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# *Preda* **PREDA MACHINE**

## ROUND DUCT MACHINE

Round Duct Lock Seam Machine

Gorelocker/elbow making machine

Round Duct Lock Forming Machine

Electric 3-Roller Rolling Machine

Rotary Beading Machine

Spiral Tubeformer (Mould Type)

Spiral Tubeformer Band Type

Ovalizer Oval Machine

Angle Iron Flange Forming Line

Plasma Cutting Machine

Angle Iron Rolling Machine

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## Spiral Tubeformer (Mould Type)

This mould type tubeformer is designed to automatically form spiral duct for HVAC round duct progress! It is an advanced spiral duct forming line with much more reliable performance due to its fixed mould design!

Each mould will form spiral tube of one fixed diameter.

Compared with band type spiral tubeformer, this machine is of higher durability and the spiral tubes formed are of better air tightness for sure!



### Basic Configuration

1. One main motor in 11KW
2. Three inner side motors
3. Electronic box with screen-touch PLC
4. Electric coil cradle
5. Slitting station
6. Four forming dies from 0.5mm to 1.2mm



### Main Technical Parameters:

No.	Description	Unit		PD-1600
1	Thickness	mm		0.4-1.2
2	Feeding steel width	mm		137
3	Working speed	m/min		1-38
4	Coiler weight capacity	kg		1200
5	Diameter	mm		100-1600
6	Cutting ways	Roller (attached)	mm	0.4-1.2
		Plasma cut (optional)	mm	0.4-1.2
7	Motor Power	kw		11+1
8	Length	( L )	mm	5500
9	Width	( E )	mm	1800
10	Height	( H )	mm	1600
11	Weight	kg		2000

## Spiral Tubeformer Band Type



Preda Machine spiral tubeformer band type is a basic spiral tube forming machine.

It is easy to handle and easy to adjust different diameters of tubes to form.

Pricewise, this is a most price competitive spiral tubeformer Preda Machine manufacture.

### Main Technical Parameters:

<b>Model</b>	PD-1200	
<b>Diameter range</b>	Φ 80- Φ 1600mm	
<b>Tube length</b>	125-6000mm	
<b>Lock seam</b>	Outside tube, on the inside on request	
<b>Material</b>	Galvanization	0.4-1.0mm
	Stainless steel	0.4-0.8mm
	Aluminum	0.4-1.2mm
<b>Strip speed</b>	Max:38m/min	
<b>Dimensions</b>	2650x1550x2000mm	
<b>Weight</b>	2200kg	
<b>Control system</b>	PLC	
<b>Main motor power</b>	5.5KW	
<b>The power of cutting motor</b>	4KW	
<b>Electrical</b>	380V/50Hz/3PH Customizable voltage	
<b>Working pressure</b>	0.5-0.7Mpa	

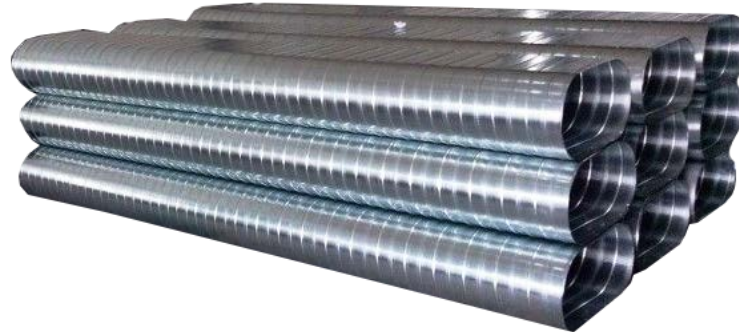
### Main features

1. Decoiler: mechanical coil cradle with capacity 1.5tons, inner diameter range 480-610mm, outer diameter 1000mm.
2. Control system: Inverter, PLC control from Taiwan.
3. Driving system with low noise.
4. Material of forming rollers: GCr15 bearing steel which is very rigid and durable!



### Ovalizer Oval Machine

The Ovalizer transforms regular round spiral duct formed by spiral tubeformer into flat-oval ducts. It is used for the ovalizer duct manufacturing. After spiral duct, the ovalizer duct machine expands it into standard size, with the character of good shape, high efficiency, easy operation. It is indispensable for duct manufacturing. Machine control is by PLC, and the LCD unit on the operation panel stores all set parameters for easy handling by the operator when required.



