

The Winning Force

DURMA

HRB SERIES Plate Roll Bending



MRB & MRB-S SERIES Motorised Plate Roll Bending



- Strong
- Precise
- Efficient
- Fast
- High Repeatability



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 m², 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.

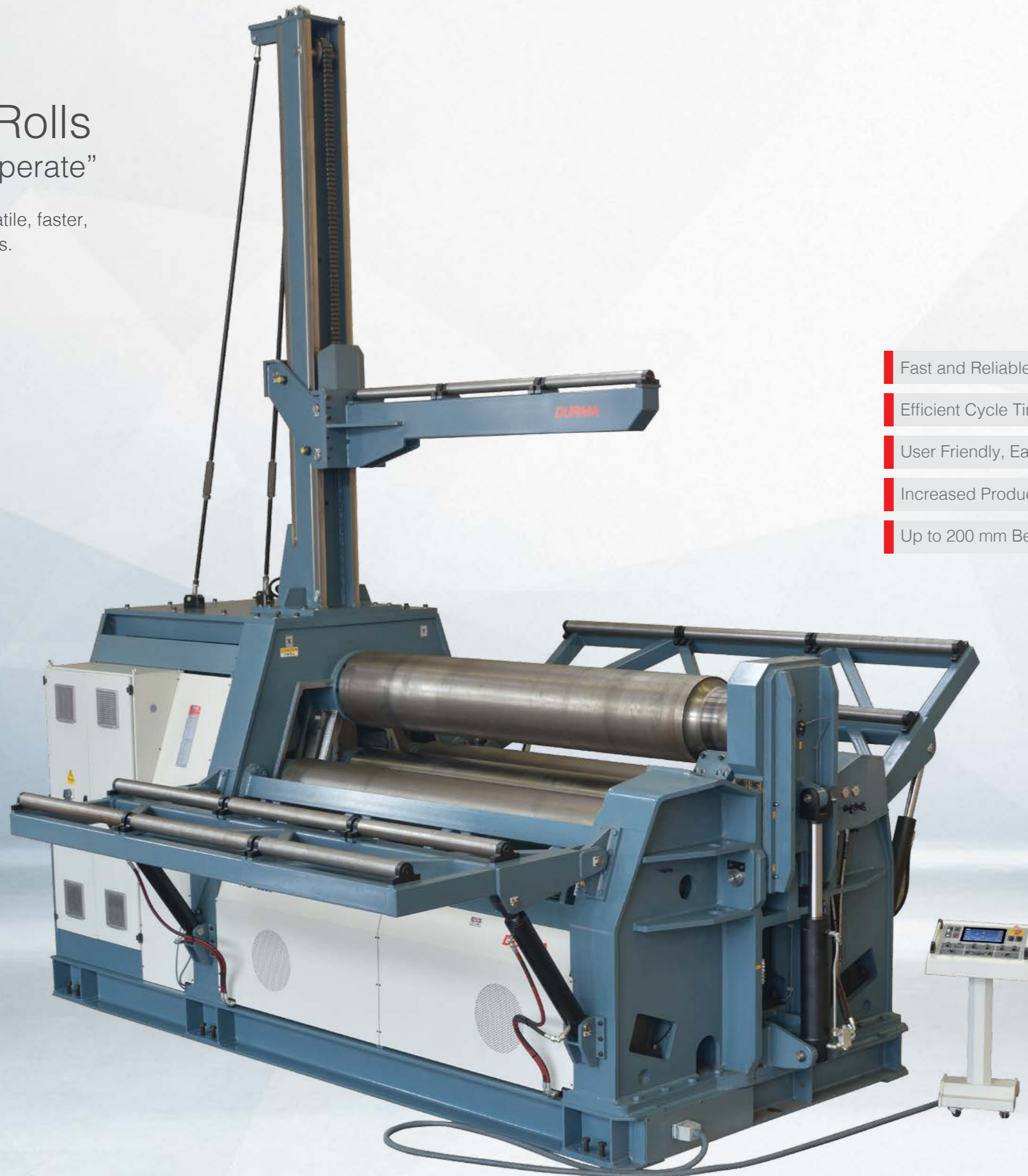
Durmazlar presents its products with **DURMA** brand to the world.

- 1 High technology, modern production lines
- 2 Top quality components
- 3 High quality machines designed in R&D Centre

HRB-4 Series Plate Rolls

“Fast, Accurate and Easy to Operate”

Four plate rolls are more precise, productive, versatile, faster, safer and easier to operate than three roll machines. They are less dependent on operator competence. Ideal for bending plates up to 200 mm thick.

