



Head Quarter & Ataevler

## Durmazlar has aimed continous development since 1956

Owes one of the world's most contemporary production plants in the production technology business .3 different plants oriented to different product families, 1000 dedicated employees and 150.000 m2 footprint.

In order to offer solution according to clients' needs and enriching the quantity and quality of its own patent rights; long experienced Engineering Department transformed to Durma Research & Develepment Center has opened in the year 2010. Designed and engineered with modern technics; its products are equipped with proven quality components to precisely fulfill your requirements. We serve " accuracy, speed, flexibility, durability, reliability and advanced technology" with high performance/price ratio.Worldwide Durma distributors and technical support network assures perfect support to our clients.

With its 55 years of experience, its product quality, innovative solutions Durma gives importance and cares you with proactive approach. We thank all our clients to hold us at the top segment of the world brands.



Ataevler



Laser Factory



Başköy Factory

## Durma Bandsaws

Today, Bandsaws are the easiest, the fastest and the best way to cut metal. They are used in cutting iron, copper compounds, aluminum compounds, production steel, carbon steel, hot-cold work tool steel, reform steel, pattern steel, nickel chrome compound steel, bearing steel, stainless steel, titanium compounds, foundries, construction steels and non-ferrous metals straight or angular. It can cut one by one and also multiple. As band saws are fast and inexpensive, they are used commonly in steel plants, craft, aircraft, automotive industries and manufacturing, construction and aluminum sectors.

