

**LEISTER**

PLASTIC WELDING

Swiss  
made



2018/19

General Catalog

# Plastic Welding

The only choice for professionals

[www.leister.com](http://www.leister.com)

**We know how.**



Leister Technologies AG, Corporate Center, Kaegiswil, Switzerland



Leister Technologies AG, factory, Samen, Switzerland



Leister Technologies AG, factory, Kaegiswil, Switzerland



Leister Technologies Ltd.,  
Shanghai, China



Leister Technologies GmbH,  
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Leister Technologies Benelux BV,  
Houten, Holland



Leister Technologies Italia S.r.l.,  
Milan, Italy



Leister Technologies LLC,  
Itasca, USA



Leister Technologies KK,  
Yokohama, Japan



Leister Technologies India Pvt,  
Chennai, India

### Leister delivers performance.

For over 65 years, Leister has been the worldwide leader in the field of plastic welding and industrial hot-air applications. In addition we also offer innovative and effective lasersystems and microsystems. Leister is proud to develop and produce all products in Switzerland – so you can always rely on the proverbial Swiss made quality.

Over 98 percent of our products are exported. With an established network of 130 sales and service centers all over the globe, you will find a Leister partner guaranteed. We are local worldwide.



## LEISTER

### PLASTIC WELDING

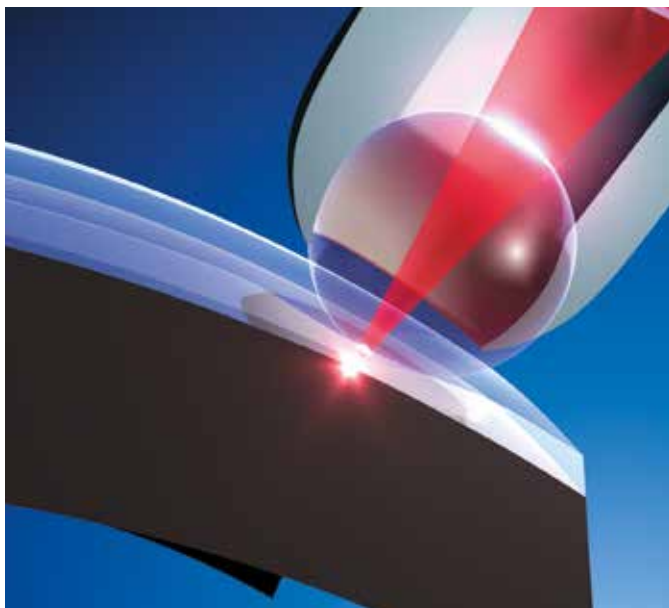
For decades now, Leister has been the worldwide market leader. The performance and reliability of our products makes Leister the first choice. Our tools are used in roofing, billboards, tarpaulins, civil engineering, tunneling, landfills, flooring, plastic fabrication, and shrinking to name a few.



## LEISTER

### PROCESS HEAT

Hot-air is increasingly deployed in industrial processes. Typical applications include activating, heating, curing, melting, shrinking, welding, sterilizing, drying and warming to name a few. Leister customers profit from our extensive engineering knowledge and benefit from our recommendations during the conceptual design of hot-air applications.



## LEISTER

### LASER PLASTIC WELDING

Leister's innovative and patented laser bonding solutions provide alternative production processes in automotive, medical, sensor, electronics and textile manufacturing as well as microsystems technology. Our clean, precise and non-invasive laser technology can also be applied to process heat applications.

### Plastic welding with Leister

Leister Technologies AG provides the appropriate high quality welding device for all sectors of the plastics processing industry. Our tools are used in sealing systems on roofs, plastic sheeting, floor coverings, in earthworks, hydraulic and tunnel engineering, equipment manufacturing and vehicle repair. However demanding the task, we provide an applicable solution.

### Research and development

With years of experience in plastic processing and industrial processes we are the ideal partner to work your plastic application. We have dedicated ourselves to constantly develop new and to persistently improve existing products. We strive to provide our customers with outstanding quality, reliability, performance and cost-efficient products.

### Quality management

As an innovative company, Leister commits to transparent and consistent quality management. Leister Technologies AG is certified to comply with the ISO 9001 quality standards. All processes are regularly audited and improved to comply with all quality-relevant criteria; therefore, our products enjoy a reputation of providing reliable service even after years of use under adverse conditions.

### Testing and certification

Our products are designed and developed to comply with nationally and internationally recognized standards. This includes both product-specific standards – such as ISO, IEC, EN or UL standards – as well as application-specific standards. For our client's protection, tests are carried out by accredited and independent test institutes. The products are then certified and qualified to carry the marking of conformity.

### Application and laboratory testing

Our team of experts will assist you in choosing the right equipment for your application process. Running test series on your applications will help optimize processes. The equipment of the application laboratory allows comprehensive testing for process analysis and documentation of the results.

### More than 130 Sales and Service Centers in more than 100 countries

We believe that the basis for customer satisfaction lies within the quality of our products and the smooth running global service network. A close network of more than 130 sales and service centers in more than 100 countries ensures competent and responsive service. Distributors and their staff are trained and certified by Leister on a regular basis; therefore, Leister know-how is locally available to you at all times.









GEOSTAR G5/G7

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Hot-Air Hand Tools

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Roofing

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Flooring and Interior Decoration





TRIAC ST for use in the roughest of environments.



Hot-Jet S ideal for detail work on the roof.










DIODE S for use with draw welding on a tank detail.








## Hot-Air Hand Tools

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## Product overview Hot-air hand tools

								
Type	TRIAC ST	TRIAC AT	ELECTRON ST	HOT JET S	GHIBLI AW	GHIBLI	HOTWIND	FORTE S3
Voltage V~	230 / 120	230 / 120	230 / 120	230 / 120	120/230	120/230	230	3 × 230 / 3 × 400
Max. power W	1600	1600	2400 / 3400	460	1800 / 2300	1500 / 2000	3700	10 000
Temperature °C	40 – 700	40 – 620	40 – 650	20 – 600	65 – 620	20 – 600	20 – 650	20 – 650
Size mm (L × Ø) Handle (Ø)	338 × 90 56	338 × 90 56	338 × 90 56	235 × 70 40	280 × 220 × 90 45	195 × 85 × 160 57	232 × 106 179	390 × 132 215
Weight kg (without cord)~	1.0	1.0	1.1	0.4	1.1	0.9	2.2	4.4
Integrated blower	✓	✓	✓	✓	✓	✓	✓	✓
Digital display		✓			✓			
Conformity mark	CE	CE	CE	CE	CE	CE	CE	CE
Approval mark	ⓈⓀ	ⓈⓀ	ⓈⓀ	ⓈⓀ	Ⓢ	Ⓢ	Ⓢ	Ⓢ
Protection class	□	□	□	□	□	□	□	□
Applications								
Outdoor use	✓	✓	✓	✓	✓			✓
Indoor use	✓	✓	✓	✓	✓	✓	✓	✓
Roofing	✓	✓	✓	✓				
Billboards / Tarpaulins	✓	✓	✓	✓	✓	✓		
Civil engineering / Tunneling / Landfills	✓	✓	✓	✓				
Plastic fabrication	✓	✓	✓	✓	✓	✓		
Flooring / Interior design	✓	✓	✓	✓	✓	✓		
Shrinking	✓	✓	✓	✓	✓	✓	✓	✓
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## Product overview Hot-air hand tools and Blower

						
Type	AIRSTREAM ST	ROBUST	WELDING PEN R / S	DIODE PID / S	MINOR	LABOR S
Voltage V~	230	3 × 230 / 3 × 400	230	230	230	230
Max. power W	215	250	1000	1600 / 2000	100	800 / 900
Temperature °C			20 – 600	20 – 600		20 – 600
Size mm (L × Ø) Handle (Ø)	600 × 250 × 362	255 × 221	270 × 43 32	265 × 57 40	250 × 95 64	180 × 54 32
Weight kg (without cord)~	24	8.0	1.0	1.15	1.15	0.15
Integrated blower	✓	✓			✓	
Digital display			✓ (R)	✓ (PID)		
Conformity Mark	CE	CE	CE	CE	CE	CE
Protection Class	⊕	⊕	□	□	□	□
Applications						
Outdoor use						
Indoor use	✓	✓	✓	✓	✓	✓
Roofing						
Billboards / Tarpaulins						
Civil engineering / Tunneling / Landfills						
Plastic fabrication	✓	✓	✓	✓	✓	✓
Flooring / Interior design						
Shrinking	✓			✓		✓
Catalog page	 26 / 27	28	29	30 / 31	31	32

# TRIAC ST – Design meets experience

The new TRIAC ST from Leister is primarily used for welding and plastic fabrication. During its development, a deliberate choice was made to do without extra technical features. Instead it is distinguished by comfort, being reliable versatile, robust and user friendly, like its predecessor the TRIAC S. A prominent feature here is the two-component handle, which is not only attractive, but also gives the user perfect grip. The low weight of less than 1 kg/2.18 lbs ensures a perfect weight balance.

## Product advantage

1



**Ergonomic handling:**  
The 2-component handle and perfect tool balance ensure ideal grip and optimum working even under the toughest conditions.

**Perfect weight:**  
Weighing less than 1 kg, the TRIAC ST is even lighter than its predecessor.

2



**Always keeps a cool head:**  
There is an actively cooled protective tube for greater work safety.

3



**Welding power:**  
Thanks to the optimized, highly robust motor, TRIAC ST guarantees high welding power.

2



1

3

4

5

4



**Reliability:**  
A new temperature manager and a high dust resistance provide the heating elements with a long service life.

5



**Swiss thoroughness:**  
The air filters, located on either side, can easily be removed and cleaned. This ensures optimum air flow and maximum power output.

**Optimum protection:**  
The filters offer active protection against moisture and dust.

## TRIAC AT: Robust and intelligent.

The TRIAC AT is an intelligent hot-air hand tool for welding and shrinking plastics that is suitable for on-site use. It is designed for the needs of even the most demanding professional. Every tool undergoes stringent quality checks prior to leaving the factory in Switzerland. This high-quality hot-air hand tool is equipped for all situations. Its universal areas of application are virtually unlimited. The TRIAC AT will continue to prove its merit in any weather condition and is just as effective outside as it is indoors – all during continuous operation.

### Hot-air hand tool

#### TRIAC ST



- Suitable for the work site
- Functional design: two-component handle grip and optimum center of gravity ensure good ergonomics
- Quick clean air filters
- Automatic carbon stop and heating element protection provide automatic protective measures

#### Technical data

Voltage	V~	120 / 230
Frequency	Hz	50 / 60
Power	W	1600 / 1600
Temperature	°C	40 – 700
Air volume (20°C)	l/min	280 (500 at max. temp)
Dynamic pressure	Pa	3000
Ø Nozzle holder	mm	31.5
Emission	dB(A)	67
Size (L × Ø)	mm	338 × 90, handle Ø 56
Weight	kg	<1 (without power cord)
Conformity mark	CE	
Approval mark	E	
Protection class II	□	

#### Article No.:

141.308	TRIAC ST, 120 V / 1600 W for push-fit nozzles with UK-plug
141.309	TRIAC ST, 230 V / 1600 W for push-fit nozzles with UK-plug
141.311	TRIAC ST, 230 V / 1600 W for push-fit nozzles with CH plug
141.227	TRIAC ST, 230 V / 1600 W for push-fit nozzles with Euro plug
144.013	TRIAC ST, 230 V / 1600 W for screw-on nozzles with Euro plug
153.891	TRIAC ST, 220 V / 1600 W for push-fit nozzles with KR-plug

### Hot-air hand tool

#### TRIAC AT



- Suitable for the work site
- Closed loop controlled temperature
- Open loop controlled air volume
- Intelligent «e-Drive» operating unit
- Ergonomic handling
- Modern design

#### Technical data

Voltage	V~	120 / 230
Frequency	Hz	50 / 60
Power	W	1600 / 1600
Temperature	°C	40 – 620
Air volume (20°C)	l/min	210 - 280 (500 at max. temp)
Dynamic pressure	Pa	1600 - 3000
Ø Nozzle holder	mm	31.5
Emission	dB(A)	67
Size (L × Ø)	mm	338 × 90, handle Ø 56
Weight	kg	1 (without power cord)
Conformity mark	CE	
Approval mark	E	
Protection class II	□	

#### Article No.:

141.319	TRIAC AT, 120 V / 1600 W, with UK-plug
141.320	TRIAC AT, 230 V / 1600 W, with UK-plug
141.314	TRIAC AT, 230 V / 1600 W, with Euro-Stecker
141.322	TRIAC AT, 230 V / 1600 W, with CH-Stecker
148.005	TRIAC AT, 220 V / 1600 W, for push-fit nozzles with KR-plug



Overlap welding

## Accessories TRIAC ST / TRIAC AT

	<p>Wide slot nozzle, push-fit  <b>107.123</b> 20 mm, 15° angled  <b>107.132</b> 40 mm, 15° angled  <b>107.133</b> 40 mm, perforated  <b>107.135</b> 40 mm, PTFE-coated  <b>107.129</b> 60 mm for bitumen  <b>107.131</b> 80 mm for bitumen</p> <p>(more: <a href="http://www.leister.com/downloads/">www.leister.com "downloads"</a>)</p>		<p><b>107.124</b> 20 mm angled nozzle, 70°, push-fit</p>
	<p>Wide slot nozzle  <b>105.475</b> 20 mm, straight  <b>105.485</b> 25 mm, straight  <b>105.494</b> 30 mm, 15° angled</p>	 	<p><b>105.431</b> 3 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle  <b>105.432</b> 4 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle  <b>105.433</b> 5 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle</p>
	<p><b>105.487</b> Wide slot nozzle 20 mm, curved and angular, with clamping angle inwards</p>	 	<p><b>107.139</b> 4.5 x 12 mm speed weld nozzle for fillet weld, push-fit on Ø 5 mm tubular nozzle  <b>107.137</b> 8 mm speed weld nozzle for tape welding, push-fit on Ø 5 mm tubular nozzle</p>
	<p><b>105.500</b> Wide slot nozzle 20 mm, 120° angled (right) 30° slanted forward openly</p>	  	<p>Speed weld nozzle, push-fit on Ø 5 mm tubular nozzle  <b>106.992</b> 5.7 mm, profile A  <b>106.993</b> 7 mm, profile B  <b>106.989</b> Ø 3 mm  <b>106.990</b> Ø 4 mm  <b>106.991</b> Ø 5 mm</p>
	<p><b>107.130</b> Wide slot nozzle 40mm, 60° bent  <b>107.125</b> 20 mm angled nozzle, 60°, push-fit, for right hander  <b>105.503</b> 20 mm angled nozzle, 60°, push-fit</p>		<p><b>156.470</b> Speed weld nozzle bend Ø 5 mm, push-fit on Ø 4/5 mm tubular nozzle</p>
	<p><b>100.303</b> Ø 5 mm, tubular nozzle, push-fit  <b>105.575</b> Ø 5 x 100 mm, tubular nozzle, push-fit  <b>106.982</b> Ø 5 x 150 mm, extension nozzle, push-fit</p>		<p><b>105.576</b> tubular nozzle Ø 5 mm, 90° curved</p>
	<p><b>105.576</b> tubular nozzle Ø 5 mm, 90° curved</p>		<p><b>106.996</b> Tacking nozzle, push-fit on Ø 5 mm tubular nozzle</p>