#### Advantages:

- » Better airflow
- » Easier to install
- » Less joints
- » Less hangers
- » Often requires less space
- » Corrugation for added strength
- » Modern design

Model	PDTY-3000
Thickness Range (mm)	0.4-1.2
Maximum Duct Length (mm)	3000
Arm Range Minimum diameter (mm)	150
Round duct diameter (mm)	Φ 350-1500
Oval duct high ('A' size) (mm)	150; 200; 250; 300; 350; 400; 450; 500
Oval duct weigh ('B' size) (mm)	520-2200
Tray Specification (mm)	50; 100; 200; 300; 400; 500; 600
Motor power (kw)	18.5
Dimension (L*W*H) (mm)	6000x1300x1200
Weight (kg)	3500

## Hydraulic Gorelocker



Preda Machine hydraulic gorelocker is professionally used for making round duct elbow. Compared with regular electric elbow making machine, it greatly increases the production speed. The frame adopts full steel welding structure with great rigidity.

There are two stations on the gorelocker—elbow lock forming station and elbow seam locking station. All these two stations are driven by independent hydraulic oil tank!

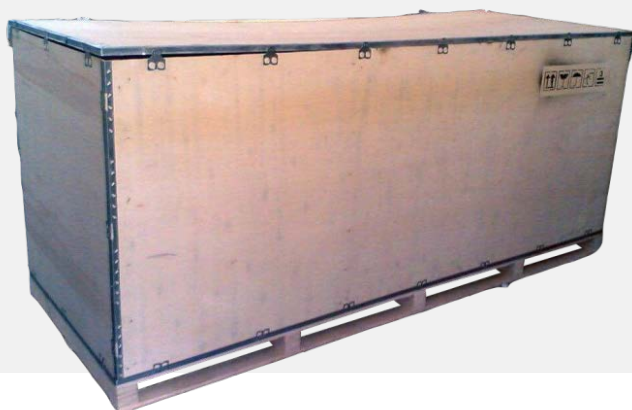
That makes the machine running automatically, accurately and in very fast speed of max. 120m/min.

This hydraulic duct elbow making machine handles a variety of duct materials and gauges to make elbows from 5"-50" or 125mm-1250mm.

The materials it supports are black steel, galvanized steel, stainless steel, aluminum and etc.

### Main Technical Parameters:

Type	Descriptions	Unit	Parameters
1	Max. speed	m/min	120
2	Diameter range	mm	125~1250
3	Black steel Galvanized steel Stainless steel Aluminum	mm	0.4-1.2 0.4-1.5 0.4-1.0 0.4-1.5
4	Oil capacity	L	55
5	Dimension	mm	2800*1000*1100
6	Weight	kg	750



### Gorelocker/elbow making machine



Gorelocker or Elbow Machine is specially designed for elbow tube forming in both Elbow Pittsburgh and seaming process.

This advanced gorelocker is 100% gear driven without belts at all!

It ensures good quality and much better durability! Currently Preda Machine gorelocker has been the most advanced electric elbow gorelocker version in the world already.

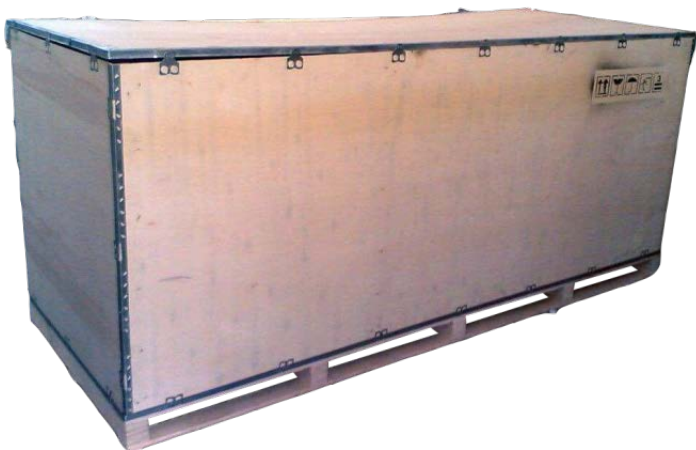


### Workstations and functions

- 1. Two motors
- 2. One electronic box
- 3. Two footswitches
- 4. Elbow lock forming station
- 5. Elbow lock seaming station

### Main Technical Parameters:

Model	Sheet thickness(mm)	Diameter(mm)	Weight(kg)	Power(kW)	Dimensions(mm) L*W*H
XMWT-A	1.2	120-1000	480	3	1940*830*1070





### Round Duct Lock Forming Machine



SA-12C and SA-15C round duct lock forming machine is designed to form female and male locks for round duct.

