

The Winning Force

***DURMA***

# VS

SERIES  
VARIABLE RAKE CNC SHEAR



- Perfect Cutting
- Fast Speed
- Powerful
- Accurate
- Efficient



# **DURMA** The Winning Force





As a total supplier for sheet metal manufacturing with almost 60 years of experience, Durma understands and recognizes the challenges, requirements and expectations of the industry. We strive to satisfy the ever higher demands of our customers by continuously improving our products and processes while researching and implementing the latest technologies.

In our three production plants with a total of 150.000 m<sup>2</sup>, we dedicate 1,000 employees to delivering high quality manufacturing solutions at the best performance-to-price ratio in the market.

From the innovations developed at our Research & Development Center to the technical support given by our worldwide distributors, we all have one common mission: to be your preferred partner.

Present Durmazlar machines with **DURMA** name to the world.



1

High technology,  
modern production  
lines



3

High quality  
machines designed  
in R&D Centre

2

Top quality  
components





# VS Series

## Variable Rake CNC Shear

Well equipped for precision cuttings ( $\pm 0.05$  cutting precision)

High technology VS variable rake shears, with **0° 30' - 2°** precise rake adjustment, cut fast and efficiently. Easy to use and good quality cutting feature are suitable for every job. By entering all cutting parameters you can have precise and perfect cutting. High efficient and maximum security VS shears will differentiate you with its precise cutting.



# Advance Your Standards

Precision and high quality cuts with automatic gap adjustment

In world standards equipped with high-tech products VS Series Shears offer you exact solutions. We have reduced the cutting angle to achieve straight precision and minimum twist tolerance.

**Easy to  
Use**

**Economic**

**Efficient**

**Faster**

**Reliable  
Brand**



## Why *DURMA* Shears

- Better and faster cuttings
- Automatic blade gap adjustment
- Stronger and rigid body structure
- High sensitivity and repeatability
- High-tech excellent equipments
- Low service cost
- Adds value to your company
- Reliable brand

# Gain More Power

## Performance and Productivity

The *DURMA* VS series CNC variable rake shear is one of the most advanced production shears available today. From 6 up to 25 mm shearing capability these highly developed machines yield the most flexibility you can hope to get in a modern shearing machine.



## General Specifications

- Robust design & powerful body for perfect cutting
- Hardened and ground blades for long life and precise
- CE standards security
- The combination of economic and perfect cutting performance
- Blade clearance and cutting angle automatically adjusted by CNC controller
- User friendly CNC touch screen control unit
- VS shears provide flexible use for narrow or wide, thin or thick sheet metal cutting.
- Automatic swing up back gauge for more comfortable use
- Sheet support arms
- Front feeding and conveyor systems
- Front support arms T-Slots for easy cutting and feeding material
- Ball Transfer table

# Standard & Optional Equipment

## Standard Equipments

CE-Norm  
Heavy duty steel construction & Stress relieved frame  
User friendly CNC Touchscreen control unit D-Touch 7  
Automatically adjusted rake angle by CNC  
Adjusted cutting length by CNC  
Ball integrated front tables  
Ball screw back gauge, 1000mm  
Flip-up finger guards 1000mm  
Squaring arm with scale T-Slot (L=1500mm)  
Support arms T-Slot & Tilting stop (L=1000mm)  
Illumination & Shadow line  
Throat depth with 350 mm  
Automatically pressure adjusted solid holddowns  
Top and bottom blades with four sides

## Optional Equipments

High speed (Stroke/Min)  
Laser Cutting Line  
Light curtains for finger protection  
Pneumatic sheet support *DURMA I*  
Pneumatic sheet support with return to sender *DURMA III*  
Pneumatic sheet support *DURMA IV*  
Sheet support device with belt conveyor and scrap container  
Stacker + Alignment System  
CNC front feeding system  
Hydraulic anti-twisting  
Special throat depth  
Back gauge 1250 mm  
X1, X2 axis  
Hydraulic swing-up back gauge  
Adjustable holddown pressure  
Oil coolant  
Oil heater  
Central lubrication manual  
Central lubrication motorized  
Adjustable angle stop 0-180°  
Add. Support arms  
Special blades  
Control Panel on opposite position  
Temperature measurement  
Overseas special packaging

# D-Touch 7 Control Unit



Fast data input



Easy connection USB port



Ethernet RJ-45 10/100M



Easy programming

## Cuttings are easier with D-Touch 7

With easy to use interface D-Touch 7 enables perfect cutting in seconds by endless programming and material entrance feature.

