

# IW SERIES

Iron Workers  
 IW 55/110 - IW 55/110 BTD  
 IW 80/150 - IW 80/150 BTD  
 IW 110/180 BTD



The DURMA Hydraulic Ironworkers are designed with multi-functions to save labor, time energy and cost. DURMA Ironworkers are well engineered, maximum efficiency and long life is guaranteed by latest manufacturing methods. These universal machines are supplied with standard tooling including 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 safety while providing precision and easy use.

DURMA Ironworkers stand for reliability, productivity and accuracy.

## P SERIES Punching Machines

		P 55	P 80	P 110
<b>PUNCHING</b>				
Punching Pressure (ton)	ton	55	80	110
Punch Capacity (Diameter x Thickness)	mm	Ø40x10 Ø20x20	Ø40x12 Ø24x24	Ø40x14 Ø28x28
Throat Depth	mm	510	510	610
Stroke length	mm	60	70	80
Cycles /Min. (20 mm stroke)	quat.	37	38	28
Table Size (W x D)	mm	550x510	550x510	550x610
Working Height up to Die	mm	1100	1195	1275
<b>OPTIONAL EQUIPMENT</b>				
Largest Hole	mm	Ø160	Ø160	Ø160
Single Vee Press Brake (W x T)	mm	250x10	300x10	300x10
Multi-Vee Press Brake (W x T)	mm	500x5	600x6	600x8
Pipe Notching	inch	1/2"-2"	1/2"-2"	1/2"-2"
A min-max	mm	120 - 260	120 - 400	140 - 400
ØD max	mm	(DIN 997) 25	(DIN 997) 28	(DIN 997) 28
S max	mm	(DIN 997) 10	(DIN 997) 14	(DIN 997) 14
B min-max	mm	100 - 320	120 - 320	120 - 400
ØD max	mm	(DIN 997)	(DIN 997)	(DIN 997)
S max	mm	(DIN 997)	(DIN 997)	(DIN 997)
<b>TECHNICAL DATA</b>				
Motorpower	KW	5,5	11	11
Oil Capacity	lt	76	76	76
Net Weight (Apr.)	kg	1300	1940	2660
Gross Weight (Apr.)	kg	1320	1960	2680
Machine Dimension (Apr.) (L x W x H)	mm	1340x930x1850	1520x930x2000	1690x930x2180
Packing Dimension (Apr.) (L x W x H)	mm	1380x700x2000	1600x820x2050	1760x820x2240

Specifications subject to change without notice.



IW SERIES	IW45	IW45 M	IW 55/110	IW 55/110 BTD	IW80/150	IW80/150 BTD	IW 11/180 BTD	
<b>PUNCHING</b>								
Punching Pressure	ton	45	45	55	55	80	80	110
Punch Capacity (Diameter x Thickness)	mm	Ø18x18 Ø18x18	Ø18x18 Ø18x18	Ø40x10 Ø20x20	Ø40x10 Ø20x20	Ø40x14 Ø24x24	Ø40x14 Ø24x24	Ø40x20 Ø28x28
Throat Depth	mm	160	160	250	510	300	510	610
Stroke length	quat.	21	21	60	60	70	70	80
Cycles /Min. (20 mm stroke)	mm	20	20	37	37	38	38	28
Table Size (W x D)	mm	450x160	450x160	550x250	550x510	550x300	550x510	550x610
Working Height up to Die	mm	1010	1010	1080	1088	1195	1195	1260
<b>OPTIONAL EQUIPMENT</b>								
Largest Hole	mm	Ø100	Ø100	Ø160	Ø160	Ø160	Ø160	Ø160
Single Vee Press Brake (W x T)	mm	-	-	250x10	250x10	300x10	300x10	300x10
Multi-Vee Press Brake (W x T)	mm	-	-	500x5	500x5	600x6	600x6	600x8
	inch	-	-	1/2" - 2"	1/2" - 2"	1/2" - 2"	1/2" - 2"	1/2" - 2"
A min-max	mm	-	-	120 - 260	120 - 260	120 - 400	120 - 400	140 - 400
ØD max	mm	-	-	(DIN 997) 25	(DIN 997) 25	(DIN 997) 28	(DIN 997) 28	(DIN 997) 28
S max	mm	-	-	(DIN 997) 10	(DIN 997) 10	(DIN 997) 14	(DIN 997) 14	(DIN 997) 14
B min-max	mm	-	-	100 - 240	100 - 240	100 - 320	100 - 320	120 - 320
ØD max	mm	-	-	(DIN 997)	(DIN 997)	(DIN 997)	(DIN 997)	(DIN 997)
S max	mm	-	-	(DIN 997)	(DIN 997)	(DIN 997)	(DIN 997)	(DIN 997)
<b>FLAT SHEARING</b>								
Flat Bar (max. thickness)	mm	200x13	200x13	200x20	200x20	300x20	300x20	400x20
Flat Bar (max. width)	mm	300x10	300x10	300x15	300x15	450x15	450x15	600x15
Blade Length	mm	305	305	305	305	475	475	605
Angle Flange Trim	mm	80	80	60	60	80	80	100
Working Height	mm	1010	1010	890	890	1032	1032	1085
<b>ANGLE SHEARING</b>								
At 90° Shearing	mm	80x80x8	80x80x8	120x120x10	120x120x10	130x130x13	130x130x13	152x152x13
At 45° Miter Shearing	mm	-	60x60x6	70x70x7	70x70x7	70x70x7	70x70x7	70x70x7
Working Height	mm	1020	1020	1100	1100	1250	1250	1305
<b>BAR SHEARING</b>								
Round Bar Shear	mm	30	25	16-40	16-40	45	45	50
Square Bar Shear	mm	30	22	16-40	16-40	45	45	50
Working Height	mm	1040	1130	1060	1060	1310	1310	1380
<b>OPTIONAL EQUIPMENT</b>								
U - Profil Shear	mm	100	100	120	120	140	140	160
T - Profil Shear	mm	40	40	50	50	60	60	60
I - Profil Shear	mm	100	100	120	120	140	140	160
<b>NOTCHING</b>								
Material thickness	mm	7	7	10	10	12	12	13
Rectangular Notcher (width)	mm	40	40	42	42	52	52	52
Rectangular Notcher (depth)	mm	50	50	90	90	90	90	90
Vee-Notcher (Side x Side x T)	mm	40x40x7	40x40x7	42x42x10	42x42x10	52x52x12	52x52x12	52x52x13
<b>OPTIONAL EQUIPMENTS</b>								
Thickness	mm	4	4	6	6	6	6	6
Width V90	mm	75	75	95	95	125	125	125
Depth	mm	75	75	95	95	125	125	125
<b>TECHNICAL DATA</b>								
Motorpower	KW	3	3	5,5	5,5	11	11	11
Oil Capacity	lt	33	33	76	76	76	76	76
Net Weight (Apr.)	kg	790	830	1280	1365	2680	2680	3730
Gross Weight (Apr.)	kg	810	850	1300	1385	2700	2700	3750
Machine Dimension (Apr.) (L x W x H)	mm	1460x1400x1620	1460x1580x1450	1480x1800x1730	1980x1800x1730	2025x1780x2700	2120x2025x1780	2560x2550x1790
Packing Dimension (Apr.) (L x W x H)	mm	1450x1480x700	1450x1600x700	1560x1840x700	1980x1840x820	1980x2090x820	2190x2090x820	2540x2280x820

