. The station comes standard with quick change punch and die holders, as well as a swing away stripper. Also included x & y coordinate gauge stops. This feature is useful for repetitive work. At punch station different punching diameter, pipe notching and bending with pres brake attachment can be performed.



String Away Stripper



Press Brake Attachment



Punching Flat Steel



Different Dimension Punch & Dies



Puching Channels Flangers and Angles

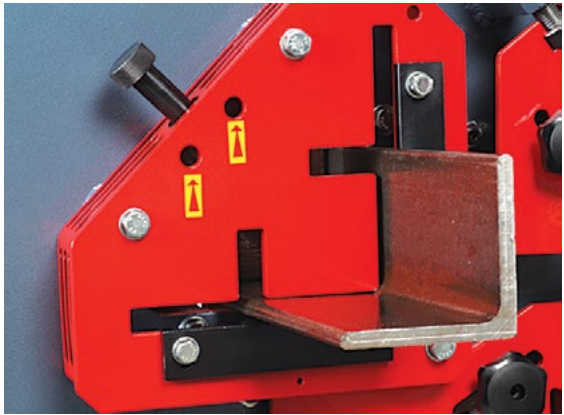


Different Dimension Punch & Dies

IW Series Features

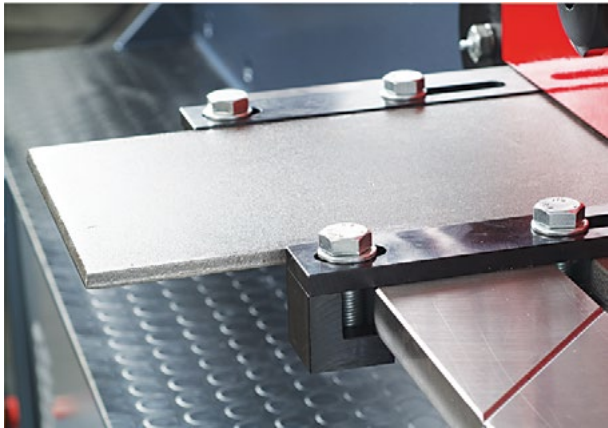
Angle Shearing Station

Blades are four sided and easily installed and rotated. Easy adjustable hold down provides for proper clamping of the material while it is being sheared.



Flat Shearing Station

An easily adjustable hold down ensures proper clamping of the plate. An entry feed table has adjustable guides and stops to make sure the material is accurately placed under the cutting blades. The blades are manufactured in such a way that allows cutting of a wide range of material thickness at a low rake angle and without the need for adjustment.



IW Series Features

Bar Shearing Stations

Bar shearing station consists of square bar shearing, round bar shearing, touch and cut electrical back gauge. Also optional U Blade and optional I&T blades are available upon request.