Durma R&D experience

Machines' strong bodies with precise machining

High motor powers chosen as design criteria for fast cutting ability

Longer tape life

Low sound level

Hydraulics and electronics system from world class producers

### HB-S, DCB-S Series

Semi Automatic Bandsaws



### DCB-M, DCB-DM Series

Miter Bandsaws



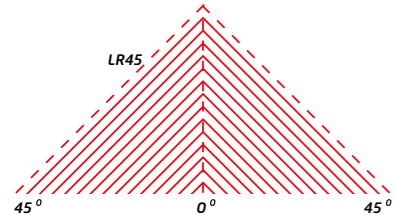
### HB-A, DCB-A, DCB-FA Series

Automatic Bandsaws

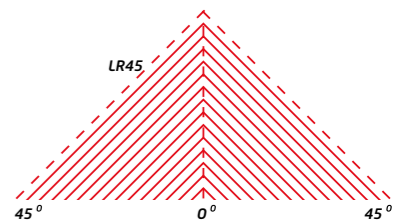


# Semi Automatic Bandsaws

## Horizontal Semi Automatic HB-S 280, 330



## Double Column Semi Automatic DCB-S 360, 460, 560, 800, 1100

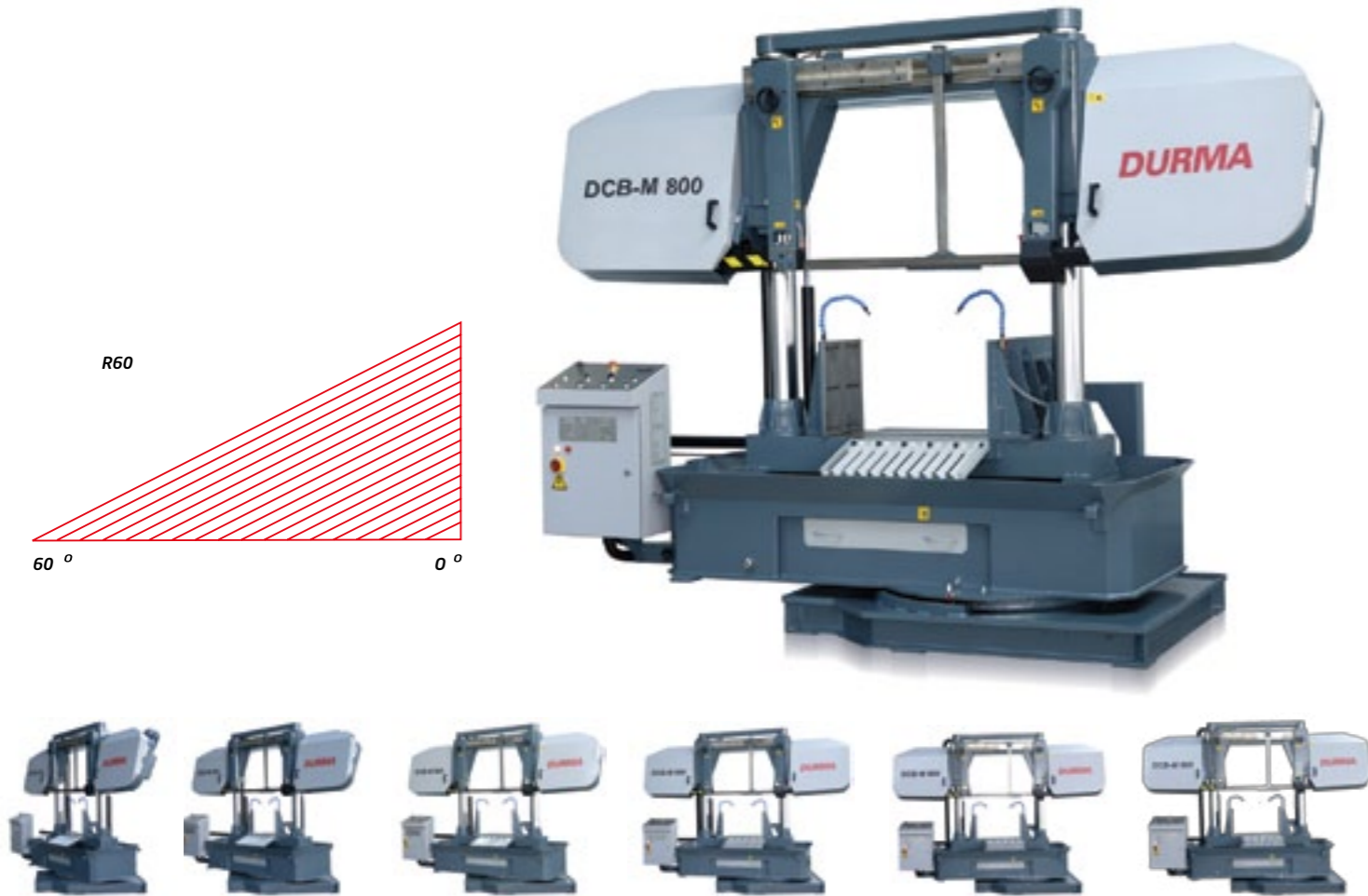


Bandsaw			HB-S 280 (Semi Automatic)	HB-S 280 (with Turning Table)	HB-S 330 (Semi Automatic)	HB-S 330 (with Turning Table)	
Capacities	90°	○	mm	Ø280	Ø280	Ø330	Ø330
		□	mm	260	260	240	240
		▭	mm	200x340	200x340	240x500	240x500
	60°	○	mm	Ø220	R Ø220 L Ø240	Ø300	R Ø330 L Ø300
		□	mm	200	200 180	230	200 230
		▭	mm	160x280	160x280 180x300	230x360	320x380 230x360
	45°	○	mm	Ø130	Ø130 Ø220	Ø260	Ø280 Ø260
		□	mm	120	120 160	200	260 200
		▭	mm	100x210	100x210 160x240	200x280	230x330 200x280
	30°	○	mm	---	---	---	---
		□	mm	---	---	---	---
		▭	mm	---	---	---	---
Motor	Main Motor	kW	1.5	1.5	2.2	2.2	
	Hydraulic Pump Motor	kW	0.37	0.37	0.37	0.37	
	Material Feed Motor	kW	-	---	-	---	
	Cooling Motor	kW	0.09	0.09	0.09	0.09	
LxWxH	mm	1940x1000x1050	1940x1100x1140	2150x1000x1250	2150x1100x1340		
Cutting Speed	m/dk	20 ~ 80	20 ~ 80	20 ~ 80	20 ~ 80		
Working Height	mm	620	710	650	740		
Weight	Kg	470	700	700	940		

