

DURMA
VS SERİSİ

CNC - Açı Ayarlı Giotin Makas



DURMA

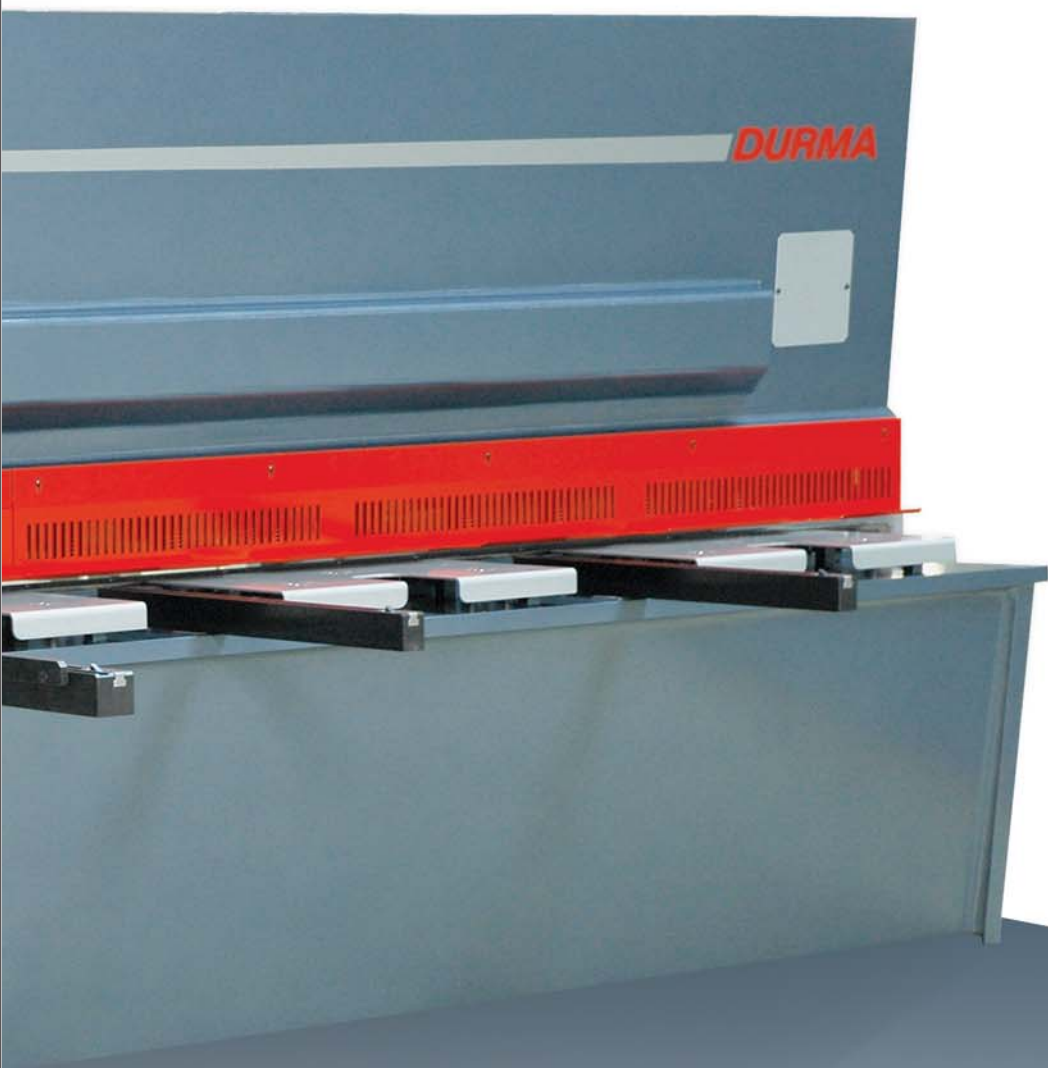
VS SERIES

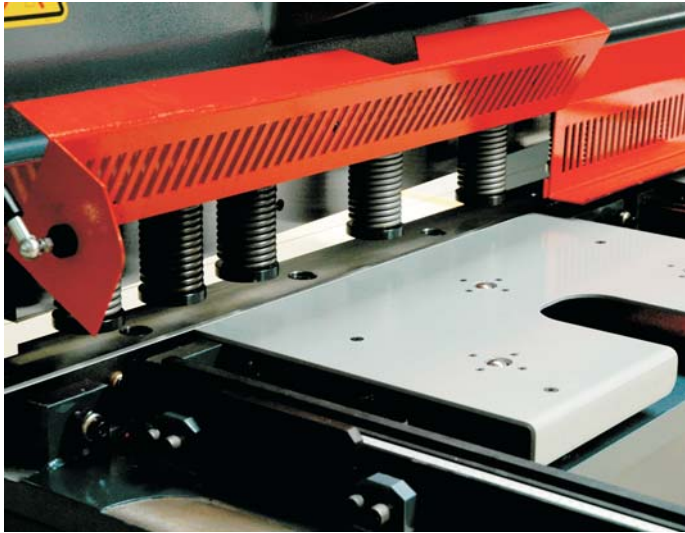
CNC Variable Rake Shears

The blade beam is secured during its cycle by adjustable preloaded and hardened guide ways. Both the beam blade and the rake angle adjustment are done hydraulically ensuring reduced maintenance and overload protected operation.

The VS (variable rake) series of shears are equipped with powered or CNC controlled adjustment of the upper blade rake angle and blade clearance. The rake angle can actually be reduced as low as 0.30°. This is helpful in reducing distortion on thin narrow strips. When equipped with CNC control, the operator simply enters material type, thickness, back gauge dimension, the CNC will then automatically set the blade clearance and rake angle accordingly, as well as back gauge position. Although available in all plate sizes, we typically offer this model in twenty foot lengths in thickness from 6mm. through 20mm.

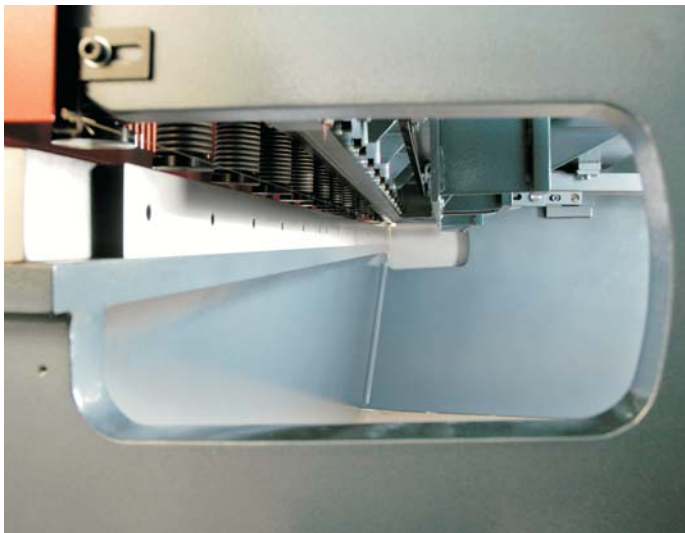






Finger Guard, Ball Transfers & Holddowns

The first one meter of the finger guard can be flipped up out of the way for easy viewing of the work piece at the point of cut. Holddowns are provided to ensure that the plate is held firmly along the length of the cutting area. The holddowns are distributed in such a way that more are closer at each end of the table. This guarantees not only safer operation at the beginning and end of the cut but also the accuracy for narrow (short) plates at each end of the machine. Each independently acting holddown is capable of applying high pressure to hold the material being cut at the same time preventing thin and delicate materials from being marked.



Large Gap

Large gaps (minimum 350 mm) in the side frames allow shearing of sheets longer than the blade length.



Back Gauge

The backgauge adjustment, standart range 1000 mm, has play free straight guides and re-circulating ball spindles; it has speed of 200 mm/sec, a setting accuracy of 0,1 mm and a repetitive accuracy of +/-0,1 mm (by means of a closed loop control). A standard feature of the backgague is clearance compensation and it retracts automatically when cutting narrow strips.

