

Preda

ROUND DUCT MAKING MACHINES

Tubeformers, Ovalizers, Gorelockers & Round Duct Equipment ·
2026



PREDA MACHINE

HVAC Duct Processing Machine Supply Manufacturer

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PREDa MACHINE offers a complete range of HVAC duct processing machines:

AUTO DUCT LINES · SPIRAL DUCT MAKING MACHINES · DUCT FITTINGS MACHINES

Spiral Tubeformer (Mould Type)

Model: PD-1600



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!

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

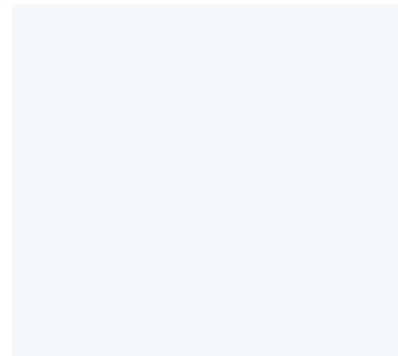
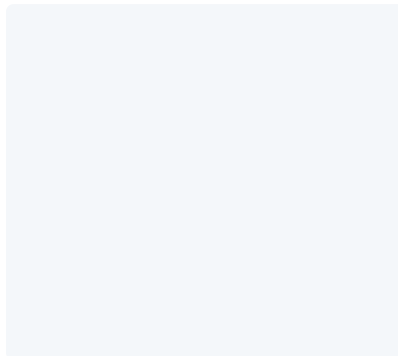
TECHNICAL PARAMETERS

Parameter	Value
Model	PD-1600
Thickness	0.4-1.2 mm
Feeding steel width	137 mm
Working speed	1-38 m/min
Coiler weight capacity	1200 kg
Diameter	100-1600 mm
Cutting ways — Roller (attached)	0.4-1.2 mm
Cutting ways — Plasma cut (optional)	0.4-1.2 mm
Motor Power	11+1 kW
Length (L)	5500 mm
Width (E)	1800 mm
Height (H)	1600 mm
Weight	2000 kg



Spiral Tubeformer Band Type

Model: PD-1200



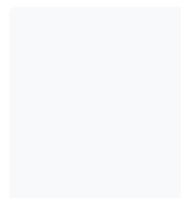
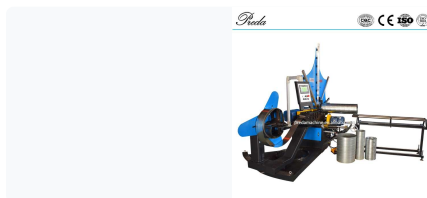
Preda Machine spiral tubeformer band type is a basic spiral tube forming machine. It is easy to handle and easy to adjust different diameters of tubes to form. Pricewise, this is a most price competitive spiral tubeformer Preda Machine manufacture.

CONFIGURATION

- 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

TECHNICAL PARAMETERS

Parameter	Value
Model	PD-1200
Diameter range	Φ80-Φ1600 mm
Tube length	125-6000 mm
Lock seam	Outside tube, on the inside on request
Material — Galvanization	0.4-1.0 mm
Material — Stainless steel	0.4-0.8 mm
Material — Aluminum	0.4-1.2 mm
Strip speed	Max 38 m/min
Dimensions	2650×1550×2000 mm
Weight	2200 kg
Control system	PLC
Main motor power	5.5 kW
Power of cutting motor	4 kW
Electrical	380V/50Hz/3PH (customizable voltage)
Working pressure	0.5-0.7 MPa



Preda Band Type Spiral Tubeformer With Plasma Cut



The Preda Band Type Spiral Tubeformer with Plasma Cut is an advanced spiral duct production machine that combines the efficient band-type locking system with an integrated 120 Amp plasma cutting system and servo-controlled rail guide. Unlike mould-type tubeformers that require a separate lock strip, the band type system forms the lock seam directly from the strip edges, simplifying the production process and reducing material costs. With a diameter range of $\Phi 80\text{--}\Phi 1600\text{mm}$ and support for galvanized steel up to 1.2mm and stainless steel up to 0.8mm, this machine covers all standard round duct ...

TECHNICAL PARAMETERS

Parameter	Value
Model	BT-1600-PLASMA
Base Type	Band Type (strip locking) Spiral Tubeformer
Diameter Range	$\Phi 80\text{--}\Phi 1600\text{ mm}$
Strip Thickness (Galvanized)	0.4–1.2 mm
Strip Thickness (Stainless)	0.4–0.8 mm
Working Speed	1–25 m/min
Lock Seam	Band type lock — no external lock strip required
--- Plasma Cutting System ---	

Parameter	Value
Plasma Power	120 Amp (120A)
Cutting Thickness	0.4–6 mm (steel)
Drive System	Servo motor driven rail guide
Rail Guide	Precision linear rail, servo controlled
Cutting Method	Flying cut — synchronized with tubeforming speed
--- Control System ---	
PLC	Panasonic (Japan)
HMI Display	Touch screen, production management

Parameter	Value
--- Main Machine Parameters ---	
Main Motor Power	7.5 kW
Decoiler	Electric coil cradle, 3T capacity
Overall Dimensions	4000×1800×1600 mm
Machine Weight	~2300 kg
Voltage	380V/50Hz, 3-phase (customizable)
--- Features ---	
Application	Band type spiral duct production with integrated in-line plasma cutting

Ovalizer Oval Machine

Model: PDTY-3000



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.