DCB-S 360 (Semi Automatic)	DCB-S 360 (with Turning Table)	DCB-S 460 (Semi Automatic)	DCB-S 460 (with Turning Table)	DCB-S 560 (Semi Automatic)	DCB-S 560 (with Turning Table)	DCB-S 800 (Semi Automatic)	DCB-S 1100 (Semi Automatic)
Ø360	Ø360	460	Ø460	Ø560	Ø560	Ø800	1100
360	360	460	460	560	560	800	1100
500x360	500x360	460x600	460x600	560x750	560x750	800x920	1100x1300
Ø280	R Ø350 L Ø280	Ø430	R Ø430 L Ø430	Ø560	Ø560 Ø560	Ø700	840
280	350 280	430	430 430	560	560 560	700	840
280x360	350x360 280x360	430x460	430x460 430x460	560x600	560x600 560x600	800x700	1100x840
Ø160	Ø200 Ø160	Ø330	Ø330 Ø330	Ø430	Ø430 Ø430	400	640
160	200 160	330	330 330	430	430 430	400	640
160x360	200x360 160x360	330x460	330x460 330x460	430x560	430x560 430x560	400x800	1100x640
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---	---	---	---	---	---	---	-
---	---	---	---	---	---	---	-
2.2	2.2	3	3	4	4	7.5	11
0.55	0.55	1.1	1.1	1.1	1.1	1.5	2.2
---	---	---	---	---	---	---	-
0.09	0.09	0.09	0.09	0.09	0.09	0.37	0.37
2480x1100x1615	2480x1250x1715	3000x1000x1900	3000x1200x2000	3450x1150x2100	3450x2000x2200	3970x1380x2660	5500x1660x3400
20-80	20-80	20-90	20-90	20-90	20-90	20-90	20-90
540	640	580	680	580	680	660	680
1500	1750	1760	2060	2450	2800	4500	7500

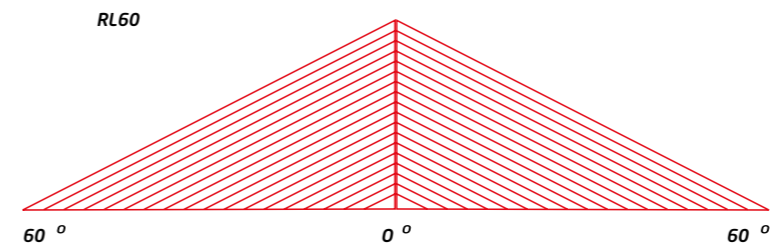
# Miter Bandsaws

## Double Column Semi Automatic Single Miter DCB-M 460, 560, 800, 1100



Bandsaw				DCB-M 460 (Miter)	DCB-M 560 (Miter)	DCB-M 800 (Miter)*	DCB-M 1100 (Miter)
Capacities	90°	○	mm	460	Ø560	Ø800	1100
		□	mm	460	560	800	1100
		▭	mm	460x620	560x750	800x920	1100x1300
	60°	○	mm	Ø460	Ø560	Ø550	840
		□	mm	460	560	550	840
		▭	mm	440x460	560x560	800x550	1100x840
	45°	○	mm	Ø290	Ø380	400	640
		□	mm	290	380	400	640
		▭	mm	290x460	380x560	400x800	1100x640
	30°	○	mm	120	160	200	360
		□	mm	120	160	200	360
		▭	mm	120x460	160x560	200x800	360x1100
Motor	Main Motor		kW	3	4	7.5	11
	Hydraulic Pump Motor		kW	1.1	1.1	1.5	2.2
	Material Feed Motor		kW	---	---	-	-
	Cooling Motor		kW	0.09	0.09	0.37	0.37
LxWxH		mm	3000x1250x2000	3400x1300x2140	3970x1670x2885	5500x2000x3550	
Cutting Speed		m/dk	20-90	20-90	20-90	20-90	
Working Height		mm	680	680	885	830	
Weight		Kg	2140	2850	5660	8400	