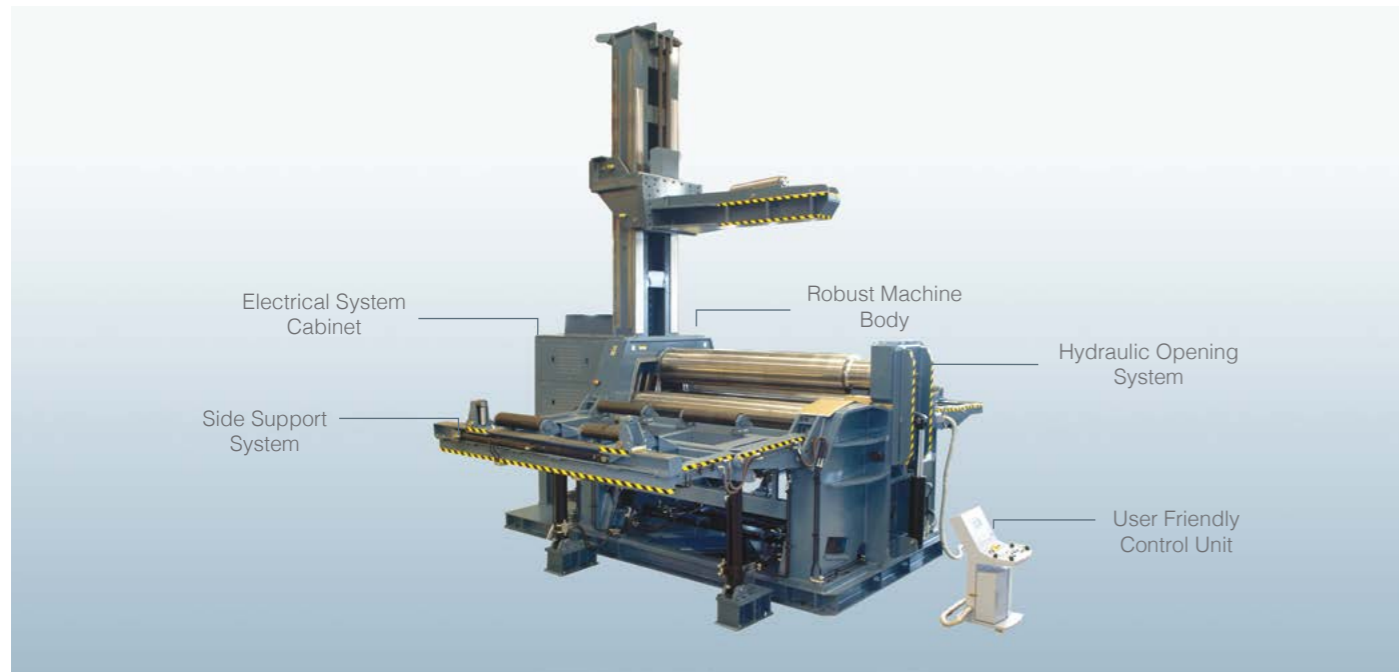


- Fast and Reliable
- Efficient Cycle Times
- User Friendly, Easy to Operate
- Increased Productivity
- Up to 200 mm Bending Thickness

Finest Bending Performance

“Durma always strives to be your preferred partner”

Robust machine body and construction ensure long machine life and low maintenance. High torque drive system allows HRB to achieve shorter cycle times. User friendly control units makes it possible to be less dependant on operator competence.



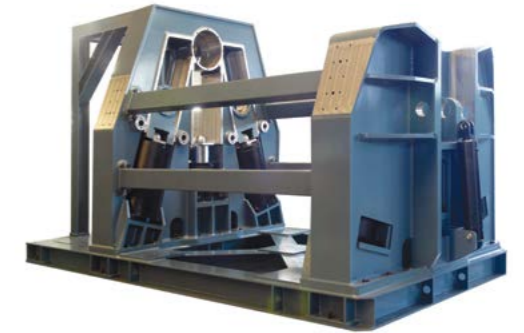
General Specifications

- Up to 8000 mm Bending Lengths
- Up to 200 mm Bending Thickness
- Accurate, Easy to Operate, Fast and Reliable
- Flat zone of the part is minimized
- Pre-bending, conical bending and ellipse bending can be done easily
- Double pre-bends (both ends) in one pass
- The sheet reference is maintained by tightening of top and bottom rolls
- Most desirable bending operation for CNC applications
- More efficient for cycle times
- Hydraulic and electrical systems have been safeguarded from overloading and require minimum maintenance.
- Hydraulic and electrical components are modual and designed according to world standards

HRB Series Standard Features

Robust Body Structure

Machine's body is strengthened and lowered to minimise the twists and deformation. Machine body, frame and steel bar connections are stress relieved after the welding operation.



Planetary Swing Rolls System

Side rolls are guided by swing beds which allows them to act as 2 independent axes moving on curve shape orbits. Side rolls are approaches to the top roll on curve movement which allows to get perfect prebendings as well as spring back minimisation. (Rectilinear Rolls System designed for top roll dia more than 460 mm)



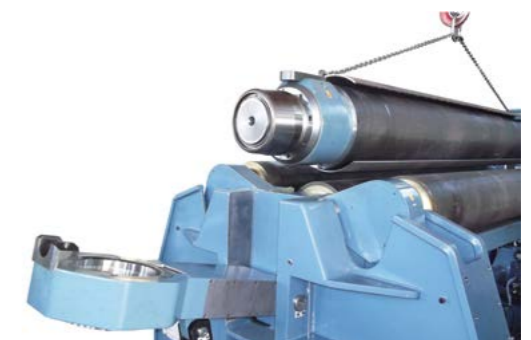
High Torque Drive System

High Torque Drive System enables Durma roller bending machines to bend metal sheets with less steps. HRB-4 machines has top and bottom rolls powered by planetary reducer, hydraulic motor and gear system. HRB-3 machines has top and side rolls powered by planetary reducer, hydraulic motor and gear system. Strong Hydraulic Brake system does not allow the sheet to slip back. Pressure safety valves are protecting the hydromotor and other components from overloads and peak pressures.