Mirror welding



Draw welding



Shrinking

	<b>105.622</b> Ø 5 mm, tubular nozzle, screw-on
	<b>106.988</b> Tacking nozzle, screw-on
	<b>126.552</b> Ø 4 mm drawing nozzle, screw-on for fluor plastics
	<b>113.666</b> Ø 3 mm drawing nozzle with tacking tip, screw-on
	<b>113.399</b> Ø 4 mm drawing nozzle with tacking tip, screw-on
	<b>113.876</b> Ø 3 mm drawing nozzle without tacking tip, screw-on
	<b>113.874</b> Ø 4 mm drawing nozzle without tacking tip, screw-on
	<b>113.670</b> Drawing nozzle triangular-shaped With tacking tip, screw-on 5.7 mm, profile A
	<b>113.877</b> Without tacking tip, screw-on 5.7 mm, profile A
	<b>106.986</b> Without tacking tip, screw-on 7 mm, profile B
	<b>106.987</b> Without tacking tip 7 × 5.5 mm
	<b>157.717</b> Protection nozzle 31.5 mm, air outlet 23 mm, protection ring 80 mm
	<b>107.344</b> 135 mm welding mirror, push-fit
	<b>143.833</b> Nozzle adapter for screw-on nozzles
	<b>143.332</b> Protection tube for screw-on nozzles (for TRIAC ST until april 2017)
	<b>156.092</b> Protection tube for screw-on nozzles (for TRIAC ST from mai 2017)
	<b>141.375</b> Connection adapter M14 for Ø 21 mm nozzle with plug

	<b>107.324</b> 12 × 10 mm sieve reflector, push-fit on Ø 8 mm tubular nozzle
	<b>107.337</b> 50 × 35 mm sieve reflector, push-fit
	<b>107.338</b> 35 × 20 mm sieve reflector, push-fit
	<b>107.326</b> 25 × 150 mm shell reflector, push-fit
	<b>107.307</b> 27 × 35 mm spoon reflector, push-fit
	<b>107.339</b> 17 × 34 mm soldering reflector, push-fit
	<b>106.128</b> 7.5 mm soldering reflector
	<b>142.717</b> Heating element for TRIAC ST / TRIAC AT, 230 V / 1550 W
	<b>142.718</b> Heating element for TRIAC ST / TRIAC AT, 120 V / 1550 W

# ELECTRON ST – Strong, compact and handy

The new ELECTRON ST is a real powerhouse among Leister's hand tools. The appearance of this tool has been modeled after the new TRIAC range. For the user, this means improved ergonomics and, as a result, the ability to work in more comfort. Existing ELECTRON nozzles fit the new model.

## Product advantages



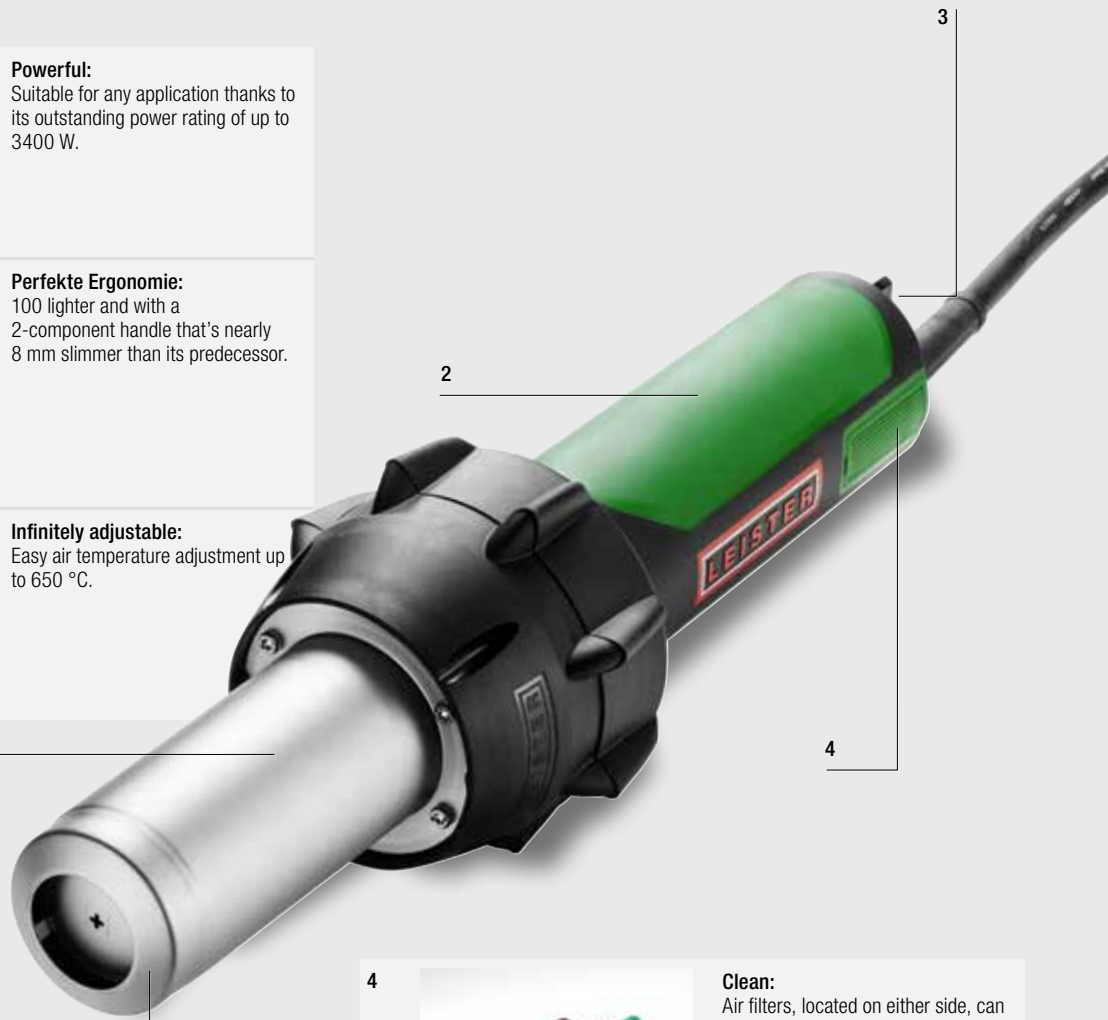
**Powerful:**  
Suitable for any application thanks to its outstanding power rating of up to 3400 W.



**Perfekte Ergonomie:**  
100 lighter and with a 2-component handle that's nearly 8 mm slimmer than its predecessor.



**Infinitely adjustable:**  
Easy air temperature adjustment up to 650 °C.



**Clean:**  
Air filters, located on either side, can be removed and cleaned in no time at all.



**Compatible:**  
All predecessor nozzles fit the ELECTRON ST.



Shrinking cable connections is just one of many applications for which the ELECTRON ST can be used.

Hot-air hand tool

## ELECTRON ST



- Suitable for construction sites
- Leister's most powerful hand tool
- Easy-clean air filter
- Carbon stop and heating element protection provide automatic protective measures
- Sturdy tool case supplied

### Technical data

Voltage	V~	230 / 230 / 200 / 120
Frequency	Hz	50 / 60
Power	W	2300 / 3400 / 3000 / 2400
Temperature	°C	40 – 650
Air volume (20°C)	l/min	430 (790 at max. temp)
Dynamic pressure	Pa	3400
Ø Nozzle holder	mm	50
Emission	dB(A)	67
Size (L × Ø)	mm	338 × 90, handle Ø 56
Weight	kg	1.1 (without power cord)
Conformity mark		CE
Approval mark		Ⓢ Ⓜ
Protection class II		Ⓜ

### Article No.

145.567	ELECTRON ST, 230 V / 3400 W for push-fit nozzles with Euro plug
149.673	ELECTRON ST, 230 V / 2300 W for push-fit nozzles with Euro plug
145.563	ELECTRON ST, 120 V / 2400 W for push-fit nozzles with UK plug
145.568	ELECTRON ST, 230 V / 3400 W for push-fit nozzles with UK plug
154.839	ELECTRON ST, 220 V / 3400 W for push-fit nozzles with KR-plug

## Accessories ELECTRON ST

	<b>107.258</b>	Wide slot nozzle, push-fit 70 × 10 mm, for bitumen
	<b>107.653</b>	Wide slot nozzle 75 × 2 mm, push-fit
	<b>151.068</b>	Tool stand for 107.653
	<b>107.270</b>	Wide slot nozzle 150 × 12 mm, push-fit
	<b>107.229</b>	Round nozzle 20 mm
	<b>107.331</b>	72 × 70 mm folding reflector, push-fit
	<b>107.330</b>	125 × 22 mm folding reflector, push-fit
	<b>107.327</b>	85 × 85 mm sieve reflector, push-fit
	<b>107.333</b>	130 × 150 mm sieve reflector, push-fit
	<b>106.127</b>	Ø 65 mm sieve reflector push-fit
	<b>107.340</b>	45 × 250 mm Shell reflector, push-fit
	<b>107.346</b>	270 mm welding mirror, push-fit
	<b>142.281</b>	Scraper nozzle
	<b>107.134</b>	Tape welding nozzle 40 mm
	<b>160.842</b>	Protection nozzle, air outlet 44 mm, protection ring 10 mm
	<b>148.933</b>	Protective tube
	<b>145.606</b> <b>149.675</b> <b>145.604</b>	Heating elements 230 V / 3300 W 230 V / 2200 W 120 V / 2300 W

More at the new accessories catalog at

[www.leister.com/accessories](http://www.leister.com/accessories)

General accessories

34/35



# HOT JET S: Small and powerful.

As the most compact hot-air hand tool from Leister, the HOT JET S' low weight of 600 grams (including cord and slim handle) ensures high-powered, fatigue-free welding.



Especially suited for precise work.

Hot-air hand tool

## HOT JET S



- The smallest Leister hot-air hand tool
- Stepless, electronically controlled temperature
- Stepless, electronically controlled air flow
- Low noise
- Flexible, integrated tool stand

### Technical data

Voltage	V~	120 / 230
Frequency	Hz	50 / 60
Power	W	460 / 460
Temperature	°C	20 – 600
Air volume (20°C)	l/min	60 – 140 (190 at max. temp)
Pressure static	Pa	230 – 1600
Ø Nozzle holder	mm	21.3
Emission	dB(A)	59
Size (L × Ø)	mm	235 × 70, handle Ø 40
Weight	kg	0.4 (without power cord)
Conformity mark	CE	
Approval mark		
Protection class II		

### Article No.:

100.648	HOT JET S, 230 V / 460 W, with Euro plug
100.862	HOT JET S, 120 V / 460 W, without plug
100.854	HOT JET S, 230 V / 460 W, with AUS plug
140.030	HOT JET S, 220V/ 460W for push-fit nozzles with KR-plug

## Accessories HOT JET S















	<b>107.141</b>	15 mm wide slot nozzle, push-fit
	<b>107.142</b>	20 mm wide slot nozzle, push-fit
	<b>105.549</b>	10 x 2 mm wide slot nozzle
	<b>107.144</b>	Ø 5 mm tubular nozzle, push-fit
	<b>105.567</b>	Ø 5 x 150 mm extension nozzle, straight
	<b>105.566</b>	Ø 8 mm tubular nozzle, straight
	<b>105.556</b>	20 mm angled nozzle, 70° angled, push-fit
	<b>106.996</b>	Tacking nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>106.989</b>	3 mm speed welding nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>106.990</b>	4 mm speed welding nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>106.991</b>	5 mm speed welding nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>156.470</b>	Speed weld nozzle bend Ø 5 mm, push-fit on Ø 5 mm tubular nozzle
	<b>106.992</b>	5.7 mm, A profilee speed welding nozzle, push-fit
	<b>106.993</b>	7 mm, B profilee speed welding nozzle, push-fit
	<b>105.431</b>	3 mm speed welding nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle
	<b>105.432</b>	4 mm speed welding nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle
	<b>105.433</b>	5 mm speed welding nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle

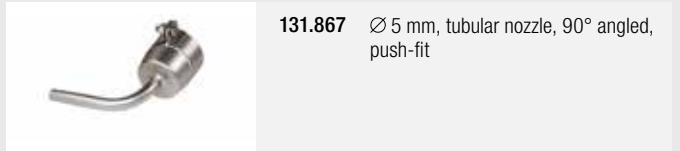


HOT JET S with angled nozzle welding a T-joint on the roof.



Fitting a solder shrink connection with the HOT JET S outfitted with a push-fit sieve reflector.

	<b>107.137</b> 8 mm speed welding nozzle for tape welding, push-fit on Ø 5 mm tubular nozzle
	<b>107.139</b> 4.5 x 12 mm speed welding nozzle for fillet weld, push-fit on Ø 5 mm tubular nozzle
	<b>107.324</b> 12 x 10 mm sieve reflector, push-fit on Ø 5 mm tubular nozzle
	<b>107.146</b> Ø 2 mm soldering nozzle
	<b>107.151</b> Ø 4 mm soldering nozzle
	<b>107.148</b> Ø 3 x 1.5 mm soldering nozzle, oval
	<b>107.310</b> 35 x 20 mm sieve reflector, push-fit
	<b>107.311</b> 50 x 35 mm sieve reflector, push-fit
	<b>107.312</b> 25 x 30 mm spoon reflector, push-fit
	<b>107.305</b> 15 x 25 mm ironing nozzle
	<b>143.831</b> Nozzle adapter for screw-on nozzles
	<b>114.734</b> Ski repair nozzle with base plate
	<b>100.818</b> 230 V / 435 W heating element
	<b>103.607</b> 120 V / 435 W heating element



**131.867** Ø 5 mm, tubular nozzle, 90° angled, push-fit

Small and handy: The HOT JET S is perfect when welding complicated details in billboard and tarpaulin applications.



# GHIBLI AW: Robust and ergonomic.

The GHIBLI AW is the robust and ergonomic heat gun used for shrink in cable manufacturing, heating and forming in the automobile industry, lap welding of truck sheeting and for deburring plastic parts. Thanks to the easy-to-grip, two-component frame, the GHIBLI AW fits perfectly in the hand. Temperature and air volume can easily be adjusted with the proven and intuitive "e-Drive" operating unit. The stand that is included in the scope of delivery and the

Heat gun

## GHIBLI AW

1		<b>Stand:</b> Thanks to the included stand, the GHIBLI AW can be placed in an optimum position at the workstation, thus reducing fatigue.	1
2		<b>Practical air filter</b> Regular cleaning of the air filters ensures optimum air flow and maximum power.	2
3		<b>Leister e-Drive</b> Temperature and air volume are easy to control and inspect with the proven "e-Drive" operating unit – for reproducible results.	3
4		<b>Fatigue-free working</b> Thanks to the integrated suspension lug, the GHIBLI AW can be suspended for fatigue-free work.	4
5		<b>Compatible</b> All of its predecessor's nozzles also fit on the GHIBLI AW. Comprehensive selection of compatible accessories.	5
6		<b>Ergonomic handling</b> The two-component handle and the perfect device balance ensure an optimal grip and comfortable work, even under the harshest of conditions.	6



practical device suspension make working easier. The air filters can be readily removed and cleaned. And of course, all of the nozzles from its predecessor fit the new GIBLI AW.