- Wide, colored, touch-screen (LCD 7" 800x480)
- Quick data entry
- Easy connection
- USB input
- Ethernet: RJ-45 10/100M
- Windows CE Unlimited program and steps
- Unlimited material type



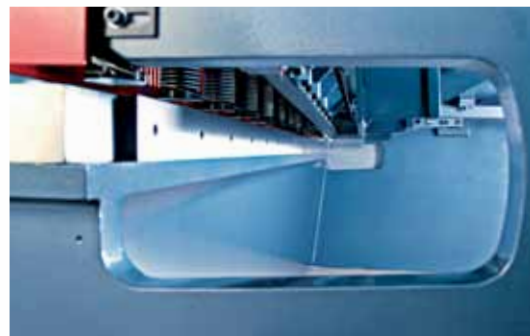


# VS Series General Features

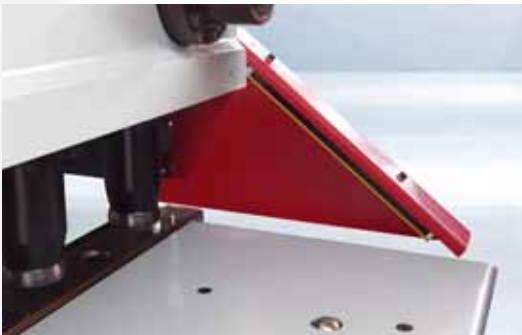
With choice of standards and optional equipment VS Series add to value your business by offering proper solutions for your needs. With the high-tech features high efficiency, high precision, high performance criteria VS Series have proved that it is user-friendly and the best of in this sector.



Flip-up Finger Guard  
Ball Transfer Table  
Hydraulic Holdowns



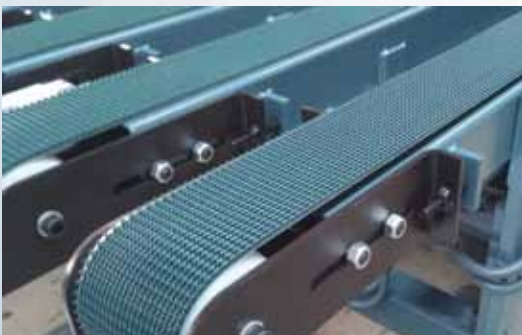
Special Throat Depth



Light Curtains For Finger Guard



Adjustable Angle Stop 0-180°



Conveyor System



Thin Sheet Support System

# Robust Back Gauge System

Precision

Robust

Min. Deformation



- Fast and high accuracy
- Reliable movement
- Adjustment at any point
- Resistance to crash
- Maintenance free
- Better and fast cutting
- Easy and secure usage
- High precision and repeatability

## Why *DURMA* Back Gauge?

One of the most important factor for cutting capacity is the design of back gauge and stability.

Quality cutting is possible with perfect product, stability and precision back gauge.

The high speed **ballscrew** back gauge system movement is also supported with **linear guides**, which helps the back gauge achieve long life, greater sensitivity and strengthens against any collisions.