Square Bar Shearing



Round Bar Shearing



Optional U Blade



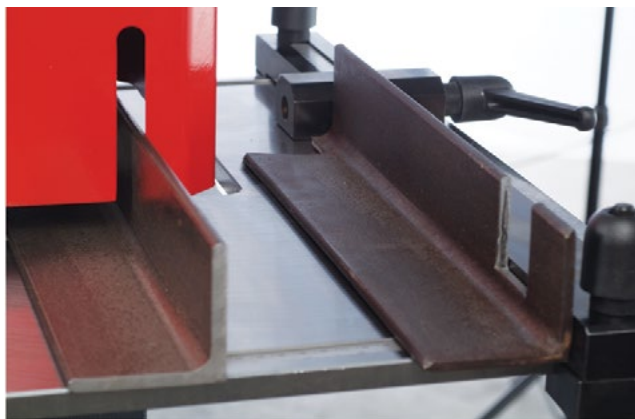
Optional I&T Blades



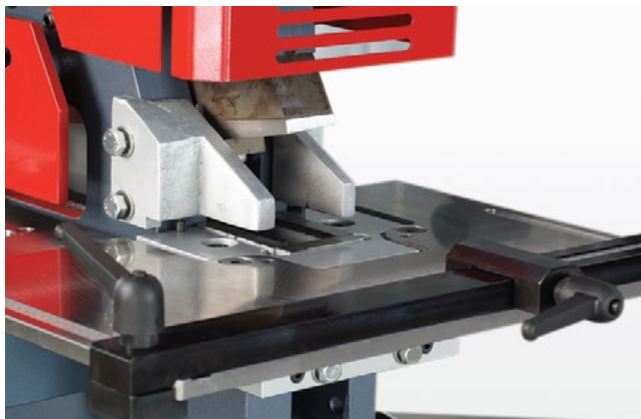
Touch and Cut Electrical Back Gauge

Notching Stations

This station comes standard with rectangular notching blades which allow side notching, therefore allowing nothing of unlimited widths. V-Notching blades can easily be installed and are available as an option. Other optional devices include tube notching. It is also possible to convert this station to a punching or bending station. A large feed and worktable with gauging stops helps speed up repetitive type of work and ease material handling.



Rectengual Notcher



Triangular Notcher Option

IW 45

"It is meant to be everlasting"

- Small Footprint
- Efficient Production
- Rigid Body Structure

"Durma IW 45 is capable of operating when high volume of work is required. 5 stations enable to make the production more efficient and it can be operated by one foot pedal. It is capable of punching, flat shearing, angle shearing, bar shearing and notching that makes it the perfect fit to serve you for your metalworking needs!"



Standard Equipment

- PUNCHING
- Table for punching station
 - Durma punch & die holder
 - 1 starting set (Punch & Die)
 - Punch holder up to 28 mm (IW 45)
 - Punch holder up to 40 mm (IW 55/110-55/110 BTD-80/150-80/150-165/300)
 - 1m. Electrical backgauge (over 55 tons)
 - 1m. Manual backgauge for 36&45 to
 - Blades for flat steel station
 - Blades for angle cutting station
 - Blades for round and square bar cutting station

Optional Equipment

- Illmunations (24V-220V)
- 1 m. Manual backgauge (additional)
- Electrical backgauge (over 1m.)
- Gress pump
- Special colour
- Overseas special packaging

PUNCHING

Pedinghaus, Mubea, Kingsland punch&die holder
Bending equipment (top tool + single Vee + Toolholder)
40-80 NPU punching equipment
"Pipe Notching Equipment (between 1/2"and 2" any diameter) without punch & die
For pipe notching punch and dies (each set)
NC control with table x=1000mm Y=350mm

FLAT SHEARING

Spare blades for flat shearing

ANGLE SHEARING

Spare blades for angle shearing

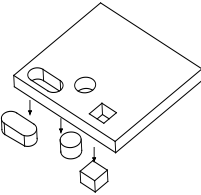
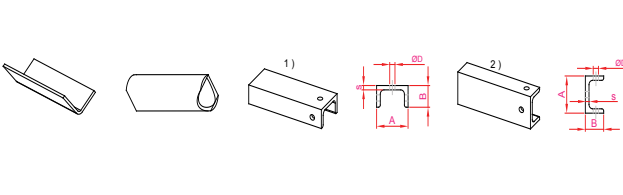
BAR SHEARING

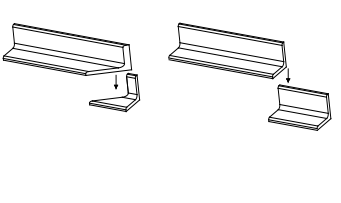
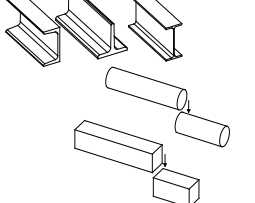
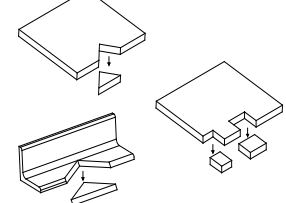
Spare blades for bar shearing

NOTCHING

Triangular notching system with blades
Spare blades for triangular notching
Spare blades for rectangular notching