Shrink applications in cable manufacturing – ideal with the GIBLI AW

Heat gun

**GIBLI AW**



- Ergonomic heat gun
- Digital temperature control
- Five-stage air volume control
- "e-Drive" operating unit for optimum process control
- 100% Swiss Made

**Technical data**

Voltage	V~	230 / 120
Frequency	Hz	50 / 60
Power	W	2300 / 1800
Temperature	°C	65 – 620
Air volume (20°C)	l/min	310 – 400 (700 at max. temp)
Pressure static	Pa	1800 – 3200
Ø Nozzle holder	mm	36.5
Emission	dB(A)	67
Dimensions (L x W x H)	mm	280 x 220 x 90, Handle Ø 45
Weight	kg	1.1 (without power cord)
Conformity mark		CE
Approval mark		Ⓢ
Protection class II		□

**Article No.:**

- 148.061 GIBLI AW, 230 V / 2300 W, Euro plug
- 150.168 GIBLI AW, 230 V / 2300 W, UK plug
- 150.169 GIBLI AW, 230 V / 2300 W, CH plug
- 150.170 GIBLI AW, 120 V / 1800 W, CEE plug
- 148.079 GIBLI AW, 100 V / 1500 W, JP plug

Scope of delivery: GIBLI AW, case, stand, Operating Instructions

**Accessories for GIBLI AW**

	<b>106.998</b>	Wide slot nozzle 20 mm, push-fit
	<b>106.999</b>	Wide slot nozzle 40 mm, push-fit
	<b>107.154</b>	Tubular nozzle Ø 5 mm, push-fit
	<b>107.006</b>	Extension nozzle Ø 5 x 130 mm, straight
	<b>107.308</b>	Sieve reflector 50 x 35 mm
	<b>107.309</b>	Sieve reflector 35 x 20 mm
	<b>107.313</b>	Spoon reflector 25 x 30 mm, with screw connector
	<b>107.314</b>	25 x 30 mm spoon reflector, push-fit
	<b>107.319</b>	Sieve reflector Ø 65 mm
	<b>107.345</b>	Welding mirror 135 mm, push-fit
	<b>158.474</b>	Protection nozzle 36.5 mm, air outlet 23 mm, protection ring 80 mm
	<b>107.007</b>	Ø 37 mm Dehorning nozzle
	<b>106.132</b>	45 x 250 mm Shell reflector, push-fit
	<b>145.582</b>	Heating element, 230 V / 2200 W
	<b>145.580</b>	Heating element, 120 V / 1700 W

More at the new accessories catalog at

[www.leister.com/accessories](http://www.leister.com/accessories)

General accessories



# GHIBLI: "The hot-air gun".

GHIBLI, derived from a hot desert wind, certainly lives up to its name. Thanks to its two-step airflow switching and steplessly adjustable temperature, the GHIBLI can be used for the most diverse applications.



Shrinking cable connections with the GHIBLI.

## Hot-air hand tool

### GHIBLI



- Universal tool for welding and shrinking
- Welding results independent of voltage fluctuations and ambient temperature
- Two-step selectable airflow

#### Technical data

Voltage	V~	120 / 230
Frequency	Hz	50 / 60
Power	W	1500 / 2000
Temperature	°C	20 – 600
Air volume (20°C)	l/min	300 / 350 (530 at max. temp)
Ø Nozzle holder	mm	36.5
Emission	dB(A)	70
Size (L × W × H))	mm	195 × 85 × 160, Handle Ø 57
Weight	kg	0.9 (without power cord)
Conformity mark	CE	
Approval mark		
Protection class II		

#### Article No.:

- 101.881 GHIBLI 230 V / 2000 W with Euro plug
- 101.887 GHIBLI 120 V / 1500 W with US plug

Additional versions available upon request.

## Accessories GHIBLI

	<b>106.998</b>	20 mm wide slot nozzle, push-fit
	<b>106.999</b>	40 mm wide slot nozzle
	<b>107.154</b>	Ø 5 mm tubular nozzle, push-fit
	<b>107.006</b>	Ø 5 × 130 mm extension nozzle, straight
	<b>107.308</b>	34 × 50 mm sieve reflector
	<b>107.309</b>	20 × 35 mm sieve reflector
	<b>107.313</b>	25 × 30 mm spoon reflector, with screw connector
	<b>107.314</b>	25 × 30 mm spoon reflector, push-fit
	<b>107.319</b>	Ø 65 mm sieve reflector
	<b>158.474</b>	Protection nozzle 36.5 mm, air outlet 23 mm, protection ring 80 mm
	<b>107.007</b>	Ø 37 mm Dehorning nozzle
	<b>107.345</b>	135 mm welding mirror, push-fit
	<b>106.132</b>	150 × 25 mm Shell reflector, push-fit
	<b>115.513</b>	230 V / 1800 W heating element
	<b>101.850</b>	120 V / 1500 W heating element

More at the new accessories catalog at

[www.leister.com/accessories](http://www.leister.com/accessories)

General accessories

# HOTWIND: The new dimension.

Weighing just 2.2 kg, the HOTWIND can be used either as an integrated or bench-top device. The high maximum temperature of 650 °C means that the HOTWIND can be used in a variety of ways.



The HOTWIND is perfectly suited for drying and baking of print on plastic components.

Hot-air hand tool

## HOTWIND PREMIUM / SYSTEM



- Ideal for warming, heating, forming and drying
- Stepless adjustment of the heating and blower
- Integrated device and heating element protection
- Extremely smooth running
- Ideal for 24/7 operation

### Technical data

Voltage	V~	230
Power	W	3700
Temperature	°C	650
Size (L × W × H)	mm	332 × 106 × 179
Weight	kg	2.2 (without power cord)
Conformity mark	CE	
Approval mark	S	
Protection class II	□	

### Article No.:

142.609 HOTWIND PREMIUM, 230 V / 3700 W, with Euro plug  
 142.645 HOTWIND SYSTEM, 230 V / 3700 W, with Euro plug

Additional versions available upon request

## Accessories

### HOTWIND PREMIUM / SYSTEM

	Wide slot nozzle, push-fit (a × b)	
	<b>107.260</b>	85 × 15 mm
	<b>107.259</b>	150 × 12 mm
	<b>105.977</b>	200 × 9 mm
	<b>107.263</b>	250 × 12 mm
	<b>107.262</b>	300 × 4 mm
<b>105.992</b>	400 × 4 mm	
<b>105.991</b>	500 × 4 mm	
	<b>125.317</b>	Flange connector, push-fit a = 90 mm
	<b>107.335</b>	∅ 150 mm sieve reflector, push-fit
	<b>107.248</b>	Stainless steel filter, push-fit on air intake
	<b>141.723</b>	Hand tool kit (handle and protective tube)
	<b>143.530</b>	230 V / 3600 W heating element

# FORTE S3: Flameless shrinking.

The most powerful hot-air hand tool from Leister. The FORTE S3 is extremely well-suited for flameless shrinking of pallets and bulky goods.



Flameless shrink-wrapping of pallets and bulky goods with the FORTE S3.

Hot-air hand tool

## FORTE S3



- Powerful pallet shrink-wrapping
- Uniform shrinkage
- May be used in confined spaces
- Integrated tool stand

### Technical data

Voltage	V~	3 × 230	3 × 400
Power	kW	10	10
Temperature	°C	650	
Size (L × W × H)	mm	390 × 132 × 215	
Weight	kg	4.4 (without power cord)	
Conformity mark		CE	
Approval mark		Ⓢ	
Protection class II		□	

### Article No.:

102.027 FORTE S3, 3 × 400 V / 10 kW with 16A CEE plug

Additional versions available upon request

# AIRSTREAM ST: The quiet and efficient air supply unit.

With its plug & play functionality, all you need to do is plug in the AIRSTREAM ST for a constant supply of clean, dry air – for welding constructions with the highest cleanliness requirements. Also ideal for use in quiet environments. Need to work with two hand tools in parallel? No problem thanks to the simultaneous power and air supply. The unit includes a hand tool stand, fits into every work bench, and is fitted with castors for easy mobility. A highly practical solution!



**Dual operation:**  
The two tool connections enable parallel operation of two tools or offer the added flexibility of having a second hand tool ready for a subsequent work step.



**The quick-change artist:**  
It is easy to integrate into the existing environment thanks to its cubic design, and can also be fitted with additional castors for easy mobility. The practical cover can be used as a tool stand. The AIRSTREAM ST can be turned around to fit perfectly into any work bench.



**Quality is measurable:**  
If you know what you want, you need to be able to set the air volume using the air volume measuring device. The volume flow is crucial for the input of energy and has a direct influence on the quality of the weld.



**Logic for a longer service life:**  
When the unit is switched on, the hand tools are always supplied with air and power at the same time. In case of reaching the daily target or a significant pause in production, the AIRSTREAM ST prevents the connected tools from overheating by employing its integrated cool-down mode.





AIRSTREAM ST, the quiet air supply unit.

## Blower

## AIRSTREAM ST



- Quiet operating mode
- Cool-Down-Mode
- Low energy consumption
- Two hand tools can be connected
- Compatible mit WELDING PEN, DIODE and LABOR
- Flow meter
- Brushless technology

## Technical Data

Voltage	V~	230
Power	W	215
Frequency	Hz	50
Air volume	L/min	200 (Total)
Emission	L <sub>pA</sub> (dB)	< 48 (with 3 m hose)
Size (L × B × H)	mm	600 × 250 × 362 (with handle)
Weight	kg	24
Conformity mark		CE
Protection class I		⊕

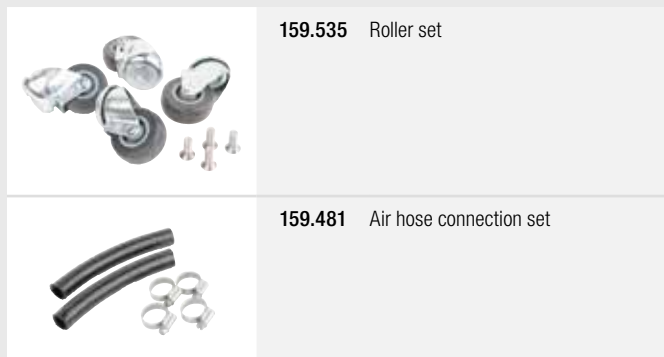
## Scope of delivery:

Air supply unit, hose transition pieces, clips, operating instructions

## Article-No.:

158.822 AIRSTREAM ST, 230 V/215 W, EU-plug

## Accessories AIRSTREAM ST



159.535 Roller set

159.481 Air hose connection set



Easy parallel operation.



A reliable companion.

## ROBUST: The powerhouse.

Versatile and operable at high ambient temperatures of up to 60 °C. Despite its small size, the ROBUST is a real powerhouse. This blower can simultaneously supply air for up to three hot-air hand tools.



ROBUST blower, serving as the external air supply for the WELDING PEN.

### Blower

## ROBUST



- High-performance, compact design
- Sound-suppression
- Can be integrated at any position
- Can be used as an external air supply to 1 WELDING PEN R or up to max. 3 DIODE S / PID or max. 3 LABOR S (with 107.281 hose adapter)


#### Technische Daten

Frequency	Hz	50	60
Power	W	250	250
Air volume (20 °C)	l/min	1200	1300
Static pressure	kPa	8.0	10.5
Max. ambient temperature	°C	60	60
Max. air inlet temperature	°C	60	60
Noise emission level	dB(A)	62	62
Protection (IEC 60529)		IP 54	IP 54
Outside diameter air inlet	Ø mm	38	38
Outside diameter air outlet	Ø mm	38	38
Weight	kg	8.0	8.0
Conformity mark		<b>CE</b>	<b>CE</b>
Protection class I		⊕	⊕

#### Artikel-Nr.:

Voltage V~	50 Hz	1 × 120	1 × 230	3 × 230 / 400
	60 Hz			3 × 440 – 480
Without cord	Article No.:	<b>103.434</b>		<b>103.429</b>
3 m cord / Euro plug	Article No.:		<b>103.432</b>	

## Accessories ROBUST

	<b>107.354</b> Stainless steel filter, push-fit on air intake
	<b>107.281</b> Ø 38 mm hose connection adapter, 3 output each 14 mm
	<b>113.859</b> Ø 14 mm air hose
	<b>101.031</b> Ø 14 mm hose clip for air hose

# WELDING PEN: Slim and flexible.

The WELDING PEN is a hot-air hand tool optimized for draw welding. Due to its slim design and swivelling external air supply it makes hard work easy.



WELDING PEN R combined with angle adapters make welding possible even in very tight spaces.

External air hand tool

## WELDING PEN R / WELDING PEN S



- Digital temperature display (WELDING PEN R)
- Connection makes working easier.
- Cooled heating element tube
- Used in combination with ROBUST blower or compressed air

Technical data		
Voltage	V~	230
Power	W	1000
Temperature	°C	20 – 600
Size (L x Ø)	mm	270 x 43, handle Ø 32
Weight	kg	1.0 (with 3 m cord / air hose and Y-connection)
Conformity mark	CE	
Protection class II	□	

Article No.:		
114.275	WELDING PEN S, 120 V / 600 W, with UK-plug, 2.5 m hose	
114.380	WELDING PEN R, 230 V / 1000 W, with Euro plug, 2.5 m hose	
113.081	WELDING PEN S, 230 V / 1000 W, with Euro plug, 2.5 m hose	
114.926	WELDING PEN R, 230 V / 1000 W, with Euro plug, 6 m hose	
114.274	WELDING PEN S, 230 V / 1000 W, with Euro plug, 6 m hose	
114.927	WELDING PEN R, 230 V / 1000 W, with Euro plug, 9 m hose	
114.273	WELDING PEN S, 230 V / 1000 W, with Euro plug, 9 m hose	

## Accessories WELDING PEN R / S

	105.622	Ø 5 mm tubular nozzle, 15° screw-on
	106.988	Tacking nozzle, screw-on
	113.666	Ø 3 mm round drawing nozzle with tacking tip, screw-on
	113.399	Ø 4 mm round drawing nozzle, with tacking tip, screw-on
	113.876	Ø 3 mm round drawing nozzle without tacking tip, screw-on
	113.874	Ø 4 mm round drawing nozzle, without tacking tip, screw-on
	113.670	Triangular drawing nozzle with tacking tip, screw-on, 5.7 mm, profile A
	113.877	without tacking tip, screw-on 5.7 mm, profile A
	106.986	without tacking tip, screw-on 7 mm, profile B
	106.987	without tacking tip, screw-on 7 x 5.5 mm
	126.552	Ø 4 mm drawing nozzle, screw-on for fluor plastics
	127.726	Angular adapter for screw-on nozzles, screw-on 30°
	127.727	45°
	141.375	Connection adapter M14 for Ø 21.3 mm nozzle with plug
	113.412	230 V / 1000 W heating element for WELDING PEN R and WELDING PEN S

Swiveling air hose for easy working.



