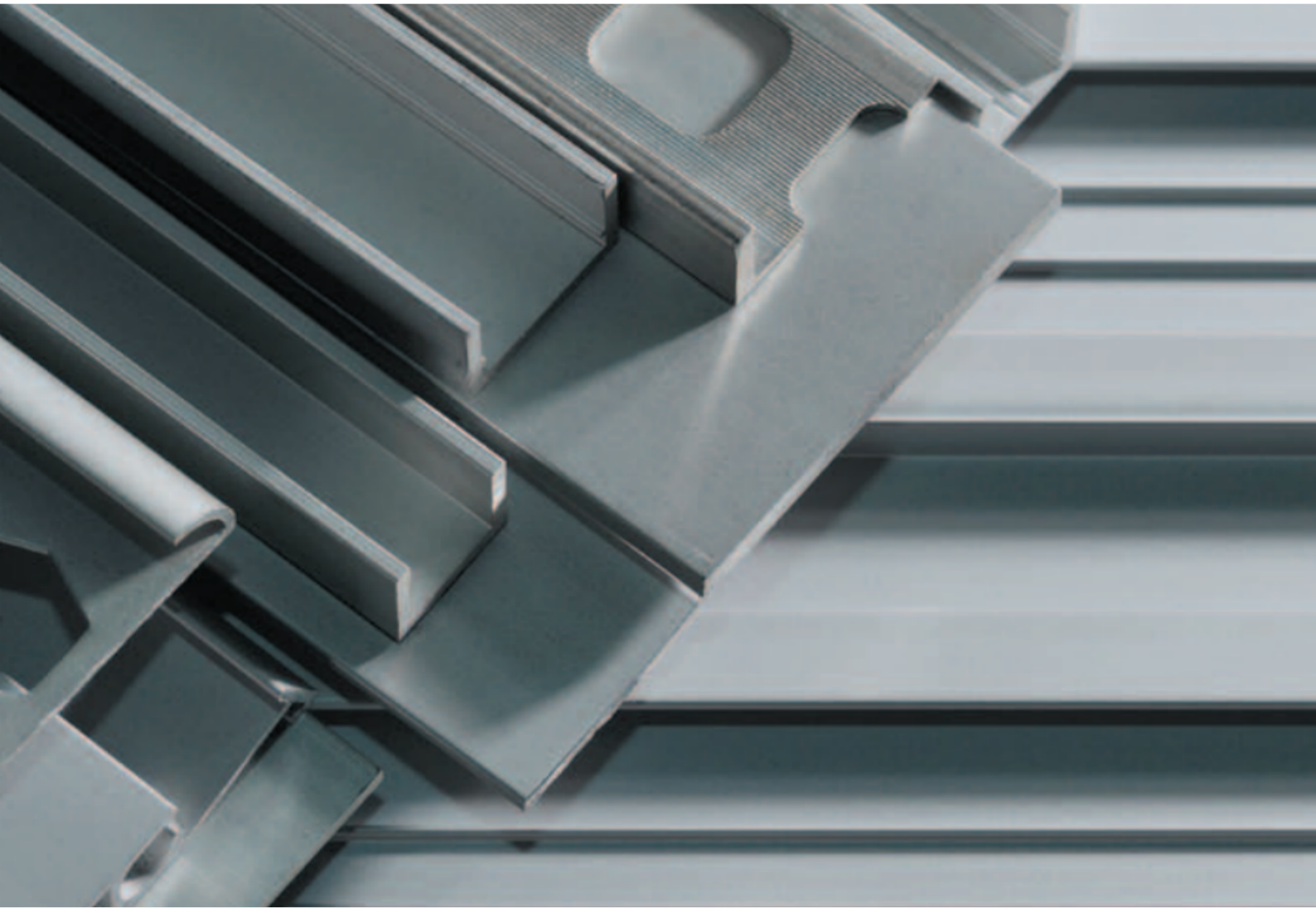
Durmark Auto

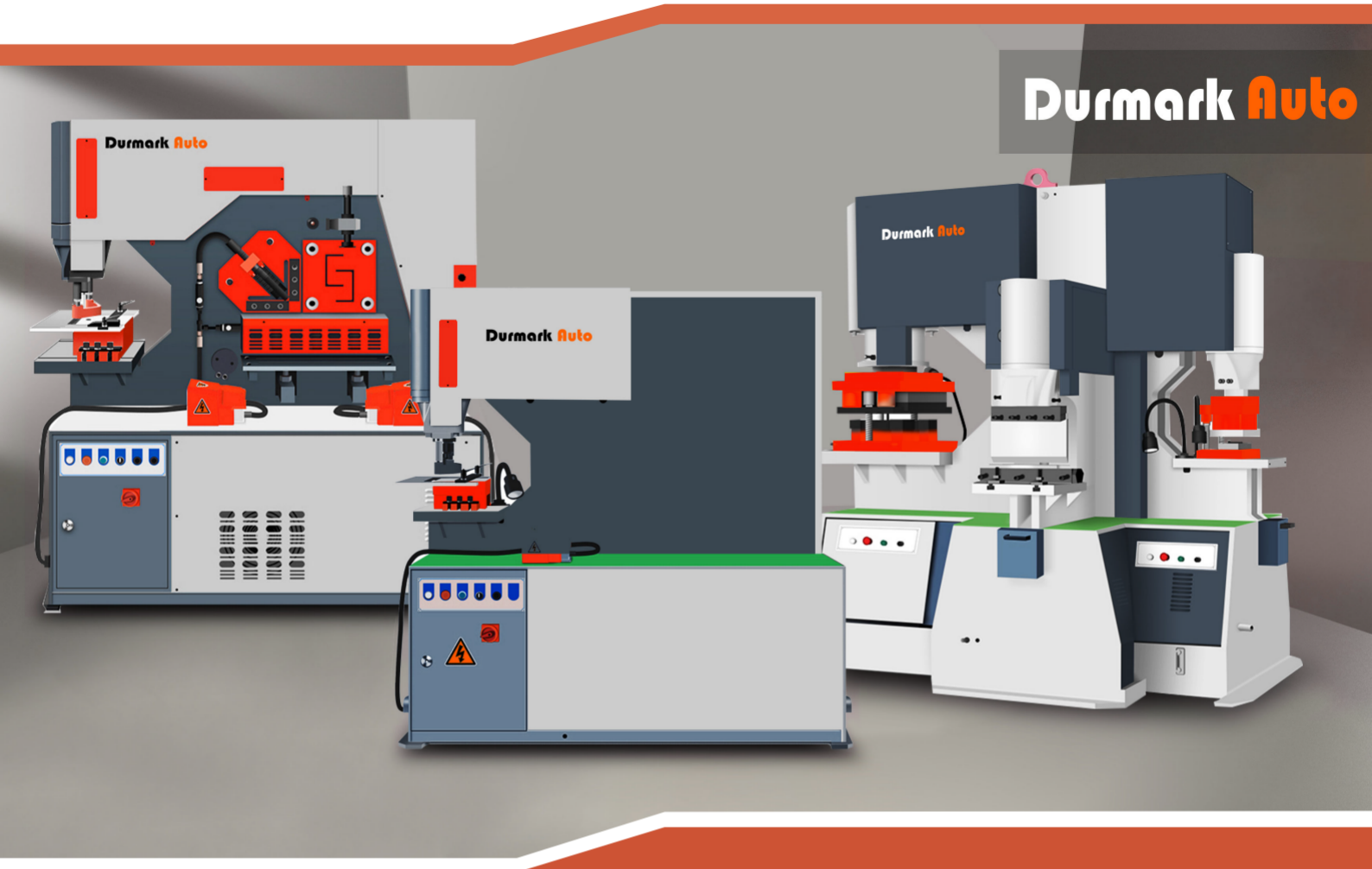
Q35Y SERIES HYDRAULIC IRONWORKER

SOLUTIONS FOR YOUR NEED



DURMARK-MACHINERY.COM

Durmark Auto



COMPANY PROFILE

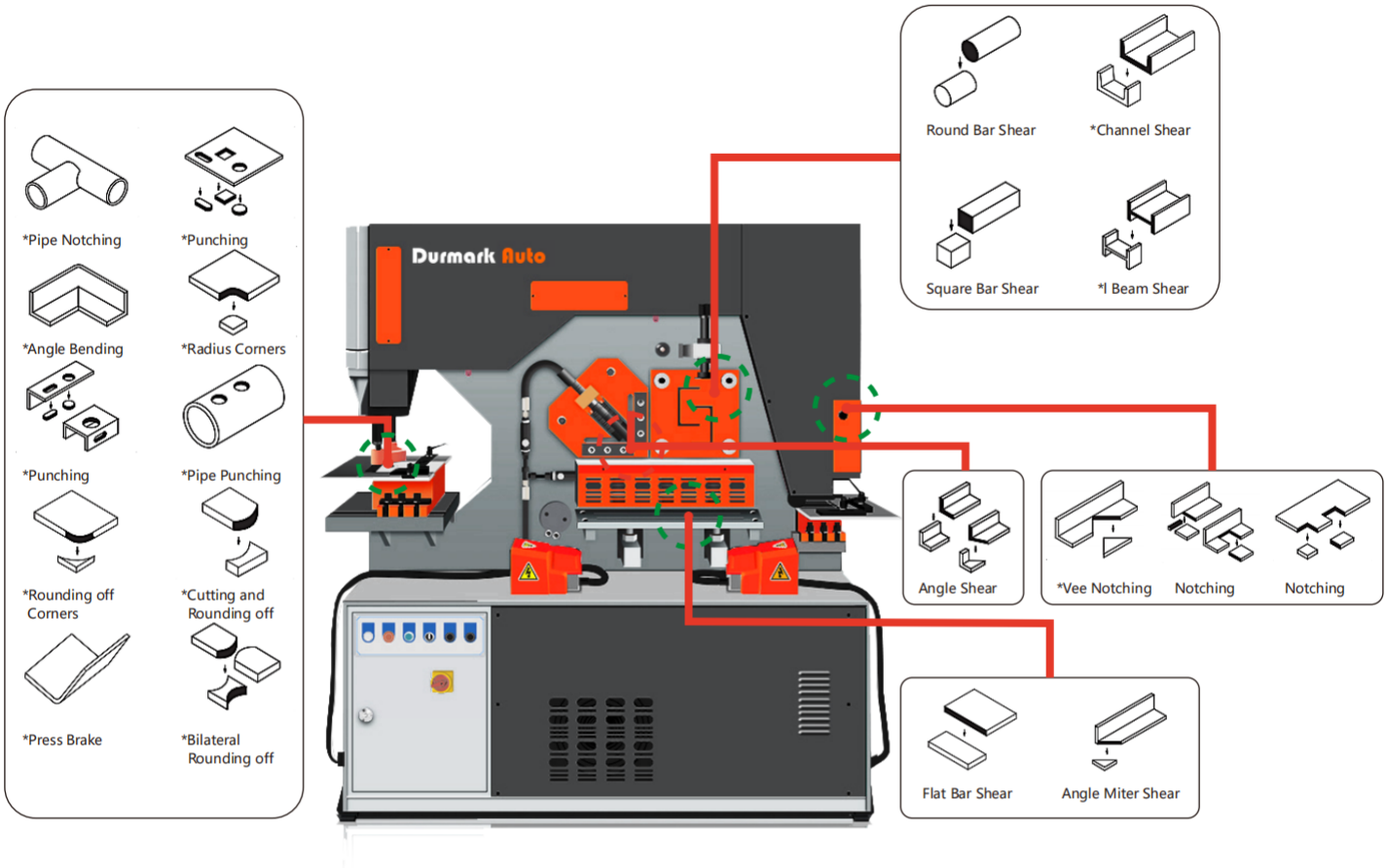
Anhui LIFU Machinery Technology Co., Ltd. is a design, development, production and sales of an integrated company. Our main development direction is producing different CNC machineries to realize of mechanical automation. Focus on R&D in technology, and have a complete R & D team, a total of 16 senior engineers for design, drawing, optimization, etc.