CONFIGURATION

- 1

Better airflow
- 2

Easier to install
- 3

Less joints
- 4

Less hangers
- 5

Often requires less space
- 6

Corrugation for added strength
- 7

Modern design

TECHNICAL PARAMETERS

Parameter	Value
Model	PDTY-3000
Thickness Range	0.4-1.2 mm
Maximum Duct Length	3000 mm
Arm Range Min diameter	150 mm
Round duct diameter	Φ350-1500 mm
Oval duct high ('A' size)	150; 200; 250; 300; 350; 400; 450; 500 mm
Oval duct width ('B' size)	520-2200 mm
Tray Specification	50; 100; 200; 300; 400; 500; 600 mm
Motor power	18.5 kW
Dimension (L×W×H)	6000×1300×1200 mm
Weight	3500 kg



Hydraulic Gorelocker

Model: —



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 — both driven by independent hydraulic oil tank! That makes the machine running automatically, accurately and in very fast speed of max. 120 m/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.

TECHNICAL PARAMETERS

Parameter	Value
Max. speed	120 m/min
Diameter range	125 - 1250 mm
Thickness — Black steel	0.4 - 1.2 mm
Thickness — Galvanized steel	0.4 - 1.5 mm
Thickness — Stainless steel	0.4 - 1.0 mm
Thickness — Aluminum	0.4 - 1.5 mm
Oil capacity	55 L
Dimension (L×W×H)	2800×1000×1100 mm
Weight	750 kg



Gorelocker / Elbow Making Machine

Model: XMWT-A



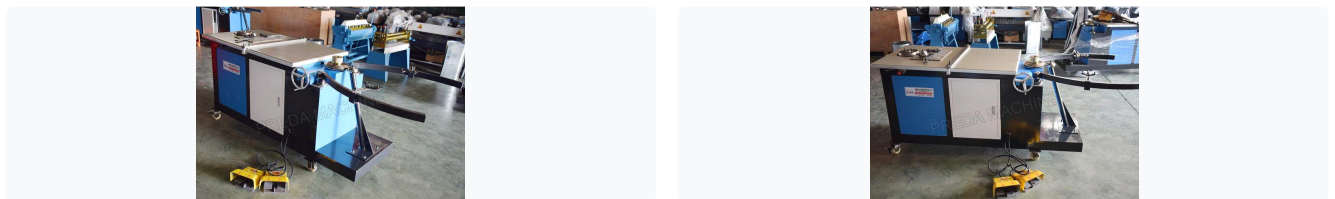
Gorelocker or Elbow Machine is specially designed for elbow tube forming in both Elbow Pittsburgh and seaming process. This advanced gorelocker is 100% gear driven without belts at all! It ensures good quality and much better durability! Currently Preda Machine gorelocker has been the most advanced electric elbow gorelocker version in the world already.

CONFIGURATION

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

TECHNICAL PARAMETERS

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



Round Duct Lock Forming Machine

Model: SA-12C



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.

TECHNICAL PARAMETERS

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



Electric 3-Roller Rolling Machine

Model: W11-1.5×1000



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!

CONFIGURATION

- 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

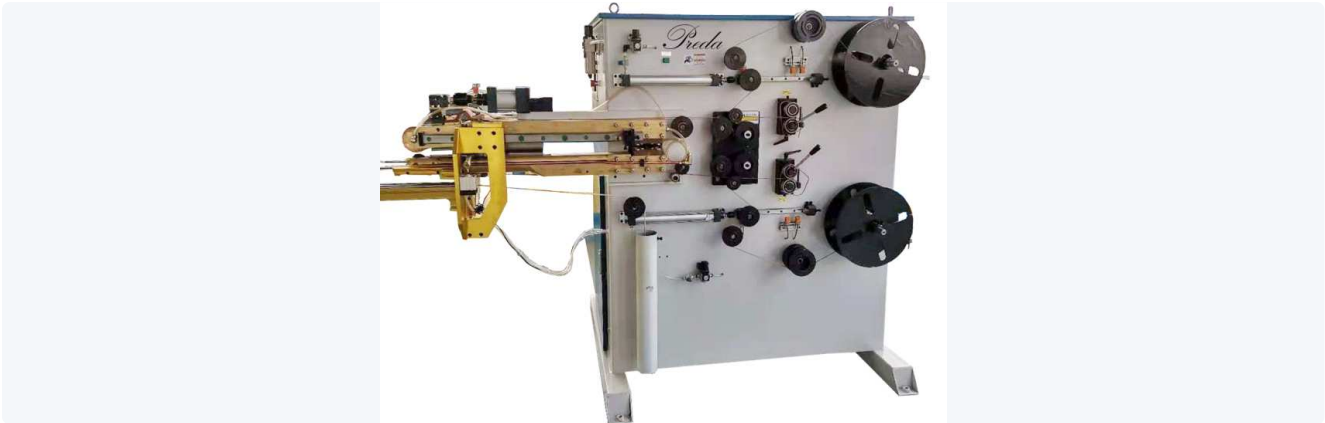
TECHNICAL PARAMETERS

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



Stitch Welder

Model: FN-25-2



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.