More at the new accessories catalog at

[www.leister.com/accessories](http://www.leister.com/accessories)

General accessories

## DIODE PID / S: The powerful pair.

There are two options for high-quality work: The closed-loop DIODE PID provides the perfect welding temperature at all times. The DIODE S easily puts you in control with a manual temperature knob.



Convenient wire welding using the powerful and lightweight DIODE PID.

### External air hand tool

## DIODE PID / DIODE S



- Operated with MINOR or ROBUST blower or with compressed air
- Digitally controlled and displayed temperatures (DIODE PID)
- Cooled heating element tube
- Suitable for field applications when used in combination with a MINOR blower

#### Technical data

Voltage	V~	120 / 230
Power	W	1600
Temperature	°C	20 – 600
Size (L x Ø)	mm	265 x 57, handle Ø 40
Weight	kg	1.15 kg (with 3 m cord / 3 m air hose)
Conformity mark	CE	
Protection class II	□	

#### Article No.:

101.303 DIODE PID, 230 V / 1600 W, push-fit, with Euro plug  
 101.281 DIODE S, 230 V / 1600 W, push-fit, with Euro plug  
 101.304 DIODE PID, 230 V / 1600 W, screw-on, with Euro plug  
 101.282 DIODE S, 230 V / 1600 W, screw-on, with Euro plug  
 101.293 DIODE S, 120 V/1600 W for push-fit nozzles, with UK-plug

Additional versions available upon request

### Hand tool and blower

## DIODE PID / DIODE S with MINOR



MINOR blower and DIODE PID with screw-on drawing nozzle.

- Ideal for assembly work

#### Technical data

Voltage	V~	120 / 230
Power	W	1600
Temperature	°C	20 – 600
Size (L x Ø)	mm	265 x 57, handle Ø 40
Weight	kg	2.5 kg (with 3 m cord / 1.5 m air hose)
Conformity mark	CE	
Protection class II	□	

#### Article No.:

108.880 DIODE PID with MINOR, 230 V / 1700 W, screw-on, 1.5 air hose, Euro-plug  
 101.441 DIODE S with MINOR, 230 V / 1700 W, push-fit, 1.5 air hose, Euro-plug

Additional versions available upon request










The MINOR blower as an air supply for the DIODE PID.

## MINOR: The mobile air supplier.










Don't be deceived by the MINOR's small size and low weight. This blower delivers sufficient air to enable quality work with the DIODE PID / DIODE S or LABOR S.

### Accessories DIODE PID / DIODE S

#### With push-fit nozzle

	<b>100.303</b> Ø 5 mm tubular nozzle, for versions with nozzles, push-fit
	Speed welding nozzle, push-fit on Ø 5 mm tubular nozzle <b>106.992</b> 5.7 mm, profile A <b>106.993</b> 7 mm, profile B
	<b>106.989</b> 3 mm <b>106.990</b> 4 mm <b>106.991</b> 5 mm
	<b>156.470</b> 5 mm bent
	<b>106.996</b> Tacking nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>143.833</b> Nozzle adapter for screw-on nozzles
	<b>100.296</b> Heating element DIODE PID, 230 V / 1550 W <b>100.650</b> Heating element DIODE PID, 120 V / 1600 W <b>100.689</b> Heating element DIODE S, 230 V / 1550 W <b>100.702</b> Heating element DIODE S, 120 V / 1600 W

#### With screw-on nozzle

	<b>105.622</b> Ø 5 mm tubular nozzle, screw-on
	<b>106.988</b> Tacking nozzle, screw-on
	<b>113.666</b> Ø 3 mm round drawing nozzle with tacking tip, screw-on <b>113.399</b> Ø 4 mm round drawing nozzle, with tacking tip, screw-on <b>113.876</b> Ø 3 mm round drawing nozzle without tacking tip, screw-on <b>113.874</b> Ø 4 mm round drawing nozzle, without tacking tip, screw-on
	<b>113.670</b> Triangular drawing nozzle, with tacking tip, screw-on, 5.7 mm
	<b>113.877</b> Without tacking tip, screw-on 5.7 mm, profile A
	<b>106.986</b> Without tacking tip, screw-on 7 mm, profile B
	<b>106.987</b> 7 x 5.5 mm
	<b>126.552</b> 4 mm drawing nozzle, screw-on, for fluor plastics
	<b>141.375</b> Connection adapter M14 for Ø 21.3 mm nozzle with plug

#### Blower

### MINOR



- Lightweight and compact
- Powerful
- Serves as a mobile air supply for the DIODE PID / DIODE S and LABOR S
- Suitable for work on construction sites

#### Technical data

Voltage	V~	230
Power	W	100
Air volume (20°C)	l/min	400
Pressure static	Pa	4000 (40 mbar)
Air outlet (external)	mm	14.5
Size (L x Ø)	mm	250 x 95, handle Ø 64
Weight	kg	1.15 (with 3 m cord)
Conformity mark	CE	
Protection class II	□	

#### Article No.:

108.747	MINOR, 230 V / 100 W, with Euro plug
109.988	MINOR, 120V / 100W, with UK plug

Additional versions available upon request

More at the new accessories catalog at

[www.leister.com/accessories](http://www.leister.com/accessories)

# LABOR S: Small and handy.

Developed for laboratory use but also eminently suitable for small welding tasks where access is difficult.



LABOR S, used in combination with MINOR as an external air supply.

External Air Hand tool

## LABOR S



- Temperature adjustment via rotary knob
- Very small and handy device
- Ideal for draw welding and tacking
- Air supply with ROBUST blower, MINOR (p. 27) or with compressed air
- Ideal for mobile use when coupled with MINOR blower







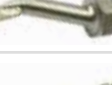





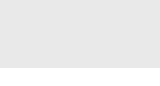






### Technical data

Voltage	V~	230
Power	W	800 / 900
Temperature	°C	20 – 600
Size (L x Ø)	mm	180, handle Ø 32
Weight	kg	0.15 (without air hose and without cord)
Conformity mark		CE
Approval mark		Ⓢ
Protection class II		Ⓜ

### Article No.:

- 101.716 LABOR S with connection box, 230 V / 800 W with Euro plug, air hose 3 m
  - 101.754 LABOR with MINOR blower, 230 V / 900 W with Euro plug, air hose 1.5 m
- Additional versions available upon request

## Accessories LABOR S

	107.144	Ø 5 mm tubular nozzle, push-fit
	106.992 106.993 106.989 106.990 106.991 156.470	Speed weld nozzle, push-fit on Ø 5 mm tubular nozzle 5.7 mm, profilee A 7 mm, profilee B 3 mm 4 mm 5 mm 5mm bent
	106.996	Tacking nozzle, push-fit on Ø 5 mm tubular nozzle
	143.831	Nozzle adapter for screw-on nozzles
	107.146	Ø 2 mm soldering nozzle
	107.151	Ø 4 mm soldering nozzle
	107.148	Ø 3 x 1.5 mm soldering nozzle, oval
	105.622	Ø 5 mm tubular nozzle, screw-on
	106.988	Tacking nozzle, screw-on
	113.666	Ø 3 mm round drawing nozzle with tacking tip, screw-on
	113.399	Ø 4 mm round drawing nozzle, with tacking tip, screw-on
	113.876	Ø 3 mm round drawing nozzle without tacking tip, screw-on
	113.874	Ø 4 mm round drawing nozzle, without tacking tip, screw-on
	113.670	Triangular drawing nozzle, with tacking tip, screw-on, 5.7 mm
	113.877	Without tacking tip, screw-on 5.7 mm, profile A
	106.986	Without tacking tip, screw-on 7 mm, profile B
	106.987	7 x 5.5 mm
	126.552	4 mm drawing nozzle, screw-on, for floor plastics
	101.581	230 V / 800 W heating element

More at the new accessories catalog at

[www.leister.com/accessories](http://www.leister.com/accessories)

General accessories

34/35





The new «Groovy» gouging tool is also perfectly suited for floor joints.

Hot-air hand tools

General accessories

	<b>106.974</b> 80 mm silicone pressure roller		<b>160.015</b> Cable extension cord 15 m PUR 5 x 2.5 mm2, with CEE 400V plug
	<b>140.160</b> 40 mm silicone pressure roller with ball bearings (silicone)		<b>159.239</b> Cable extension cord 15 m PUR 3 x 2.5 mm2, with EU plug 230V
	<b>140.599</b> Spare roll for 140.160		<b>106.997</b> Ø 6 mm rotary burr for drilling machine, for car repairs
	<b>140.161</b> Pressure roller 28 mm, with ball bearings (silicone)		<b>116.798</b> Brass brush
	<b>140.598</b> Spare roll for 140.161		<b>142.647</b> Brass brush Ø 3 mm
	<b>106.976</b> 28 mm pressure roller (PTFE)		<b>107.348</b> Tool rest for TRIAC AT, TRIAC ST, ELECTRON ST
	<b>106.972</b> Brass pressure roller with ball bearings		<b>103.401</b> Tool rest for HOT JET, LABOR S
	<b>106.981</b> Pressure roller for custom seal		<b>137.855</b> Leister cutter with four spare blades
	<b>138.314</b> Seam probe tester for overlap seams		<b>138.902</b> Hooked blade for LEISTER-cutter (10 dispenser with 10 pcs=100 pcs)
	<b>111.346</b> Chamfer planer with seven spare blades, for sealing sheets		<b>138.539</b> Straight-edge blade for LEISTER-cutter (10 dispenser with 10 pcs = 100 pcs)
	<b>111.348</b> Spare blades kit containing ten blades		<b>151.382</b> Inside corner tool
	<b>106.966</b> Hand grooving tool		<b>153.009</b> Plastfix
	<b>106.968</b> Spare blades for hand grooving tool		<b>154.259</b> Scraper blade
	<b>151.188</b> Chamfer planer for T-joints for sealing sheets		<b>154.026</b> Contour scraper
	<b>152.676</b> Weld seam template		<b>116.586</b> Storage case for TRIAC AT, TRIAC ST, ELECTRON ST
	<b>157.544</b> Leister Universal scissors 260 mm with special shaft grinding		
	<b>160.353</b> Cable cord roller 25 m PUR 5 x 2.5 mm2, with 1 x CEE 400V and 2 x EU socket 230V		
	<b>161.152</b> Cable cord roller 25m PUR 5x2.5mm2, with 1x CEE 400V and 2x T23 CH socket 230V		
	<b>161.207</b> Cable cord roller 25m PUR 5x2.5mm2, with 1x CEE 400V and 2x Typ E with ground pin socket 230V		

More at the new accessories catalog at

[www.leister.com/accessories](http://www.leister.com/accessories)



## Welding rods

Article		Profile	Colour	kg
<b>Welding accessories PE</b>				
104.283	HDPE welding rod	A	■	3
104.294	HDPE welding rod	A	□	3
104.284	HDPE welding rod	B	■	5
104.299	HDPE welding rod	B	□	5
106.650	HDPE welding band	C	□	1
104.300	LDPE welding rod	A	■	3
161.612	HDPE welding rod	D	■	2
116.918	PE100 welding rod	D	■	2
<b>Welding accessories PP</b>				
104.287	PP welding rod	A	■	3
104.301	PP welding rod	A	■	3
104.288	PP welding rod	B	■	5
126.356	PP welding band	C	□	2
161.611	PP welding rod	D	■	2
<b>Welding accessories PVC</b>				
104.296	PVC-U welding rod (hard)	A	□	3
104.278	PVC-U welding rod (hard)	A	■	3
106.641	PVC-U welding rod	A	■	3
104.280	PVC-U welding rod (hard)	B	■	5
104.279	PVC-U welding rod (hard)	B	■	5
104.302	PVC-P welding rod (soft)	A	□	3
<b>Welding accessories ABS</b>				
104.295	ABS welding rod	A	□	3
113.587	ABS welding rod	A	■	3
107.027	ABS welding band	C	□	1

## Profile sizes

Dimensions in mm

Profile A	Profile B	Profile C	Profile D

Article		Profile	Colour	kg
<b>Welding accessories div.</b>				
104.297	PA welding rod	A	■	3
104.298	PC welding rod	A	□	3
104.313	PC welding rod / ABS / ALPHA (Honda)	A	■	3
104.308	PUR welding rod	A	■	3
106.654	Xenoy welding band	C	■	2
106.642	PPs welding rod, flame resistant	A	■	3
104.304	PVDF welding rod	A	□	3
104.303	POM welding rod	A	□	3
<b>Test bundles</b>				
107.036	Test bundle bodywork welding rods, each consisting of profile A pieces of 37 cm single marked 6x HDPE, 6x PP, 6x PA, 6x PC, 6x ABS, 6x PCABS / ALPHA Honda, 6x PC / PBTP / Xenoy	A		
107.037	Test bundles standard each consisting of profile A pieces of 37 cm single marked 5x PVC-U, 5x PVC-P, 5x PP, 5x ABS, 5x HDPE, 3x PC, 3x PA, 3x POM, 3x LDPE, 3x PC / ABS / ALPHA Honda, 3x PC / PBTP / Xenoy	A		
107.040	Test bundle welding band each consisting of profile A pieces of 37 cm single marked 9x HDPE, 8x 2 mm white, 9x PP, 8x 2 mm natural, 9x ABS, 8x 2 mm white, 9x PC / PBTP / Xenoy grey	C		





Aldi logistics center 50000m2 TPO Membrane, Switzerland



Exploration Place First, Wichita, USA



Schöni transport Centre, Switzerland

## Roofing

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Simple operation in combination with high welding performance.



Flameless welding of modified bitumen with the BITUMAT. B2.

