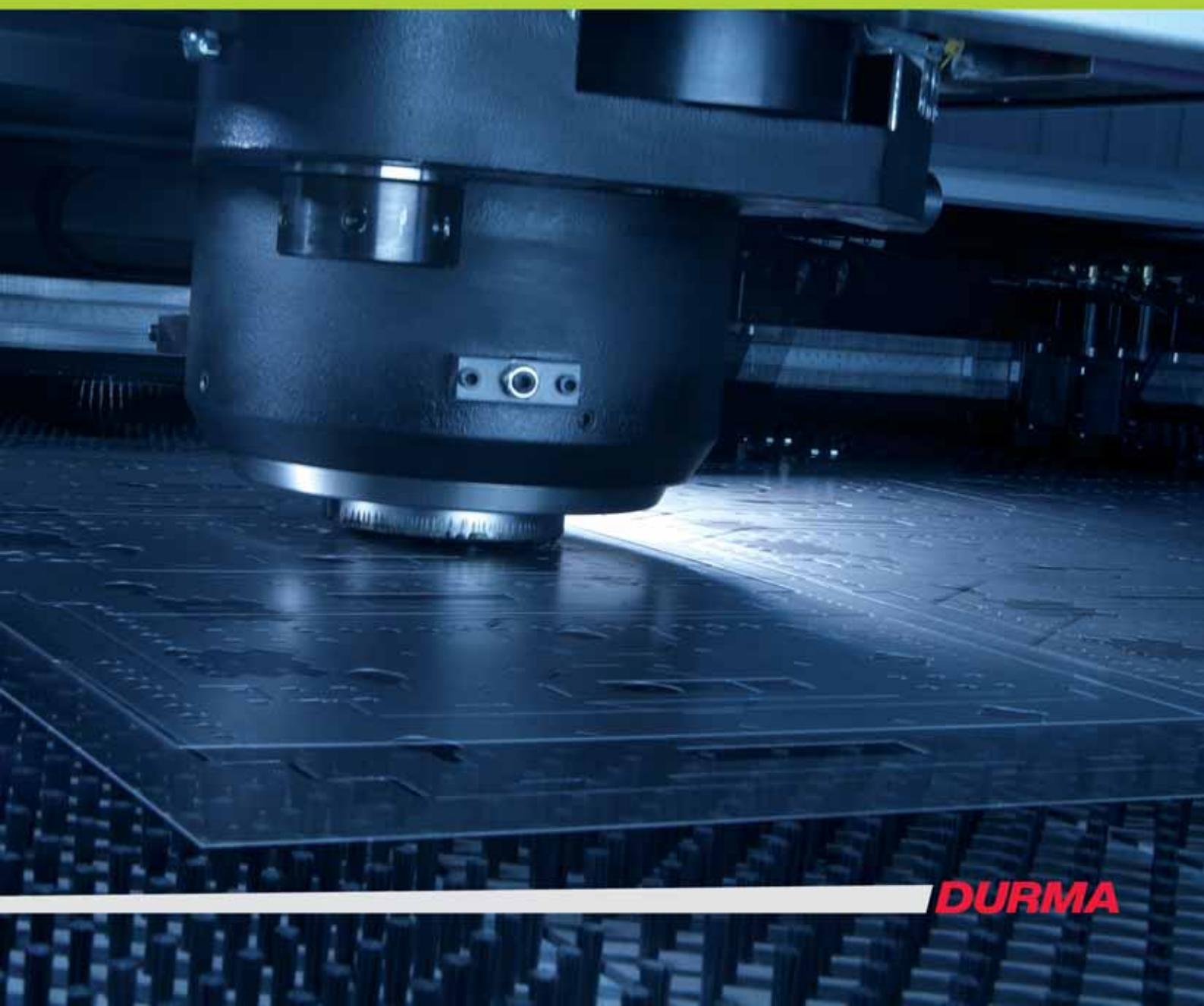


# **DURMA**

**FP SERIES  
RP SERIES**

Fixed Punching Machines  
Rotation Punching Machines



**DURMA**

## FP6 SERIES

### Multi-Tool Fix Punch Press

The new FP6 Multi -Tool Fix Punch Press from Durmazlar has multi tool with 6 tools and 30 Ton capacity. The main frame is made of welded steel construction. All the stressed points were designed with large radius to prevent welding cracks. The frame is fully stress relieved during welding and after welding. The machine has very strong and rigid frame according to its competitors. The X & Y axes are on liner guide ways and ball screws. Each axis is controlled by servo-motor. Electrical circuit components are supplied by Siemens, Telemecanique and Merlin Gerin. Position accuracy is 0.1 mm. Hydraulic system components are supplied by Rexroth & Bosch. The hydraulic seals are supplied by Merkel or Busak. The machine has auto sheet lubrication system.

