



MODERN TOOL (B.C.) LTD.

1385 Kingsway Avenue, Port Coquitlam, B.C. V3C 1S2

Tel.: 604-472-1444 | Fax: (604)472-1455

TOLL FREE: 1800-717-1440

www.moderntoolbc.com

"NEW" DURMA IW 80/150 HYDRAULIC IRONWORKER



The DURMA Hydraulic Ironworkers are designed with multi-functions to save labour, 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 fi ve 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.



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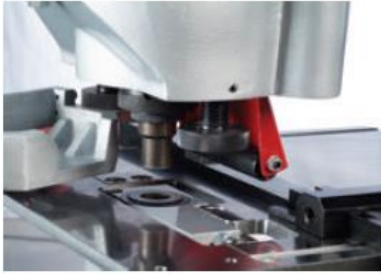
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IW Series Features



Swing Away Stripper



Punching Flat Steel



Punching Channel
Flangers And Angles



Different Dimension Punch & Dies



Press Brake Attachment

Punching Station

The punch station is designed with versatility in mind. The station 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 pres brake attachment can be performed.

*Some Optional Tooling shown (not included)



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.



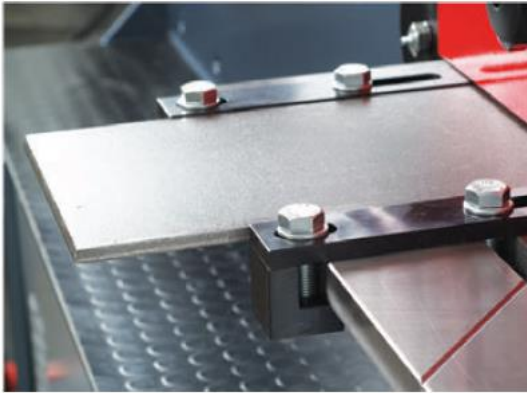
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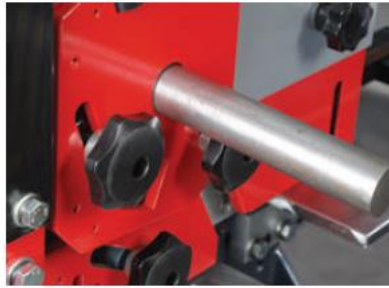


Flat Shearing Station

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.



Square bar Shearing



Round bar Shearing



Optional U blade

*Some Optional Tooling shown (not included)



Optional I & T blades



Touch and cut electrical back gauge



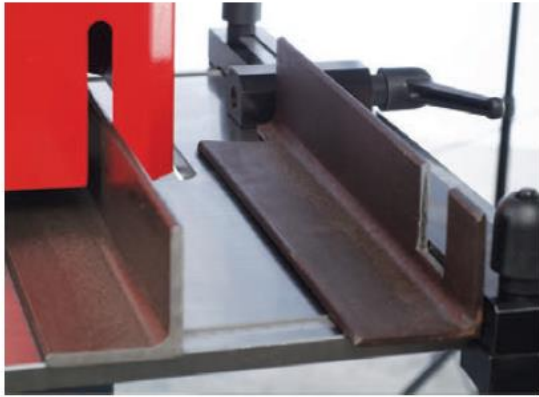
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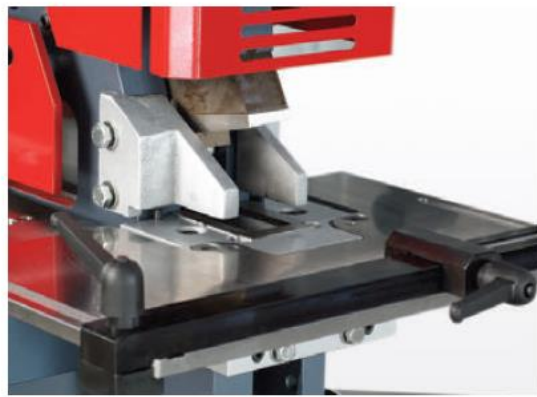
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Rectangular Notcher



Triangular Notcher Option)

Notching Stations

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.

