

Preda

SQUARE DUCT MAKING MACHINES

Lockformers, Flangers, Folders & Rectangular Duct Equipment ·
2026



PREDAMACHINE

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

Pittsburgh Lock Forming Machine



Pittsburgh Lock former machine / Pittsburgh lock roll former is a basic HVAC duct forming machine that forms the locks of a duct. Preda Machine Pittsburgh lock former is made from highest quality components which include an all steel forming head hardened with ground shafts. The steel forming rolls on this Pittsburgh machine are hardened using matching cut gears and needle bearings which can be used for years.

CONFIGURATION

- Seven stations available: Arc shape, Claw shape, Orthogonal shape, U shape, Union shape, Z shape, Lock pin
- SA-12HB is capable of 1.2mm(18Ga) galvanized steel and SA-15HB is capable of 1.5mm(16Ga) galvanized sheet or 1.0mm(20Ga) stainless steel. Main difference between SA-12HB and SA-15HB is the rollers: SA-12HB uses 45# steel and SA-15HB uses GCr15 steel
- SA-12C and SA-15C are specially designed for round duct lock forming
- 380V/50Hz/3PH standard voltage; 220V/50Hz/1PH or 420V/50Hz/3PH available free of charge
- Preda Machine provides rollers and axles changing the whole life time of the machine
- Customized roll forming flange size and shape available

TECHNICAL PARAMETERS

Parameter	Value
Model	SA-12HB
Max sheet thickness	1.2 mm
Power	1.5 kW
Weight	230 kg
Dimensions (L×W×H)	1070×570×1000 mm
Model	SA-15HB
Max sheet thickness	1.5 mm
Power	3 kW
Weight	250 kg
Dimensions (L×W×H)	1100×600×1000 mm

Parameter	Value
Model	SA-12C
Max sheet thickness	1.2 mm
Power	1.5 kW
Weight	230 kg
Dimensions (L×W×H)	1070×570×920 mm
Model	SA-15C
Max sheet thickness	1.5 mm
Power	3 kW
Weight	350 kg
Dimensions (L×W×H)	1200×650×1050 mm

Preda S Cleat Pittsburgh Lock Former

Model: SA-12S



Preda Machine "S" Cleat Pittsburgh Lock Former includes following lock cleats: S cleat profile, L shape cleat profile, C shape locking pin / Drive cleat Pittsburgh lock (regular flange lock for square duct), Round duct female lock cleat, Round duct male lock cleat. Capacity: 18-24 Gauge (0.5-1.2 mm) galvanized steel or other low carbon steel. This lock forming machine is designed for industrial manufacture of ducts with high efficiency, low noise and good performance. 1 Year Warranty.

CONFIGURATION

- | | |
|--|--|
| 1 Heat treated rollers with hardened character | 5 Roller shaft material: Thermal refined 45# |
| 2 Machine makes 5 different lock shapes without roller changing at all | 6 Motor: 2.2 kW |
| 3 Arc welded steel stand, heavy top plate | 7 Speed: 26 FPM (9 m/min) |
| 4 Roller material: GCr15 | 8 Compact size and mobility |
| | 9 High efficiency |

TECHNICAL PARAMETERS

Parameter	Value
Model	SA-12S
Pittsburgh lock — thickness	0.5-1.2 mm
Pittsburgh lock — material width	30 mm
Pittsburgh lock — molding	13.2 mm
Claw Shape — thickness	0.5-1.2 mm
Claw Shape — material width	9 mm
'C' cleat — thickness	0.5-1.0 mm
'C' cleat — material width	54 mm
'S' shape — thickness	0.5-0.8 mm
'S' shape — material width	92 mm
Power	2.2 kW
Weight	365 kg
Dimensions (L×W×H)	1512×628×1190 mm



Snap Lock Forming Machine

Model: SN-10



The Snap lock machine is one of the most basic production equipment in the production of air ducts. It can process the "S"-shaped interface, so that the interface of the air pipe is perfectly hidden, and the surface of the air pipe is smooth and flat. Easy to join. Suitable for 0.4-1.2mm thick galvanized sheet or carbon steel sheet.