Back gauge can swing away at the end of its travel to allow the shearing of unlimited length drop pieces.



CNC Control

For shears with up to maximum 4 axes. The specific software handles all functions of this machine, like back gauge, back gauge retraction, back gauge removal, X1-X2 front gauges, free axes (feeder, loader, etc.) and, ofcourse, automatically adjusts rake angle, blade gap (1 or 2 actuators), cutting length. The CNC can display predefined messages.



Protractor

This device allows easy and fast angle cutting of the sheet. Calibrated in degrees the operator can position the sheet at the angle of cut desired.

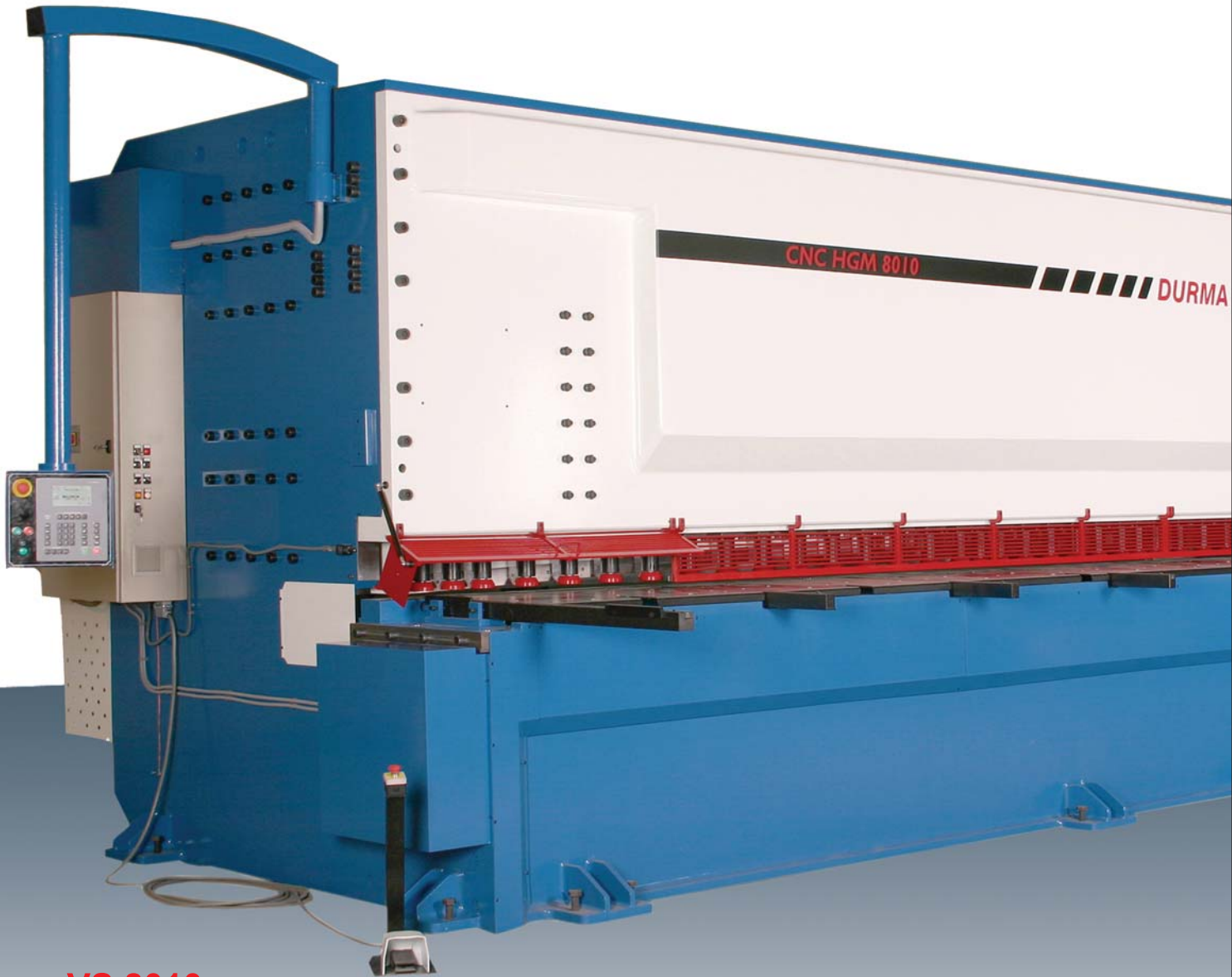
(Option)