*Some Optional Tooling shown (not included)

	IW 80/150	METRIC	IMPERIAL
PUNCHING	Punching Pressure	ton 80	ton 88
	Punch Capacity(Diameter x Thickness)	mm $\varnothing 40 \times 14$ mm $\varnothing 24 \times 24$	inch $\varnothing 1.5 \times 0.5$ inch $\varnothing 0.9 \times 0.9$
	Throat Depth	mm 300	inch 11.81
	Stroke length	mm 70	inch 2.75
	Cycles /Min. (20 mm stroke)	# 38	# 38
	Table Size (W x D)	mm 550x300	inch 21.6x11.8
	Largest Hole	mm $\varnothing 160 \times 3$	inch 6.29" x 0.12
	Single Vee Press Brake (W x T)	mm 300x10	inch 11.8 x 0.3
	Multi-Vee Press Brake (W x T)	mm 600x6	inch 23.6 x 0.24
	Pipe Notching	inch 1/2" - 2"	inch 1/2" - 2"
	1) A min-max for NPU	mm 120 - 400	inch 4.72 - 15.75
	Maximum S - Maximum $\varnothing D$ (Accor DIN 997)	mm 14 - $\varnothing 28$	inch 0.55 - $\varnothing 1.10$
	2) A min-max for NPU	mm 100 - 320	inch 3.94 - 12.60
	Maximum S - Maximum $\varnothing D$ (Accor DIN 997)	mm 14 - $\varnothing 28$	inch 0.55 - $\varnothing 1.10$
	FLAT SHEARING	Flat Bar (max. thickness)	mm 300x20
Flat Bar (max. width)		mm 450x15	inch 17.7x0.5
Blade Length		mm 475	inch 18.70
Angle Flange Trim		mm 80x80x10	inch 3.1x3.1x0.3



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	IW 80/150	METRIC	IMPERIAL
ANGLE SHEARING	At 90° Shearing	mm 130x130x13	inch 5.1x5.1x0.5
	At 45° Miter Shearing	mm 70x70x7	inch 2.7x2.7x0.2

	IW 80/150	METRIC	IMPERIAL
BAR SHEARING	Round Bar Shear	mm 45	inch 1.77
	Square Bar Shear	mm 45	inch 1.77
	U - Profile Shear	mm 140	inch 5.51
	T - Profile Shear	mm 60	inch 2.36
	I - Profile Shear	mm 140	inch 5.51

	IW 80/150	METRIC	IMPERIAL
NOTCHING	Material thickness	mm 12	inch 0.47
	Rectangular Notcher (width)	mm 52	inch 2.04
	Rectangular Notcher (depth)	mm 90	inch 3.54
	Vee-Notcher (Side x Side x T)	mm 52x52x12	inch 2x2x0.47
	Triangular notching material tickness	mm 6	inch 0.24
	Triangular notching width V90	mm 125	inch 4.92
	Triangular notching depth	mm 125	inch 4.92

	IW 80/150	METRIC	IMPERIAL
GENERAL INFORMATION	Motorpower	kw 11	Hp 15
	Oil Capacity	lt 76	gal 20
	Weight	kg 2260	lbs 4982
	Machine dimensions (L x W x H)	mm 2025x1780x2700	inch 79x70x106
	Working Height	mm 1195	inch 47

STANDARD EQUIPMENT

- Punch station with Durma adapter
- Table for punching station
- Durma quick change punch & die holder up to 40mm
- 1 starting set (Punch & Die)
- 1m. Electrical back gauge
- Blades for flat steel station
- Blades for angle cutting station
- Blades for round and square bar cutting station
- Rectangular notcher complete with down holder
- Table for notching station



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- Two foot pedals

OPTIONAL EQUIPMENT

DESCRIPTION
Illumination (24V-220V)
Electrical Back gauge (over 1 m.)
Bending equipment (top tool +single Vee +tool holder)
Bending equipment (top tool +multi Vee +tool holder)
Pipe Notching Equipment (1/2" and 2" any diameter) w/o punch & die
For pipe notching punch and dies (each set)