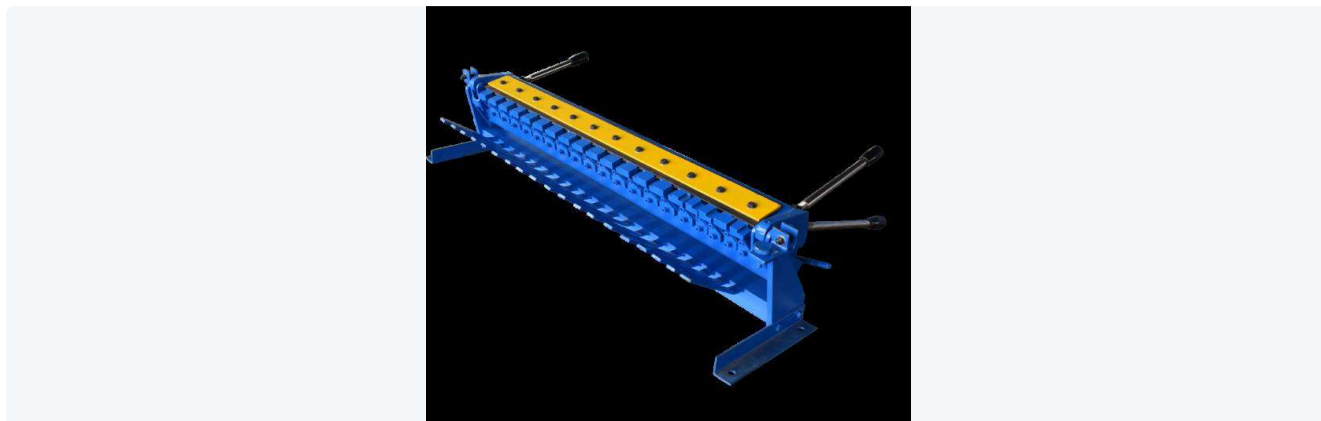
TECHNICAL PARAMETERS

Parameter	Value
Model	SN-10
Thickness	0.5-1.2 mm
Power	2.2 kW
Weight	340 kg
Dimensions (L×W×H)	1500×630×1000 mm



Cleat Bender / Drive Cleat

Model: SN-20



Preda Machine cleat bender is suitable for mobile construction sites, ventilation duct manufacturing, and processing of metal tin box parts. It is widely used worldwide for its lightness, energy saving, high work efficiency and high rate of production outcome. The cleat bender machine is an ideal energy-saving equipment for enterprises and factories.

CONFIGURATION

- 1 The machine is small, light and easy to carry
- 2 The effect handling the thin iron sheet is even better than electric machines
- 3 The machine is simple and easy to operate

TECHNICAL PARAMETERS

Parameter	Value
Model	SN-20
Thickness	0.5-1.0 mm
Useful length	750 mm
Weight	20 kg
Dimensions (L×W×H)	1000×400×320 mm



Tdf Flange Forming Machine

Model: T12 / T15



TDF flange forming machine / TDF roll former / TDF roll forming machine, mainly used for making flange at edge of plate for further joint, is also among basic equipments for modern duct forming line. All bearings used are ball bearings rather than traditional needle bearings so the machine is more durable. All gears, axles and rollers equipped in the machine are made from high quality steel to ensure their stability and durability. The flange shape made by the machine is nice and practical, which makes it a perfect part of duct forming line. Preda Machine TDF roll former has two versions, T-12 capable of 1.2mm and T-15 capable of 1.5mm galvanized metal sheet.

CONFIGURATION

- 1

Two stations available on each side: one side capable of TDF flange, the other side capable of "Claw shape" flange connector
- 2

Optional GCr15 material rollers and axles (equipped on T-15) ensure very long durability
- 3