Specifications subject to change without notice.



**Punching Station**



The punching station comes standard with quick change punch and die holders, as well as a swing away stripper



Punching channel flanges and angles



Punching flat steel



Different dimension Punch & Dies



Iron Workers  
Punch



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**DURMA**



## Bar Shearing Stations

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.



Square bar shearing



Round bar shearing



Square bar shearing



Optional T & C blades



Touch and feel electrical back gauge

## Notching Station

This station comes standard with rectangular notching blades which allow side notching, therefore allowing notching of unlimited widths. Vee 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 work and ease material handling.



Rectangular Notcher



Triangular Notcher (Option)



Well know and quality hydraulic parts guarantees perfect reliability on the hydraulic system



Limit switches enable setting of short punch and notch stroke to improve efficiency

## IW 45 & IW 45 M



Durma IW 45 Series Ironworkers are specially designed for high volumes and with its 5 stations enables to make efficient production. 45 ton machines have single cylinder and 5 stations can be operated by one foot pedal.



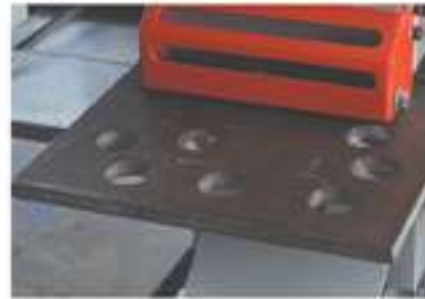
## Punching Station



Punching station has max. capacity of Ø27 x13 & Ø18 x18



Swing away stripper



Punching flat steel

## Flat Shearing Station



200x15 mm. & 300x12 mm. flat steel cutting capacity

## Angle Shearing Station for IW45 M



At angle shear station with Z shape aperture, it is possible to make miter shear on angle bars

## Angle Shearing Station for IW45



## Notching Station



In this station standard rectangular notching and with special blade triangular notching can be performed

## Bar Shearing Stations



This station allows to cut special bars with special blades such as round, square, channels and many other special profiles

## Punching Station

The punch station is designed with versatility in mind. The design of the bolster plate, makes it possible to perform a wide range of punching. This includes the punching of 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 are x & y coordinate gauge stops. This feature is useful for repetitive work. At punch station different punching diameter, pipe notching and bending with press brake attachment can be performed.



Swing away stripper



Punching flat steel



Punching channel flanges and angles



Press brake attachment



Different dimension punch & dies



## Angle Shearing Station

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



45° miter cut and 90° shearing



## 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.