Rear Sheet Support System

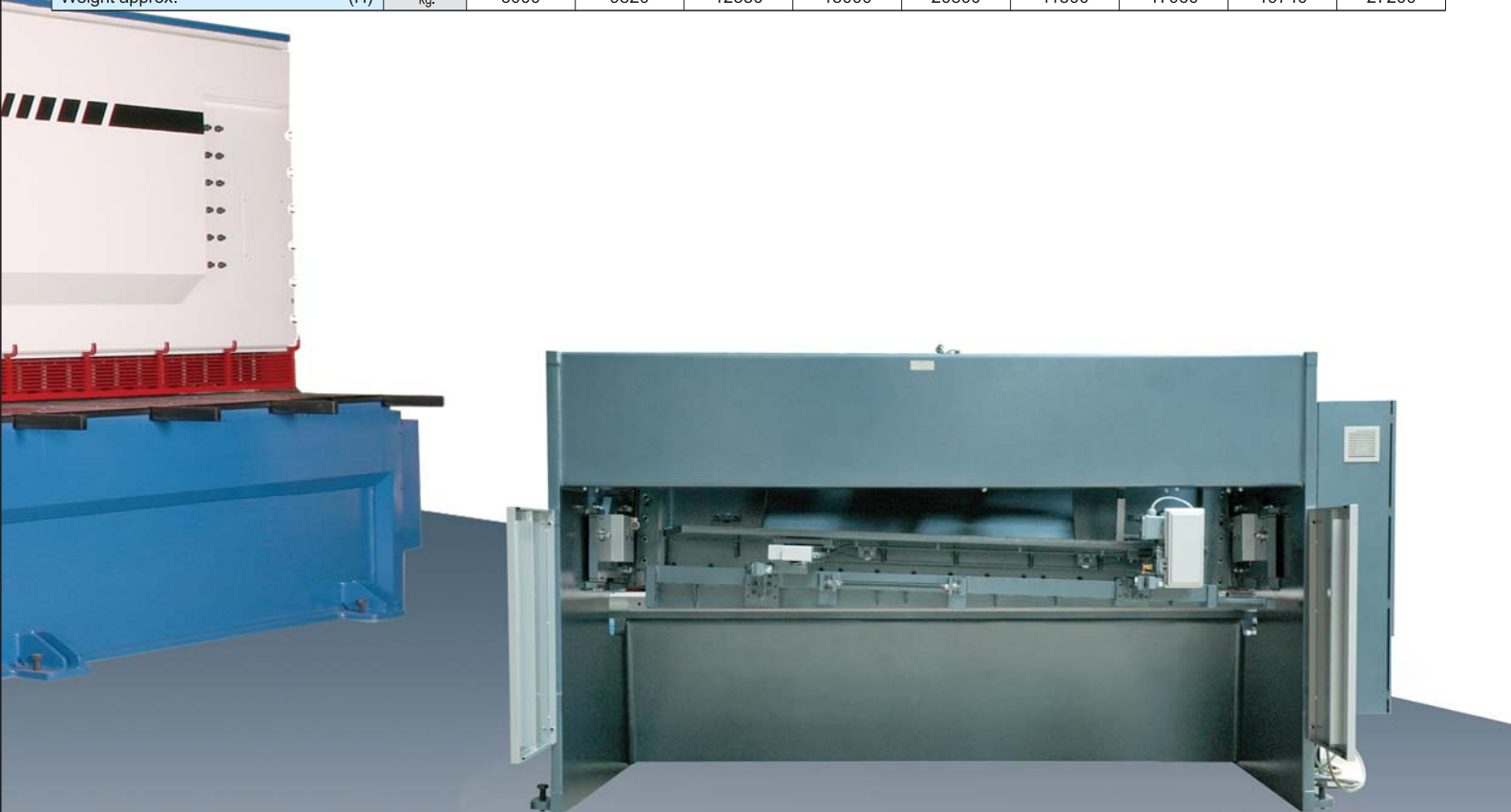
When shearing long drop pieces of thin material the sheet can droop before it reaches the gauge bar, therefore making it impossible to gauge or, at least gauge accurately. In this system support arms which are pneumatically activated support the sheet while gauging and then automatically move away for shearing after the sheet is securely clamped and gauged. This also eliminates the need to front gauge and the need for the operator or additional personnel, to manually support the sheet from the rear side of the machine, which is not only costly, but unsafe.