The 6 stations multi tool reducers are used to convert to A, B, C, D style tooling. This machine can use Trumpf and thick turret type tooling. Automatic repositioning System, allows punching in the clamp areas, on long sheets 2000+



#### Standard Equipment

- 2 Pieces Clamps
- 1 Pieces command pedal
- standart tool customer demand
- 6 pieces thick turret tool and guide (gap 0.2 mm)
  - round Ø6
  - round Ø8
  - round Ø12.7
  - rectangle 4 x 10
  - rectangle 4 x 10
  - square 10

or



- 6 pieces Durma tool and guide (gap 0.3 mm)
  - round Ø8
  - round Ø10
  - round Ø20
  - rectangle 4 x 20
  - rectangle 20 x 4
  - square 17
- Machine instruction and maintenance manual
- 1 piece software PUNCH 5 or cncKAD and 1 piece activator (lock)
- 1 piece floppy driver
- 1 piece USB driver
- Automatic sheet lubrication
- Scrap box
- Control panel



### Optional Equipment

- Cutting and forming tools in different kinds of dimensions and forms
- CE Mechanical protection system and safety bar around the machines
- Additional clamps
- 4 stationed multi tool and PLC support
- Different kinds of software options
- CD-ROM driver
- Adapters for different stations (like B-C-D)
- Required adapters for Trumpf connection system
- Coated tools, to be used especially for stainless steel material cutting
- Second soft key



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

## RP6 SERIES Rotation Multi-Tool Punch

Durma rotation punch is cost effective machine by using few numbers of tools (3, 6, 8, 10 tools) you can punch every type of angular shapes.

Specially designed for

- High flexibility
- Maximum efficiency
- High productivity
- Fast simple operation
- Strong and reliable construction

Material up to 6 mm can be punched and clamped easily. The machine frame is made of welded steel construction. Frame is fully stress relieved during and after welding. Positioning accuracy  $\pm 0,1$  mm and repeatability  $\pm 0,05$  mm



### Control System

Siemens Sinumerik 840 DI control system is applied for punching with strategic alliance with Siemens. Controls and screen are mounted on a mobile control panel. The computer and other hardware are mounted in a separate cabinet. Machining can be started with just a few steps. Network (Ethernet or RS 232), COM-Port 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 answers all questions at the location they arise. The diagnostic concept provides visual depictions of any function faults. Tele service is a matter of course over Internet for diagnostics options 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.

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



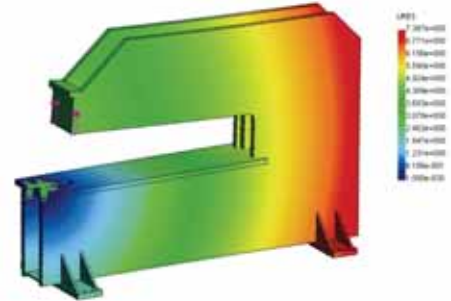
**DURMA**

## RP6 SERIES Rotation Multi-Tool Punch



Durma rotation punch press machine top and bottom tools work synchronize to obtain all required angular punching and forming operation. The angular pitch can be  $\pm 0,02^\circ$ .

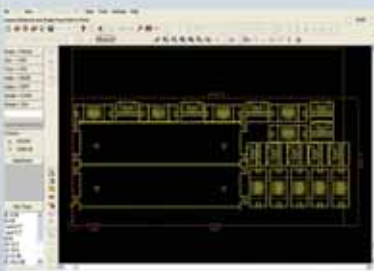
- High rotational speed 50 rpm makes the machine one of the fastest in the market.
- By using zero backlash Harmonic Drive Gear system for index position punching.
- Automatic reposition in the X axis enables to punch longer than 2 meters and eliminate the death area on the sheet.