## Double Column Semi Automatic Double Miter DCB-DM 560



Bandsaw				DCB 560 DM (Double Miter)
Capacities	90°	○	mm	Ø580
		□	mm	560
		▭	mm	560x1050
	60°	○	mm	Ø580
		□	mm	560
		▭	mm	560x880
	45°	○	mm	Ø580
		□	mm	560
		▭	mm	560x700
	30°	○	mm	Ø470
		□	mm	470
		▭	mm	470x560
Motor	Main Motor		kW	7.5
	Hydraulic Pump Motor		kW	3
	Material Feed Motor		kW	---
	Cooling Motor		kW	0.37
LxWxH		mm	4100x2080x2620	
Cutting Speed		m/dk	20-100	
Working Height		mm	780	
Weight		Kg	5300	



# Automatic Bandsaws

## Horizontal Automatic HB-A 280, 330

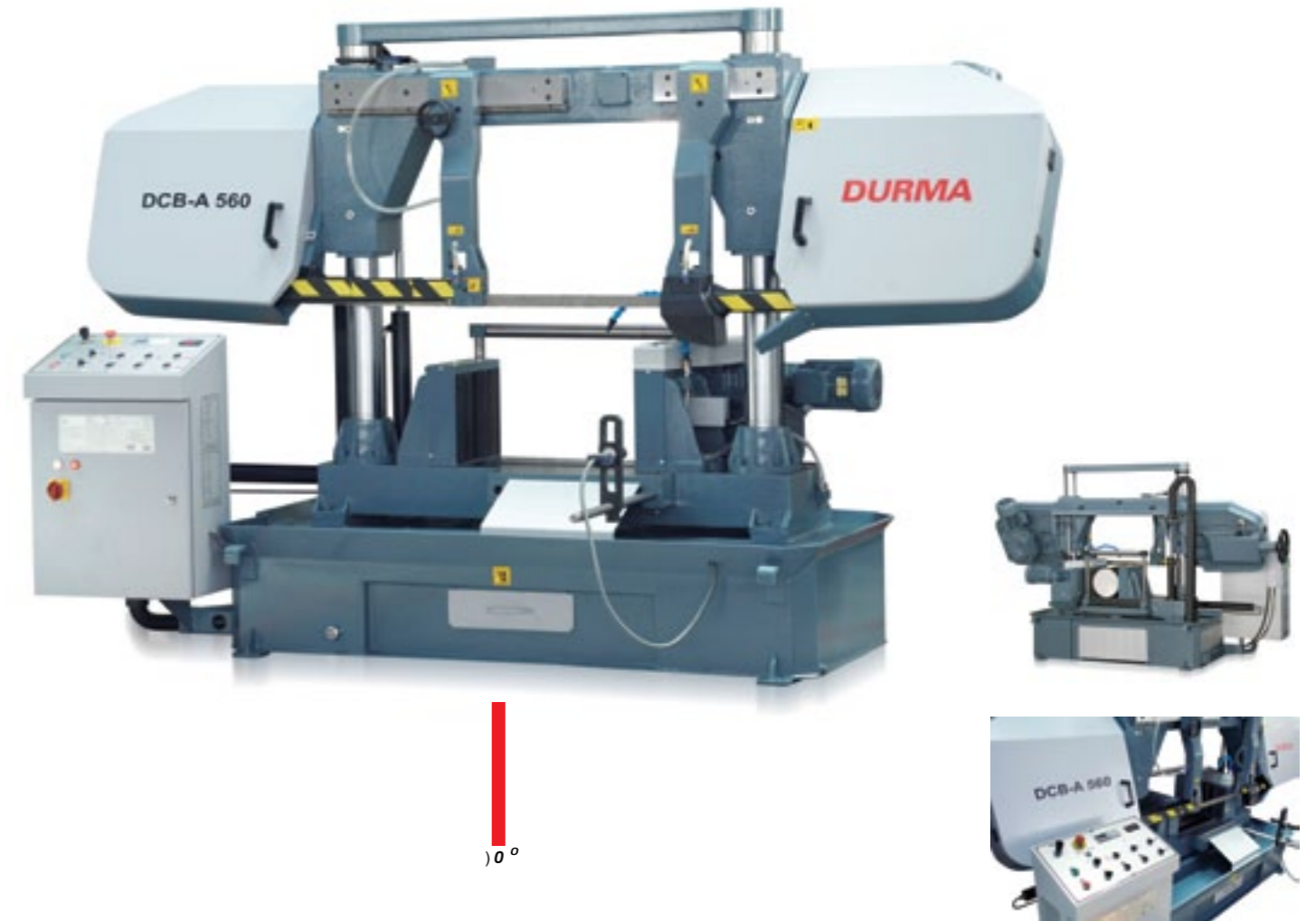


90°



Bandsaw			HB-A 280 (Automatic)	HB-A 330 (Automatic)
Capacities	90°		mm Ø280	Ø330
			mm 240	300
			mm 220x280	300x400
			mm ---	---
			mm ---	---
			mm ---	---
	60°		mm ---	---
			mm ---	---
			mm ---	---
			mm ---	---
			mm ---	---
			mm ---	---
45°		mm ---	---	
		mm ---	---	
		mm ---	---	
		mm ---	---	
		mm ---	---	
		mm ---	---	
30°		mm ---	---	
		mm ---	---	
		mm ---	---	
		mm ---	---	
		mm ---	---	
		mm ---	---	
Motor	Main Motor	kW	1.5	2.2
	Hydraulic Pump Motor	kW	0.37	0.37
	Material Feed Motor	kW	0.25	0.25
	Cooling Motor	kW	0.09	0.09
LxWxH	mm	1940x1050x1050	2200x1100x1250	