TECHNICAL PARAMETERS

Parameter	Value
Model	FN-25-2
Voltage	380 V
Drive form	Automatic
Purpose	Seam stitch welding
Welding diameter	48-500 mm (or customized)
Welding capacity	1000-2000 pcs/day
Welding speed	6-12 m/min
Welding pressure	50 N
Weight	1200 kg
Size (L×W×H)	1800×1200×2100 mm



Round Duct Welding Machine

Model: SW-400



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

CONFIGURATION

- 1

Cross sea longitudinal seam and horizontal and vertical seam
- 2

Quick welding speed and high welding efficiency
- 3

Continuous weld and pulse weld functions as per clients' demand
- 4

High reliability control box
- 5

Continuously regulated welding speed
- 6

Suitable for on-site working environment

TECHNICAL PARAMETERS

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



Spot Welder

Model: PD-40



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.

TECHNICAL PARAMETERS

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



Pneumatic Riveting Machine

Model: PD-40



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

CONFIGURATION

- 1

Vertical riveting in great performance
- 2

Quick riveting speed and high efficiency
- 3

Continuous and pulse riveting as per demand
- 4

High reliability control box
- 5

Continuously regulated working speed
- 6

Suitable for on-site working environment

TECHNICAL PARAMETERS

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



Rotary Beading Machine

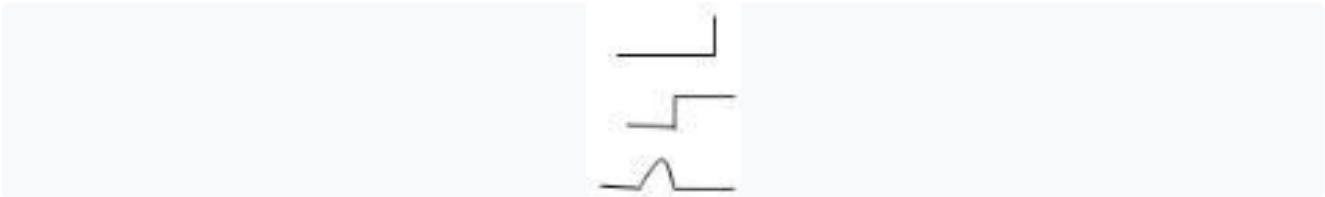
Model: LH-12



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.

TECHNICAL PARAMETERS

Parameter	Value
Model	LH-12
Sheet thickness	1.2 mm
Power	0.75 kW
Weight	105 kg
Dimensions (L×W×H)	900×50×1000 mm



Angle Iron Rolling Machine

Model: JT-50



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.

TECHNICAL PARAMETERS

Parameter	Value
Model	JT-50
Field limit	≤245 mm
Min diameter	400 mm
Max capacity	L50×5 mm
Power	3 kW
Weight	360 kg
Dimensions (L×W×H)	760×780×1150 mm



Hydraulic Angle Iron Rolling Machine

Model: YJT-50 / YJT-63 / WS-80



Hydraulic angle iron rolling machine is a hydraulic driven, advanced rolling machine for a better and more precise rolling effect on round flanges for round duct connections.

TECHNICAL PARAMETERS

Parameter	Value
Model	YJT-50 / YJT-63 / WS-80
Field limit	≤245 / ≤245 / ≤245 mm
Max capacity	L50×5 / L60×5 / L80×5 mm
Min diameter	350 / 350 / 600 mm
Main power	3 / 4 / 4 kW
Oil pump power	1.5 / 1.5 / 1.5 kW
Reducer	135A / B135 / 250
Dimensions (L×W×H)	900×850×1000 / 900×900×1000 / 950×1200×1100 mm
Weight	550 / 580 / 1800 kg



Round Duct Lock Seam Machine

Model: YJB-1250



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!

TECHNICAL PARAMETERS

Parameter	Value
Model	YJB-1250
Thickness of plate	0.4-1.2 mm
Machining length	1250 mm
Power	0.75 kW
Weight	360 kg
Dimensions (L×W×H)	2250×610×1450 mm



Cnc Plasma Cutting Machine

Model: PC-1540



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... 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!

TECHNICAL PARAMETERS

Parameter	Value
Model	PC-1540
Cutting way	Plasma cutting
Cutting voltage	380+10% VAC 50Hz
Effective cutting range (W×L)	1500×4000 mm or as per requirements
Maximum speed	more than 12000 mm/min
Cutting thickness	0.5-5 mm
Control mode	Beijing Starfire CNC system
Cutting angle	3-5 degree
Transmission way	Gear wheel and rack, linear guide rail
Height adjusting method	Pneumatic height regulating
Software	CAM-DUCT



Auto Angle Iron Punching Machine

Model: J-50



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.