## Overview Roofing Welders

				
<b>Materials</b>	Thermoplastic Single-Ply membranes			Modified Bitumen
<b>Type of welding machine</b>	UNIROOF AT/ST	VARIMAT V2 / VARIMAT S	TRIAC DRIVE AT with guide	BITUMAT B2
<b>Main application</b>	Parapets, edges Residential construction surfaces under 500 m2	Welding close to edges Industrial surfaces over 500 m2	Cramped conditions, vertical parapets, round welds (for ventilation pipes)	First bitumen layer
<b>Roof construction</b>				
Flat roof	✓✓✓	✓✓✓	✓✓✓	✓✓✓
Sloped roof	✓✓	✓	✓✓	✓
Basic weld seams	✓✓	✓✓✓	✓	✓✓✓
Detail work	✓✓✓	✓	✓✓✓	✓
<b>Thickness of sealing sheets</b>	up to 1.8 mm	up to 2 mm / 1.8 mm	up to 1.8 mm	up to 6 mm
<b>Special features</b>	Ideal for roof edge welding	Double welding performance against competitors	Vertical welding	Flameless welding
<b>Parapet spacing in mm</b>	100	110	40	200
<b>Generator operation</b>	At least 6 kW to supply a hot air hand tool	At least 10 kW to supply a hot air hand tool		
<b>Electronics</b>				
Regulated for drive and blowers (closed-loop system)	X	VARIMAT V2	× (blower)	
Controlled for drive and blowers (open loop)	UNIROOF ST - closed-loop (drive)	VARIMAT S	× (drive)	X
<b>Speed m/min.</b>				
Drive	1 – 10	0.7 – 12	0.5 – 3	0.8 – 12
Welding speed (depending on material)	2 – 3	4 – 8	1.5 – 3	3 – 6
Recommended welding start parameter depending type of membrane (tested by room condition 20°C)	<b>UNIROOF AT</b> PVC: 2.0 m/min, 520°C, air volume 100% TPO: 2.5 m/min, 450°C, air volume 100% <b>UNIROOF ST</b> PVC: 1.8 m/min, 520°C, air volume 100% TPO: 2.0 m/min, 450°C, air volume 100%	<b>VARIMAT V 2</b> PVC: 4.0 m/min, 550°C, air volume 85% TPO: 5.0 m/min., 500°C, air volume 100% <b>VARIMAT S:</b> PVC: Temperature level 8.5–9 (550°C) TPO: No trailing roller, can only be used to limited degree	TPO: Stufe 2.5 (1.5 m/min. 380°C, air volume 100%)  PVC: Stufe 1.5 (1 m/min. 400°C, air volume 100%)	nozzle till 100 mm  Modified Bitumen: 5.0 m/min, 650°C, air volume 100%
<b>Weight kg</b>	17.5	35 / 28	4	40
<b>Blower technology</b>	Brushless	Brushless / Brush motor	Brush motor	Brush motor
<b>Catalog page</b>	 39-41	42/43	45	46

✓✓✓ = Highly suitable, ✓✓ = Suitable, ✓ = Limited suitability

# UNIROOF AT/ST: Welding close to the edge made easy.

The new UNIROOF AT/ST roof welder is your flexible partner for welding thermoplastic roofing membranes on flat or pitched roofs (up to 30°). Thanks to its slim design and construction, as well as the movable transport axle, converting of the machine is no longer needed. Now, you can effortlessly weld close to the edge (to 100 mm) at the parapet or on the parapet and as easily in narrow circumstances.

Hot-air welder

## UNIROOF AT/ST



**No more time consuming converting:** The ultra slim roof welding machine with its movable transport axle masters welding close to the edge (up to 100 mm) at or on the parapet, and wherever it gets narrow.



**UNIROOF provides elaborate ergonomic handling thanks to steering bar and handle:** Roll or carry the UNIROOF whenever, wherever you want to, it's so handy!



**UNIROOF AT: The closed-loop technology** for drive motor, temperature and air blower keeps the welding parameters at a constant level and thus delivers reliably leak proof results – a clear asset when it comes to process reliability and investment safety.



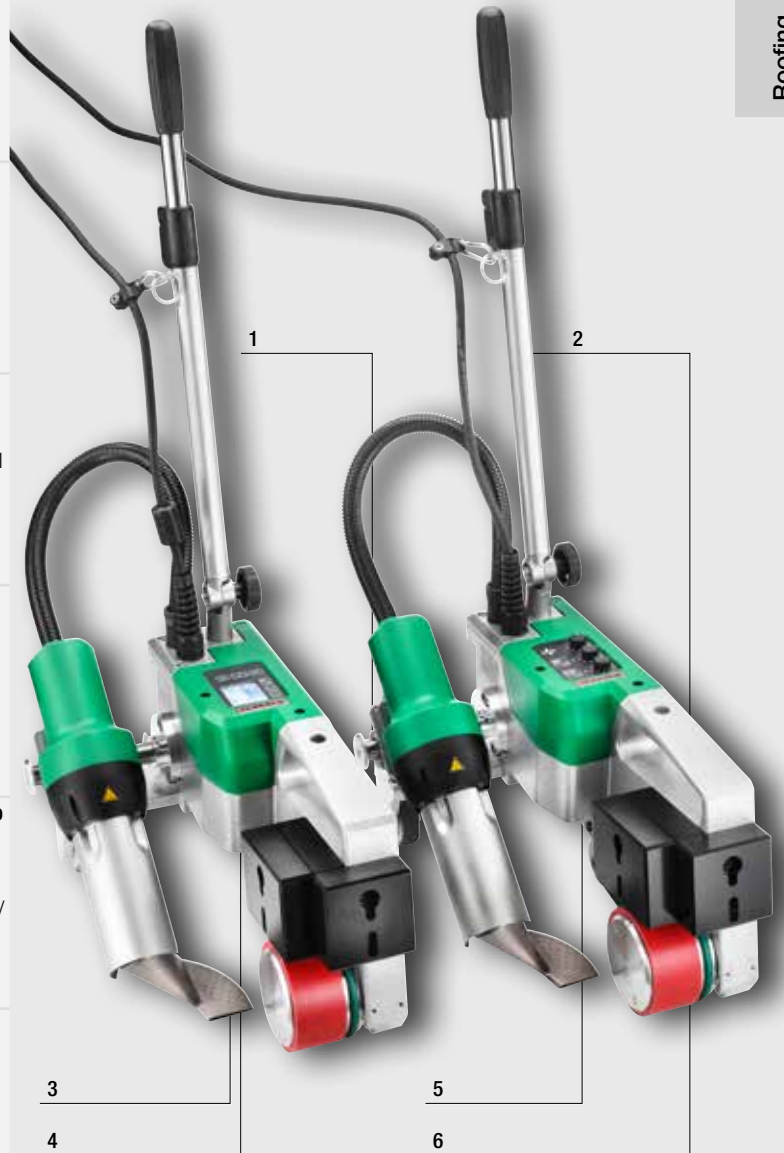
**UNIROOF AT: Functional control panel with display** for welding parameters (set point and actual figures during runtime) as well as voltage for better control. Save time with programmable welding profiles for common roof membranes.



**UNIROOF ST for purists: Closed-loop controlled drive motor with open-loop technology** for the control of temperature and air blower. Simple control (regulation) with potentiometer/rotary knobs.



**Optimum overall performance and easy-to-operate:** The direct-driven, maintenance-free pressure wheel [brushless drive motor integrated in pressure wheel] leads to higher contact pressure, welding speed and thus causes zero chain wear.



Roofing

With 3450 W performance, 230 V and 15 Amps in the box, the UNIROOF AT/ST offers speedy top performance on any roof.



Thanks to its ultra slim design, the UNIROOF welds effortlessly even in areas which are narrow and difficult to access.

Hot-air welder

## UNIROOF AT



- No retooling, thanks to movable transportation axle
- Maintenance-free direct drive and closed-loop technology
- Ergonomic handling, flexible relocating and optimal machine guiding
- 66% higher welding performance compared to similar machines
- Welding roof structure profiles

Technical Data		UNIROOF AT
Voltage	V~	100 / 220 – 240
Frequenz	Hz	50/60
Power	W	1500 / 3450
Temperature, stepless	°C	100 – 620
Air flow range	%	45 – 100
Drive speed, stepless	m/min	1.0 – 10.0
Size (L × B × H)	mm	475 × 244 × 260
Weight	kg	17.5 (incl. 3 additional weights)
Materials		PP, PVC, TPO, ECB, EPDM, EVA, FPO, PO, PIB (other materials upon request)
Conformity mark		<b>CE</b>
Protection class I		⊕
Fan		maintenance-free
Operation		Digital with display
Temperature control		Closed-loop System

### Article No.:

- 153.598 UNIROOF AT, 220 – 240 V / 3450 W, 40 mm, with Euro-plug
- 153.599 UNIROOF AT, 120 V / 1800 W, 40 mm (1.6 inch), with US-plug
- 157.188 UNIROOF AT, 230 V / 3450 W, 30 mm with Euro-plug

Hot-air welder

## UNIROOF ST



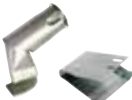
- No retooling, thanks to movable transportation axle
- Maintenance-free direct drive and open-loop technology
- Ergonomic handling, flexible relocating and optimal machine guiding
- 38% higher welding performance compared to similar machines
- Welding roof structure profiles

Technical Data		UNIROOF ST
Voltage	V~	100 / 220 – 240
Frequenz	Hz	50/60
Power	W	1500 / 3450
Temperature, stepless	°C	100 – 620
Air flow range	%	45 – 100
Drive speed, stepless	m/min	1.0 – 10.0
Size (L × B × H)	mm	475 × 244 × 260
Weight	kg	17.5 (incl. 3 additional weights)
Materials		PP, PVC, TPO, ECB, EPDM, EVA, FPO, PO, PIB (other materials upon request)
Conformity mark		<b>CE</b>
Protection class I		⊕
Fan		brush motor
Operation		Potentiometer
Temperature control		Open-loop System

### Article No.:

- 153.600 UNIROOF ST, 220 – 240 V / 3450 W, 40 mm, with Euro-plug
- 157.189 UNIROOF ST, 230 V / 3450 W, 30 mm with Euro-plug
- 153.601 UNIROOF ST, 120 V / 1800 W, 40 mm (1.6 inch), with US-plug

## Accessories UNIROOF AT/ST

	<b>155.414</b> Roof structure profile kit
	<b>155.325</b> Grip-nozzle 40 mm
	<b>149.597</b> spring plate
	<b>152.742</b> Additional weight, front
	<b>152.741</b> Additional weight, lateral
	<b>154.462</b> Nozzle calibration device
	<b>132.429</b> 2 welding plates for optimum welding start
	<b>138.817</b> Steelbrush to clean nozzle
	<b>154.522</b> Transportation axle 300 mm
	<b>152.706</b> Transportation axle 220 mm for radius welding
	<b>154.827</b> Storage case UNI
	<b>155.577</b> Locking plate for additional weights
	<b>137.843</b> T-shape guide bar

	<b>108.129</b> T-shape guide bar upper part
	<b>156.446</b> UNIROOF AT/ST 80 mm bitumen kit
	<b>155.473</b> Heating element 230 V / 3300 W
	<b>153.947</b> Heating element 120 V / 1800 W
	<b>154.231</b> Heating element 100 V / 1500 W
	<b>145.604</b> Heating element 120 V / 2300 W*
	* Suitable for undervoltage so that the temperature can be reached



versatile, easy to maintain, efficient.

# VARIMAT V2: Fast and dependable.

Using the new VARIMAT V2, polymer roofing membranes can be welded more rapidly resulting in lower cost. Users appreciate its streamlined ergonomics and its ease of use. The clearly laid out operating unit's "e-Drive" allows for the control of all relevant weld parameters.



Highly reliable in application even at undervoltage.

Hot-air welder

## VARIMAT V2



- Process reliability: Machine cuts out if undervoltage is too high
- Patented spherical roller compensates unevenness
- Guide bar for ergonomic handling
- Maintenance free blower means lower service costs
- User-friendly display with "e-Drive" (press and turn control) to recall preset and saved welding settings
- Constant drive with regulated electronics






### Technical data

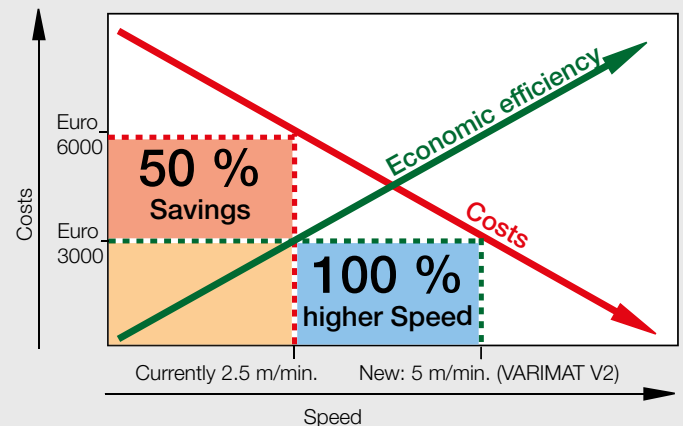
Voltage	V~	230 / 400
Power	W	3680 / 5700
Temperature	°C	100 – 600
Speed	m/min	0.7 – 12
Air flow range	%	50 – 100
Width of welding nozzle	mm	40
Size (L x W x H)	mm	640 x 430 x 330
Weight	kg	35
Conformity mark		CE
Protection class I		⊕

### Article No.:

- 138.108 VARIMAT V2, 230 V / 3680 W, Euro plug, storage case
- 137.821 VARIMAT V2, 400 V / 5700 W, 16 A CEE-plug, storage case
- 141.572 VARIMAT V2, 230 V / 3680 W, with 80 mm nozzle for bitumen, Euro plug, device case
- 153.428 VARIMAT S, 230 V / 4600 W, Euro-plug
- 153.427 VARIMAT S, 400 V / 5700 W, CEE-plug

## Accessories VARIMAT V2

1		<b>Ergonomic</b> Height and angle of guide-bar can be adjusted easily
2		<b>Maintenance-free</b> High performance and brushless blower motor, no brushes to change
3		<b>Intuitive</b> Protected design. Easy-to-view display with "e-drive" and easy-to-store welding settings
4		<b>Weld seam control</b> The green air dam belt keeps the hot air in the welded seam. <b>High speed</b> New welding nozzle with protected design for reliable welding quality
5		<b>More stability</b> The patented pressure roller smoothes out any unevenness





Welded with standard nozzle.



Welded with grip nozzle 25% higher weld seam strength. Mainly for TPO sealing sheets.

	<b>113.995</b> Grip-nozzle 30 mm for TPO / FPO single plies
	<b>113.600</b> Grip-nozzle 40 mm for TPO / FPO single plies
	<b>110.805</b> 20 mm overlap welding nozzle for thermoplastic sealing sheeting
	<b>107.067</b> Additional weight for even more pressure
	<b>139.048</b> Sturdy storage case 720 × 470 × 450 mm plywood, green included with purchase
	<b>107.649</b> Replacement rolls
	<b>132.429</b> 2 welding plates for optimum welding start included with purchase
	<b>138.817</b> Steel brush to clean nozzle included with purchase
	<b>146.514</b> Solar profile kit for Renolit
	<b>143.162</b> Gentle pressure roller for difficult ground conditions
	<b>119.111</b> Chuck cone for replacing silicone pressure roller
	<b>151.530</b> Mirror welding kit, nozzle right, for special welding applications
	<b>107.612</b> Heating elements 230 V / 4400 W
	<b>107.613</b> 400 V / 5500 W

	<b>143.179</b> Complete set with rake nozzle, 40 mm, and pressure roller, soft 40 mm  Rake nozzle to solve the problems caused by bubbles forming on hard surfaces.
	<b>116.323</b> Rake nozzle, 40 mm
	<b>143.163</b> Pressure roller, soft, 40 mm (silicone only)
	<b>108.923</b> Welding unit bitumen-kit 80 mm, 230 V
	<b>108.924</b> Welding unit bitumen-kit 100 mm, 230 V
	<b>108.925</b> Welding unit bitumen-kit 120 mm, 230 V
	<b>108.927</b> Welding unit bitumen-kit 100 mm, 400 V / 6100 W
	<b>108.928</b> Welding unit bitumen-kit 120 mm, 400 V / 6100 W
	<b>115.892</b> Welding unit bitumen-kit 80 mm, 400 V / 6100 W
	<b>159.408</b> Nozzle positioning gauge VARIMAT V2



# TRIAC DRIVE AT: The all-purpose hot-air tool.

The unique, semi-automatic welding tool. The flexible concept makes the TRIAC DRIVE AT an all-around tool that is universal in use.