In addition, we have long-term close cooperation with domestic well-known Metal forming Machinery Research Institute, cutting off stamping machinery surrounding automation equipment manufacturers, and CNC automation control system manufacturers.

The company occupies an area of about 100,000 square meters, of which about office space 2,000 square meters , a semi-finished workshop about 6,000 square meters, finishing department about 8,000 square meters, welding workshop about 4,000 square meters, Grinding processing workshops about 2,000 square meters, a variety of spare parts warehouse of about 2,000 square meters. With improved processing power, equipped with large CNC pentahedrons processing center, two sets large boring and milling machine, four sets large gantry milling machine, two sets vertical boring machine, one set large horizontal lathe with max 600mm process diameter.

HYDRAULIC IRONWORKER

▶ EXCEPTIONAL VALUE

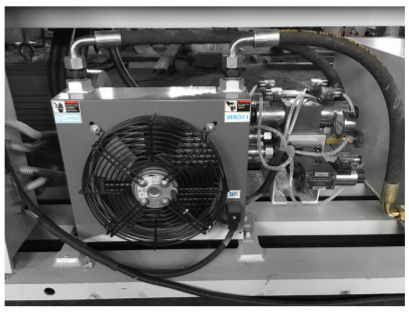




The use German Rexroth hydraulic components ensure excellent reliability of the hydraulic system.



Schneider-Electric cabinet with low 24 volt DC control circuit provides full protection on and safety.



Air cooling plant
Control oil temperature, reduce oil temperature of hydraulic oil, ensure service life of machine, prevent aging of seals.

Q35Y Series Hydraulic Ironworker

HYDRAULIC IRONWORKER

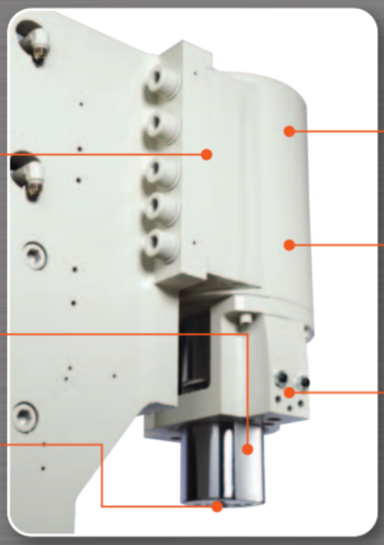
Durmark® Hydraulic Ironworkers are designed with multiple functions to save labor, time, energy and cost. This allowsSunrise Ironworkers to meet the diversified needs of the metal fabricating industry.Maximum efficiency and long life is guaranteed by using the latest manufacturing methods, including powerful CADdesign, modern production line with CNC equipment and continuous quality control.Each work station is equipped with specially designed hold-downs to ensure safely while providing precision andease of use. These ironworkers are the most economical and efficient machines in the industry for themanufacturing of metal products.
All Sunrise ironworkers and punching machines come standard with a low pressure tool alignment mode. Theoperator can use the JOG mode to run the machine in low pressure and low speed for tool alignment, bladechanges and maintenance operations. This greatly improves operator salety and prevents tool damage in case ofmis-alignment.

Key features on the dual cylinder models:

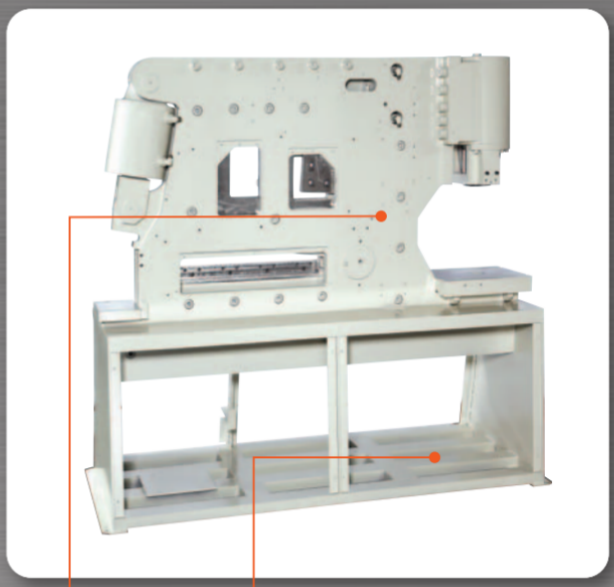
The dual cylinder models feature a separate cylinder for independent operation from shearing stations.

Cylinder ram with flat surface for rigid guiding and to ensure proper alignment of tool.

Keyed punch ram to ensure alignment of shaped tooling.



