

BENDING MACHINES



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Metal Fabricating Solutions

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Trick Tools

High Performance Tools for the Fabricator

TUBING BENDERS & NOTCHERS
SAWS, GRINDERS, AND IRON WORKERS
SHEET METAL EQUIPMENT

*Free Catalog *Online ordering



Ineco Bending Machines can provide you many opportunities to generate revenue for your business. Ineco Bending Machines are widely used, with over 1,000 installations, in the following areas: Race Car Chassis, Job Shops, Structural Steel Fabricators, Hydraulics, Ship Repair, Dairy Products, Hand Railings, Automotive and many more.

Ineco Bending Machines are fully electric, with microprocessor PLC controls. Independent motors drive the rotary bend head and linear pressure dies. A programmable pressure die (VDE) ensures accurate repeatability while bending thin wall tubes. Each machine is constructed of a robust top housing and gear system enclosed by steel. Retractable handles allow for portability in small spaces. Each machine goes through a 25-point inspection prior to delivery ensuring quick production results.

In-stock Tooling program

Our in-stock tooling program offers the end user 2 BIG advantages: 1) Quick Delivery and 2) Low Prices

All in-stock bend dies are made from a cast steel molds in large quantities and put on the shelf immediately.

All Pressure Dies (CB Dies) are made of Ampco Bronze (Bronze Aluminum Nickel Alloy) which guarantees longer tool life.

Custom Steel Dies are also available for schedule 80, 160 and XXS. Some steel dies may require a tie bar support system for added safety. You may also bend Squares, Rectangles and Extrusions using this very versatile machine.

Warranty:

Ineco includes a 12 month warranty on all replacement parts. Tooling is considered a wear item and not covered under the warranty.

Note: Bending attachments for flat bar are unsafe and not offered by Ineco.

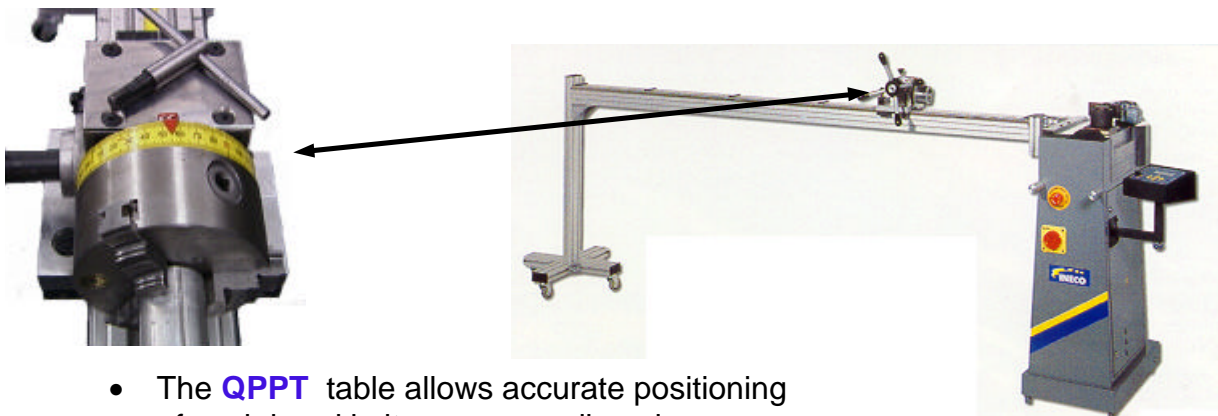
How They Match Up

There are two types of machines available in both capacities.

"VDM" Models vs. "VDE" Models

Easy to use menu driven control	vs.	Easy to use menu driven control
Utilizes manual clamping of pressure die via hand wheel	vs.	Utilizes programmable movement of pressure die
Manual or Step-by-Step Mode pressing foot pedal for each function	vs.	Manual, Step-by-Step and Automatic Operation (Auto Mode) by holding foot pedal
Primarily for Prototype to Moderate Production	vs.	Moderate Production or Frequent job change where accuracy and repeatability is required
Storage for 25 parts, 10 sequential bends (angle only)	vs.	Storage for 25 parts, 10 sequential bends (angle and Pressure Die position)
Overload protection on Bend Head	vs.	Overload Protection on Bend Head and Pressure Die

QPPT Attachment



- The **QPPT** table allows accurate positioning of each bend in its corresponding plane as well as the distance between bends.
- Available in various lengths ranging from 8' to 21' with multiple stops. Available for Model 50 & Model 76.