CONFIGURATION

- 1

Motors
- 2

Auto feeding system
- 3

Notching station
- 4

Punching station
- 5

Cutting station
- 6

Numeral control system

TECHNICAL PARAMETERS

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



Angle Iron Punching Machine

Model: J-50H



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.

TECHNICAL PARAMETERS

Parameter	Value
Model	J-50H
Working range	30/40/50 angle steel
Power	3 kW
Weight	300 kg
Dimensions (L×W×H)	640×550×1400 mm

Preda Pd1600 Plasma Cut Spiral Tubeformer



The Preda PD1600 Plasma Cut Spiral Tubeformer is an enhanced version of our best-selling PD1600 mould type spiral tubeformer, integrated with a high-performance 120 Amp plasma cutting system and servo-controlled rail guide. Building on the proven reliability of the PD1600 platform — which produces spiral round ducts from $\Phi 80$ to $\Phi 1600$ mm using 137mm wide galvanized or stainless steel strip — this upgraded model eliminates the need for a separate cutting station by integrating in-line plasma cutting directly into the tubefforming process. The 120 Amp plasma torch cuts cleanly through ...

TECHNICAL PARAMETERS

Parameter	Value
Model	PD1600-PLASMA
Base Model	PD1600 Mould Type Spiral Tubeformer
Diameter Range	$\Phi 80$ – $\Phi 1600$ mm
Strip Thickness (Galvanized)	0.4–1.2 mm
Strip Thickness (Stainless)	0.4–0.8 mm
Feeding Steel Width	137 mm
Working Speed	1–20 m/min
Tube Length	125–6000 mm (adjustable)
Lock Seam	Outside tube, reinforced lock seam
--- Plasma Cutting System ---	

Parameter	Value
Plasma Power	120 Amp (120A)
Cutting Thickness	0.4–6 mm (steel)
Cutting Speed	0–6000 mm/min
Drive System	Servo motor driven rail guide
Rail Guide	Precision linear rail, servo controlled
Cutting Method	Flying cut — synchronized with tubefforming speed
--- Control System ---	
PLC	Panasonic (Japan)
HMI Display	Touch screen, production management
Control Type	Fully automatic, CNC controlled

Parameter	Value
--- Main Machine Parameters ---	
Main Motor Power	7.5 kW
Decoiler	Electric coil cradle, 3T capacity
Coil Inner Diameter	$\Phi 480$ – $\Phi 610$ mm
Overall Dimensions	4000×1800×1600 mm
Machine Weight	~2500 kg
Voltage	380V/50Hz, 3-phase (customizable)
--- Features ---	
Application	Spiral duct production with integrated in-line plasma cutting, eliminates separate cutting station

Preda Heavy Duty Spiral Tubeformer 2000

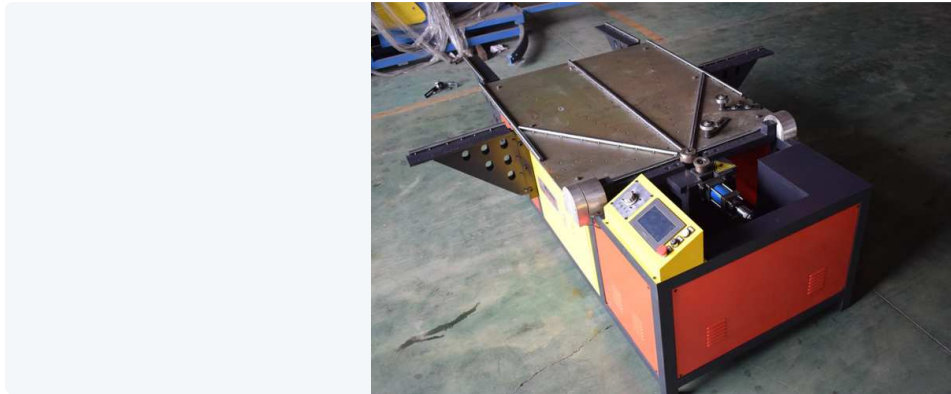


The Preda Heavy Duty Spiral Tubeformer 2000 is our largest and most powerful spiral duct forming machine, designed for industrial applications requiring large diameter ducts up to $\Phi 2000\text{mm}$ (80 inches). Building on the proven technology of our standard spiral tubeformers, the PD-2000 features a reinforced frame, heavier duty forming head, and four inner side motors (compared to two on standard models) to handle the increased torque required for large diameter, thick gauge duct production. With a strip thickness range of 0.4–2.0mm galvanized steel, 0.4–1.3mm stainless steel, and 0.4–2.0mm ...