Hydraulic Opening

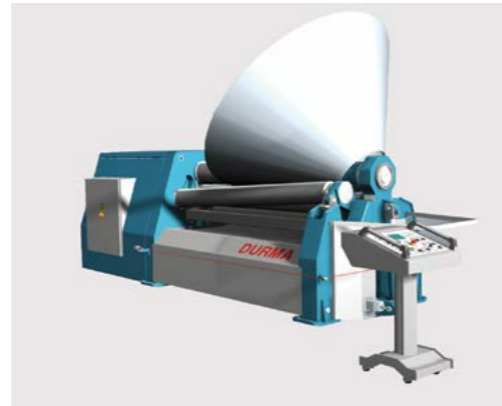
Hydraulic opening drop-end for easy remove completed the bending.



HRB Series Standard Features

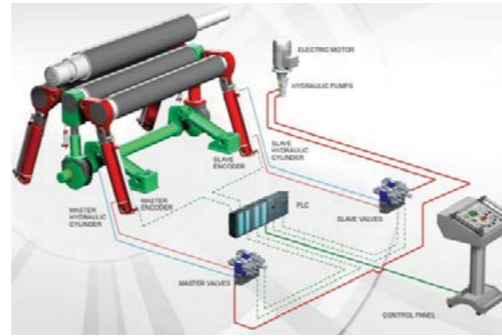
Conical Bending System

Strong body and angular bottom and side rolls enables to easily conical bend materials. While machine in the market bends conical 3 times of top roll diameter, Durma HRB machines can bend 1.5 times easily.



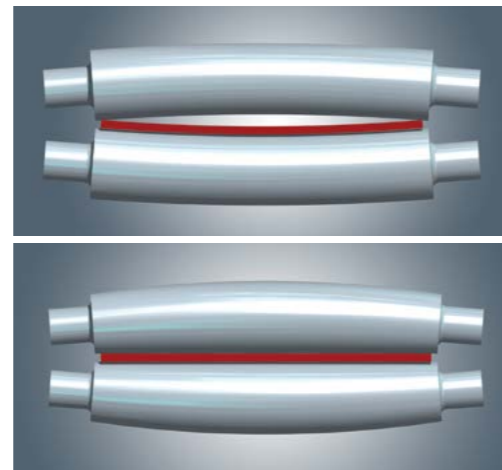
Synchronized Rolls System

Side rolls triggered by 4 different strong hydraulic cylinders. Synchronization between Thanks to high precision load holding valves. Bottom roll tightens different thickness of sheets without deformation and taking to the consideration of its parallelism by hydraulic adjustable pressure torsion bar.



Hardened Rolls And Crowning System

Highly durable carbon steel (C45) rolls are machined by CNC Lathes with high precision without creating notch effect. Working surfaces of the rolls are induction hardened to HRC 54±2. Rolls are machined as crowning shape to compensate the deflections on the rolls during the bending.



Strengthen Bearing System

Rolls are guided with spherical roller bearings and bronze housings. Guiding system requires less lubrication and keeps its precision in long term.



Hydraulic System

Rolls are positioned by hydraulic components. The precision of axes are maintained through the use of Bosch Rexroth valves. Pressure safety valves protect against peak pressures and overloads.



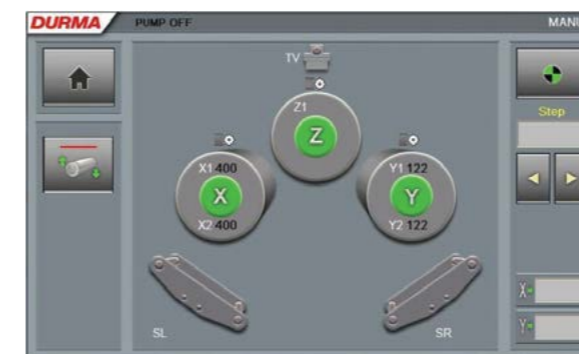
Electrical and Electronic System

Electrical system is designed compatible with CE safety regulations. The system consists of well known electrical components. The system is protected by current overloads for its components, power supplies and motors.



User Friendly Control Unit

The standard control unit ensures that machine's bottom and side rollers operate smoothly.



User Friendly Control Unit HRB-3



User Friendly Control Unit HRB-4

HRB Series Optional Features

NC Control Unit (HRB-4)

In addition to standard user friendly control unit, all bending steps are recorded for operator in teaching mode. All recorded movements can be repeated using automatic mode. NC control system has capacity to save 70 programs up to 100 steps each.



CNC Control Unit (HRB-4)

CNC control unit features a graphical control system that enables the operator to realize the bending step by step or automatically calculate bending process. It includes a bending library that features polysentric and ellipse bending shapes.



Vertical and Side Support System

Optional hydraulic side and vertical supports the sheet's stretch and prevent deterioration of the bending form in big shaped bending.