## Semi-automatic hot-air tool

### TRIAC DRIVE AT



- More consistent and up to three times faster than manual welding
- Unique semi-automatic welding tool
- Automatic welding in areas inaccessible to other tools
- With welding guide, inside nozzle or outside nozzle, the unit is suitable for all roofing applications and other areas of use












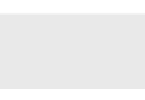

#### Technical data

Voltage	V~	230
Power	W	1700
Temperature	°C	40 – 650
Speed	m/min.	0.5 – 3
Size (L × W × H)	mm	300 × 230 × 380
Weight (with 3 m cable)	kg	4.1
Conformity mark	CE	
Protection class II	□	

#### Article No.:

- 117.331 TRIAC DRIVE AT 230 V / 1700 W, without guide, nozzle inside, 30 mm, without grip, Euro plug
- 117.332 TRIAC DRIVE AT 230 V / 1700 W, with guide, nozzle inside, 30 mm, without grip, Euro plug
- 117.333 TRIAC DRIVE AT 230 V / 1700 W, with guide nozzle inside, 30 mm, without grip, Euro plug, with extension for parapet welding
- 148.605 TRIAC DRIVE AT, 230V / 1700 W, without guide, inside nozzle 38 mm, without grip, pressure roller steel, Euro plug
- 148.606 TRIAC DRIVE AT, 230 V / 1700 W, without guide, inside nozzle 12 mm, with grip, pressure roller steel, Euro plug

### Accessories TRIAC DRIVE AT

	<b>115.274</b>	12 mm pressure roller, steel
	<b>115.176</b>	30 mm pressure roller, steel
	<b>115.712</b>	40 mm pressure roller, steel
	<b>115.857</b>	30 mm pressure roller, silicone
	<b>115.921</b>	40 mm pressure roller, silicone
	<b>115.276</b>	Support carrier single, brass
	<b>107.552</b>	Support carrier duplex, Silicon
	<b>138.570</b>	Transport roller 12 mm, silicone
		Overlap welding nozzle, inside, push-fit
	<b>115.283</b>	12 mm, with grip
	<b>115.279</b>	30 mm, with grip
	<b>115.281</b>	38 mm, with grip
	<b>115.699</b>	12 mm, without grip
	<b>115.701</b>	30 mm, without grip
	<b>115.703</b>	38 mm, without grip
		Overlap welding nozzle, outside, push-fit
	<b>115.282</b>	12 mm, with grip
	<b>115.278</b>	30 mm, with grip
	<b>115.280</b>	38 mm, with grip
	<b>115.700</b>	30 mm, without grip
	<b>115.702</b>	38 mm, without grip
	<b>138.549</b>	Guide for TRIAC DRIVE AT, for easy horizontal welding, e.g. for parapets
		115.700 Overlap welding nozzle 30 mm, outside, push-fit, without grip (included with purchase)
	<b>142.422</b>	Guiding help with extension for parapet
	<b>142.413</b>	Extension bar for extension on parapet
	<b>108.985</b>	Storage case (included with purchase)
	<b>142.717</b>	Heating element, 230 V / 1550 W, for TRIAC AT

## BITUMAT B2: The flameless.

Welding of modified bitumen sheeting (SBS, APP) with the flameless BITUMAT B2 is much safer than welding with an open flame. The weld strength is significantly better and the single step process makes welding more economical.



Easy unit guidance and clean working with the BITUMAT B2.

Hot-air welder

### BITUMAT B2



- Flameless welding of modified bitumen
- No shrinking of the insulation due to integrated air dam
- Uniform welding results
- High working speed
- Requires only one user to efficiently weld seams (torch welding requires two)







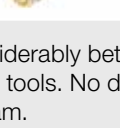

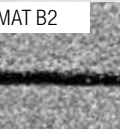


#### Technical data

Voltage	V~	230 / 400
Power	W	6700 / 6700
Temperature	°C	20 – 650
Speed	m/min	0.8 – 12
Air flow range	%	85 – 100
Welding nozzle width	mm	75 / 100 / 120
Size (L x W x H)	mm	690 x 490 x 330
Weight	kg	40 (with cable)
Conformity mark		CE
Approval mark		Ⓢ
Protection class I		Ⓜ

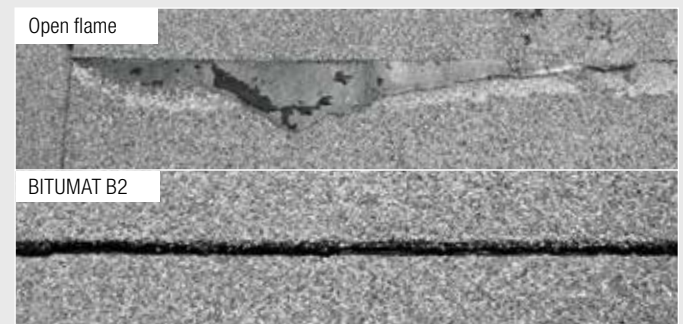
#### Article No.:

- 140.438 BITUMAT B2 400 V / 6700 W, 75 mm, 16 A-CEE-plug
  - 140.437 BITUMAT B2 400 V / 6700 W, 100 mm, 16 A-CEE-plug
  - 140.436 BITUMAT B2 230 V / 6700 W, 75 mm, 32 A-CEE-plug
  - 138.386 BITUMAT B2 230 V / 6700 W, 100 mm, 32 A-CEE-plug
- Additional versions available upon request.

### Accessories BITUMAT B2

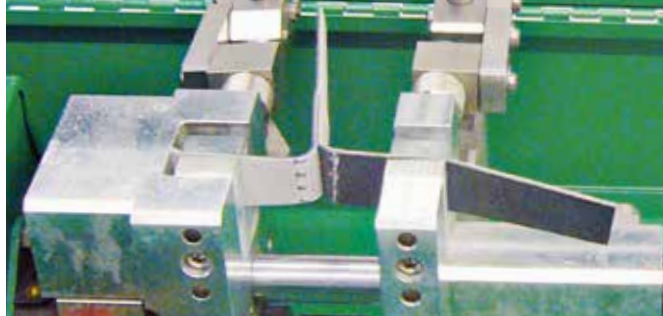
	<b>138.048</b>	75 mm bitumen nozzle
	<b>138.047</b>	100 mm bitumen nozzle
	<b>137.895</b>	100 mm pressure roller with gap
	<b>137.896</b>	75 mm pressure roller with gap
	<b>140.229</b>	100 mm pressure roller without gap
	<b>140.228</b>	75 mm pressure roller without gap
	<b>156.447</b>	80 mm silicon pressure roller
	<b>158.222</b>	100 mm silicon pressure roller
	<b>140.476</b>	Lifting device
	<b>155.328</b>	BITUMAT B2 120 mm bitumen kit
	<b>140.489</b>	Sturdy storage case, 750 x 555 x 450 mm (included with purchase)
	<b>126.594</b>	Heating elements 400 V / 6500 W
	<b>126.386</b>	230 V / 6500 W

Considerably better welding results when compared with open flame tools. No damage to insulating material due to integrated air dam.



# EXAMO USB: The inspector.

Is the welding seam sealed and can it withstand the specified peel, tensile and shear forces? EXAMO performs tests at the construction site – quick, reliable and uncomplicated.



Testing a weld seam with the EXAMO USB.

## Testing instrument EXAMO USB



- Handy, robust and reliable
- Testing of elongation, peak force, tear force, test speed and position
- Construction-site approved

### Technical Data

Type		300F	600F
Voltage	V~	230	230
Power	W	200	200
Tensile load	N	4000	4000
Range	mm	300	600
Test speed	mm/min	20 – 550	20 – 550
Sample thickness	mm	max. 7	max. 7
Sample width	mm	max. 40 (60 optional)	max. 40 (60 optional)
Size (L x W x H)	mm	750 x 270 x 190 (storage case)	1050 x 270 x 190 (storage case)
Weight	kg	14	17.5
Conformity mark		CE	CE
Approval mark		Ⓢ	Ⓢ
Protection class I		Ⓛ	Ⓛ

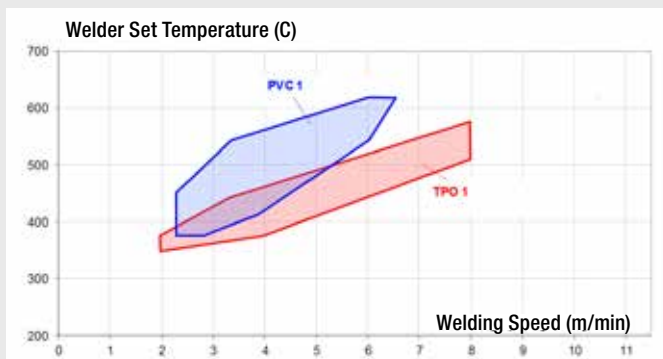
### Article No.:

- 139.059 EXAMO 300F USB, 230 V / 200 W, incl. USB memory stick, Euro plug  
 139.060 EXAMO 600F USB, 230 V / 200 W, incl. USB memory stick, Euro plug

## Accessory EXAMO USB

	<b>134.832</b> Testing and calibration kit To test and calibrate your EXAMO USB
	<b>144.416</b> USB memory stick

Leister offers a service to create a welding window. With new sealing sheets in particular, it is important to have the right starting parameters.



Typical welding windows for TPO and PVC



For testing T-joints

### Article No.:

- 153.026 VACUUM BELL Ø 320 mm  
 153.024 VACUUM PUMP 230V  
 153.025 VACUUM PUMP 120V



HEMTEK ST  
made in Switzerland

HEMTEK  
ST  
1000  
1000  
1000



Truck cover



Awning



Flood protection

## Technical Textiles & Industrial Fabrics

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## Hot-Air Hand Tools

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Billboard




## Stationary welding machine

				
Device type	HEMTEK ST	HEMTEK K-ST	SEAMTEK 900 AT	SEAMTEK W-900 AT
Max. voltage V~	120 / 230	120 / 130	230 / 240	230 / 240
Max. power W	1800 / 2350 / 3450	1800 / 2350	4500	3900
Temperature °C	100 - 650	100 - 650	120 - 700	0 - 680
Speed m/min	0.8 - 12	0.8 - 12	0.1 - 30	0 - 30
Welding width mm	20 / 30 / 40	8	8 - 64	8 - 64
Size (L × W × H) mm	433 × 350 × 600	433 × 350 × 600	1500 × 702 × 1500	1700 × 702 × 1500
Weight kg	27.0	27.0	268.0	238.0
<b>Welding options</b>				
Overlap welding	✓		✓	✓
Hem welding	✓		✓	✓
Piping welding	✓	✓	✓	✓
Tape welding	✓		✓	✓
Prayer weld			✓	✓
Hem pipe	✓		✓	✓
Butt joint with tape			✓	✓
<b>Welding technologies</b>				
Hot-air welding	✓	✓	✓	
Hot-wedge welding				✓
<b>Features</b>				
Temperature regulation			✓	✓
Drive regulation			✓	✓
Temperature and drive infinitely adjustable	✓	✓	✓	✓
Digital display			✓	✓
Catalog page	 52 / 53	54 / 55	56 / 57 / 60	58 - 60



Tents

## Product overview hot-air welders for Technical Textiles & Industrial Fabrics

						
Device type	VARIANT T1 Overlap	VARIANT T1 TAPE 50 mm	VARIANT T1 TAPE 25 mm	UNIPLAN E / S	TAPEMAT 50 mm	TAPEMAT SPRIEGEL 100 / 125 mm
Max. voltage V~	230 / 400	230 / 400	230 / 400	230	3 × 400	3 × 400
Max. power W	3680 / 5700	3680 / 5700	3680 / 5700	2300	10 000	10 000
Temperature °C	100 – 620	100 – 620	100 – 620	80 – 620	100 – 650	100 – 650
Speed m/min	1.5 – 18	1.5 – 18	1.5 – 18	1.0 – 7.5	4.0 – 20	4.0 – 20
Welding width mm	20 / 40	50	25	20 / 30	50	2 × 20
Size (L × W × H) mm	500 × 400 × 195	700 × 415 × 85	700 × 415 × 85	420 × 270 × 210	555 × 435 × 370	555 × 435 × 370
Weight kg	22.5	28.0	28.0	11.5	35.0	40.0
Conformity mark	CE	CE	CE	CE	CE	CE
Certification scheme	CCA	CCA	CCA	CCA	CCA	CCA
Protection class	II	II	II	II	II	II
<b>Welding options</b>						
Overlap welding	✓			✓		
Hem welding	✓			✓		
Piping welding	✓			✓		
Tape welding		✓	✓		✓	✓
Prayer weld	✓	✓	✓	✓	✓	✓
Hem pipe	✓	✓	✓	✓	✓	✓
<b>Welding technologies</b>						
Hot-air welding	✓	✓	✓	✓	✓	✓
Hot-wedge welding						
<b>Features</b>						
Temperature regulation	✓	✓	✓	✓		
Drive regulation	✓	✓	✓	✓		
Temperature and drive infinitely adjustable	✓	✓	✓	✓	✓	✓
Digital display	✓	✓	✓	✓		
Catalog page	 62 / 63	64	64	65	66	66

# HEMTEK ST: Hem Welding has never been so easy.

The HEMTEK ST is designed for a wide range of applications and is particularly intuitive to use. Once the machine is mounted, you can start welding immediately. Preparing or finishing with hot-air hand tools is no longer necessary. From now on, you can quickly weld promotional banners or tarpaulins from corner-to-corner with ease.

## Hot-air Welding machine

### HEMTEK ST



**Hem guide:**  
Three applications possible with one hem guide: Hem (20/30/40 mm); Pole pocket up to 100 mm; Piping.



**Table clamp:**  
The quick-clamp lock enables you to mount the machine quickly and easily onto almost any work table.



**Control panel:**  
The intuitive control unit guarantees a stress-free welding experience. Temperature, speed and airflow can easily be adjusted. Integrated cooldown mode gently cools the machine.



**Foot pedal:**  
The HEMTEK ST can be operated comfortably with the foot pedal so that both hands are free to guide the material.



**Pressure roller:**  
Thanks to the integrated weight, pressure can be adjusted steplessly. The roller incorporates high contact pressure with an intelligent eccentric system. Various nozzle widths and rollers for specific applications are available.



Thanks to the foot pedal, both hands are free to guide the material. High weld quality and stress-free welding experience guaranteed.



Whether sitting or standing, the HEMTEK ST can be used at almost any work table.