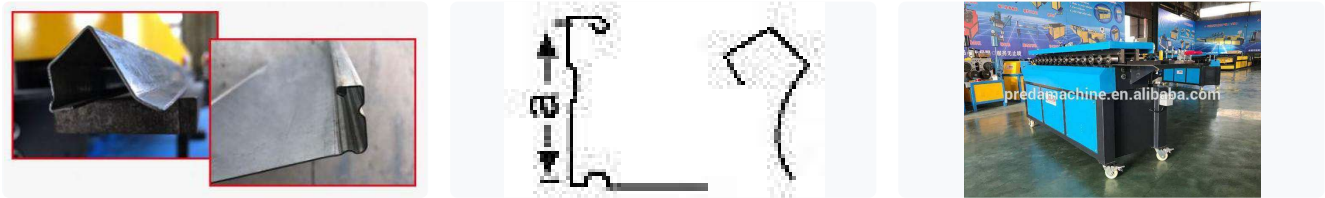
T-12 is capable of maximum 1.2mm(18Ga) galvanized steel sheet while T-15 is capable of 1.5mm(16Ga) galvanized or 1.0mm(20Ga) stainless steel sheet
- 4

Preda Machine provides rollers and axles changing the whole life time of the machine
- 5

Customized roll forming flange size and shape available

TECHNICAL PARAMETERS

Parameter	Value
Model	T12 / T15
Power	3 kW
Sheet thickness	0.5-1.2 / 0.8-1.5 mm
Weight	720 kg (T15)
Dimensions (L×W×H)	2550×700×1100 mm



Duplex Tdf Flange Forming Machine

Model: T-12-2 / T-15-2



Preda



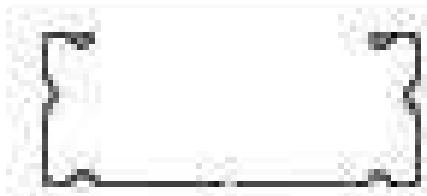
Duplex TDF flange forming machine overcomes the normal TDF flange forming machine's disadvantage that only one end of the sheet can be operated to form flange. Duplex TDF flange forming machine provides a perfect solution for that by having two stations of roll forming so to make TDF flange on both sides of a coil plate. Flange forming can be achieved for both ends at a time, which makes the flanging process much more efficient and stable. This machine is a top priority for companies who are short of staff but desire massive production.

CONFIGURATION

- 1 Duplex TDF flange forming stations on both sides of a plate
- 2 Transporting table in between the two TDF flange forming stations
- 3 Optional Claw shape roll forming available in case required by customer
- 4 GCr15 material rollers and axles ensure very long durability
- 5 Preda Machine provides rollers and axles changing the whole life time of the machine
- 6 Capable of galvanized sheet within 16Ga/1.5mm, and stainless metal sheet within 20Ga/1.0mm
- 7 Customized roll forming flange size and shape available

TECHNICAL PARAMETERS

Parameter	Value
Model	T-12-2 / T-15-2
Power	4 / 5.5 kW
Sheet thickness	0.5-1.2 / 0.8-1.5 mm
Weight	2100 kg (T-15-2)
Dimensions (L×W×H)	2450×2700×1100 mm



Tdc Flange Forming Machine

Model: PDT-20



The TDC flange forming machine is one of the major systems for universal flange making in the world. It has the characteristics of time saving, material saving, high work efficiency, better sealing, sturdy and durable, and strong connection. It is best suitable for ducts with a large cross-section of general purpose duct. The TDC flange forming machine is mainly composed of a coil decoiler, the rolling forming main body and a cutting part. The cutting part can be divided into a grinding wheel cutting and keep cutting, and the cutting system can realize the cutting of the length. The burr is small and can be fully automated. Its working speed is 5-7 m/min. There are 4 types according to its working performance and flange forming strength and sealing strength: PDT-20, PDT-30, PDT-35, PDT-40.

TECHNICAL PARAMETERS

Parameter	Value
Model	PDT-20
Shape high	20 mm
Thickness	0.8 mm
Power	3 kW
Weight	2000 kg
Dimensions (L×W×H)	6300×1200×1700 mm
Model	PDT-30
Shape high	30 mm
Thickness	1 mm
Weight	2200 kg
Model	PDT-35
Shape high	35 mm
Weight	3000 kg
Model	PDT-40
Shape high	40 mm
Thickness	1.2 mm
Power	4 kW
Weight	3000 kg



Power Fastener

Model: PF-12



Preda Machine power fastener is used for TDC flange ducts. You can use this machine to fasten TDC flange ducts quickly and easily! Thickness capable for the sheet is 0.8mm-4mm with adjustment to the sheet thickness automatic. This machine is in 12KG, power is 1.4kW, which is easy to carry and suitable for on-site ductworks.