The cylinder ram is guided at three positions to provide extra support and absorb side-load forces for added protection of cylinder seals.



The base of the machine is made from welded channel in a grid pattern for a rigid machine foundation.

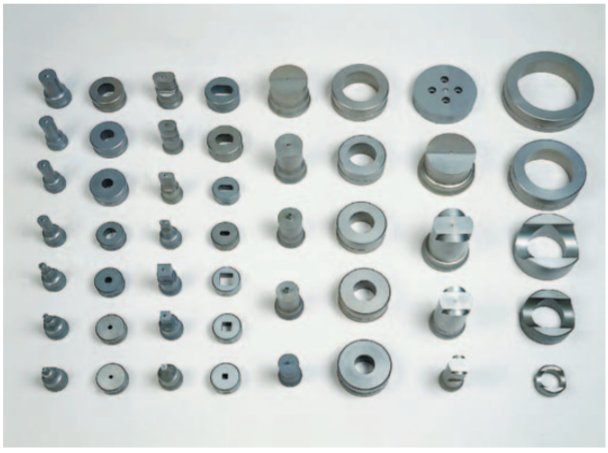
The frame of the machine is a monoblock construction that integrates both bolts and welding reinforcement to provide maximum frame structure rigidity.



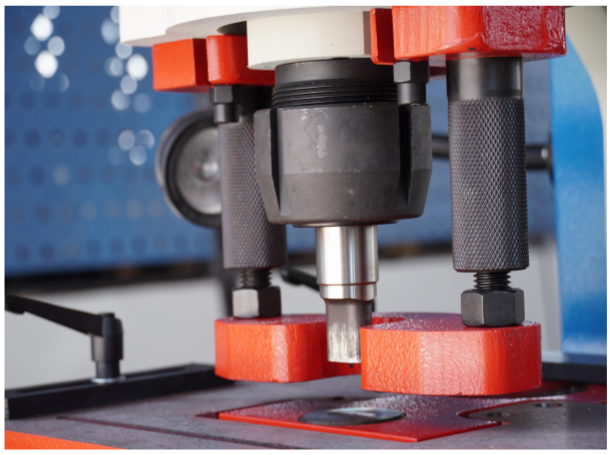
The punching station features a large cylinder mounting plate to ensure maximum cylinder support under heavy load. The punching base is one solid plate with T-slot grooves for universal tool fixture.

PUNCHING STATION

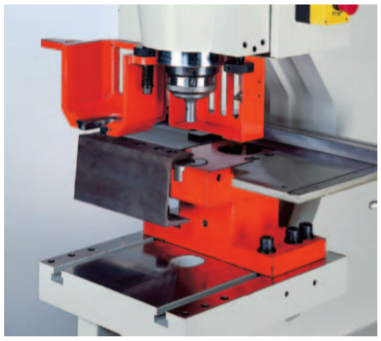
- A full range of punches and dies are available for various punching needs.
- Quick change retaining nut system for fast punch tooling change.
- Thoughtfully designed stripper for visibility, safety and ease of use.
- A large 2-piece table with scales and gauging stops is standard on all models.
- Stripper with interchangeable plates of various openings to minimize deformation is standard on all models.
- Optional hydraulic stripper is available on dual-cylinder ironworkers and all punching machines.



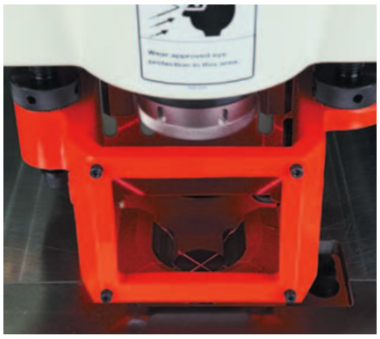
* Punches and dies are sold separately.



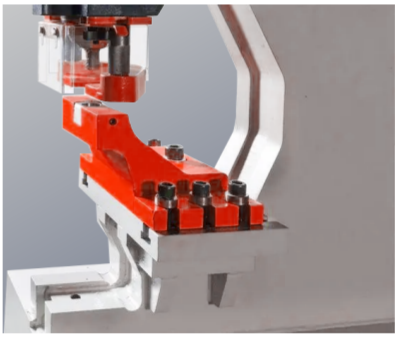
* Standard dual-opening die block for up to 50mm round punch and die.



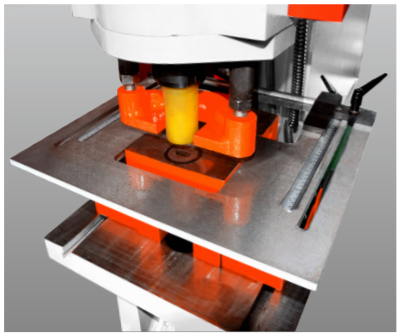
Overhang die holder for punching channel flanges and angles.
(optional on single cylinder models)



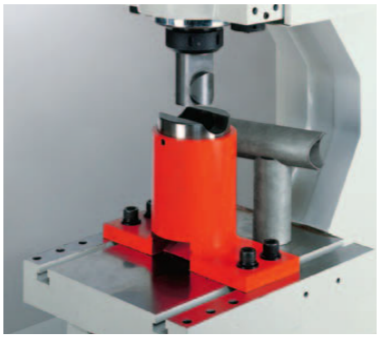
*Laser alignment system for more accurate positioning of marked parts.



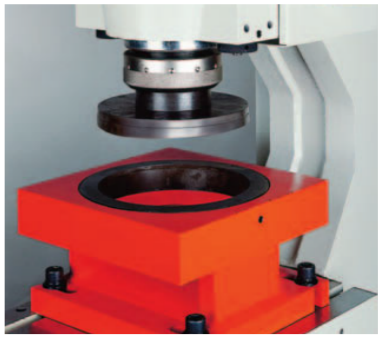
*Goose-neck die holder for punching channel flanges and webs.