## Hot-air Welding machine

### HEMTEK ST

- Welding speeds of up to 12 m per minute
- Very strong blower
- Tool-free setting of the hem guide
- One hem guide, three applications:  
Hem: 20/30/40 mm; Pole pocket: up to 100 mm; Piping
- Easy-to-use: Thanks to the foot pedal, your hands are free to guide the material
- Everything in a single step: No need to weld with hot-air hand tools afterwards
- All welding parameters are adjustable
- Cooldown mode
- Can be mounted onto almost any table: freely adjustable quick-clamp lock

Technical data		120 V		230 V	
Voltage	V~	120	230	230	230
Frequency	Hz	50/60	50/60	50/60	50/60
Power	W	1800	3450	3450	2350
Temperature, stepless	°C	100 – 650			
Air quantity, stepless		1 – 10			
Drive, stepless	m/min	0.8 – 12			
Welding width	mm	20/30/40	30/40	20	
Emission	L <sub>pA</sub> (dB)	70 (K = 3 dB)			
Size (L × W × H)	mm	433 × 350 × 600			
Weight	kg	27 (Including table mount)			
Conformity mark		CE	CE	CE	
Protection class I		⊕	⊕	⊕	












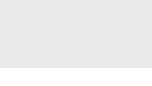
#### Included with purchase:

Hot-air welder, table mount, hem guide, scraper, silicone stopper, operating instructions, general catalog, folder

#### Article No.:

- 157.862 HEMTEK ST, 230 V/2350 W, 20 mm, EU-plug
- 157.861 HEMTEK ST, 230 V/3450 W, 30 mm, EU-plug
- 157.860 HEMTEK ST, 230 V/3450 W, 40 mm, EU-plug
- 157.868 HEMTEK ST, 230 V/2350 W, 20 mm, UK-plug
- 157.867 HEMTEK ST, 230 V/3450 W, 30 mm, UK-plug
- 157.866 HEMTEK ST, 230 V/3450 W, 40 mm, UK-plug

## Accessories HEMTEK ST

	<b>157.048</b> 20 mm <b>157.047</b> 30 mm <b>108.117</b> 40 mm	Pressure roller, top
	<b>157.070</b> 20 mm <b>157.071</b> 30 mm <b>161.202</b> 40 mm	Pressure roller, bottom
	<b>157.707</b> 20 mm <b>157.706</b> 30 mm <b>157.705</b> 40 mm	Nozzle
	<b>157.098</b>	Nozzle adjustment gauge
	<b>156.472</b>	Adjustable hemming/piping guide
	<b>157.879</b>	Adjustable hemming/piping guide for heavy materials
	<b>155.800</b>	Overlap guide
	<b>159.780</b>	Tape welding guide
	<b>160.269</b>	Contact pressure weight large
	<b>153.947</b> 120V/1800W (20/30/40 mm) <b>149.675</b> 230V/2200W (20 mm) <b>155.473</b> 230V/3300W (30/40 mm)	Heating elements
	<b>157.540</b>	Rubber stoppers
	<b>116.798</b>	Brass brush

# HEMTEK K-ST: Piping creation made easy

Based on your individual needs, you can produce your own piping with the HEMTEK K-ST. Because the HEMTEK K-ST is extremely flexible, you can react even faster to specific customer inquiries. The easy-to-use, infinitely-adjustable guide enables process-reliable piping creation with different lug widths. The foot pedal means you have both hands free and can use them to guide the material. This allows you to concentrate fully on the welding process.

Hot-air welder

## HEMTEK K-ST



**Piping guide:**  
Process-secure, easy guidance of the piping cord up to 13mm for optimum results.



**Control panel:** The intuitive control unit guarantees a stress-free welding experience. The temperature and speed can be adjusted easily. The integrated cool-down mode gently cools the machine.



**Table clamp:**  
The quick-clamp lock enables you to mount the machine quickly and easily onto any work table.



**Foot pedal:** The HEMTEK K-ST can be operated comfortably with the foot pedal so both hands are free to guide the material.





You can operate the HEMTEK K-ST at any work table – sitting or standing.

## Hot-air welder

### HEMTEK K-ST

- Piping creation made easy
- Lug width infinitely adjustable
- Piping diameter 3-13 mm
- Up to 12 m/min
- Quick and easy installation of the machine
- Thanks to the foot pedal, you can use both hands to guide the material and piping. High welding quality and a stress-free welding experience are guaranteed.

Technical Data		120 V	220 – 240 V
Voltage	V~	120	230
Frequency	Hz	50/60	50/60
Power	W	1800	2350
Temperature, stepless	°C	100 – 650	
Drive, stepless	m/min	0.8 – 12	
Welding seam width	mm	8	
Emission	L <sub>pA</sub> (dB)	70 (K = 3 dB)	
Size (L × B × H)	mm	433 × 350 × 600	
Weight	kg	27 (including table fastening)	
Conformity mark		CE	CE
Protection class I		⊕	⊕

**Scope of delivery:**  
Hot-air welder, table fastening console, flap piping guide, operating instructions, main catalog, folder

**Article no.**  
162.499 HEMTEK K-ST, 230 V / 2350 W, EU plug  
162.605 HEMTEK K-ST, 120 V / 1800 W, US plug

## Accessories

	<b>163.796</b> Modification kit K-ST
	<b>161.202</b> Pressure roller below 40 mm
	<b>161.259</b> Flap-piping nozzle 8 mm
	<b>163.798</b> Nozzle adjustment gauge
	<b>160.749</b> Double flap-piping guide
	<b>149.675</b> Heating element 230 V / 2200 W
	<b>116.798</b> Brass brush

### Piping kits for converting HEMTEK ST to HEMTEK K-ST

Existing	Required for HEMTEK K-ST (piping production)		
HEMTEK ST	Modification kit K-ST 163.796	Pressure roller below 161.202	Heating element 230 V / 2200 W 149.675
157.862 20 mm EU plug	•	•	
157.861 30 mm EU plug	•	•	•
157.860 40 mm EU plug	•	•	•
157.868 20 mm UK plug	•	•	
157.867 30 mm UK plug	•	•	•
157.866 40 mm UK plug	•	•	•
157.871 20 mm US plug	•	•	
157.870 30 mm US plug	•	•	
157.869 40 mm US plug	•		

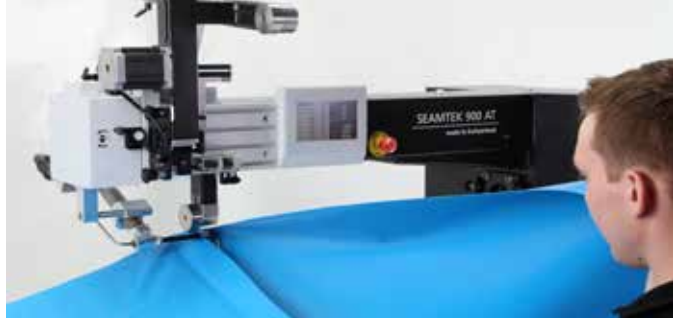
# SEAMTEK 900 AT: New Generation

The intelligent construction of the SEAMTEK 900 AT makes practically any welding application possible. Thanks to the well-thought-out multi-arm system, the machine can be set to a specific configuration for the application in record time. The huge selection of various drive wheels, nozzles and guides guarantees maximum flexibility. The intuitive operation of the user interface takes place entirely via touchscreen and permits simple adjustment of the regulated parameters.

1		<p><b>Intuitive</b></p> <ul style="list-style-type: none"> <li>• All parameters can be modified via touchscreen</li> <li>• Complete regulation of all parameters</li> </ul>
2		<p><b>Application-friendly</b></p> <ul style="list-style-type: none"> <li>• Tool-free nozzle adjustment</li> <li>• Rapid wheel replacement</li> </ul>
3		<p><b>Pedestal</b></p> <ul style="list-style-type: none"> <li>• Overlap welding</li> <li>• Hem and piping welding</li> <li>• 3D / Inflatable welding</li> <li>• Tape welding</li> </ul>
4		<p><b>Quickarm</b></p> <ul style="list-style-type: none"> <li>• Endless welding of pipes and hoses</li> <li>• Overlap welding</li> </ul>
5		<p><b>Sidearm</b></p> <ul style="list-style-type: none"> <li>• Circumference welding</li> <li>• Tape welding</li> <li>• Sealing of end caps</li> <li>• Strip welding</li> </ul>
6		<p><b>Tape Delivery System</b></p> <ul style="list-style-type: none"> <li>• Application of seam sealing tape</li> <li>• Welding of reinforcement tape</li> <li>• Welding of hot melt adhesive tape</li> </ul>



Leister SEAMTEK 900 AT



Easy, economical and safe welding.

**Welding machine**

**SEAMTEK 900 AT**



- Multi-arm system guarantees great flexibility
- Digitally regulated welding parameters
- Intuitive user interface
- Quiet operation
- Test mode for rapid parameter determination
- Drive wheels and guides can be quickly changed
- Maintenance-free and durable





**Technical data**

Voltage	V~	230 / 240
Power	W	4500
Temperature	°C	120 – 700
Speed		0.1 – 30
Size (L × W × H)	mm	1500 × 702 × 1500
Weight	kg	238 kg Base 268 kg Fully loaded
Required air pressure	bar	6.2
Welding seam width	mm	8 – 64

**Article No.:**

- 155.555 SEAMTEK 900 AT Base version with pedestal, 2 steel pressure rollers 25 mm, standard nozzle 25 mm
- 155.777 Quick arm
- 155.666 Side arm
- 155.888 Tape Delivery System (TDS)
- 156.314 Transport Box

**Accessories SEAMTEK 900 AT**

	Wheel, Steel, Ø 63.5 mm
	155.392 8 mm
	155.393 13 mm
	155.863 19 mm
	154.593 25 mm
	155.864 38 mm
	155.394 50 mm
155.865 57 mm	
154.619 64 mm	
	SEAMTEK Nozzle
	157.808 8 mm (Low Flow)
	157.799 13 mm (Low Flow)
	151.598 13 mm
	151.601 19 mm
	151.597 25 mm
	151.608 38 mm
	151.599 50 mm
151.850 55 mm	
151.600 64 mm	
	152.941 Closing nozzle with angle
	152.956 Hem nozzle



SEAMTEK 2000 AT (2 m frame) available, delivery time on request.

Technical Textiles and Industrial Fabrics

General accessories



# SEAMTEK W-900 AT: Variable speed for maximum efficiency

Based on the proven SEAMTEK W-900AT is this the first machine worldwide with this new and innovative low voltage wedge technology. With the genuine innovation of variable speed during welding process, this machine will change your welding experience. Weld the best possible, highest quality seams. Meet the world champion in efficiency.

1		<b>Innovation</b> <ul style="list-style-type: none"><li>• Changeable speed during welding process like a sewing machine</li><li>• Automatic temperature adjustment according to your speed</li><li>• High efficiency, up to 680°C (1,256°F)</li></ul>	
2		<b>Save a lot of money</b> <ul style="list-style-type: none"><li>• Nearly no energy consumption while in stand-by mode</li><li>• Far less energy consumption than comparable machines</li><li>• Affordable replacement wedges</li></ul>	
3		<b>Ready in a few seconds</b> <ul style="list-style-type: none"><li>• No pre-heat needed</li><li>• Wedge heats up instantaneously after starting the welding process</li></ul>	
4		<b>Safe and simple</b> <ul style="list-style-type: none"><li>• Slow down the speed for difficult product sections</li><li>• Once disengaged (or in stand-by mode), the wedge cools immediately and reduces any risk of burning</li></ul>	
5		<b>Great seam results</b> <ul style="list-style-type: none"><li>• Get flat and precise seams, even when welding curves</li><li>• Weld sensitive materials easily without waves and wrinkles</li></ul>	

Leister SEAMTEK W-900 AT





New, innovative welding wedge solution.

**Welding machine**

**SEAMTEK W-900 AT**



**Accessories SEAMTEK W-900 AT**

3D wedge bracket	
	162.854 8 mm
	162.847 13 mm
	162.846 19 mm
	162.700 25 mm
	162.809 38 mm
	162.818 50 mm
	162.829 57 mm
	162.837 64 mm
HS Wedge bracket	
	163.172 8 mm
	163.173 13 mm
	163.174 19 mm
	163.175 25 mm
	163.176 38 mm
	163.177 50 mm
	163.178 57 mm
	163.179 64 mm

Technical Textiles and Industrial Fabrics

- Quick change fastener for changing welding widths
- Multi-arm system with pedestal and quick arm
- Welding parameters digitally regulated
- Intuitive user interface
- Practically silent
- Compressed air connection not required

**Technical data**

Voltage	V~	230 / 240
Power	W	3900
Temperature	°C	0 – 680
Speed		0 – 30
Size (L × W × H)	mm	1700 × 702 × 1500
Weight	kg	238
Welding seam width	mm	8 – 64

**Article No.:**

- 159.159 SEAMTEK W-900 AT with pedestal and a power supply (without welding rollers and wedge adapter)
- 155.777 Quick arm
- 155.888 Tape Delivery System (TDS)












Inflatables (picture © Marek Ullasz | Dreamstime.com)

General accessories



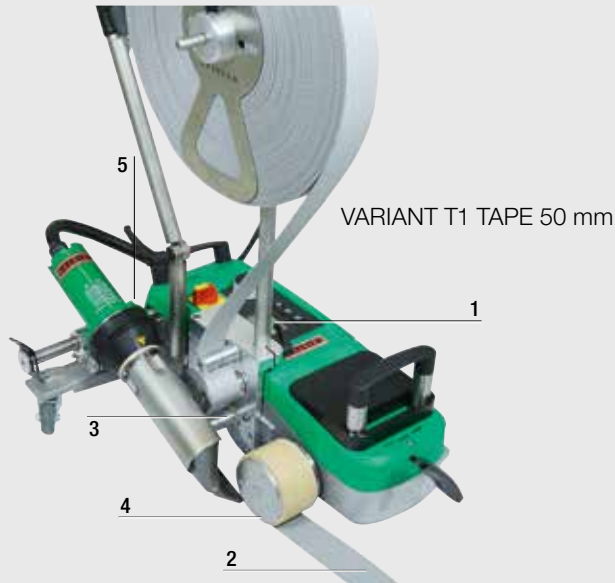
## Accessories SEAMTEK 900 AT / SEAMTEK W-900 AT

	<p>Wheel, Silicone, 50A, Ø 63.5 mm</p> <p><b>155.401</b> 13 mm  <b>155.402</b> 19 mm  <b>155.403</b> 25 mm  <b>155.404</b> 38 mm  <b>155.405</b> 50 mm  <b>155.406</b> 57 mm  <b>155.407</b> 64 mm</p>		<p><b>155.400</b> Holder system for guides</p>
	<p><b>155.660</b> Adjustable overlap guide, 0 - 64 mm</p>		<p><b>156.780</b> Overlap guide for quick arm</p>
	<p><b>155.530</b> Adjustable hem-/ piping guide 0 - 50 mm</p>		<p><b>155.410</b> Connection adapter for fume extraction</p>
	<p><b>155.760</b> Adjustable hem-/ piping guide 0-60 mm, for heavy materials</p>		<p><b>158.789</b> Tape cutting unit 18 - 25 mm</p>
	<p><b>155.380</b> Open Hem/Pocket Guide up to 110 mm</p>		<p><b>158.928</b> Puller unit</p>
	<p><b>155.540</b> Modular 3D guide</p>		<p><b>159.389</b> Adjustable Pedestal table</p>
	<p><b>156.760</b> Overlap guide from the left</p>		
	<p><b>156.770</b> Adjustable acrylic tape guide</p>		



# VARIANT T1: Quality, productivity, ergonomic.

The robust VARIANT T1 is very versatile. It is used in various applications for hem, overlap and tape welding. VARIANT T1 convinces with its high working speed, particularly with vehicle tarpaulin production for welding lap, reinforcement and anti-vandalism tapes. Thanks to the "e-Drive" operating concept, setting the relevant welding parameters could not be easier.