Ineco Model 50 VDM

- **Microprocessor Control Unit:** bending angle and springback factor, are fully programmable and monitored thru the control panel.
- **User friendly programming:** easy step by step method. Capable of storing 25 parts, 10 sequential bends per part.
- **Electronic overload device:** automatically protects the mechanical system from possible damage caused by oversized material and / or excessive bend speed.
- **Low maintenance:** requires lubrication of counterbend die only.
- **Quick change tooling.**
- **Portable:** built in wheels and extractable handles.
- **100% Electric Machines** with multiple voltage settings. Available in Single phase 208 volts or Three phase 208-575 volts.



- **Maximum Capacity: 1-1/2" Pipe** (mild steel, schedule 40). Wide range of bend radii available from 3/8" to 8-3/4" CLR.
- **Maximum Capacity: up to 2" OD** (mild steel, .125" wall thickness). Wide range of bend radii available from 3/8" to 8-3/4" CLR.
- **Multiple Bending Speeds:** Allows operator to set required speed for various material, i.e. stainless and chromolly require slow speed settings.

Ineco Model 50 VDE



- **Maximum Capacity: up to 1-1/2" Pipe** (mild steel, schedule 40). Wide range of bend radii available from 3/8" to 8-3/4" CLR.
- **Maximum Capacity: up to 2" OD** (mild steel, .125" wall thickness). Wide range of bend radii available from 3/8" to 8-3/4" CLR.
- **Multiple Bending Speed:** Allows operator to set required speed for various material, i.e. stainless and chomolly require slow speed settings.

- Operates in **Step-by-Step Mode** or **Auto Mode** for production use.
- Includes **additional 1 Hp motor** for driving pressure (CB Die).

- **Microprocessor Control Unit:** bending angle, springback factor, and electronic programming position of counterbend die (**VDE model only**) are fully programmable and monitored thru the control panel.
- **Independent 1 HP motor** drives linear pressure die.
- **User friendly programming:** easy step by step method. Capable of storing 25 parts, 10 sequential bends per part.
- **Electronic overload device:** automatically protects the mechanical system from possible damage caused by oversized material and / or excessive bend speed.
- **Low maintenance:** requires lubrication of counterbend die only.
- **Quick change tooling.**
- **Portable:** built in wheels and extractable handles.
- **100% Electric Machines** with multiple voltage settings. Available in Single phase 208 volts or Three phase 208-575 volts.

Ineco Model 76 vDM

- **Microprocessor Control Unit:** bending angle, springback factor, and programmable position of counterbend die (VDE model only) are fully programmable and monitored thru the control panel.
- **User friendly programming:** easy step by step method. Capable of storing 25 parts, 10 sequential bends per part.
- **Electronic overload device:** automatically protects the mechanical system from possible damage caused by oversized material and / or excessive bend speed.
- **Multi-language control panel** with backlit LCD **display** enhances ease of operation and programming.
- **Low maintenance:** requires lubrication of counterbend die only.
- VDE model **available with motorized counterbend die positioning.**
- **Quick change tooling.**
- **Portable:** built in wheels and extractable handles.
- **Available in single phase, or three phase** with multiple voltage settings.
- **100% Electric Machines** with multiple voltage settings. Available in Single phase 208 volts or Three phase 208-575 volts.



- **Maximum Capacity: up to 3" OD** (.125" wall thickness). Wide range of bend radii available up to 15-3/4" CLR.
- **Maximum Capacity: up to 2" Pipe** (mild steel, schedule 40) or **up to 2-1/2" Pipe** (mild steel, schedule 10). Wide range of bend radii available up to 15-3/4" CLR.
- **Variable Bending Speed:** Allows operator to set required speed for various material, i.e. stainless and chromolly require slow speed settings.