TECHNICAL PARAMETERS

Parameter	Value	Parameter	Value	Parameter	Value
Model	PD- 2000 (Heavy Duty)	Lock Seam	Outside tube, on the inside, reinforced lock seam	Machine Weight	~3500 kg
Diameter Range	$\Phi 80\text{--}\Phi 2000\text{ mm}$ (3"–80")	Main Motor Power	15 kW	Voltage	380V/50Hz (Customizable)
Strip Thickness (Galvanized)	0.4–2.0 mm	Inner Side Motors	4 sets (heavy duty)	Optional Configurations	STANDARD / HIGH SPEED / HEAVY GAUGE
Strip Thickness (Stainless)	0.4–1.3 mm	Control System	PLC + 10" Touch screen, frequency controlled main drive	Special Functions	Strengthened weld beads, tendon sheet pipes, METU flange notches, large diameter industrial ducts
Strip Thickness (Aluminum)	0.4–2.0 mm	Decoiler	Electric coil cradle, 3T capacity	Application	Industrial construction, mining, large-scale HVAC projects requiring large diameter ducts
Feeding Steel Width	137 mm	Coil Inner Diameter	$\Phi 480\text{--}\Phi 610\text{ mm}$	Market Position	Heavy duty flagship model, competes with Spiro Tubeformer 2020, largest diameter in Preda lineup
Working Speed	1–30 m/min	Cutting System	Patented flying slit, burr-free cuts, high speed synchro cutting		
Tube Length	125–6000 mm (adjustable)	Overall Dimensions (L×W×H)	4500×2000×1800 mm		

Preda Cnc Rotary Beading Machine



The Preda CNC Rotary Beading Machine is a computer-controlled rotary forming machine designed to roll reinforcing beads, flanges, and stiffening rings onto round ducts produced by spiral tubeformers and straight duct roll lines. Equipped with a servo-driven carriage and CNC touch-screen control, this machine allows operators to program the exact number, spacing, and profile of beads on each duct — replacing manual measurement and inconsistent results with fully repeatable, automated forming. The RBM-1600-CNC handles round ducts from $\Phi 80$ to $\Phi 1600$ mm in diameter, working with galvanized steel ...

TECHNICAL PARAMETERS

Parameter	Value
Model	RBM-1600-CNC
Machine Type	CNC-controlled rotary beading / rolling machine
--- Working Range ---	
Diameter Range	$\Phi 80$ – $\Phi 1600$ mm
Plate Thickness (Galvanized)	0.4–1.5 mm
Plate Thickness (Stainless)	0.4–1.0 mm
Bead Types	Single bead, double bead, reinforcing ring, flanging
Number of Beads	Programmable, multiple beads per tube
--- Drive System ---	

Parameter	Value
Main Motor	3 kW
Drive Type	Servo motor controlled
Rotational Speed	0–20 m/min (variable)
Axial Feed Speed	0–10 m/min (programmable)
--- Control System ---	
Controller	CNC touch screen, programmable bead patterns
Program Storage	Multiple bead patterns stored in memory
Operation	Semi-automatic / fully automatic mode
--- Machine Specifications ---	

Parameter	Value
Clamping Method	Pneumatic / hydraulic clamping
Tool Material	Cr12MoV alloy steel, hardened
Overall Dimensions	2500×1500×1400 mm
Weight	~1200 kg
Voltage	380V/50Hz, 3-phase (customizable)
--- Features ---	
Application	Rolling reinforcing beads on round ducts, flange rolling, edge flanging for spiral and straight round ducts

Preda Cnc Laser Cutting Machine



The Preda CNC Laser Cutting Machine is a high-precision fiber laser cutting system designed for sheet metal fabrication in HVAC and general manufacturing applications. Equipped with a powerful fiber laser source (1000W–3000W options), this machine delivers clean, burr-free cuts on carbon steel up to 12mm thick, stainless steel up to 8mm, aluminum up to 6mm, and galvanized steel up to 8mm — making it ideal for cutting duct flanges, fitting brackets, angle iron profiles, and custom sheet metal parts used in ventilation system fabrication. The standard 1500×3000mm cutting table accommodates ...

TECHNICAL PARAMETERS

Parameter	Value
Model	PL-1530 / PL-1560 / PL-2060 (customizable)
Machine Type	Fiber laser cutting machine
--- Cutting Specifications ---	
Laser Power	1000W / 1500W / 2000W / 3000W (optional)
Cutting Area	1500×3000 mm (standard), customizable
Max Cutting Thickness (Carbon Steel)	0.5–12 mm
Max Cutting Thickness (Stainless)	0.5–8 mm
Max Cutting Thickness (Aluminum)	0.5–6 mm
Max Cutting Thickness (Galvanized Steel)	0.5–8 mm

Parameter	Value
Positioning Accuracy	±0.03 mm
Re-positioning Accuracy	±0.02 mm
Max Travel Speed	120 m/min
Max Cutting Speed	0–60 m/min (material dependent)
--- Machine Specifications ---	
Laser Source	Raycus / IPG / MAX fiber laser
Cutting Head	Precision focusing head with auto-height tracking
Drive System	Servo motors, helical rack & pinion, linear guide rails
Control System	CNC system with touch screen, USB/network transfer