Cutting Speed	m/dk	20 ~ 80	20 ~ 80	
Working Height	mm	620	650	
Weight	Kg	580	820	

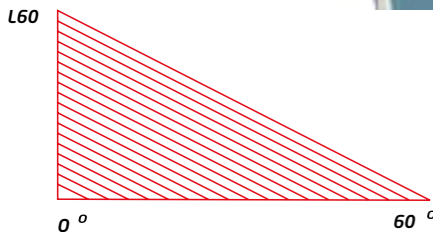
## Double Column Automatic DCB-A 360, 460, 560, 800, 1100



90°

Bandsaw			DCB-A 360 (Automatic)	DCB-A 460 (Automatic)	DCB-A 560 (Automatic)	DCB-A 800 (Automatic)	DCB-A 1100 (Automatic)
Capacities	90°		mm 360	460	Ø560	800	1100
			mm 360	460	560	800	1100
			mm 360x380	460x470	560x610	800x920	1100x1300
			mm -	-	-	-	-
			mm -	-	-	-	-
			mm -	-	-	-	-
	60°		mm -	-	-	-	-
			mm -	-	-	-	-
			mm -	-	-	-	-
			mm -	-	-	-	-
			mm -	-	-	-	-
			mm -	-	-	-	-
45°		mm -	-	-	-	-	
		mm -	-	-	-	-	
		mm -	-	-	-	-	
		mm -	-	-	-	-	
		mm -	-	-	-	-	
		mm -	-	-	-	-	
30°		mm -	-	-	-	-	
		mm -	-	-	-	-	
		mm -	-	-	-	-	
		mm -	-	-	-	-	
		mm -	-	-	-	-	
		mm -	-	-	-	-	
Motor	Main Motor	kW	2.2	3	4	7.5	11
	Hydraulic Pump Motor	kW	0.55	1.1	1.1	1.5	3
	Material Feed Motor	kW	0.25	0.75	1.1	Hyd	Hyd
	Cooling Motor	kW	0.09	0.09	0.09	0.37	0.37
LxWxH	mm	2480x1100x1650	3000x1150x1820	3300x1150x2040	3970x2000x2660	5500x2400x3400	
Cutting Speed	m/dk	20-80	20-90	20-90	20-90	20-90	
Working Height	mm	540	580	580	660	680	
Weight	Kg	1650	2300	2600	4500	9400	