*Urethane spring stripper for minimal deformation.
Safety cover removed for showing.



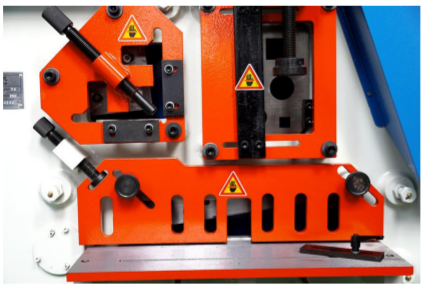
*Pipe notcher.

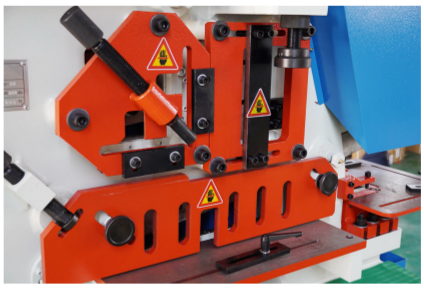


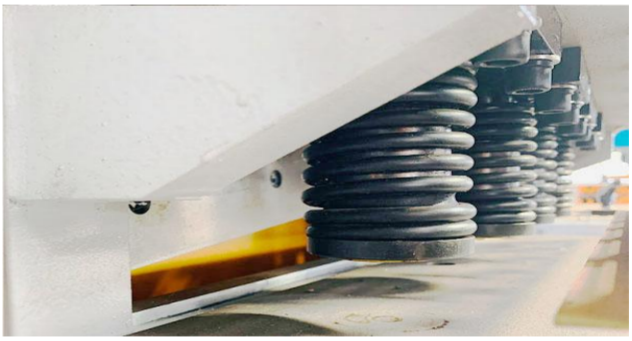
*Oversize punch attachment.
Safety cover removed for showing.

FLAT BAR SHEARING STATION

- Specially machined upper blade to give a clean shear with minimum distortion.
- Lower blade has four usable cutting edges
- Variable degree miter-cutting on angle flange.
- Easily adjustable hold-down
- Support table with guides for accurate positioning.



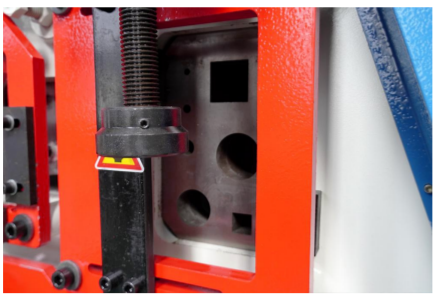




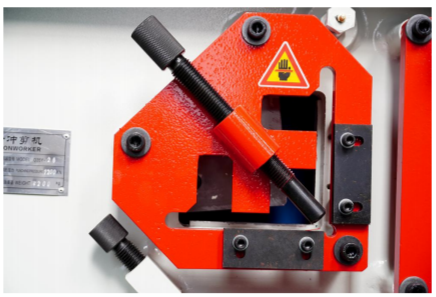
*Optional hydraulic tightening device,
automatic tightening when cutting plate

BAR SHEARING STATION

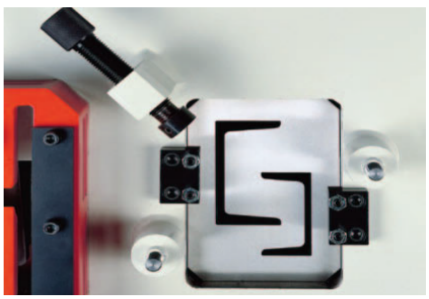
- One hold-down for various sizes of square bar shearing and round bar shearing.
- Optional channel and section bar shear tooling is available for most models. (See specification chart for details)



Round steel,
square steel shear



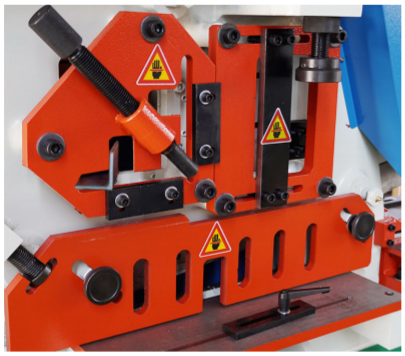
Angle shear



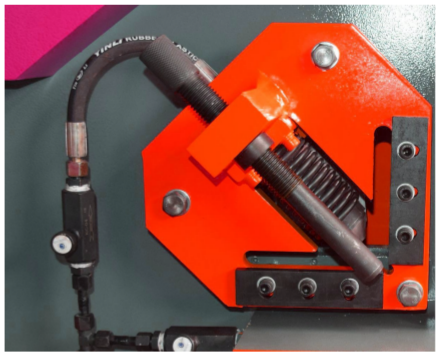
* Channel blades. (optional)

ANGLE SHEARING STATION

- Single shear with no material loss and minimal deformation.
- 45° miter-cut is easy and clean.
- Stationary blades with four usable cutting edges.
- Selectable corner radii on moving blades for optimum results on small or large angles.



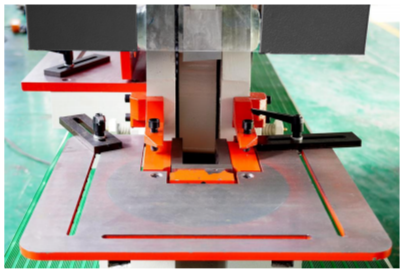




*Optional hydraulic hold-down for angle shear.