Parameter	Value
Cooling System	Industrial water chiller
--- Main Machine Parameters ---	
Overall Dimensions	~3500×2200×1800 mm (1530 model)
Machine Weight	~2500 kg (1530 model)
Voltage	380V/50Hz, 3-phase (customizable)
Total Power	~12 kW
--- Features ---	
Application	Precision cutting of sheet metal for duct flanges, fittings, brackets, and general HVAC fabrication
Software	Supports DXF, DWG, PLT formats

Preda Canvas Flexible Duct Forming Line



The Preda Canvas Flexible Duct Forming Line (RLJ-600) is a fully automatic production line for manufacturing flexible canvas duct connectors — the essential soft connections installed between HVAC air handling units and ductwork to absorb vibration, reduce noise, and compensate for thermal expansion. This integrated line combines two steel strip decoilers, a hydraulic punching station, a precision roll forming system, a cloth/PVC feeding mechanism, and an automatic recoiler into a single continuous workflow. The production process begins with two galvanized steel strips being decoiled from ...

TECHNICAL PARAMETERS

Parameter	Value
Model	RLJ-600
Line Type	Fully automatic flexible canvas duct connector production line
--- Material Specifications ---	
Galvanized Sheet Thickness	0.4-0.6 mm
Galvanized Sheet Width	50-130 mm
Fireproof Cloth / PVC Width	80-630 mm
Material Overlap (cloth)	~12 mm on each side
Material Overlap (steel)	~20 mm on each side
--- Product Specifications ---	
Final Product Width	120-750 mm

Parameter	Value
Product Type	Canvas duct connector, polyester duct connector, fiberglass duct connector
Application	Round and square duct connections in HVAC systems
--- Machine Specifications ---	
Working Speed	0-8 m/min
Main Power	10 kW
Weight	~3600 kg
Dimensions (L×W×H)	4500×1200×2000 mm
--- Line Configuration ---	
Decoilers	2× electric decoilers (steel strip), 1× cloth/poly feeder
Punching System	Hydraulic punching, servo feeder, 25T capacity

Parameter	Value
Roll Forming	Multi-stage roll forming, precision profiles
Cutting System	Flying cut, automatic length control
Recoiler	Automatic recoiler for finished connectors
--- Control System ---	
PLC	Touch screen control, automatic length setting
Operation	Fully automatic, one-person operation
--- Features ---	
Working Process	Steel decoiling → Hydraulic punching → Cloth feeding → Roll forming → Notching → Flying cut → Recoiling
Voltage	380V/50Hz, 3-phase (customizable)

Preda Round Flange Forming Line



The Preda Round Flange Forming Line is a complete three-machine production system for manufacturing high-quality round flanges used in spiral duct connections, fan flanges, and industrial ventilation systems. This integrated solution combines three essential machines — the CNC Round Flange Forming Machine (YFL-40), the Double-head CNC Round Flange Punching Machine (YCK-40), and the Round Flange Butt Welder (DH-40) — into a single continuous workflow that produces finished, ready-to-use round flanges from raw angle steel coil with minimal operator intervention. The process begins with the ...

TECHNICAL PARAMETERS

Parameter	Value
Line Configuration	3-in-1: Flange Forming Machine + Double-head Punching Machine + Butt Welder
--- 1. CNC Round Flange Forming Machine (YFL-40) ---	
Model	YFL-40
Processing Thickness	2-4 mm (angle steel / flat strip)
Processing Width	40×40 mm (angle iron)
Rolling Diameter Range	Φ210-Φ2000 mm
Feeding Speed	15 m/min
Main Dimensions	Host: 4300×800×1500 mm; Decoiler: 1400×700×1000 mm
Weight	3500 kg
Display	Kunlun Tongtai (MCGS) HMI
Reducer	97-series hard gear reducer
PLC	Panasonic (Japan)
Contact / Relay	Schneider (France)
Power Supply	Mean Well (Taiwan)

Parameter	Value
Oil Pump Motor	4 kW Shandong Kaiyuan
Pressure Relief Valve	Beijing Huade
--- 2. Double-head CNC Round Flange Punching Machine (YCK-40) ---	
Model	YCK-40
Processing Range	2-4 mm
Punching Diameter Range	Φ220-Φ2000 mm
Rotary Speed	12 m/min
Main Dimensions	3100×1500×1700 mm
Weight	1500 kg
Display	Kunlun Tongtai (MCGS) HMI
Servo Motor	TECO (Taiwan)
PLC	Panasonic (Japan)
Contact / Relay	Schneider (France)
Power Supply	Mean Well (Taiwan)

Parameter	Value
Main Motor	4 kW
Pressure Relief Valve	Beijing Huade
--- 3. Round Flange Butt Welder (DH-40) ---	
Model	DH-40
Processing Range	2-4 mm
Welding Diameter Range	Φ200-Φ2000 mm
Main Dimensions	1100×1100×1850 mm
Weight	650 kg
--- Line Specifications ---	
Total Weight	~5650 kg
Voltage	380V/50Hz (3-phase)
Application	Full automatic production of round flanges for spiral ducts, fan flanges, HVAC ventilation systems
Working Process	Decoiling → Roll forming angle steel → Rolling & cutting → Auto punching (evenly spaced holes) → Butt welding into complete ring