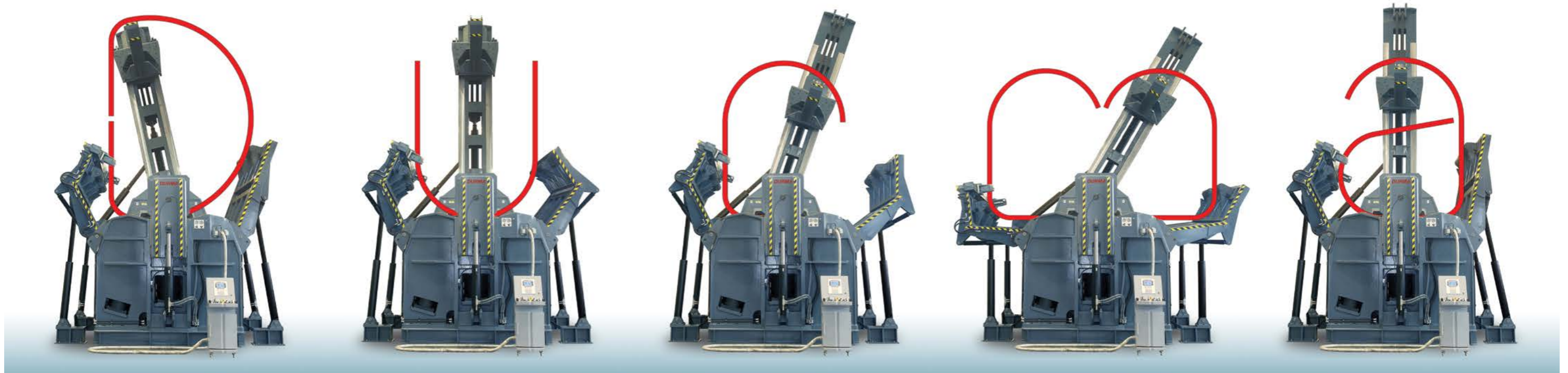
Moveable gauges with hydraulic double cylinders are produced from St52 steel construction. Sheet is easy sliding movement on supports by support rollers which is housing by bearings.

Each support can be controlling from control panel separately. It is possible to vertical support's capacity is to provide $\varnothing 2000$ mm to $\varnothing 6000$ mm sheet and 4 ton to 6 ton capacities. Vertical and side support system can be controlling automatically NC mod in CNC and NC machines.



Especially the during bendings of the large diameter and thin material ellipse, parallel corners and polycentric shaped may effect the precisions and can cause deformation of the material, when there is not enough support

from the standard sheet support systems the double knuckle side support system may interfere and provides a precise and perfect bendings, if need the sizes of these support can be build according to the customers request.



HRB Series Optional Features

Both Vertical and Horizontal Working

This option can be used when the large diameters bendings are not achieved with the support systems and the height is limited, its requires a pit and with this pit machine can be more usefull as well as the height advantages.

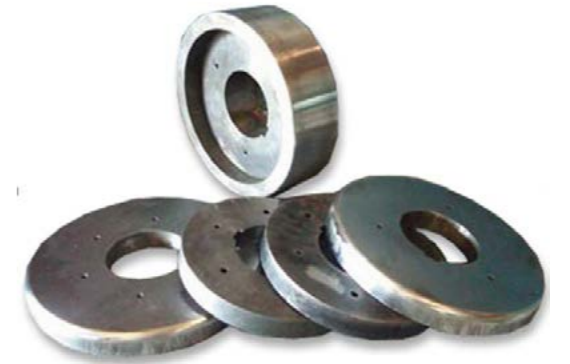


Special solution for corrugated sheet



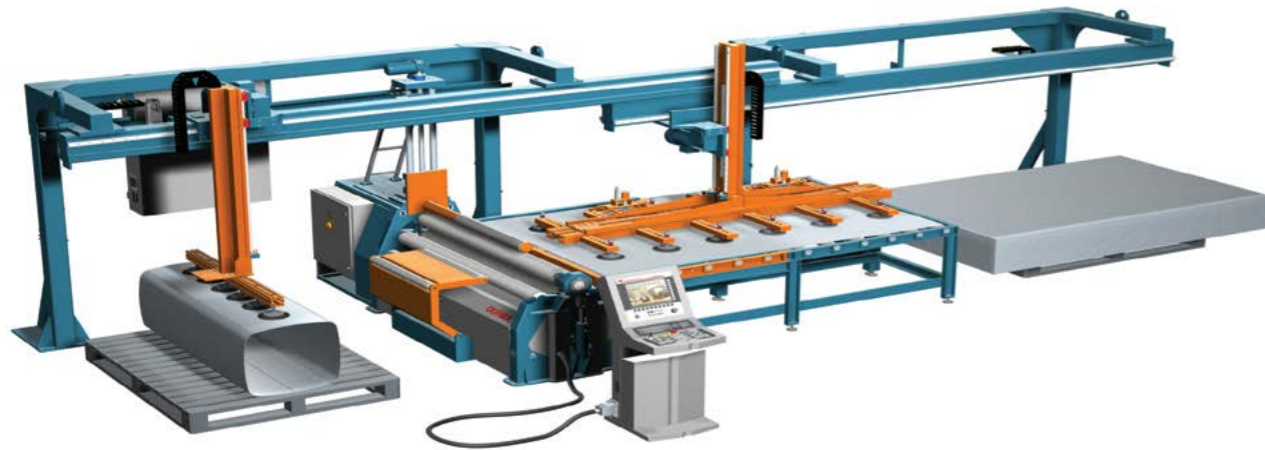
Extended and Profile Bending Rolls

Extenden top and side Rolls with the universal bending roll sets bar, profile, angle profile can be easlie produced without needing any additional machinery, if needed special roll set can also be provided for customers requirements straightness or if needed conical bendings can be adjusted.