NOTCHING STATION

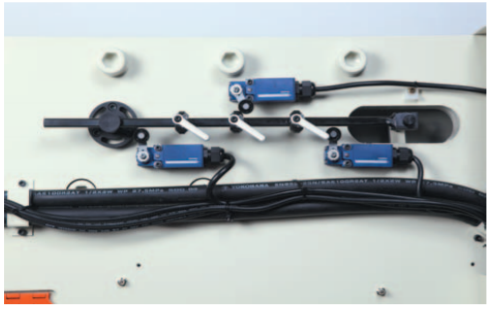
- Ideal for notching of flat bars and angles
- Electrically interlocked safety guard for maximum safety and visibility.
- Gauging table included with stops for precise positioning.



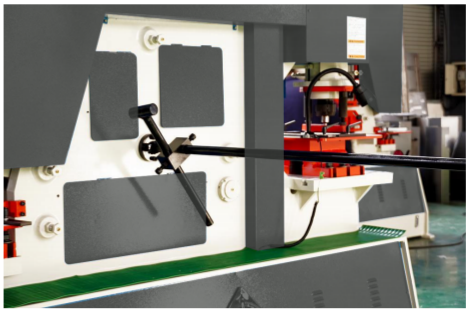


*Optional V-notcher.

OTHER INCLUDED FEATURES







*Optional rear retaining positioning device

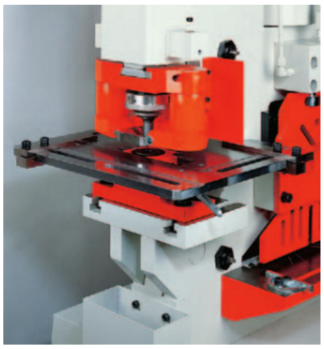
- Three limit switches enable setting of short notch stroke to improve efficiency.
- Magnetic base LED work light for safe operation.
- 1000mm electric backgauge for higher efficiency in repetitious work.
- The backgauge extension is available depending on request.

Q35Y SERIES IRONWORKERS

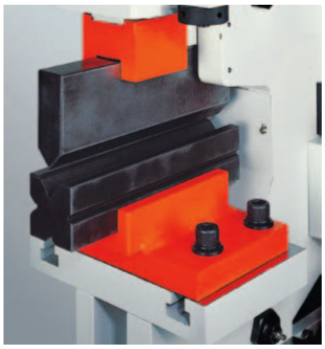
The Q35Y are special designed compact ironworkers with vertical movements at all stations. The entire main slide moves in straight up and down motion to provide the optimum results for punching, shearing, notching, and bending. Hydraulic hold-down and urethane spring stripper are also available for the best performance.The fast cylinder stroke greatly improves the efficiency. This model incorporates versatility, efficiency, accuracy, and ease of use at an excellent price.



* Single V bending



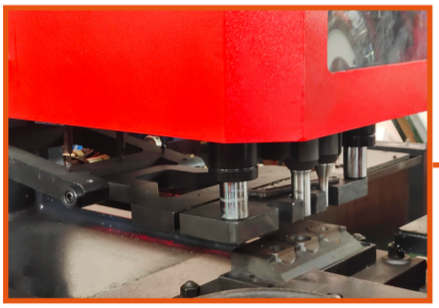
* Urethane spring stripper.



*Multi V bending

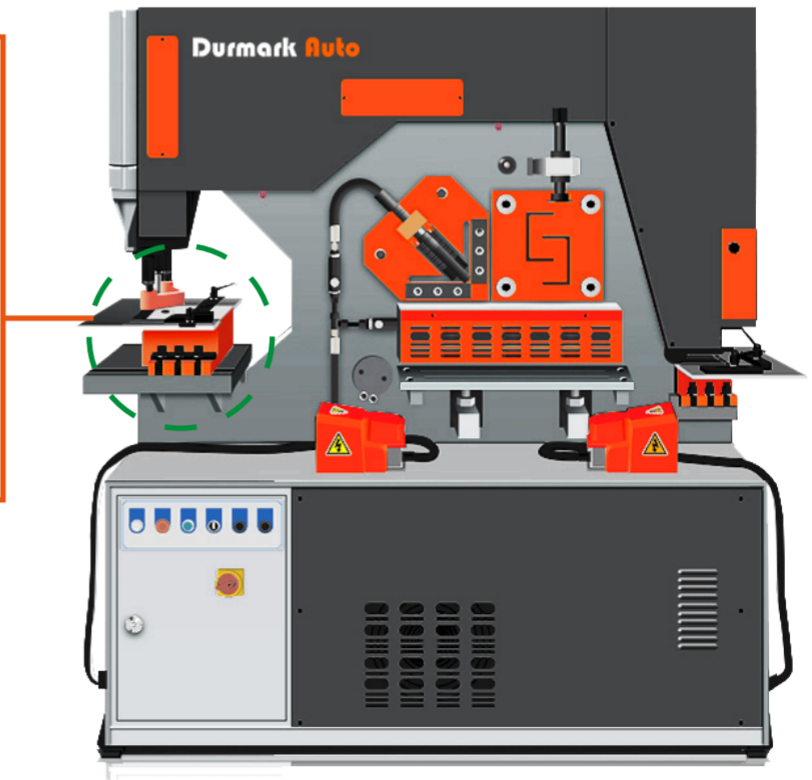


*Channel Shear.