Ball table mainly easy movement of the sheet, brush table is generally for sensitive and soft material punching for not to scratch the sheet. Both is available according customer demands.



- Adjustable clamp positioning system and sheet removable sensor is optional.



- Programming time minimized by using fast and easy CAD-CAM software (cncKAD, Linea 5)
- By choosing the effective position of the tool automatically to use maximum area of the sheet, additional reposition and work strips is eliminated.



- Upper and lower index groups have no mechanical connections which means they can be perfectly aligned, even defect in the tools can be adjusted. It has a wide tooling usage capacity with 3, 6, 8, 10 tools multi tool selection.

# RP6 SERIES

## Rotation Multi-Tool Punch

### Standard Equipment

- 2 Pieces Clamps
- 1 Pieces command pedal
- standart tool customer demand
- 8 pieces Wilson tool and guide( gap 0.2 mm )
- round Ø5
- round Ø6
- round Ø8
- round Ø12.7
- rectangle 5 x 10
- rectangle 3 x 14
- square 7
- square 10

or

- 6 pieces Durma tool and Fguide( gap 0.3 mm )
- round Ø8
- round Ø10
- round Ø20
- rectangle 4 x 20
- square 7
- square 17
- Machine instruction and maintenance manual
- 1 piece software PUNCH5 or cnckAD and 1 piece activator (lock)
- 1 piece floppy driver
- 1 piece USB driver
- Automatic sheet lubrication
- Scrap box
- Control panel
- Cooler

### Optional Equipment

- Cutting and forming tools in different kinds of dimensions and forms
- CE Mechanical protection system and safety bar around the machines
- Additional clamps
- 3, 10 stationned multi tool and PLC support
- Different kinds of software options
- CD-ROM driver
- Adapters for different stations (like B-C-D)
- Required adapters for Trumpf connection system
- Coated tools, to be used especially for stainless steel material cutting
- Second soft key

FP/RP SERIES		FP6 12530	RP6 12530	RP9 12530
Maximum tonnage	ton	30	30	20
X axis movement	mm.	2000 + R	2000 + R	2000 + R
Y axis movement with multiple tool	mm.	1250	1250	1250
Y axis movement with single tool	mm.	1285	1285	1285
Automatic positioning range	mm.	10000*	10000*	10000*
Speed of Y axis	m./min.	50	50	75
Speed of X axis	m./min.	60	60	96
Lateral speed Y + X	m./min.	75	75	120
Max. working cycles ( in 1 mm. step, 1 mm. thickness )	stroke/min.	600	600	850
Max. working cycles ( in 25 mm. step, 1 mm. thickness )	stroke/min.	280	280	320
Accuracy for positioning	mm.	± 0.1	± 0.1	± 0.1
Tool setting time	sec.	15 - 20	15 - 20	15 - 20
Quantity of station	pcs.	6	8 or 6	8 or 6
Max. weight of sheet	kg.	100	100	120
Hard disk	Gbyte	40	40	40
RAM	Mb EDO	256	256	256
Network system	-	Windows XP	Windows XP	Windows XP
LCD colorscreen Super VGA	-	12.1"	12.1"	12.1"
Floppy disk	-	3.5"	3.5"	3.5"
Working height	mm.	980	980	980
Table width	mm.	2400 x 3600	2400 x 3600	2400 x 3600
Machine sizes	mm.	3600 x 4100 x 2450	3600 x 4100 x 2450	3600 x 4100 x 2450
Motor	kw.	15	15	7.5
Oil tank	lt.	250	250	200
Weight	kg.	~ 11100	~ 11100	~ 11100
Maximum punching stroke	mm.	25	25	25
Maximum punching diameter ( for Multitool )	mm.	24	16 or 24	16 or 24
Workholder number	pcs.	2	2	2-3**
Workholder force	kg.	1000	1000	840
Table type	-	Brush	Brush	Brush
	-	Ball **	Ball **	Ball **
	-	Ball + Brush **	Ball + Brush **	Ball + Brush **

\* : Special table must be added to the machine and the light barriers must be located the correct position. Max.weight 100 kg.

\*\* : Optional

# ***DURMA***

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FP-RP / ENG 05-08