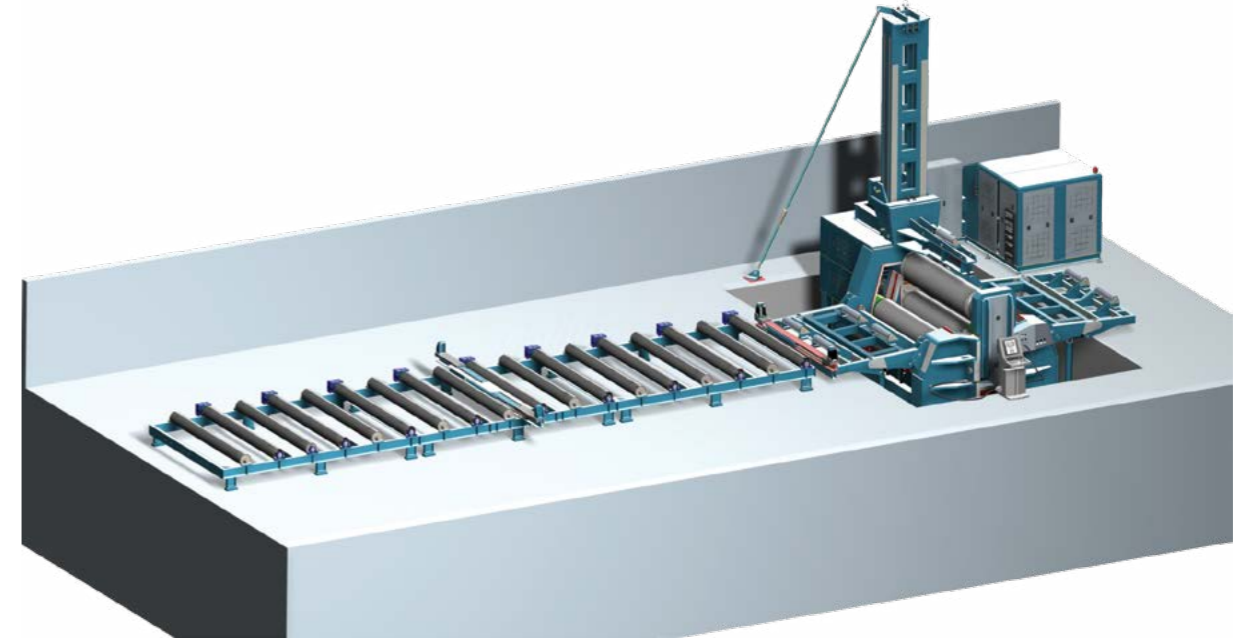


HRB Series Special Features

Full automatic bending line with loading and unloading



Wind tower bending line



Anguler Material Feeding System



Material Feeding and Lip Alignment System

With the long and large sizes of metal sheets there may always have difficulties to providing the accuracy, placing and keeping the control of the product. Robust Bearing and housing bearing will provide smooth movement towards the machine, motorized or manual feeding tables also ensures the reduction of time and easy process. Opposite hydraulic cylinders will provide correctioning and will also help with the straightness or if needed conical bendings can be adjusted.



Standard & Optional Equipment

Standard Equipments

- PLC control system
- Conical bending
- Induction hardened rolls
- Stress relieved steel construction body
- High tensile carbon steel rolls
- Sealed spherical roller bearings
- 2 rolls drive system (Upper roll Ø 200 mm - Ø 430 mm)
- 4 rolls drive system (Upper roll <Ø 430 mm)
- Fixed top roll (Upper roll Ø 200 mm - Ø 430 mm)
- Hydraulic opening cover
- Welding possibility on the machine
- Electronic synchronized rolls
- Mechanical synchronized bottom rolls
- Adjustable pinching pressure
- Overload protection
- Safety wire around the machine and emergency stop button on control panel
- Manual lubrication
- User manual
- CE

Optional Equipments

- NC Control Unit
- CNC Control Unit
- Polished rolls
- Adjustable turning speed (NC, CNC Standard)
- Vertical or horizontal working position
- Hydraulic vertical support preparation (Full / Mechanical)
- Hydraulic vertical support
- Side support preparation (Full / Mechanical)
- Hydraulic side supports
- Hydraulic side supports with double joint
- NC included side and vertical supports
- Interchangeable top roll
- Longer rolls for profile bending and special bending rolls
- Oil cooling
- Oil heating
- Automatic centralized lubrication system
- Hydraulic roll crowning system
- Plate feeding platform with alignment unit
- Special plate support systems
- Loading, unloading systems
- Seperate power cabinet
- Special solutions for wind tower projects