Preda 4-Roller Plate Rolling Machine



The Preda 4-Roller Plate Rolling Machine is an advanced numerical control plate bending machine that offers significant advantages over traditional three-roller designs. The four-roller configuration enables one-pass forming with hydraulic pre-bending at both ends, resulting in minimal remaining straight edge (less than 5mm) — a critical improvement over three-roller machines which typically leave 15–20mm of straight edge requiring secondary processing. The W12-4×2000 model handles plates up to 4mm thick and 2000mm wide, with a minimum rolling diameter of $\Phi 150$ mm, making it ideal for round ...

TECHNICAL PARAMETERS

Parameter	Value
Model	W12-4×2000
Max Plate Thickness	4 mm
Max Plate Width	2000 mm
Min Rolling Diameter	$\Phi 150$ mm
Roller Diameter	$\Phi 160$ mm (top), $\Phi 140$ mm (bottom), $\Phi 120$ mm (side)
Main Power	7.5 kW

Parameter	Value
Hydraulic Power	3 kW
Weight	3500 kg
Dimensions (L×W×H)	2800×1500×1600 mm
Control System	PLC + Touch screen, numerical control, one-time forming
Pre-bending	Hydraulic pre-bending, minimal remaining straight edge (<5mm)
Roller Material	45# steel, hardened and ground

Parameter	Value
Bearing	Self-aligning roller bearing
Voltage	380V/50Hz
Application	Rolling thin metal sheets into cylindrical and conical shapes for round duct production
Advantages over 3-roller	One-pass forming, better pre-bending, shorter remaining straight edge, higher precision, easier operation

Preda Laser Welding Machine



The Preda Laser Welding Machine is a state-of-the-art fiber laser welding system designed specifically for HVAC duct fabrication, offering a revolutionary alternative to traditional TIG welding for stainless steel ductwork. Available in 1500W, 2000W, and 3000W configurations, these continuous wave fiber laser welders deliver welding speeds up to four times faster than TIG, with perfect weld appearance that requires no post-weld grinding or polishing. The handheld welding gun with 10-meter fiber cable (15m optional) provides maximum flexibility for welding ducts, elbows, flanges, and ...

TECHNICAL PARAMETERS

Parameter	Value
Model	LW-1500 / LW-2000 / LW-3000
Laser Power	1500W / 2000W / 3000W
Wavelength	1064 nm
Welding Type	Continuous Wave (CW) Fiber Laser
Max Welding Thickness	0.5-5 mm (stainless steel), 0.5-4 mm (carbon steel)
Welding Speed	0-6000 mm/min

Parameter	Value
Fiber Length	10 m (standard), 15 m (optional)
Cooling System	Industrial water chiller, built-in
Control System	PLC + Touch screen, handheld welding gun
Welding Modes	Spot welding, continuous welding, stitch welding
Applicable Materials	Stainless steel, carbon steel, aluminum, copper, brass, galvanized steel
Power Supply	380V/50Hz, 3-phase

Parameter	Value
Total Power Consumption	6 kW / 8 kW / 12 kW
Weight	250 kg / 280 kg / 320 kg
Dimensions (L×W×H)	900×700×1100 mm
Application	Stainless steel duct welding, round duct longitudinal seam, elbow welding, flange welding, TIG replacement
Advantages over TIG	4x faster welding speed, no consumables, perfect weld appearance, no post-grinding needed, lower operator skill requirement
HVAC Specific	Ideal for stainless steel duct fabrication, cleanroom ductwork, kitchen exhaust ducts

Preda Flexible Aluminum Duct Machine



The Preda Flexible Aluminum Duct Machine is a specialized production system for manufacturing flexible and semi-rigid aluminum ducts used in HVAC ventilation, kitchen hood exhaust, dryer vents, and chimney liners. This machine produces ducts from pure aluminum foil, aluminum foil with polyester film, and single or double layer configurations, with diameter ranges from $\Phi 60$ – $\Phi 300$ mm covering all standard residential and light commercial applications. The omnipotent mould design is a key advantage — a single mould can produce multiple duct diameters, significantly reducing investment costs ...