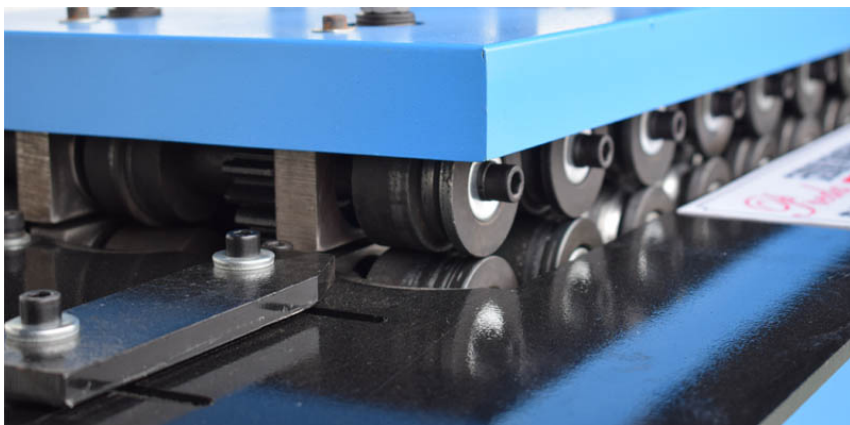
It has two stations to form female and male locks separately.

By using high quality GCr15 steel rollers, the locks formed are nice and clean with the joint be tight and firm.



#### Main Technical Parameters:

Model	Max thickness(mm)	Power(kW)	Shape	Weight(kg)	Dimensions (mm) L*W*H
SA-12C	1.2	1.5		220	1050*570*870
SA-15C	1.5	3		340	



### Electric 3-Roller Rolling Machine



This 3-roller bending/rolling machine is designed for rolling thin metal sheet with max. thickness of 2mm.

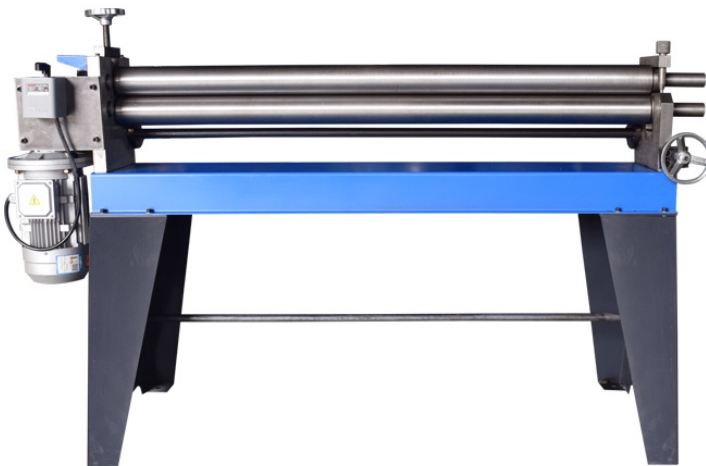
This is powered by 1.5Kw motor and can roll forward and backward with a switch installed.

Min. diameter the roller can roll is 100mm.

Preda Machine electric rolling machine is a very basic machine for round duct forming process!

#### Main Technical Parameters:

Model	Max thickness (mm)	Max width(mm)	Min diameter(mm)	Power(kw)	Weight (kg)	Dimensions(mm) L*W*H
W11-1.5*1000	1.5	1000	100	1.5	210	1400*350*1100
W11-1.5*1300	1.5	1300	100	1.5	240	1700*350*1100
W11-1.5*1500	1.5	1500	100	1.5	270	1900*350*1100