HRB-4 Technical Specifications

TYPE	Bending Length	Min. Int. Dia ØDmin			Top Roll	Bottom Roll	Side Rolls	Max. Pass Through	Length	Width	Height	Working Height	Weight	Motor Power	Min. Additional top roll diameter	Hydraulic Tank Capacity
		Ødx5	Ødx3	Ødx1,5												
		Bending Capacities	Bending Capacities	Pre-Bending Capacities												
HRB-4 1505	1550	6	5	4	150	150	130	12	3100	970	1140	875	2490	5.5	140	90
HRB-4 1507	1550	8	7	5	170	170	140	15	3100	970	1140	865	2660	5.5	140	90
HRB-4 2004	2050	5	4	3	150	150	130	12	3600	970	1140	875	2690	4	140	90
HRB-4 2006	2050	7	6	4	170	170	140	15	3600	970	1140	865	2920	5.5	140	90
HRB-4 2008	2050	10	8	6	200	200	190	30	3830	1160	1180	840	4340	7.5	200	160
HRB-4 2010	2050	12	10	8	210	190	180	30	3830	1160	1180	835	4250	11	200	160
HRB-4 2013	2050	15	13	10	230	210	190	30	3830	1160	1180	825	4570	11	200	160
HRB-4 2016	2050	18	16	13	270	250	220	50	4260	1660	1590	1155	8000	15	270	400
HRB-4 2020	2050	22	20	16	300	270	220	50	4260	1660	1590	1140	8500	18.5	270	400
HRB-4 2025	2050	28	25	20	330	300	240	50	4260	1660	1590	1125	9200	22	270	400
HRB-4 2030	2050	33	30	25	360	330	270	60	4510	2060	2050	1510	13950	30	360	600
HRB-4 2035	2050	38	35	30	400	370	290	65	4510	2060	2050	1490	15300	37	360	600
HRB-4 2040	2050	44	40	35	430	400	320	70	4510	2060	2050	1475	16380	45	360	600
HRB-4R 2050	2050	55	50	40	460	440	360	105	4634	2280	2375	1767	23800	45+22	430	830
HRB-4R 2060	2050	65	60	45	480	455	370	90	4634	2280	2375	1757	24800	55+22	430	830
HRB-4R 2065*	2050	70	65	50	520	490	410	140	5035	2630	2787	2045	38000	30+30	500	1100
HRB-4R 2070*	2050	75	70	55												
HRB-4R 2075*	2050	80	75	60												
HRB-4R 2080*	2050	85	80	60												
ASK FOR DETAILS																
HRB-4 2506	2550	7	6	4	200	200	190	30	4330	1160	1180	840	4970	7.5	200	160
HRB-4 2508	2550	10	8	6	210	190	180	30	4330	1160	1180	835	4850	11	200	160
HRB-4 2510	2550	12	10	8	230	210	190	30	4330	1160	1180	825	5250	11	200	160
HRB-4 2513	2550	15	13	10	270	250	220	50	4760	1660	1590	1155	8840	15	270	400
HRB-4 2516	2550	18	16	13	300	270	220	50	4760	1660	1590	1140	9600	18.5	270	400
HRB-4 2520	2550	22	20	16	330	300	240	50	4760	1660	1590	1125	10500	22	270	400
HRB-4 2525	2550	28	25	20	360	330	270	60	5010	2060	2050	1510	15150	22	360	600
HRB-4 2530	2550	33	30	25	400	370	290	65	5010	2060	2050	1490	16420	30	360	600
HRB-4 2535	2550	38	35	30	430	400	320	70	5010	2060	2050	1475	17750	37	360	600
HRB-4R 2540	2550	44	40	35	460	440	360	105	5134	2280	2375	1767	26400	37+22	430	830
HRB-4R 2550	2550	55	50	40	480	455	370	90	5134	2280	2375	1757	32200	45+22	430	830
HRB-4R 2560 *	2550	63	60	45												
ASK FOR DETAILS																
HRB-4 3006	3100	7	6	4	210	190	180	30	4880	1160	1180	835	5200	7.5	200	160
HRB-4 3008	3100	10	8	6	230	210	190	30	4880	1160	1180	825	5800	11	200	160
HRB-4 3010	3100	12	10	8	270	250	220	50	5310	1660	1590	1155	9700	11	270	400
HRB-4 3013	3100	16	13	10	300	270	220	50	5310	1660	1590	1140	10600	15	270	400
HRB-4 3016	3100	18	16	13	330	300	240	50	5310	1660	1590	1125	11600	18.5	270	400
HRB-4 3020	3100	22	20	16	360	330	270	60	5560	2060	2050	1510	16650	22	360	600
HRB-4 3025	3100	28	25	20	400	370	290	65	5560	2060	2050	1490	18300	30	360	600
HRB-4 3030	3100	33	30	25	430	400	320	70	5560	2060	2050	1475	20500	37	360	600
HRB-4R 3035	3100	38	35	30	460	440	360	105	5684	2280	2375	1767	31500	37+22	430	830
HRB-4R 3040	3100	44	40	35	480	455	370	90	5684	2280	2375	1757	35000	45+22	430	830
HRB-4R 3050 *	3100	53	50	40	520	500	410	165	6085	2630	2787	2045	45000	30+30	500	1100
HRB-4R 3060 *	3100	63	60	45												
HRB-4R 3070 *	3100	74	70	50												
HRB-4R 3090 *	3100	95	90	70												
ASK FOR DETAILS																
HRB-4 4008	4100	10	8	6	300	270	220	50	6310	1660	1590	1140	12700	15	270	400
HRB-4 4010	4100	12	10	8	330	300	240	50	6310	1660	1590	1125	14100	15	270	400
HRB-4 4013	4100	15	13	10	360	330	270	60	6560	2060	2050	1510	19350	18.5	360	600
HRB-4 4016	4100	18	16	13	400	370	290	65	6560	2060	2050	1490	21300	22	360	600
HRB-4 4020	4100	22	20	16	430	400	340	70	6560	2060	2050	1475	23810	30	360	600
HRB-4 4025	4100	28	25	20	460	440	360	90	7200	2300	2530	1875	39000	37	430	830
HRB-4 4030	4100	33	30	24	480	455	370	90	6684	2280	2375	1757	43000	37+22	430	830
HRB-4 4035 *	4100	39	35	28	520	500	410	165	7085	2630	2787	2045	50000	30+30	500	1100