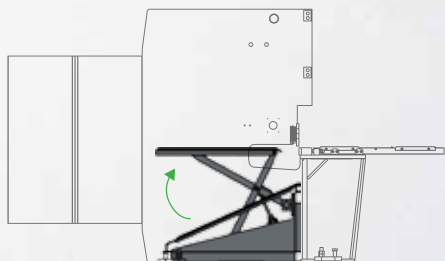


Ballscrew back gauge

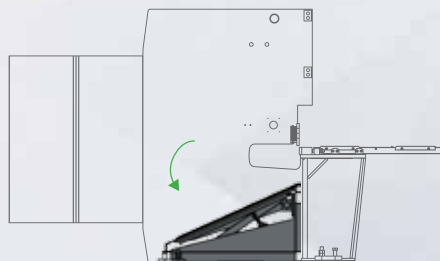
# Sheet Support Systems

Pneumatic Thin Sheet Support System

DURMA I



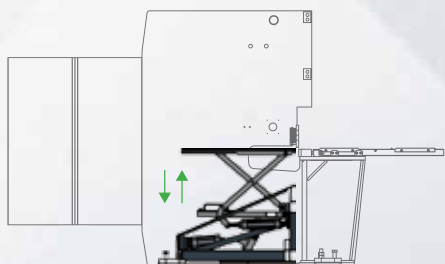
Step 1



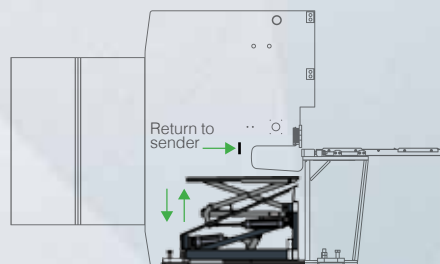
Step 2

Pneumatic Thin Sheet Support System

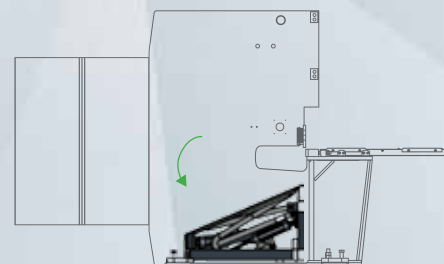
DURMA III



Step 1



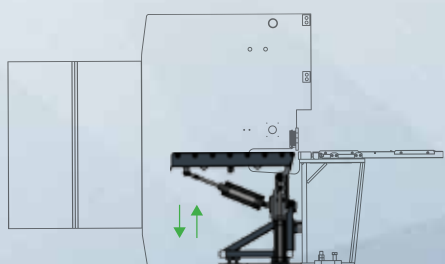
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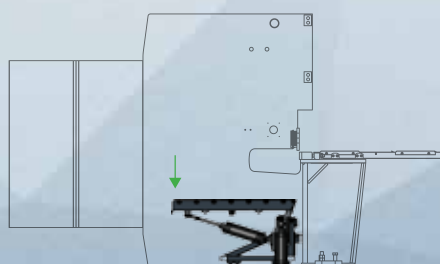
Step 3