TECHNICAL PARAMETERS

Parameter	Value
Model	PF - 12
Sheet thickness	0.8 - 4 mm
Weight	12 kg
Power	1.4 kW



Hand Folding Machine

Model: WS-1.5×1300 / 1500 / 2000 / 2500



Folding machine or Folder is a very basic machine for HVAC ductworks. It is used to fold sheet metal and also used for making air duct and fittings manual. Frame of Preda Machine Folding machine is made of steel welded construction with single bladed available for different sizes of sheets to be folded. A heavy duty welded steel frame with strong top and bottom beam makes the machine very strong and good for long using life.

TECHNICAL PARAMETERS

Parameter	Value
Model	WS-1.5×1300 / 1500 / 2000 / 2500
Max thickness	1.5 mm
Max width	1300 / 1500 / 2000 / 2500 mm
Min folding angle	45°
Weight	318 / 336 / 388 / 430 kg
Dimensions (L×W×H)	1950×650×1550 / 2160×650×1550 / 2650×650×1550 / 3100×650×1550 mm



Hand Tdf Folding Machine

Model: TDF-1.5×1300 / 1500 / 2000 / 2500



TDF folding machine or folder is capable of plates with TDF flange on it! So normally TDF Folders are used together with TDF Flange Formers. It has slots on the bottom bed in which the formed flange lies during folding operation process. With this machine you can make L profiles or fully wrap around duct-work as per your needs. Generally it is a perfect companion to TDF Flange Former! Standard capability is 1.5mm×1300mm, 1.5mm×1500mm, 1.5mm×2000mm, 1.5mm×2500mm...

TECHNICAL PARAMETERS

Parameter	Value
Model	TDF-1.5×1300 / 1500 / 2000 / 2500
Max thickness	1.5 mm
Max width	1300 / 1500 / 2000 / 2500 mm
Min folding angle	45°
Weight	320 / 340 / 390 / 450 kg
Dimensions (L×W×H)	1950×650×1550 / 2160×650×1550 / 2650×650×1550 / 3100×650×1550 mm



Pneumatic Folding Machine

Model: QTDF-1.5×1300 / 1500 / 2000 / 2500



A pneumatic folder adopts 4-pneumatic-cylinder as the power source driven by 0.6Mpa air pressure. Two cylinders of the four are used for folding when the other two are used for pressing the plates. It works stably without electricity by just connecting the air pump. The worker can operate the upper die up down and folding and releasing by controlling foot pedal. The max. folding thickness of Preda Machine pneumatic folder is 1.5 mm, which also depends of the plate width. For example, a 1300mm or 1500mm pneumatic folding machine is capable of max. 1.5mm with no problem, but a 2000mm or 2500mm version would be capable of max. 1.0mm! Of course a pneumatic folder has two versions also, which are normal folder and TDF pneumatic folding machine. As an efficient equipment for folding TDF flange duct sheet metal, this machine can be customized according to customers' requirement.

TECHNICAL PARAMETERS

Parameter	Value
Model	QTDF-1.5×1300 / 1500 / 2000 / 2500
Max thickness	1.5 mm
Max width	1300 / 1500 / 2000 / 2500 mm
Min folding angle	45°
Air pressure	0.6 MPa
Weight	350 / 400 / 460 / 500 kg
Dimensions (L×W×H)	2000×800×1550 / 2200×800×1550 / 2700×800×1550 / 3200×800×1550 mm



Electric Shearing Machine



Electric plate shearing machine. Rigid frame with strong steel welded is simple but nice. Low electricity consuming and ease for operation make it widely used for shearing thick steel plate sheet. The whole machine body uses the integrally weld structure, ensuring the high strength and good rigidity of the machine. The machine hasn't the clutch and the flywheel. It shears the sheet-metal directly driven by the magnetic brake motor. This reduces the idle time of the motor and saves the energy. Preda Machine's machine blade uses 6Cr2Si material, ensuring the good performance and long performance life.