* On mentioned models : Ø Dmin= Ødx2 (pre bending) ; Ødx4 (bending)
 The mentioned values above is only works for 240 N/mm²
 Different material and widths , can be calculated by DURMA Roll Bending Calculator
 Conic bending capacities depends on the angle and half value of mentioned values above
 Weight and motor powers optionally goes higher levels with additional



PLANETARY ROLLS SYSTEM
 Top Roll: Ø 140-Ø430 mm
 Drive: Top&Bottom



RECTILINEAR ROLLS SYSTEM
 Top Roll: Ø 430-Ø760 mm
 Drive: All Rolls

HRB-3 Series Plate Rolls

“Fast, Accurate and Easy to Operate”

Hydraulics Plate 3-Roll Bending Machine
Flexibility of 3 roll for medium sizes by Durma technology
Prebending of both the leading and trailing edge



- Flexible machine for medium to thick material
- Cost effective solutions for large diameters
- Wide working range
- Excellent for rolling cones
- Great value for precision and reliability
- All rolls are driven with superior torque and speed

Standard Equipments

- PLC control system
- Conical bending
- Induction hardened rolls
- Stress relieved steel construction body
- High tensile carbon steel rolls
- Sealed spherical roller bearings
- 3 rolls drive system
- Fixed top roll and hydraulic opening cover
- Welding possibility on the machine
- Electronic synchronized rolls
- Overload protection
- Safety wire around the machine and emergency stop button on control panel
- Manual lubrication
- User manual
- CE

HRB-3 Technical Specifications

TYPE	Bending Length	Min. Int. Dia ØDmin			Top Roll	Side Rolls	Max. Pass Through	Length	Width	Height	Working Height	Weight (kg)	Motor Power (kW)	Min. Additional top roll diameter	Hydraulic Tank Capacity
		Bending Capacities	Bending Capacities	Pre-Bending Capacities											
		Ødx5	Ødx3	Ødx1,5											
L (mm)	S (mm)	S (mm)	s (mm)	Ød (mm)	Ø (mm)	A (mm)	U (mm)	G (mm)	Y (mm)	C (mm)		(kW)	Ø (mm)		
HRB-3 2008	2050	10	8	6	200	180	90	3830	1160	1180	840	3420	7.5	200	160
HRB-3 2010	2050	12	10	8	210	190	80	3830	1180	1180	835	3600	7.5	200	160
HRB-3 2013	2050	15	13	10	230	200	70	3830	1180	1180	825	3800	11	200	160
HRB-3 2016	2050	18	16	13	270	250	140	4260	1660	1590	1155	6850	15	270	400
HRB-3 2020	2050	22	20	16	300	270	115	4260	1660	1590	1140	7300	18.5	270	400
HRB-3 2025	2050	28	25	20	330	290	90	4260	1660	1590	1125	7930	22	270	400
HRB-3 2030	2050	33	30	25	360	330	195	4510	2060	2050	1510	12640	30	360	600
HRB-3 2035	2050	38	35	30	400	350	165	4510	2060	2050	1490	13400	37	360	600
HRB-3 2040	2050	44	40	35	430	380	135	4510	2060	2050	1475	14300	45	360	600
HRB-3 2506	2550	7	6	4	200	180	90	4330	1160	1180	840	3800	7.5	200	160
HRB-3 2508	2550	10	8	6	210	190	80	4330	1160	1180	835	4000	7.5	200	160
HRB-3 2510	2550	12	10	8	230	200	70	4330	1160	1180	825	4350	11	200	160
HRB-3 2513	2550	15	13	10	270	250	140	4760	1660	1590	1155	7550	15	270	400
HRB-3 2516	2550	18	16	13	300	270	115	4760	1660	1590	1140	8200	18.5	270	400
HRB-3 2520	2550	22	20	16	330	290	90	4760	1660	1590	1125	8900	22	270	400
HRB-3 2525	2550	28	25	20	360	330	195	5010	2060	2050	1510	12380	22	360	600
HRB-3 2530	2550	33	30	25	400	350	165	5010	2060	2050	1490	13300	30	360	600
HRB-3 2535	2550	38	35	30	430	380	135	5010	2060	2050	1475	14500	37	360	600
HRB-3 3006	3100	7	6	4	210	190	80	4880	1160	1180	835	4500	7.5	200	160
HRB-3 3008	3100	10	8	6	230	200	70	4880	1160	1180	825	4800	7.5	200	160
HRB-3 3010	3100	12	10	8	270	250	140	5310	1660	1590	1155	8280	11	270	400
HRB-3 3013	3100	15	13	10	300	270	115	5310	1660	1590	1140	9200	15	270	400
HRB-3 3016	3100	18	16	13	330	290	90	5310	1660	1590	1125	9850	18.5	270	400
HRB-3 3020	3100	22	20	16	360	330	195	5560	2060	2050	1510	14900	22	360	600
HRB-3 3025	3100	28	25	20	400	350	165	5560	2060	2050	1490	16150	30	360	600
HRB-3 3030	3100	33	30	25	430	380	135	5560	2060	2050	1475	17700	37	360	600
HRB-3 4006	4100	7	6	4	270	250	140	6310	1660	1590	1155	9710	11	270	400
HRB-3 4008	4100	10	8	6	300	270	115	6310	1660	1590	1140	10600	11	270	400
HRB-3 4010	4100	12	10	8	330	290	90	6310	1660	1590	1125	11780	15	270	400
HRB-3 4013	4100	15	13	10	360	330	195	6560	2060	2050	1510	17200	18.5	360	600
HRB-3 4016	4100	18	16	13	400	350	165	6560	2060	2050	1490	18900	22	360	600
HRB-3 4020	4100	22	20	16	430	380	135	6560	2060	2050	1475	21200	30	360	600