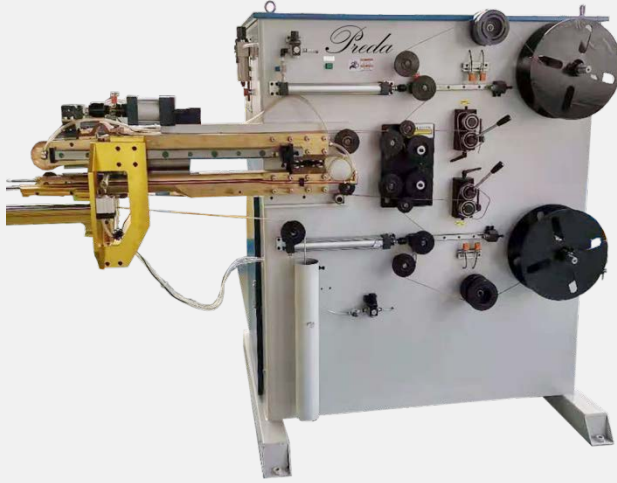
#### Workstations and functions

1. One motor
2. One upper adjustable upper roller
3. Two down rollers
4. Switch to start and control
5. Wheel to control rolling angle





### Stich Welder



The seam welding machine is a full-automatic welding equipment with automatic control function in pneumatic pressure mode. It is mainly suitable for welding various thin-plate structured round duct or container workpieces. The welded seam can ensure the water tightness and air tightness of the work piece.

It is with high welding tightness, no damage under high pressure.

Compared with similar products, it has obvious advantages such as simple operation, large output power, high welding efficiency, and low equipment failure rate so that it can meet various welding needs of users.

#### Main Technical Parameters:

Model	FN-25-2
Voltage (V)	380
Drive form	automatic
Purpose	seam stitch welding
Welding diameter (mm)	48-500 (Or customized)
Welding capacity (pcs/day)	1000-2000
Welding speed (m/min)	6-12
Welding pressure (N)	50
Weight(T)	1200
Size (L*W*H) (mm)	1800*1200*2100





### Round Duct Welding Machine

- 1. Cross sea longitudinal seam and horizontal and vertical seam.
- 2. The speed of welding is quick and the efficiency of welding is high.
- 3. According to the clients' demand, set the function of continuous weld and pulse weld.
- 4. Equipped with a high reliability control box
- 5. The welding speed can be regulated continuously.
- 6. Suitable for on-site working environment

#### Main Technical Parameters:

Model	SW-400
Voltage (V)	380/220/415/230
Thickness (mm)	0.5-2
Electrode arm length (mm)	400
Application of welding Max plate (mm)	2
Weight(kg)	200
Size (L*W*H) (mm)	1100*600*1400





### Spot Welder

Preda spot welding machine adopts the principle of double-sided double-point over-current welding. When working, two electrodes pressurize the workpiece to make two layers of metal form a certain contact resistance under the pressure of the two electrodes, and the welding current flows from one electrode to the other electrode. An instantaneous thermal fusion is formed at the two contact resistance points, and the welding current instantaneously flows from the other electrode along the two workpieces to the electrode forming circuit, and does not damage the internal structure of the workpiece to be welded. The spot welding machine is used for spot welding of thin plates. It is suitable for spot welding of round pipe seams, saving the step of locking the edges and seaming, and has strong firmness.

#### Main Technical Parameters:

Model	PD-40
Voltage (V)	380
Welding time regulation (s)	0-0.99
Electrode arm length (mm)	400
Electrode arm spacing (mm)	250
Rated input capacity (KVA)	40
Application of welding Max plate (mm)	2+2
Control range (s)	0-9.9
Weight(kg)	200
Size (L*W*H) (mm)	1100*600*1400







### Pneumatic riveting machine

1. It is in vertical riveting in great performance.
2. The speed of riveting is quick and the efficiency of the riveting is high.
3. According to the clients' demand, set the function of continuous riveting and pulse riveting.
4. Equipped with a high reliability control box
5. The working speed can be regulated continuously.
6. Suitable for on-site working environment.

#### Main Technical Parameters:

Model	PD-40
Voltage (V)	220
Weight(kg)	600
Size (L*W*H) (mm)	1150*800*2280
Power (kw)	0.02
Total trip (mm)	100
Application	HVAC industry, automobile industry
Fastest frequency of use	1 time/sec

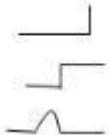




### Rotary Beading Machine

Electric rotary beading machine is capable of 0.5mm-1.8mm galvanized steel sheet. Three beading shapes are capable with three separate sets of moulds. It makes beadings and flanges for round duct. Powered by 0.75Kw makes it a more efficient rotary beader than traditional manual beader. By customizing new moulds to form new beading shapes, customer can use them for their other special usage.