CONFIGURATION

- 1

Integrally weld structure ensuring high strength and good rigidity
- 2

No clutch and flywheel — shears directly driven by magnetic brake motor, saving energy
- 3

Blade uses 6Cr2Si material for good performance and long life
- 4

Simple structure, easy operation and low consumption

TECHNICAL PARAMETERS

Parameter	Value
Model	1.5×600 / 1.5×1000 / 1.5×1300 / 1.5×1500
Max thickness	1.5 mm
Max width	600 / 1000 / 1300 / 1500 mm
Cutting angle	1°30'
Backage range	350 mm
Power	1.5 / 1.5 / 1.5 / 2.2 kW
Model	2×1000 / 2×1300 / 2×2500
Max thickness	2 mm
Cutting angle	2°14'
Backage range	400 / 400 / 500 mm

Parameter	Value
Power	3 / 3 / 5.5 kW
Model	3×1000 / 3×1300 / 3×1600
Max thickness	3 mm
Cutting angle	2°14'
Backage range	400 / 500 / 500 mm
Power	4.5 kW
Model	4×1600
Max thickness	4 mm
Power	5.5 kW

Tiltable Punching Machine

Model: J23-25T



J23 series — remarkable and flexible pressing quality and capacity in great cost performance. Rigid frame is built with thick concrete plate steel to ensure function stability and durability. Steel rotating key clutch is installed for easy operation. Overload protecting device, which will collapse as safeguard, is equipped in band brake system to protect operators and equipment. This series is most widely used among all press machines due to verified precision, stability and durability. This type is of tiltable design for easy blanking of finished part and waste materials down from the working table. Equipped with our TDF corner dies, J23-25 can produce HVAC duct TDF corners fast and accurately! Additionally, by using automatic air feeding mold and TDF corner dies, J23-40 can produce TDF corners automatically in very fast speed!

TECHNICAL PARAMETERS

Parameter	Value
Model	J23-25T
Pressure	250 kN
Dimension of die holder	40×60 mm
Slide stroke	70 mm
Time	60 min
Power	2.2 kW
Dimensions (L×W×H)	1220×920×2060 mm
Model	J23-40T
Pressure	400 kN
Dimension of die holder	50×70 mm
Slide stroke	100 mm
Time	50 min
Power	3 kW
Dimensions (L×W×H)	1320×970×2380 mm



Tdf Corner Dies

Model: TDF-35



TECHNICAL PARAMETERS

Parameter	Value
Model	TDF - 35
Application	TDF corner punching for rectangular duct
Compatible	Fits J23 series punching machines
Corner Size	35 mm standard TDF
Material	Cr12MoV alloy steel, hardened
Weight	25 kg/set
Certification	CE
Warranty	12 months
Features	Precision ground, long service life, quick corner punching



Duct Bearer

Model: G1.2×1300 / G1.2×2000



Preda Machine duct bearer is designed and built in Anhui, China. This machine is used to form beads on flat sheet metal for stiffening ductwork and fittings. The machine has a 1.2mm×1300mm capacity. Beading rolls are designed for easy replacement if damaged and bead rolls are etched into the bead roll shaft for easy alignment. Duct beading is a much faster practice as compared to the original cross breaking method. A Duct Bearer machine is a fairly simple machine wherein you feed flat sheet metal into the machine and the machine forms 5 beads on 1300mm width sheet or 7 beads on 2000mm!! (depending on the machine model).

TECHNICAL PARAMETERS

Parameter	Value
Model	G1.2×1300 / G1.2×2000
Max thickness	1.2 mm
Max width	1300 / 2000 mm
Power	1.5 / 2.2 kW
Weight	380 / 570 kg
Dimensions (L×W×H)	1550×900×1060 / 2300×900×1120 mm



Duct Bearer And Leveler

Model: JXP-1.5×1300



Duct bearer and leveler is an upgraded machine of normal duct bearer. This machine is equipped with leveling station before beading station, so that the finished sheet metal and duct are flatter. Dealing with coil steel, this is definitely a more advanced and better machine for beading. Tooling of Preda duct bearer, if broken or damaged, is replaceable without replacing an entire machine. You can adjust the beading depth by rolling up/down of beading rollers. (A convenient handwheel raises or lowers the top roll assembly to set depth of bead. The top and bottom rollers are kept parallel with adjustable screw.)