The mentioned values above is only works for 240 N/mm²
Different material and widths - can be calculated by DURMA Roll Bending Calculator
Conic bending capacities depends on the angle and half value of mentioned values above
Weight and motor powers optionally goes higher levels with additional

Optional Equipments

- Polished rolls
- Adjustable turning speed
- Vertical or horizontal working position
- Hydraulic vertical support preparation (Full / Mechanical)
- Hydraulic vertical support
- Side support preparation (Full / Mechanical)
- Hydraulic side supports
- Hydraulic side supports with double joint
- Interchangeable top roll
- Longer rolls for profile bending and special bending rolls
- Oil cooling
- Oil heating
- Automatic centralized lubrication system
- Plate feeding platform with alignment unit
- Special plate support systems
- Loading, unloading systems
- Separate power cabinet



PLANETARY ROLLS SYSTEM
Top Roll: Ø200-Ø430 mm
Drive: All Rolls

MRB-S Series Plate Rolls

Motorised Assymetrical 3 Roll Machine

Especially for thinner sheets with small lot sizes
 Easy prebending thanks to top & bottom rolls tighten the workplace
 Cost-oriented solutions for small and medium enterprises
 Wide range of industrial usage



MRB-S	Unit	1506	2005	2006	2504	2506	2508	3004	3006
Bending Length	mm	1530	2030	2030	2530	2530	2530	3030	3030
Bending Capacity	mm	6	5	6	4	6	8	4	6
Pre Bending	mm	4	4	5	3	4	6	2	4
Tolp roll Ø	mm	150	160	170	170	190	220	180	220
Motor Power	kW	4	4	4	4	5,5	5,5	4	5,5
Length	mm	3100	3600	3600	4100	4250	4250	4600	4750
Height	mm	1120	1120	1120	1120	1200	1200	1120	1200
Width	mm	1020	1020	1020	1020	1150	1150	1020	1150
Weight	kg	2100	2300	2400	2700	3750	4430	4250	4920

Standard Equipment

- CE
- Conical bending
- Motorised back roll
- Top & Bottom rolls gear driven
- Pendant command panel
- SAE 1050 steel rolls
- Induction hardened rolls
- Stress relieved steel construction
- Support on 2,5 and 3 m machines
- Brake system for precise bendings

Optional Equipment

- Digital readout
- Motorised bottom roll tightening
- Ground rolls
- Roll extension for profile bending
- Special rolls for profile bending
- Special packing for overseas shipments

MRB Series Plate Rolls

Motorised 3 Roll Machine

MRB Series	Unit	1004	1204	1503	1504	2004
Bending Length	mm	1030	1280	1530	1530	2030
Bending Capacity	mm	4	4	3	4	4
Pre Bending	mm	3	3	2	3	2,5
Tolp roll Ø	mm	110	120	110	130	140
Motor Power	kW	2,2	2,2	2,2	2,2	2,2
Length	mm	1900	2150	2400	2400	2900
Height	mm	1120	1120	1120	1120	1120
Width	mm	940	940	940	940	940
Weight	kg	1195	1345	1388	1425	1565

Standard Equipment

- CE
- Conical bending
- Motorised back roll
- Top & Bottom rolls gear driven
- Pendant command panel
- SAE 1050 steel rolls
- Induction hardened rolls
- Stress relieved steel construction
- Support on 2,5 and 3 m machines
- Brake system for precise bendings

Optional Equipment

- Digital readout
- Motorised bottom roll tightening
- Ground rolls
- Roll extension for profile bending
- Special rolls for profile bending
- Special packing for overseas shipments

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HRB SERIES
Plate Roll Bending

MRB & MRB-S SERIES
Motorised Plate Roll Bending

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