Iron Worker Series Technical Specification

IW Series	Punching Pressure		Punching Capacity (DiameterxThickness)				Throat Depth		Stroke Lenght		Cycles /Min. (15mm. Stroke)		Cycles /Min. (20mm. Stroke)		Table Size (WxD)		Largest Hole		Single Vee Press Brake (W xT)		Multi-Vee Press Brake (W xT)		Pipe Notching		1) A min-max for NPU		Maximum S-Maximum øD(Accor DIN 997)		2) A min-max for NPU		Flat Bar (max. thickness)		Flat Bar (max. width)		Blade Lenght		Angle Frame Trim	
	Punching																				Flat Shearing																	
																																						
	ton	mm	mm	mm	quat.	quat.	mm	mm	mm	mm	mm	inch	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	
IW 45	45	27x13 18X18	160	21	20	-	450x160	100x3	-	-	-	-	-	-	-	-	-	200x13	300x10	305	80x80x10																	
IW 55/110	55	40x10 20X20	250	60	-	37	550x250	160x2	250x10	500x5	1/2"-2"	120-260	10-Ø25	100-240	200x20	300x15	305	60x60x8																				
IW 55/110 BTD	55	40x10 20X20	510	60	-	37	550x510	160x2	250x10	500x5	1/2"-2"	120-260	10-Ø25	100-240	200x20	300x15	305	60x60x8																				
IW 80/150	80	40x14 24X24	300	70	-	38	550x300	160x3	300x10	600x6	1/2"-2"	120-400	14-Ø28	100-320	300x20	450x15	475	80x80x10																				
IW 80/150 BTD	80	40x14 24X24	510	70	-	38	550x510	160x3	300x10	600x6	1/2"-2"	120-400	14-Ø28	100-320	300x20	450x15	475	80x80x10																				
IW 110/180 BTD	110	40x20 28X28	610	80	-	28	550x610	160x5	300x10	600x8	1/2"-2"	140-400	14-Ø28	100-320	400x20	600x15	605	100x100x12																				
IW 165/300 BTD	165	40x30 34X34	610	90	-	31	750x510	160x7	415x12	835x8	1/2"-2"	120-400	14-Ø28	100-320	400x30	750x20	765	120x120x12																				

At 90° Shearing	At 90° Shearing width slight deformation	At 45° Miter Shearing	Round Bar Shear	Square Bar Shear	U Profile Shear	T Profile Shear	I Profile Shear	Material Thickness	Rectangular Notcher (Width)	Rectangular Notcher (Depth)	Vee-Notcher (SidexSidexT)	Triangular Notching Material Thicknes	Triangular Notching Width V90	Triangular Notching Depth	Motor Power	Oil Capacity	Weight	Machine Dimension (LxWxH)	Working Height
Angle Shearing		Bar Shearing						Notching						General Information					
																			
mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	kw	lt	kg	mm	mm
80x80x8	100x100x10	-	30	30	-	-	-	7	40	50	40x40x7	4	75	75	3	33	870	1460x1400x1620	1010
120x120x10	-	70x70x7	20-40	20-40	120	50	120	10	42	90	42x42x10	6	95	95	5.5	76	1250	1480x1800x1730	1080
120x120x10	-	70x70x7	20-40	20-40	120	50	120	10	42	90	42x42x10	6	95	95	5.5	76	1660	1980x1800x1730	1088
130x130x13	-	70x70x7	45	45	140	60	140	12	52	90	52x52x12	6	125	125	11	76	2250	2025x1780x2700	1195
130x130x13	-	70x70x7	45	45	140	60	140	12	52	90	52x52x12	6	125	125	11	76	2500	2120x2025x1780	1195
152x152x13	-	70x70x7	50	50	160	60	160	13	52	90	52x52x13	6	125	125	15	76	3600	2560x2550x1790	1260
205x205x18	-	70x70x7	60	60	200	80	200	16	58	110	58x58x16	10	125	125	22	150	8000	3230x1100x2280	1110