TECHNICAL PARAMETERS

Parameter	Value
Model	JXP-1.5×1300
Max thickness	1.5 mm
Max width	1300 mm
Power	2.2 kW
Weight	700 kg
Dimensions (L×W×H)	1550×1100×1050 mm



Slitting Machine

Model: LQ-15



Preda Machine slitting machine (also called "beader and slitter") is capable of both beading and slitting function in one machine! It is equipped with two sets of moulds for beading and slitting. Its size is not big which is very easy to take to working site for duct-works. Power with 1.5kW motor makes it functioning fast and easy!

CONFIGURATION

- 1

One motor in 1.5 kW
- 2

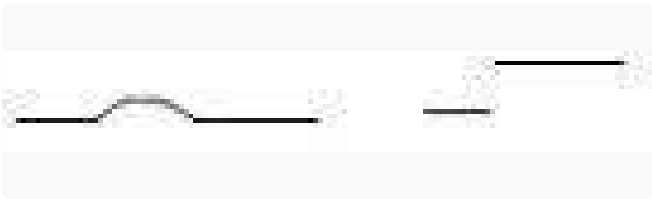
One set of slitting roller moulds
- 3

One set of beading roller moulds
- 4

One switcher and rod

TECHNICAL PARAMETERS

Parameter	Value
Model	LQ-15
Sheet thickness	0.5 - 1.2 mm
Power	1.5 kW
Weight	260 kg
Dimensions (L×W×H)	1600×630×1120 mm



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.

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
Plasma source brand	63A Huayuan plasma source
Cutting angle	3-5 degree
Transmission way	Gear wheel and rack, linear guide rail
Height adjusting method	Pneumatic height regulating
Software	CAM-DUCT

Hydraulic Duct Seam Closing Machine

Model: HF-1550



Hydraulic duct seam closing machine for rectangular duct seaming process! This is an automatic vertical lock seaming machine, which is driven by hydraulic oil and it can seam 1550mm length rectangular ducts. It is controlled through PLC and Japan Mitsubishi system which operates easily. The tightness of seam closing is very good.

CONFIGURATION

- 1

One control box
- 2

One control system
- 3

One cylinder
- 4

One foot switch

TECHNICAL PARAMETERS

Parameter	Value
Model	HF-1550
Thickness	0.5 - 1.2 mm
Max length	1550 mm
Power	3 kW
Weight	800 kg
Dimensions (L×W×H)	1000×1000×2250 mm



Pneumatic Lock-Seaming Machine

Model: HF-1250



Pneumatic lock seaming machine is an auto seam locker for rectangular duct. It is driven by air pressure so it is a very power saving machine which makes lock seaming easy. The locks that are seamed by this machine are smooth and even, which is much better than manual work. Easy handling and efficiency makes it a useful HVAC machine for duct makers.

TECHNICAL PARAMETERS

Parameter	Value
Model	HF - 1250
Max thickness	1.0 mm
Max duct length	1250 mm
Fluid pressure	0.6-0.8 MPa
Weight	660 kg
Dimensions (L×W×H)	3200×1000×1030 mm

Electric Seam Locker

Model: L-12



Preda Machine seam locker is used for closing Pittsburgh seams on straight or curved ducts. You can use this machine to seam the Pittsburgh locks quickly and easily! Thickness capable for the sheet is 0.5mm-1.2mm with adjustment to the sheet thickness automatic. Suitable for flange heights of 9 mm – 13 mm and for sheet thicknesses of 0.5 mm – 1.25 mm. This machine is in 6KG, which is easy to carry and suitable for on-site ductworks.

TECHNICAL PARAMETERS

Parameter	Value
Model	L-12
Max thickness	1.2 mm
Power	0.75 kW
Weight	11 kg
Dimensions (L×W×H)	400×150×200 mm



Pneumatic Corner Matics

Model: PC-12



Pneumatic corner matics for rectangular duct forming process! Fixing one TDF corner will take only about 6 seconds, which is extremely efficient! What's more, it is much nicer for a TDF corner fixed on the duct than fixing manually! This machine is a perfect match to work with TDF flange forming machine. Also it is a companion with 25T punching machine and TDF corner moulds, which can make TDF corners in massive quantity in short time!