## Double Column Automatic Miter DCB-FA330

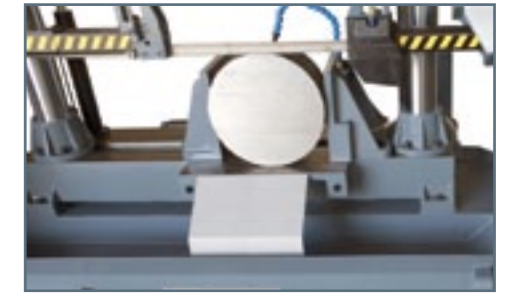


Bandsaw			"DCB-FA 330 (Full Automatic)"	
Capacities	90°	○	mm	Ø330
		□	mm	330
		▭	mm	330x370
	60°	○	mm	310
		□	mm	310
		▭	mm	330x310
	45°	○	mm	220
		□	mm	220
		▭	mm	330x220
	30°	○	mm	120
		□	mm	120
		▭	mm	330x120
Motor	Main Motor	kW	1.5	
	Hydraulic Pump Motor	kW	0.55	
	Material Feed Motor	kW	1.1	
	Cooling Motor	kW	0.09	
LxWxH	mm	1950x2150x1710		
Cutting Speed	m/dk	20-100		
Working Height	mm	700		
Weight	Kg	1200		

## Features

### Hydraulic Vice ) HV)

One of the most important factors for cutting quality is to fasten the material between the vices. The materials are fastened by hydraulic driven vices in order to prevent any loosening during cutting.



### Electronic Cutting Speed Adjustment with Inverter ) INV)

The appropriate cutting speed is very important for providing ideal cutting. In case of cutting speed is faster or slower, it affects the cutting quality as well as shortens the tape life. Cutting speed is easily adjustable on the digital control panel.



### Bimetal Bandsaw & Cooling System ) Saw)

As a standard one bi-metal bandsaw for general purpose is given with the machine. Different model or geared lanes are given on request. Water based boron oil is spread with desired flow to the tape bed and cutting area with strong centrifugal pump. The machine is dispatched without boron oil.



### Cutting Height Adjustment ) CHA)

According to work piece height, appropriate positioning of the tape saves great time especially at serial cuttings.



### Bearing and Carbide Type Blade Housing ) BH)

When the right saw tape is used, the steepness and tangential of the cutting is mostly depends to tape guiding. Ideal cutting is achieved by carbide metals guides that touch to the tape side surface thanks to its vertical positioned bearings that assures proper gap and parallelism. By this way, tape and material costs are minimized and finishing operations eliminated.



### Blade Tensioning ) Mechanic ) TM)

Tape tension is very important for ideal cutting. In case the tape is too tight or loose, it affects the cutting process negatively and shortens tape life. Tape tightening process is done mechanically, hydro mechanically or hydraulic-driven. In each application there are switches automatically measures the tape tension. If the tension is not in right level, the system doesn't work and in case the tape is broken the system stops automatically.





### **Chip Brush ) CB)**

Cleaning the chips between the tapes is very important for the tape's life. Manual chip brush cleans most of the chips and prevents the dirt gathering on the body.