(Option)

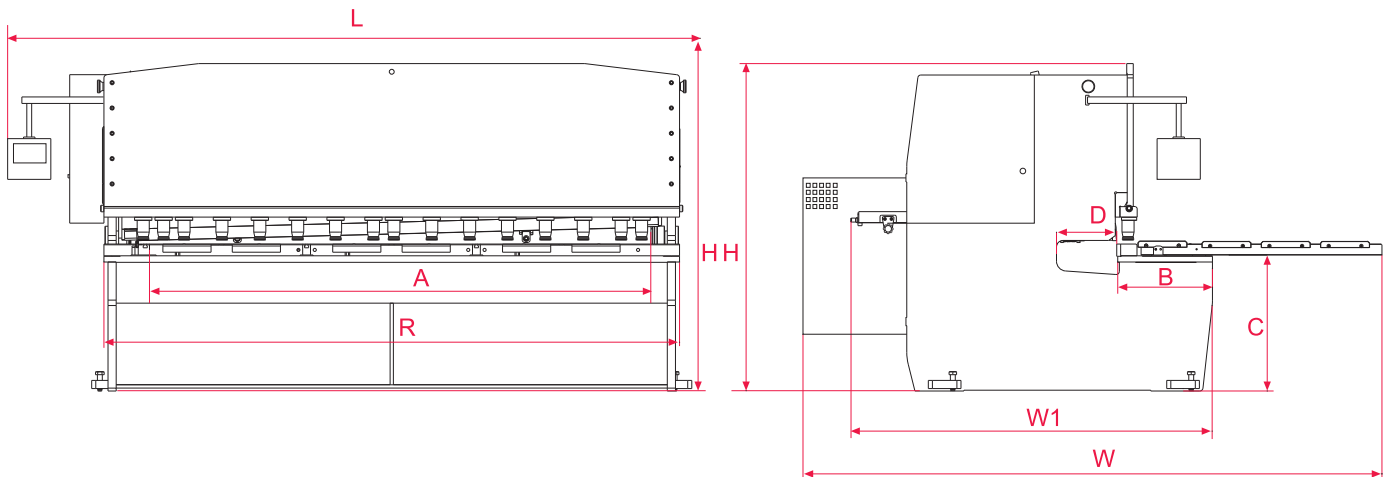


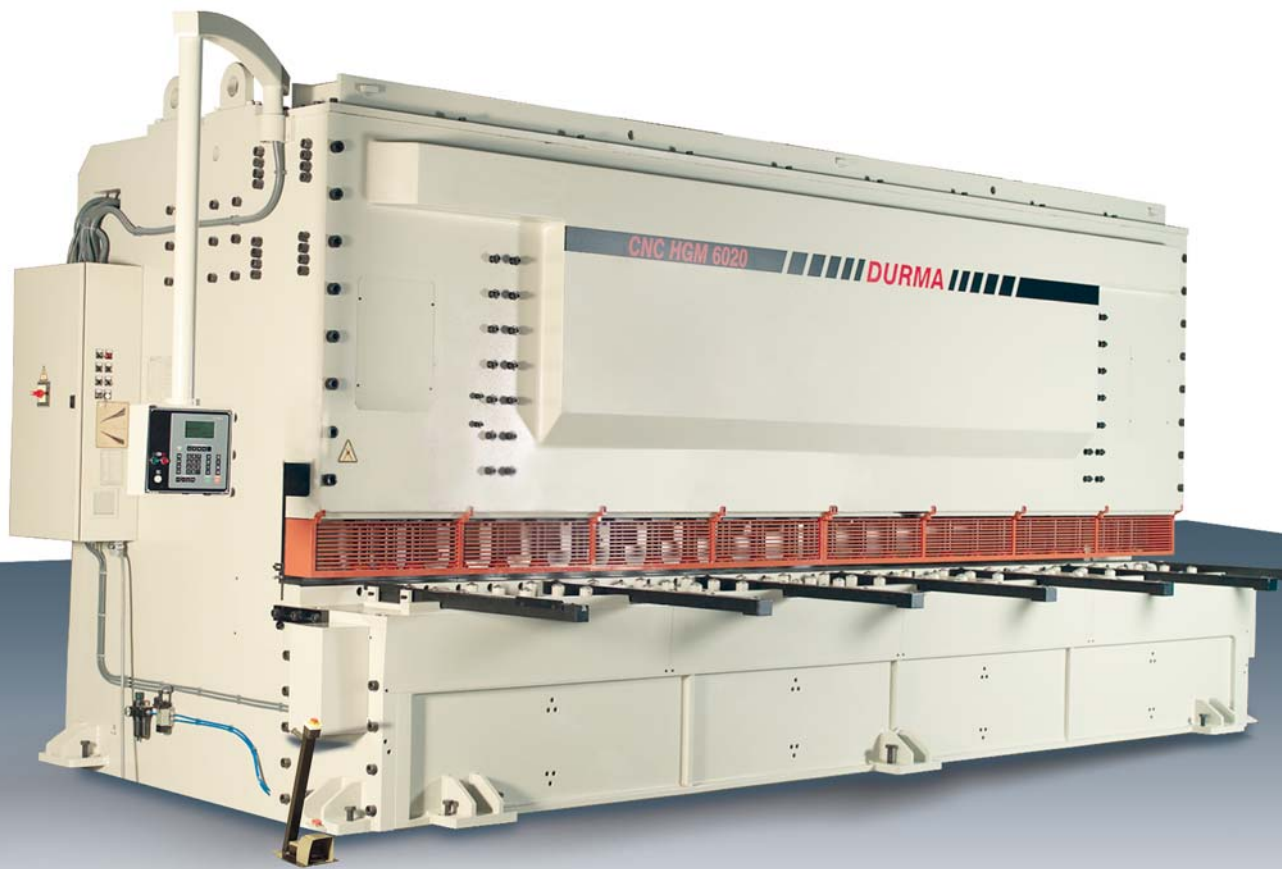
VS 8010

VS SERIES			3006	3010	3013	3016	3020	4006	4013	4016	4020
Cutting length	(A)	mm.	3080	3080	3080	3080	3080	4080	4080	4080	4080
Cutting capacity	MS (450 N/mm ²)	mm.	6	10	13	16	20	6	13	16	20
	SS (700 N/mm ²)	mm.	4	6	8	10	13	4	8	10	13
Stroke per min	min./min.		12	10	10	7	5	10	8	8	4
	max./min.		30	20	20	11	8	28	14	16	8
Rake angle	minimum		0°30'	0°30'	0°30'	0°30'	0°30'	0°30'	0°30'	0°30'	0°30'
	maximum		2°	2°	2°30'	2°30'	2°30'	2°	2°30'	2°30'	2°30'
Blade gap adjustment	min./mm.		0.05	0.05	0.05	0.07	0.09	0.05	0.05	0.07	0.09
	max./mm.		0.75	1.05	1.45	1.80	2.20	0.75	1.45	1.80	2.20
Table height	(C)	mm.	907	907	935	935	900	907	908	935	900
Table width	(B)	mm.	494	554	559	554	580	494	589	554	600
Table length	(R)	mm.	3280	3360	3380	3420	3460	4290	4400	4440	4460
Number of holddowns		amount	14	14	14	14	14	18	18	18	18
Holddown force	min./ton		6	12	16	21	27	7	20	26	32
	max./ton		11	24	32	42	53	14	39	51	65
Back gauge range		mm.	1000	1000	1000	1000	1000	1000	1000	1000	1000
Back gauge power		kw.	0.75	0.75	0.75	0.75	1.1	1.1	1.1	1.1	1.5
Back gauge speed		1/min.	200	200	200	200	200	200	200	200	200
Motor power		kw.	11	22	30	45	45	11	30	45	45
Oil capacity		lt.	125	180	300	450	500	140	300	400	500
Throat depth	(D)	standard/mm.	350	350	350	350	350	350	350	350	350
Number of sheet supports		amount	2	2	2	2	2	3	3	3	3
Length		mm.	3750	3800	4200	3800	4100	5150	5000	5200	5200
Width	(L)	mm.	2100	2250	2250	2250	2350	2100	2250	2250	2350
Total width	(W1)	mm.	3550	3550	3500	3950	3850	3550	3100	3950	3700
Height	(W)	mm.	2000	2350	2200	2420	2800	2050	2400	2250	2750
Weight approx.	(H)	kg.	6000	9820	12380	15000	20800	11300	17060	19740	27200