TECHNICAL PARAMETERS

Parameter	Value
Model	PC-12
Sheet thickness	1.2 mm
Fluid pressure	0.6-0.8 MPa
Weight	300 kg
Dimensions (L×W×H)	1500×800×1050 mm



Hydraulic Corner Matics

Model: TDF-12



Hydraulic corner installation machine is a new design, dedicated to the installation of the corner: the standard corner size is placed in the mold, the mold is portable, and then placed on the TDF flange duct — press the button and the corner is automatically fastened securely to the TDF flange duct. The machine is hydraulically operated, mobile and economical; it is a best choice for duct production.

CONFIGURATION

- 1 One control box
- 2 One hydraulic station
- 3 TDF corner fixed mold

TECHNICAL PARAMETERS

Parameter	Value
Model	TDF - 12
Sheet thickness	1.2 mm
Oil capacity	20 L
Weight	100 kg
Dimensions (L×W×H)	800×400×900 mm



Angle Iron Flange Forming Line

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 work 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

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Decoiler

Model: —



Preda Machine decoiler is specially designed for duct forming line to make the material loading and transporting stable. Generally, auto duct line 2 and auto duct line 3 would be equipped with 2 coil holders, while auto duct line 4 and auto duct line 5 would be equipped with 4 coil holders. Each coil holder is capable of 5 tons of coils.

TECHNICAL PARAMETERS

Parameter	Value
Coil holder capacity	5 tons each
Auto duct line 2 / 3	2 coil holders
Auto duct line 4 / 5	4 coil holders



Portable Machines

Model: —



Portable HVAC tools series for on-site duct installation and repair.

CONFIGURATION

- | | | | |
|---|---------------------------------------|---|--|
| 1 | Claw cleat cutting machine | 6 | Manual notching machine |
| 2 | Portable clinching / riveting machine | 7 | Portable electric scissors (shear metal plate within 1.0mm) |
| 3 | Cleat bender | 8 | Portable pneumatic scissors (shear metal plate within 0.8mm) |
| 4 | Hydraulic notching machine | 9 | Portable slitter |
| 5 | Pneumatic notching machine | | |



Preda Fire Damper Production Line



The Preda Fire Damper Production Line is a fully automated manufacturing system for producing fire dampers, smoke dampers, and fire-smoke combination dampers — critical life safety products mandated by building codes in commercial, industrial, and institutional construction. With fire safety regulations becoming increasingly stringent worldwide, the demand for certified fire dampers is growing rapidly, creating a high-margin market with significant barriers to entry. The FDL-1500 handles damper sizes from 100×100mm to 1500×800mm (customizable), with frame material thicknesses from ...

TECHNICAL PARAMETERS

Parameter	Value
Model	FDL-1500
Damper Types	Fire Damper (72°C/150°C/280°C), Smoke Damper, Fire-Smoke Combination Damper
Damper Sizes	100×100 mm – 1500×800 mm (customizable)
Frame Material Thickness	1.2–2.5 mm (galvanized steel)
Blade Material Thickness	1.0–2.0 mm
Production Speed	0–12 m/min
Total Power	30 kW
Hydraulic Power	11 kW

Parameter	Value
Weight	10000 kg
Dimensions (L×W×H)	22000×3000×2000 mm
Control System	PLC + 15" Touch screen, fully automatic, production data management
Integrated Processes	Decoiling, Leveling, Punching, Notching, Roll forming, Cutting, Blade forming, Fusible link mounting, Assembly
Frame Forming	Heavy duty multi-station roll forming, reinforced frame design
Punching System	CNC hydraulic punching, automatic hole positioning for fusible link, actuator, mounting brackets
Blade Forming	Automatic blade roll forming with reinforced ribs
Fusible Link	Automatic fusible link installation station (72°C/150°C/280°C)

Parameter	Value
Applicable Materials	Galvanized steel, Stainless steel
Voltage	380V/50Hz, 3-phase
Application	Fully automatic production of fire dampers, smoke dampers for HVAC fire protection systems
Market Drivers	Mandatory fire safety regulations, commercial building construction, industrial facilities, data centers
Daily Production Capacity	100–300 dampers (depending on size and type)
Testing	Built-in leakage testing station (optional), meets AMCA 500-D standards
Optional Equipment	Electric/pneumatic actuator mounting, labeling and packaging, automatic stacking