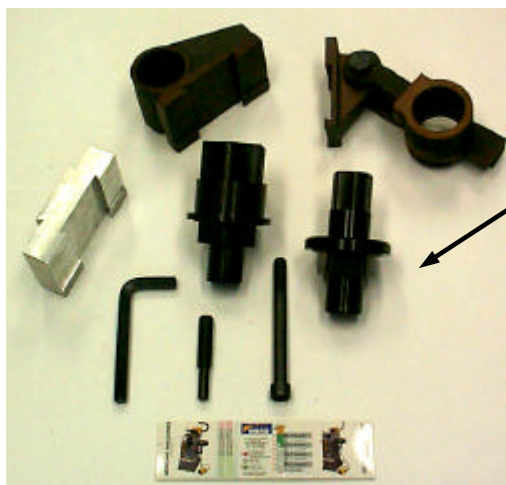
Ineco Model 76 VDE

- **Maximum Capacity: up to 3" OD** (.125" wall thickness). Wide range of bend radii available up to 15-3/4" CLR.
- **Maximum Capacity: up to 2" Pipe** (mild steel, schedule 40) or **up to 2-1/2" Pipe** (mild steel, schedule 10). Wide range of bend radii available up to 15-3/4" CLR.
- Model 76 VDE **Programmable clamping** of pressure die.
- **Multiple Bending Speeds:** adjusted on control panel. Allows operator to set required speed for various material, i.e. stainless and chomolly require slow speed



- **Microprocessor Control Unit:** bending angle, springback factor, and programmable position of counterbend die (VDE model only) are fully programmable and monitored thru the control panel.
- **User friendly programming:** easy step by step method. Capable of storing 25 parts, 10 sequential bends per part.
- **Electronic overload device:** automatically protects the mechanical system from possible damage caused by oversized material and / or excessive bend speed.
- **Low maintenance:** requires lubrication of counterbend die only.
- **Independent 1 HP motor** drives linear pressure die.
- **Quick change tooling.**
- **Portable:** built in wheels and extractable handles.
- **100% Electric Machines** with multiple voltage settings. Available in Single phase 208 volts or Three phase 208-575 volts.
- **Model 76 VDE/S** available when higher speeds are required; capacity is same, bend speed is 2.5 times faster. See back page for details.
- **100% Electric Machines** with multiple voltage settings. Available in Single phase 208 volts or Three phase 208-575 volts.

TECHNICAL FEATURES	Model 50 VDM VDE	Model 76 VDM VDE VDE/S
MAX. BENDING CAPACITY Mild Steel	○ 1-1/2" Pipe sched. 40 2" OD x .125" wall	○ 2-1/2" Pipe sched. 10 3" OD x .125" wall
MAX. BENDING CAPACITY Solid Bar	● 1-1/8" OD	● 1-5/8" OD
MAX. BENDING CAPACITY .125 Wall	◻ 1-1/2" x 1-1/2"	◻ 2" x 2" x .125" wall
MAX. BENDING RADIUS (measured to the CENTER LINE)	CLR 8-3/4"	CLR 15-3/4"
MIN. BENDING RADIUS (measured to the CENTER LINE)	CLR 3/8"	CLR 3/8"
MAX. PROGRAMMING STORAGE CAPACITY	25 parts, 10 bends per part	25 parts, 10 bends per part
MAX. BENDING ANGLE	180°	180°
MAX. PROGRAMMABLE SPRINGBACK FACTOR	40°	40°
MACHINE DIMENSIONS Length x Width x Height	25" x 14" x 39"	30" x 18" x 36"
MACHINE WEIGHT With standard accessories	375 lbs.	500 lbs.
PACKAGING DIMENSIONS Length x Width x Height	33" x 20" x 49"	46" x 22" x 51"
MAX. ELECTRICAL CONSUMPTION Total Installed Motors	VDM - 1.5 HP / 1.1 Kw VDE - 2.0 HP / 1.5 Kw	VDM - 3 HP / 2.2 Kw VDE - 3 HP / 2.2 Kw VDE/S - 5 HP / 4.4 Kw
BEND SPEEDS (Bend Time Only at 100%)	3.5 seconds 90° 7 seconds 180°	VDM/E 8.5 seconds 90° VDM/E 17.5 seconds 180° VDE/S 5 seconds 90° VDE/S 10 seconds 180°



Machine Accessories

Tooling Kit