VS SERIES			6006	6013	6016	6020	8010	10013
Cutting length (A)		mm.	6080	6080	6080	6080	8100	10100
Cutting capacity	MS (450 N/mm ²)	mm.	6	13	16	20	10	13
	SS (700 N/mm ²)	mm.	4	8	10	13	6	8
Stroke per min	min./min.		9	6	5	5	3	3
	max./min.		20	14	12	12	6	6
rake angle	minimum		0°30'	0°30'	0°30'	0°30'	0°30'	0°30'
	maximum		2°	2°30'	2°30'	3°15'	2°	2°12'
Blade gap adjustment	min./mm.		0.05	0.05	0.07	0.09	0.05	0.05
	max./mm.		0.75	1.45	1.80	2.20	1.05	1.45
Table height (C)	mm.		880	1004	1035	1040	1220	1210
Table width (B)	mm.		610	590	550	800	850	860
Table length (R)	mm.		6370	6490	6480	6595	8545	10630
Number of holddowns	amount		30	30	30	27	40	52
Holddown force	min./ton		10	29	38	48	40	60
	max./ton		20	58	75	95	60	81
Back gauge range	mm.		1000	1000	1000	1000	1000	1500
Back gauge power	kw.		1.5	1.5	1.5	1.1	3	4
Back gauge speed	1/min.		200	200	200	200	200	200
Motor power	kw.		22	37	45	45	30	45
Oil capacity	lt.		160	400	550	700	550	650
Throat depth	standard/mm.		350	350	350	350	500	750
Number of sheet supports	amount		5	5	5	6	6	8
Length	mm.		7100	7300	7300	8100	9100	11500
Width (L)	mm.		2200	2350	2350	3300	3350	3400
Total width (W1)	mm.		3550	4100	4100	3650	4200	4240
Height (W)	mm.		2200	2720	3100	3180	3280	3800
Weight approx. (H)	kg.		20360	30340	36500	73000	87000	147000





VS 6020

Standard Equipment

- Independent hold downs
- Motorized blade gap adjustment by DNC
- Variable cutting length by DNC
- Rake angle adjustment
- 1000 mm DNC controlled back gauge on ball screws
- 1500 mm front support arms with T-slot
- Two 1000 mm squaring arms with T-slot & disappearing stop
- Table with Ball transfers
- Remote foot control
- 1000 mm flip up finger guard
- Emergency stop buttons
- Scales mm & inch
- Pendant arm control
- Shadow light

Optionel Equipment

- 2000 mm & 3000 mm sheet supports
- Laser Beam Guard
- Front gauge
- 0-180° adjustable protractor
- Pneumatic Thin sheet support
- Oil cooler
- Throat depth 500 mm and more
- Increased strokes per minute
- Hydraulic Swing-up back gauge

DURMA

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