TECHNICAL PARAMETERS

Parameter	Value
Model	FAD-300
Duct Diameter Range	$\Phi 60$ – $\Phi 300$ mm
Material	Pure aluminum foil, aluminum foil + polyester film, single/double layer
Strip Width	60 mm (standard)
Production Speed	0–15 m/min
Duct Length	Customizable, standard 3m / 6m / 10m

Parameter	Value
Main Power	4 kW
Control System	PLC + Touch screen, automatic length counting and cutting
Coil Weight	Max 500 kg
Coil Inner Diameter	$\Phi 300$ – $\Phi 500$ mm
Cutting System	Pneumatic flying cutter, clean cuts
Weight	1200 kg

Parameter	Value
Dimensions (L×W×H)	6000×1200×1500 mm
Voltage	380V/50Hz
Application	Produces flexible aluminum ducts for HVAC ventilation, kitchen hood exhaust, dryer vents, chimney liners
Product Types	Semi-rigid aluminum duct, flexible aluminum duct, insulated flexible duct (with fiberglass)
Market Segment	Growing demand in residential HVAC, kitchen exhaust, industrial ventilation
Optional Equipment	Wire reinforcement unit, fiberglass insulation wrapping unit, packaging unit



Preda Duct Collar Maker

Model: CD-142



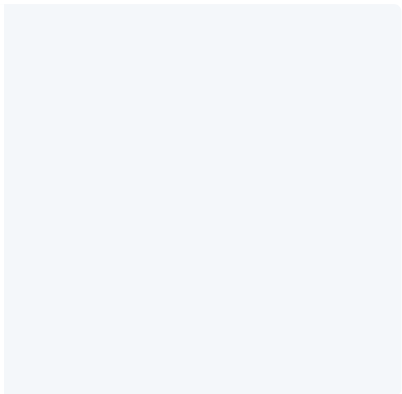
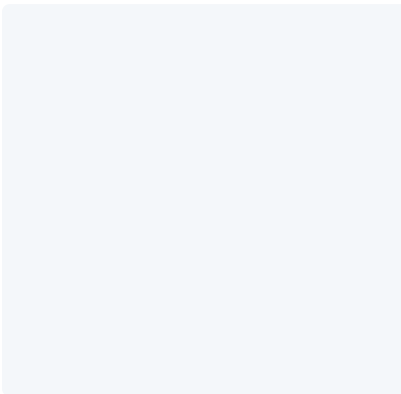
The Preda Duct Collar Maker (CD-142) is a compact electric rolling machine for producing round starting collars — the flanged connector rings used to join flexible ducts, spiral pipes and HVAC equipment to duct systems. The machine combines notching, beading, crimping and rolling in one operation: a flat galvanized strip is fed in, the edges are notched with dovetail tabs, beaded for stiffness and airtightness, and then progressively rolled into a perfect circle by four hardened forming rollers — producing a complete, ready-to-install collar in a single pass. The CD-142 forms collars from 0.4–1.2 mm galvanized steel in diameters from 80 to 350 mm, covering all standard round duct sizes used in residential and commercial ventilation. Roller spacing is adjusted by hand cranks, so one operator can switch between collar diameters within minutes. With its small footprint (850×520×980 mm), 1.5 kW motor and simple push-button control, it is an ideal companion machine for spiral tubeformer and flexible duct production lines, allowing duct manufacturers to produce their own starting collars in-house instead of buying them pre-made — at a fraction of the cost.

TECHNICAL PARAMETERS

Parameter	Value
Model	CD-142
Product	Round starting collars for duct connections
Collar Diameter	80–350 mm
Sheet Thickness	0.4–1.2 mm
Applicable Material	Galvanized steel strip
Functions	Notching, beading, crimping & rolling in one operation
Rollers	4× hardened forming rollers
Motor Power	1.5 kW
Control	Push - button start/stop, hand - crank roller adjustment
Voltage	380V/3PH/50Hz (customizable)
Weight	150 kg
Dimensions (L×W×H)	850×520×980 mm
Certification	CE
Warranty	12 months
Application	Starting collars for flexible ducts, spiral duct connections, HVAC fittings



Preda Cnc Round Duct Forming Line



The Preda CNC Round Duct Forming Line (HZ-1250) is a fully automatic production machine for straight round HVAC ducts. In one continuous pass it shears the galvanized sheet to length with a hydraulically driven alloy blade (quenched and aging-treated for a long service life), rolls it into a perfect circle, forms the double-edge bead rings at both duct ends, and locks the longitudinal seam — the finished straight duct comes off the line ready for insulation jacketing, with no secondary operations required. Forming diameter starts from $\Phi 120$ mm with practically no upper limit, duct length ...

TECHNICAL PARAMETERS

Parameter	Value
Model	HZ-1250
Product	Straight round ducts, double-edge beaded & seam locked
Forming Diameter	$\Phi 120$ mm and above
Duct Length (per piece)	1000–1250 mm
Sheet Thickness	0.5–1.2 mm
Sheet Width	Up to 1250 mm

Parameter	Value
Shearing Speed	260–280 m/h
Processing Accuracy	Circumference ± 1 mm
Main Power	5.5 kW
Shearing System	Hydraulic shear, quenched & aging-treated alloy blade
Forming Operations	Shearing, rolling, double-edge beading & seam locking in one pass
Feeder	Electric auto start/stop feeder (included)

Parameter	Value
Operation	Fully automatic, high-efficiency output
Weight	1400 kg
Dimensions (L×W×H)	2000×1400×1400 mm
Voltage	380V/3PH/50Hz
Application	Straight round ducts for HVAC; output ready for insulation jacket