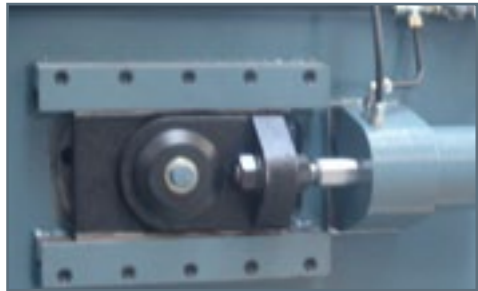
### **Motorized Chip Brush ) CBM)**

Cleaning the chips between the tapes is very important for the tape's life. Motorized chip brush cleans most of the chips and prevents the dirt gathering on the body.



### **Blade Tensioning ) Hydromechanic ) THM)**

During the tensioning of the blade provides an ideal view of the tension from the manometer. In the event of rupture of the tape it stops the system.



### **Blade Tensioning ) Hydraulic ) TH)**

Provides blade tensioning done via the control panel without the need for human operation. When ideal stress occurs, the process terminates tension. In the event of rupture, the system stops.



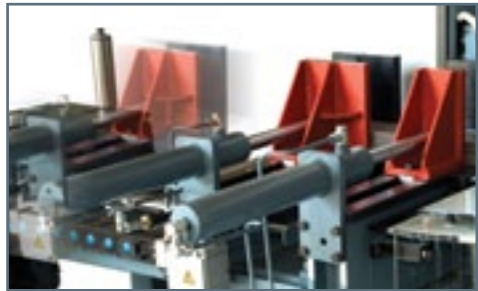
### **Turning Table ) TT)**

The machine is turned manually on turning table to gain the requested angle. This way, in simple angled cutting it saves time and working space. It is optional in semi-automatic models.



### **Motorized Roller Feeding ) RFM)**

It is the fastest and the simplest material driving system at automatic models. All rollers are driven with chains from the motor exit. It provides great advantage in general purpose cuttings.



### **Motorized Vice Feeding ) VFM)**

The electrical motor driving group in the hydraulically tightened material with capacity to move 600 mm forward and backward, desired  $\pm 0,2$  mm susceptible cuts can be made.

Through PLC controlled automatic repeating feature, material in long lengths are cut in the same tolerance. And through fast driving and minimized waiting time more pieces are made in the cycle. It is ideal for cutting materials which deformation is not wanted on the surface.

### **Hydraulic Vice Feeding ) VFH)**

The hydraulic motor driving group in the hydraulically tightened material with capacity to move 600 mm forward and backward, desired  $\pm 0,5$  mm susceptible cuts can be made. Through PLC controlled automatic repeating feature, material in long lengths are cut in the same tolerance. And through fast driving and minimized waiting time in the cycle more pieces are made in the sector. It is ideal for cutting materials which deformation is not wanted on the surface. Heavy pieces are easily moved by the hydraulic driven rolls.



### **Top Clamping - Mechanical ) TCM)**

In bonded material cutting process, hydraulically adjusted with bearing roll prevents the material to be separated from the package.



### **Top Clamping ) Hydraulic ) TCH)**

In bonded material cutting process, hydraulically adjusted with bearing roll prevents the material to be separated from the package.



### **Length Adjustment ) Mechanical ) LAM)**

In semi automatic models length adjustment of the material is done manually up to 600 mm of the mechanical gauge. This way you dont have to measure for every piece.



### **Length Adjustment ) Electrical ) LAE)**

Automatic models length adjustment of the material is done manually up to 600 mm of the switched mechanical gauge. In serial cuttings roller collar clamp(MRV); drives the material till the gauge, when in contact with the gauge the desired length is obtained and then driving process ends and cutting process begins. When cutting is over the piece falls the conversion is repeated.



### **Part Counter ) PC)**

In automatic models information of pieces of the material to be cut is entered in order to provide the serial cutting. Apart from this, also displays information about the machine, alarm and cutting.