Pneumatic Thin Sheet Support System

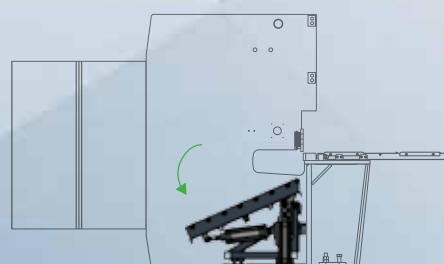
DURMA IV



Step 1



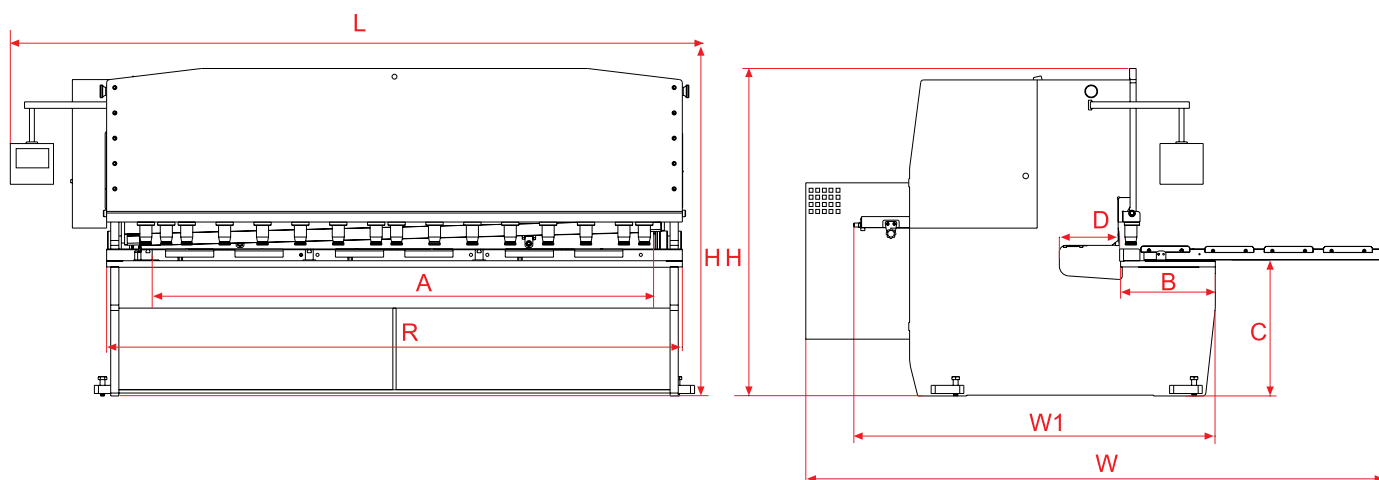
Step 2



Step 3

## VS Series Technical Details

VS Series	Cutting Length	Cutting Capacity		Stroke per min.	Cutting Angle		Number of Holddowns	Holddown Force		Back Gauge Range
		MS (450 N/mm <sup>2</sup> )	SS (700 N/mm <sup>2</sup> )	Minimum - Maximum	Minimum	Maximum		Minimum	Maximum	
	mm	mm	mm	1/min.	°	°	mm	Ton	Ton	mm
	A									
3006	3080	6	4	12 - 20	0° 30'	2°	16	4	20	1000
3010	3080	10	7,5	10 - 20	0° 30'	2°	16	4	20	1000
3013	3080	13	10	9 - 17	0° 30'	2° 30'	17	8	40	1000
3016	3080	16	12	7 - 12	0° 30'	2° 30'	14	11	55	1000
3020	3080	20	15,5	6 - 12	0° 30'	2° 30'	14	17	83	1000
4006	4080	6	4	10 - 20	0° 30'	2°	20	4	20	1000
4013	4080	13	10	7 - 13	0° 30'	2° 30'	20	10	48	1000
4016	4080	16	15	5 - 9	0° 30'	2° 30'	17	50	100	1000
4020	4080	20	15,5	4 - 8	0° 30'	2° 30'	21	50	100	1000
6006	6080	6	4	6 - 10	0° 30'	2°	29	10	20	1000
6013	6080	13	10	5 - 10	0° 30'	2° 30'	29	29	58	1000
6016	6080	16	12	4 - 10	0° 30'	2° 30'	29	29	58	1000
6020	6080	20	15,5	3 - 6	0° 30'	3° 15'	29	48	100	1000
6025	6100	25	19	3 - 6	0° 30'	3° 25'	30	150	250	1000
8010	8100	10	7,5	3 - 6	0° 30'	2°	40	40	60	1000
10013	10100	13	10	3 - 6	0° 30'	2° 12'	52	60	81	1500



Back Gauge Speed	Motor Power	Oil Capacity	Throat Depth	Front Arms	Table Height	Table Width	Table Length	Length	Width	Total Width	Height	Weight
mm/sec.	kW	lt	mm	Unit	mm	mm	mm	mm	mm	mm	mm	~kg
			D		C	B	R	L	W1	W	H	
200	11	125	350	3	820	494	3280	4100	2050	3650	1950	7980
200	22	180	350	3	820	554	3360	3800	2050	3550	2150	9300
200	30	300	350	3	835	559	3380	4200	2100	3560	2450	12860
200	45	450	350	3	840	554	3420	4130	2210	3820	2570	18150
200	45	500	350	3	840	580	3460	4100	2300	3700	2650	21400
200	11	125	350	4	820	494	4400	5150	2100	3550	2050	10470
200	30	330	350	4	835	589	4400	5200	2150	3560	2550	17720
200	45	400	350	4	1000	630	4385	5890	2100	3625	2950	24400
200	45	500	350	4	1000	630	4405	5900	2200	3775	2950	30320
200	22	200	350	6	900	630	6370	7300	2150	3400	2750	25500
200	37	400	350	6	950	650	6375	7400	2200	3700	2900	33820
200	45	550	350	6	950	650	6375	7400	2200	3790	2950	39300
200	45	700	350	6	1000	800	6595	8100	2800	4100	3530	61000
200	55	750	350	6	1000	900	6750	7850	2900	4250	3400	72000
200	30	550	500	7	1220	850	8545	9100	3350	4200	3280	87000
200	45	650	750	9	1210	860	10630	11500	3400	4240	3800	147000



# Special Projects

## CNC Front Feeding



## Sheet Support + Belt Conveyor + Stacker + Scrap Container



# Fast on Service and Spare Parts

*DURMA* provides the best level of service and spare parts with qualified personnel and spare parts in stock. Our experienced and professional service personnel are always ready at your service. Our professional training and application enriched courses will give you an advantage to use our machinery.



Consultancy



Spare Parts



R&D Center



After Sales  
Service

***DURMA***

Solution Center



Service  
Agreements



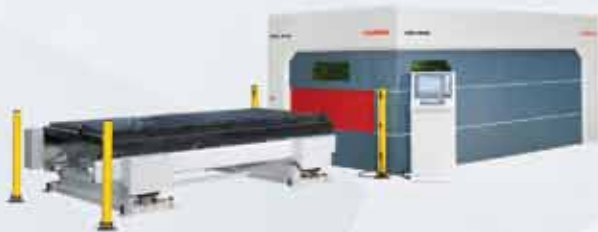
Software



Training



Flexible Solution



FIBER LASER



PUNCH



PLASMA



L ANGLE PROCESSING CENTER



IRON WORKER



POWER OPERATED SHEAR

***DURMA***



PRESS BRAKE



VARIABLE RAKE SHEAR



ROLL BENDING



PROFILE BENDING



BANDSAW



CORNER NOTCHER

[illegible]





# DURMA

Today, Tomorrow and Forever with You...

**VS** SERIES  
VARIABLE RAKE CNC SHEAR

Durmazlar Makina San. Tic. A.Ş. has right to change catalogue values and machine technical details without notice.

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