#### Main Technical Parameters:

Model	Shape	Sheet thickness(mm)	Power(kW)	Weight(kg)	Dimensions(m m) L*W*H
LH-12		1.2	0.75	105	900*50*1000



### Angle Iron Rolling Machine



Angle iron rolling machine is used for making round flange for round duct connections. The rollers can be customized according different needs. Such as rolling flat iron, pipe, channel iron, rectangular tube and etc. The gaps between the rollers can be adjusted as per customer's rolling demands. It's widely used in HVAC duct forming, construction, fitment, hardware, light industry and chemical industries. For a better and more precise rolling effect, hydraulic angle iron rolling machine is an advanced rolling machine, which is hydraulic driven.

#### Main Technical Parameters:

Model	Lield limit(mm)	Min diameter(mm)	Max capacity(mm)	Power(kw)	Weight(kg)	Dimensions(mm) L*W*H
JT-50	≤245	400	L50*5	3	360	760*780*1150



### Hydraulic Angle Iron Rolling Machine

Model	YJT-50	YJT-63	WS-80
Lield limit(mm)	≤245	≤245	≤245
Max capacity(mm)	L50*5	L60*5	L80*5
Min diameter(mm)	350	350	600
Main power(kw)	3	4	4
Oil pump power(kw)	1.5	1.5	1.5
Reducer	135A	B135	250
Dimensio ns(mm)	L	900	900
	W	850	900
	H	1000	1000
Weight(kg)	550	580	1800





### Round Duct Lock Seam Machine



Round duct lock seaming machine is used to automatically seam round duct locks formed by round duct lock former. The seaming is nicer and even compared with manual seaming. What's more important is that it is much more time saving.

Standard round duct lock seaming machine is capable of max. 1.2\*1300mm round duct.

We can also accept customizing demand for longer round duct seaming, for example 1500mm or even 2000mm!

#### Main Technical Parameters:

Model	Thickness of plate(mm)	Machining length(mm)	Power(kw)	Weight(kg)	Dimensions(m m) L*W*H
YJB-1250	0.4-1.2	1250	0.75	360	2250*610*1450



## CNC Plasma Cutting Machine

Rigid frame built with thick concrete plate steel to ensure function stability and durability.

High speed cutting with great precision.

Starfire CNC system makes operating easy, effective and precise.

Huayuan Brand generator ensures stable and durable cutting performance!

Large variety of cutting material: steel, copper, iron, aluminum, galvanized sheet...

Wide use for cutting operation on traditional plate shearing, duct manufacture line...



### Software

The machine adopts the latest CAM-DUCT software which is easy to learn and operate. Choose the size and shape you need and leave the rest to the plasma cutting machine itself running automatically!

### Specification

Model	PC-1540
Cutting way	Plasma cutting
Cutting voltage	380+10%VAC 50HZ
Effective cutting range (WxL)mm	1500x4000 or as per requirements
Maximum speed mm/min	more than 12000
Cutting thickness (mm)	0.5mm-5mm
Control mode	Beijing Starfire CNC system
Cutting angle	3-5degree
Transmission way	Gear wheel and rack, linear guide rail
Height adjusting method	Pneumatic height regulating

## Auto Angle Iron Punching Machine



Angle iron flange forming line can automatically punch holes on Angle iron to make it suitable for further flange forming process!

Meanwhile it can also shear or notch Angle iron as per your requirements.

All processes are well controlled by numeral control system! You can just put in all the data and let the machine working automatically.

### Basic Parts

- 1.Motors
- 2.Auto feeding system
- 3.Notching station
- 4.Punching station
- 5.Cutting station
- 6.Numeral control system

### Main Technical Parameters

Model	Working range	Power(kW)	Weight(kg)	Dimensions(mm) L*W*H
J-50	30/40/50 angle steel	5	900	3650*1100*1450

## Angle Iron Punching Machine

Angle iron punching machine can punch holes on angle iron to make it suitable for further flange forming process!

Meanwhile it can also shear or notch angle iron as per your requirements.

All processes are well controlled by hand control. All the size you can cut and punch according to your requirements.



### Main Technical Parameters

Model	Working range	Power(kW)	Weight(kg)	Dimensions(mm) L*W*H
J-50H	30/40/50 angle steel	3	300	640x550x1400