### NC Control System ) NC)

All functions operation, the amount of length, cutting units and other parameter use controlling via the touch screen provides ease of use. Material between the clamp controlled by PLC provides desired length cut. Provides the material which is compressed between the roller collar clamps, to be cut in desired length measured with the encoder; without need of having swich type of automatic size system (SLA).



### Chip Conveyor ) CC)

Especially solid material cutting creates big amounts of chips and needs to be cleaned frequently. The motorized chip conveyor transfers the chips out of the machine.



### Laser Marking ) LM)

It helps length adjustment of the work piece. The laser line reflecting on the front side of the tape allows seeing the length and the cutting line of the material easier. Tape placed higher than the material and during feeding of the material, tape is not damaged by hitting the material. This system provides convenience in half-automatic machines and special cutting works.



### Roller Table ) RT)

At the front or back side of the machine the table provides easy material entrance by bear driven rolls. One table is standard with the related machine. Extra tables can be put together, this way longer materials are supported.

### Microspray Cooling ) MC)

The spray is used on the tape instead of boron oil to prevent over heating. It minimizes the heating by spraying special mixture of micronized cutting oil and air to make longer tape life and facilitate the cutting. Besides being ecological it also minimizes the boron oil costs.

### Automatic Cutting Pressure Control ) ACP)

Setting the appropriate landing speed is very important to obtain an ideal cut. If landing speed is more or less, the result of cutting is effected negatively and the life of the tape is shortened. Automatic pressure control provides the tape cutting in ideal load and this way the tape lasts longer.

## Standard & Option Table

MODELS	AUTOMATIC		MITER	SEMI AUTOMATIC			
	DOUBLE COLUMN	HORI ZONTAL		DOUBLE COLUMN	HORI ZONTAL		
	DCB-FA 330	DCB-A 460	DCB-DM 560	DCB-S 1100	HB-S 280		
			S			HV	HYDRAULIC VICE
			S			INV	ELECTRONIC SPEED ADJ. WITH INVERTER
			S			SAW	BIMETAL BANDSAW&COOLING SYSTEM
			S			CHA	CUTTING HEIGHT ADJ.
			S			BH	BEARING AND CARBIDE TYPE BLADE HOUSING
	S	O		S	O	CB	CHIP BRUSH
				O		CBM	MOT. CHIP BRUSH
	N/A	S		N/A	S	TM	BLADE TENSIONING-MECHANIC
	N/A	S	N/A	S	O	THM	BLADE TENSIONING-HYDROMECHANIC
		O	S	O	O	TH	BLADE TENSIONING-HYDRAULIC
		N/A			O	TT	TURNING TABLE
	N/A	S		N/A		RFM	MOT. ROLLER FEEDING
S				N/A		VFM	MOT. VICE FEEDING
N/A	S			N/A		VFH	HYDRAULIC VICE FEEDING
N/A	S			N/A	S	TCM	TOP CLAMPING-MECHANICAL
	O	S		O		TCH	TOP CLAMPING-HYDRAULIC
	N/A		N/A	S	S	LAM	LENGTH ADJ. MECHANICAL
N/A	S			N/A		LAE	LENGTH ADJ. ELECTRICAL
N/A	S			N/A		PC	PART COUNTER
S	O			N/A		NC	NC CONTROL SYSTEM
				O		CC	CHIP CONVEYOR
				O		LM	LASER MARKING
				O		MC	MICROSPRAY COOLING
				O		ACP	AUTO. CUTTING PRESSURE CONTROL
				N/A	S	RT	ROL. TABLE (SINGLE)
S	N/A	S		N/A	S	RT1000	ROL. TABLE L1000MM
	S	N/A		S	N/A	RT1200	ROL. TABLE L1200MM
S		N/A	S	S	N/A	RT1500	ROL. TABLE L1500MM
	N/A			O	N/A	RT3000	MOT. ROL. TABLE L3000MM