Special mold
(optional)





SPECIFICATIONS

Model	Q35Y-16	Q35Y-20	Q35Y-25	Q35Y-30	Q35Y-40	Q35Y-50
Punching Pressure (T)	65	90	120	160	200	250
Max.cutting thickness of steel plates (mm)	12	20	25	30	40	50
Plate strength (N/mm²)	≤450	≤450	≤450	≤450	≤450	≤450
Angle of Shear (°)	7°	8°	8°	8°	8°	8°
Slider stroke (mm)	80	80	80	80	80	80
Stroketimes (times/min)	9-25	12-28	12-28	12-28	10	10
Throat depth (mm)	300	355	400	600	600	600
Main Motor Power (KW)	4	5.5	7.5	11	15	18.5
Overall dimensions (L×W×H) (mm)	1640×730×1770	1860×800×1900	2355×960×2090	2680×1040×2300	2970×1240×2350	3000×1440×2450
Weight	1900	2500	5200	6800	11000	14500

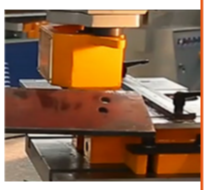
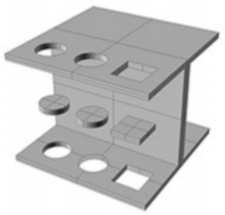
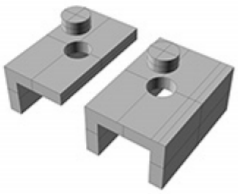
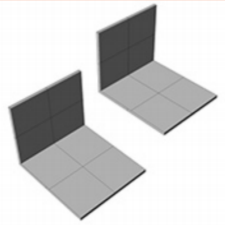
Profile		Section View	Q35Y-16	Q35Y-20	Q35Y-25	Q35Y-30	Q35Y-40	Q35Y-50
Punching holes (diameter×thickness) (mm)			25×16	30×20	35×25	38×30	40×35	40×40
			50×8	50×12	50×18	50×24	50×28	50×32
Table height			960	970	1065	1170	1215	1245
Shear plate (mm)	Plate shear (wide×thick)		250×16 400×8	330×20 480×10	330×25 600×16	330×30 600×20	400×35 700×25	400×40 750×30
	Blade length		410	485	605	605	710	760
	Angle steel trimming		25×125×12	140×140×12	160×160×14	180×180×16	200×200×18	200×200×20
	Table height		860	890	900	950	935	950
Round Bar(mm)			45	50	60	65	70	80
Square Bar(mm)			40×40	45×45	50×50	55×55	60×60	65×65
Angle Steel (mm)	90° Shearing		125×125×12	140×140×12	160×160×14	180×180×16	200×200×18	200×200×20
	45° Shearing		50×50×5	50×50×5	60×60×6	60×60×6	100×100×10	120×120×10
	Table height		860	890	900	950	935	950
Type shear (mm)	I-Bar		120×120×12 60×60×8	140×140×12 70×70×10	160×160×14 80×80×10	180×180×16 80×80×10	200×200×18 80×80×10	200×200×18 80×80×10
	T-Joist		60×60×8	70×70×10	80×80×10	80×80×10	80×80×10	80×80×10
	U-Channel		126×53×5.5	160×60×6.5	210×75×9	280×86×11.5	300×89×12	320×92×12
	Table height		1210	1220	1260	1470	1510	1550
Die shear (mm)	Notching (W×D×T)		100×53×10	100×57×13	100×57×14	100×60×16	100×60×18	200×60×20
	V-notching die (S×S×T)		95×95×10	100×100×12	105×105×13	105×105×16	105×105×18	105×105×20
	Big V-notching die (S×S×T)		145×145×18	145×145×10	145×145×12	145×145×13	145×145×15	145×145×18
	Table height		910	900	860	965	950	975
V-bending (wide×thick) (mm)	Single-V-bending (W×T)		250×15	250×18	250×20	250×20	250×22	250×24
	Multi-V-bending (W×T)		500×5	500×5	600×5	700×5	700×8	700×8

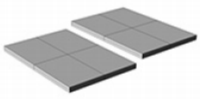
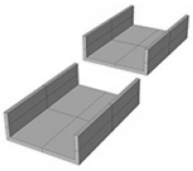
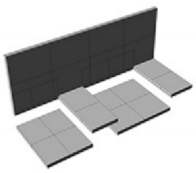
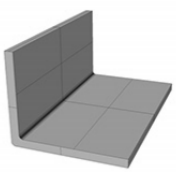
CONFIGURATION

Standard configuration	
Electircal	Schneider from French brand
Main motor	Siemens beide from Germany brand
Hydraulic system	Rexroth hydraulic system from Germany
Pressure gage	Hangzhou pressure gauge
Oil pump	First or Sunny from U.S.A brand

Optional configuration	
PLC	Siemens from Germany brand
Oil cooler unit	Wuxi from China
Auto-feeder	Durmark from China
Ball screw	HIWIN from Taiwan
Linear guideway	HIWIN from Taiwan

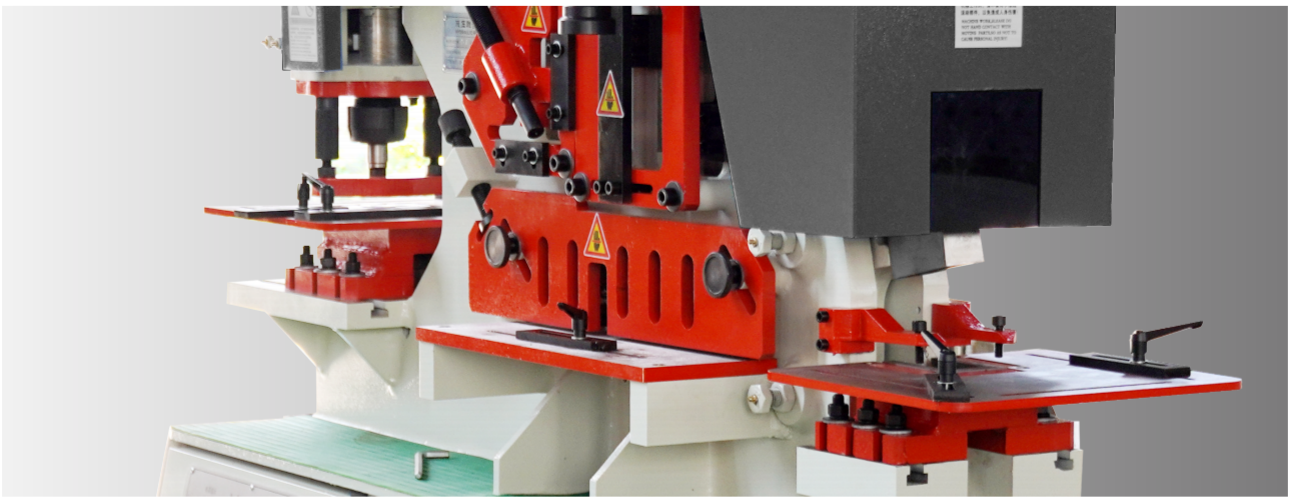
PICTURE DISPLAY

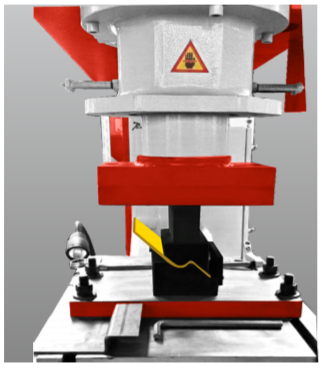
Mold diagram	Effect drawing	Actual picture
 ① Puching hole mold		
 ② Eccentric puncher		
 ③ Oval hole punching mold		
 ④ Double head oval hole punching mold		
 ⑤ Angle shear blade		

Mold diagram	Effect drawing	Actual picture
 ⑥ Plate shear blade		
 ⑦ Round and square bar shear blade		
 ⑧ Channel steel shear blade		
 ⑨ Die cutting mold.		
 ⑩ Bending mold		

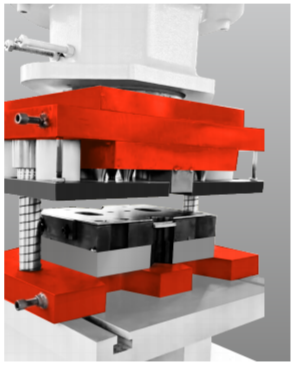
Q35Y Series Hydraulic Ironworker

OPTIONAL TOOLING

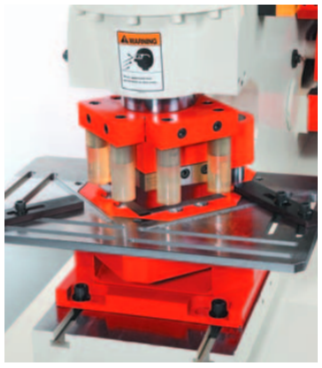




*Special press brake.



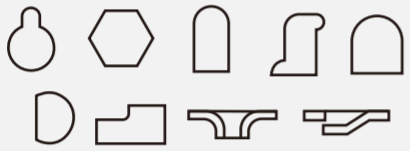
*Special punching.



*Large vee-notcher. (Punch side)



*Angle bending press.



*Special shape punches and dies.

*Optional Semi-Automatic CNC
Tables with 1000x400 mm travel.
Shown with optional hydraulic clamp.



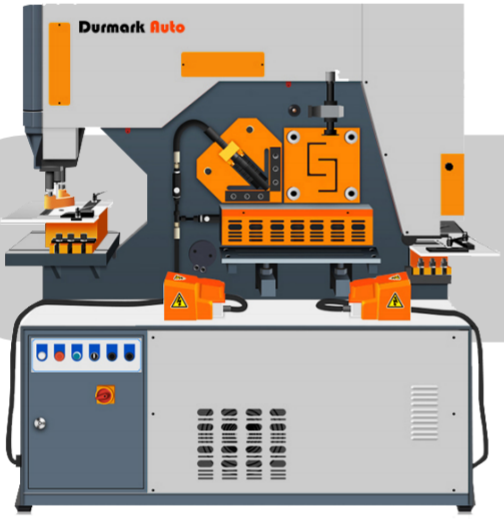
Q35Y Series Hydraulic Ironworker

APPEARANCE CAN BE CUSTOMIZED

Appearance can be customized according to your demands.

RAL 5015

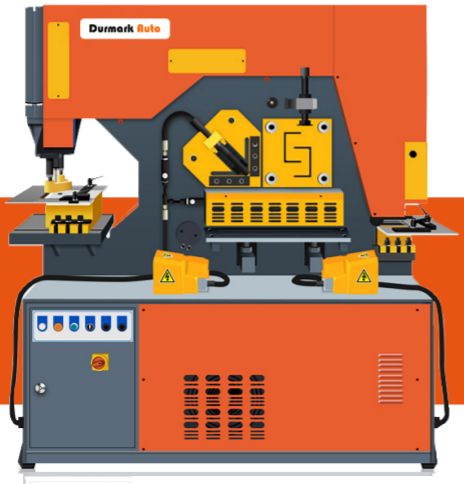




RAL 7001

RAL 7040





RAL 2008

Durmark Auto

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