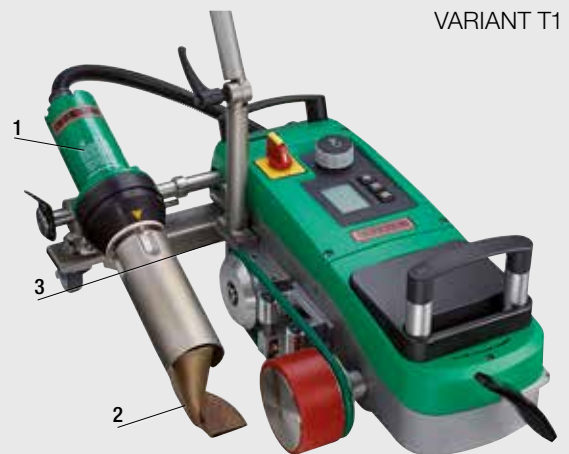
VARIANT T1 TAPE 50 mm

## VARIANT T1

1		<p><b>Economical:</b> Up to 18 m/min welding speed and powerful, maintenance-free hot air blower.</p>
2		<p><b>Reliable:</b> Constant, wrinkle-free welds thanks to process-optimised nozzle.</p>
3		<p><b>Hem- / piping welding kit:</b> Welding hems, hem pockets and piping in short time with easy-to-use accessories.</p>

## VARIANT T1 TAPE

1		<p><b>User-friendly:</b> Clear display plus "e-Drive" and storable welding parameters.</p>
2		<p><b>Highly flexible:</b> Conversion kits make it possible to work with different types of tape: 50 mm reinforcement and 25 mm anti-vandalism tapes (see image).</p>
3		<p><b>Feeding to perfection:</b> The new guide rollers make it easy to position the material and keep it taut right up to the final centimeter.</p>
4		<p><b>Dual-action:</b> The pressure roller can easily be converted from a 50 mm width to a 25 mm one (anti-vandalism tape) or vice versa.</p>
5		<p><b>Optional:</b> The laser guide keeps the VARIANT T1 TAPE firmly on course.</p>



VARIANT T1

## VARIANT T1: Compact, fast and reliable.

This tool's top welding speed of up to 18 m/min and its slim, compact design make it a winning choice.



Very easy hem and piping welds with the hem / piping welding kit.

Hot-air welder

### VARIANT T1 Overlap



- Top welding speed up to 18m/min
- Perfect view into the weld seam
- Sturdy and durable for professional use
- Smooth lifting device for precise positioning
- Simple operation due to "e-Drive" operating concept

#### Technical data

Voltage	V~	230 / 400 (3LNPE)
Power	W	3680 / 5700
Temperature	°C	100 – 620
Speed	m/min	1.5 – 18
Air flow range	%	40 – 100
Welding seam width	mm	20 or 40
Size (L × W × H)	mm	500 × 400 × 195
Weight	kg	22 (without 1.5 m cord)
Conformity mark		CE
Protection class I		⊕

#### Article No.:

141.891	VARIANT T1, 230 V / 3680 W, 40 mm nozzle, with Euro plug
141.892	VARIANT T1, 230 V / 3680 W, 20 mm nozzle, with Euro plug
141.893	VARIANT T1, 400 V / 5700 W, 40 mm nozzle, with CEE plug (3LNPE)
141.894	VARIANT T1, 400 V / 5700 W, 20 mm nozzle, with CEE plug (3LNPE)
156.145	VARIANT T1, 230 V / 3680 W, 40 mm, nozzle, with CEE 3-16 plug

Additional versions available upon request.

### Accessories VARIANT T1 Overlap

	<b>142.650</b>	Hem / piping welding kit complete, comprising:
	<b>142.221</b>	Hold-down device
	<b>141.326</b>	Piping roll
	<b>140.530</b>	Hem / piping add-on part
	<b>148.961</b>	Conversion kit, VARIANT T1 Overlap to VARIANT T1 TAPE 25 mm
	<b>148.962</b>	Conversion kit, VARIANT T1 Overlap to VARIANT T1 TAPE 50 mm
	<b>160.850</b>	Weight bracket complete
	<b>161.297</b>	Overlap kit 50 mm
	<b>159.899</b>	Impeller adjustable
	<b>139.438</b>	Additional weight 3 kg
	<b>116.798</b>	Brass brush
	<b>140.771</b>	Overlap welding nozzle 20 mm
	<b>141.558</b>	Overlap welding nozzle 40 mm
	<b>140.429</b>	25 mm pressure roller complete
	<b>138.938</b>	45 mm pressure roller complete
	<b>142.705</b>	Sturdy storage case
	<b>107.612</b>	Heating elements 230 V
	<b>107.613</b>	Heating elements 400 V



An economical, ergonomic tool for welding reinforcement tapes.

## Tape hot-air welder

### VARIANT T1 TAPE



VARIANT T1 TAPE 25 mm, anti-vandalism

- Fastest, most precise automatic tape welding tool (up to 18 m/min)
- "e-Drive" operating unit
- Easy to use
- Taut tape guidance
- Kits for converting VARIANT T1 Overlap to 25 or 50 mm TAPE

#### Technical data











Voltage	V~	230 / 400
Power	W	3680 / 5700
Temperature	°C	100 – 620
Air flow range	%	50 – 100
Speed	m/min	1.5 – 18
Welding seam width	mm	50 oder 25
Size (L x W x H)	mm	700 x 415 x 85
Weight	kg	28 (with 3 m cord)
Conformity mark	CE	
Protection class I	⊕	

#### Article No.:

148.963	VARIANT T1 TAPE 25	mm, 230 V / 3680 W, with Euro plug
148.964	VARIANT T1 TAPE 50	mm, 230 V / 3680 W, with Euro plug
148.965	VARIANT T1 TAPE 25	mm, 400 V / 5700 W, with Euro plug
148.966	VARIANT T1 TAPE 50	mm, 400 V / 5700 W, with Euro plug

Additional versions available upon request.

### Accessories VARIANT T1 TAPE

	<b>149.652</b>	Conversion kit VARIANT T1 TAPE 25 mm to VARIANT T1 TAPE 50 mm: 1 nozzle, 4 guide rollers, 1 gauge
	<b>149.653</b>	Conversion kit VARIANT T1 TAPE 50 mm to VARIANT T1 TAPE 25 mm: 1 nozzle, 4 guide rollers, 1 gauge
	<b>149.654</b>	Conversion kit VARIANT T1 TAPE to VARIANT T1 Overlap 20 mm
	<b>149.655</b>	Conversion kit VARIANT T1 TAPE to VARIANT T1 Overlap 40 mm
	<b>149.100</b>	Magnetic tool holder
	<b>149.344</b>	Laser guide
	<b>139.438</b>	Additional weight 3 kg
	<b>116.798</b>	Brass brush
	<b>160.189</b>	Anti-vandal tape
	<b>107.612</b> <b>107.613</b>	Heating elements 230 V 400 V

# UNIPLAN: Just perfect.

The small, lightweight and handy hot-air welder produces perfect welding results. UNIPLAN E is electronically controlled for reproducible results.



The handy partner for precise welding: UNIPLAN E.

## Hot-air welder

### UNIPLAN E / UNIPLAN S



UNIPLAN E

- Small, lightweight and handy
- High welding speed
- Reproducible welding results (UNIPLAN E)
- Handy, robust case included in delivery
- Digital display (UNIPLAN E)

#### Technical data

Voltage	V~	230
Power	W	2300
Temperature	°C	80 – 620
Speed	m/min	1.0 – 7.5
Air flow range	%	50 – 100 (for UNIPLAN E steplessly)
Welding seam width	mm	20 oder 30
Size (L × W × H)	mm	420 × 270 × 210
Weight	kg	11.5 (with 3 m cord)
Conformity mark	CE	
Protection class I	⊕	

#### Article No.:

114.221	UNIPLAN E 20 mm, 230 V / 2300 W, with Euro plug
114.318	UNIPLAN E 30 mm, 230 V / 2300 W, with Euro plug
115.049	UNIPLAN S 20 mm, 230 V / 2300 W, with Euro plug
115.050	UNIPLAN S 30 mm, 230 V / 2300 W, with Euro plug
156.288	UNIPLAN E 30mm, 230 V / 2300 W, UK-plug

Additional versions available upon request.

## Accessories UNIPLAN E / UNIPLAN S

	<b>115.065</b>	20 mm overlap welding unit
	<b>115.066</b>	30 mm overlap welding unit
	<b>115.067</b>	Weight with holder
	<b>115.839</b>	Handle with holder and screws
	<b>119.933</b>	20 mm hem welding kit
	<b>119.934</b>	30 mm hem welding kit
	<b>122.013</b>	Hem cord welding kit with lifting (for units built prior to 2003)
	<b>122.016</b>	Hem cord welding kit without lifting (for units built from 2004)
	<b>147.836</b>	Guide bar complete
	<b>116.798</b>	Brass brush to clean nozzle
	<b>126.448</b>	Sturdy storage case included with purchase
	<b>103.604</b>	230 V / 2100 W heating element, for UNIPLAN E
	<b>101.910</b>	230 V / 2100 W heating element, for UNIPLAN S

# TAPEMAT: The power pack.

For rapid, economical strip welding of truck covers and industrial curtains. Very fast strip welder at up to 20 meters per minute.



Welding tape at maximum speed.

Tape hot-air welder

## TAPEMAT



- High welding speed
- Process-optimized nozzle
- Maintenance-free, brushless blower
- Intuitive operation and simple handling

Sprigel hot-air welder

## TAPEMAT SPIEGEL



- Top welding speed
- Process-optimized, high-precision nozzle
- Maintenance-free, brushless blower
- Easy to exchange counter-pressure roller
- Constant tarpaulin bow tension

## Accessories

### TAPEMAT / TAPEMAT SPIEGEL

Technical data		TAPEMAT	TAPEMAT SPIEGEL
Voltage	V~	3 × 400	3 × 400
Power	kW	10	10
Temperature	°C	~ 650	~ 650
Speed	m/min	4 – 20	4 – 20
Welding seam width	mm	50	100 / 125
Size (L × W × H)	mm	555 × 435 × 370	555 × 435 × 370
Weight	kg	35	40
Conformity mark		CE	CE
Approval mark		Ⓢ	Ⓢ
Protection class I		Ⓢ	Ⓢ

#### Article No.:

- 129.757 TAPEMAT 50 mm, 400 V / 10 kW, with 16A CEE plug
- 138.229 TAPEMAT Spriegel 100 mm, 400 V / 10 kW, with 16A CEE plug
- 133.597 TAPEMAT Spriegel 125 mm, 400 V / 10 kW, with 16A CEE plug

	<b>138.242</b> Lifting device
	<b>131.690</b> TAPEMAT 50 mm welding nozzle
	<b>137.412</b> TAPEMAT SPIEGEL 100 mm welding nozzle, complete weld seam 20 mm left and right
	<b>135.392</b> 125 mm welding nozzle, complete weld seam 20 mm left and right
	<b>101.991</b> 3 × 400 V / 3 × 3300 W heating element

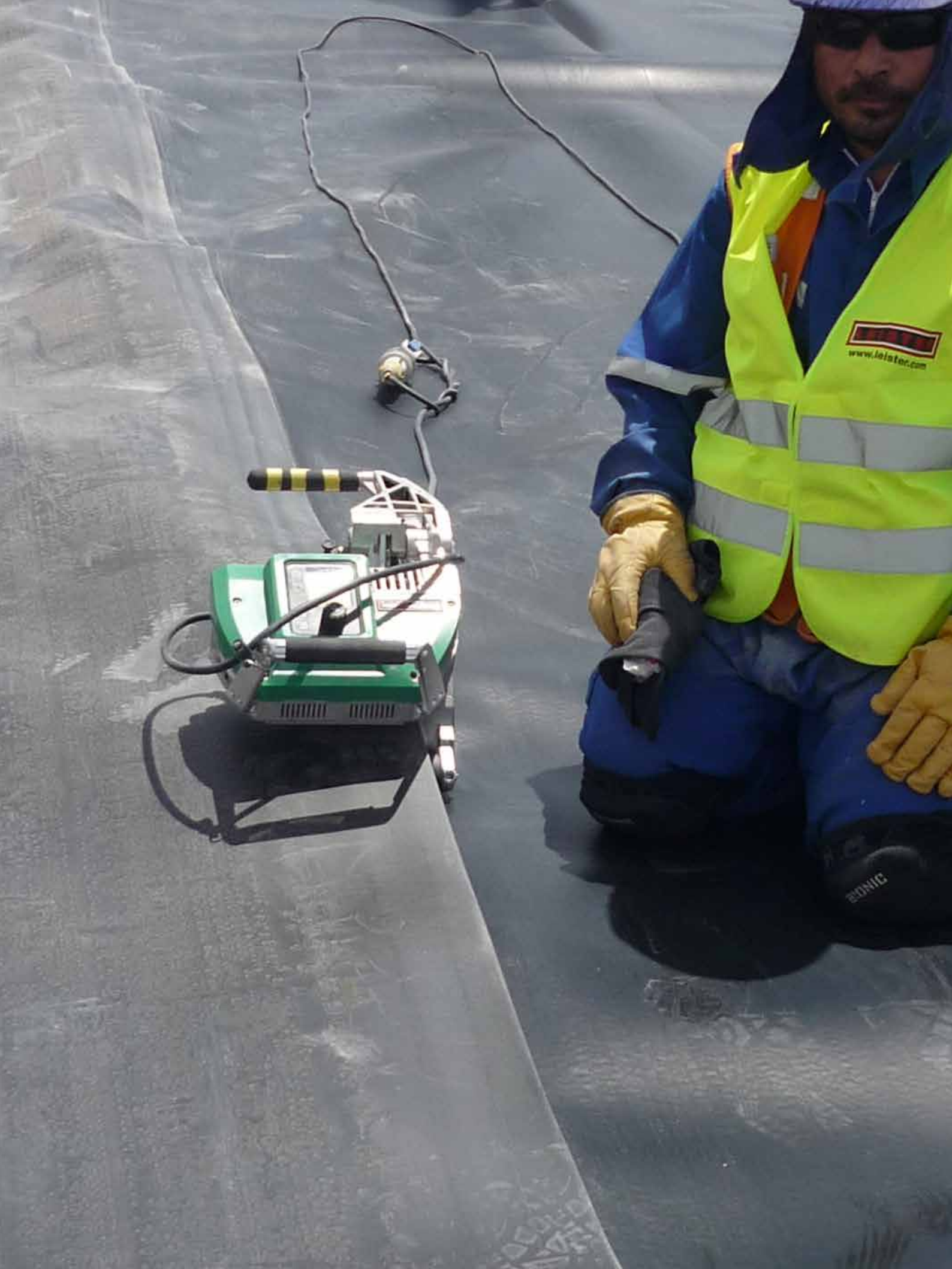


BAHNSPIRACIA

IL CIELO DEI SOSPIRI

IL CIELO DEI SOSPIRI







Shrimp Farm HDPE 0.5 mm



Tunnel PVC 2.5 mm



Water Reservoir HDPE 2.0 mm

## Civil Engineering / Tunneling / Landfills

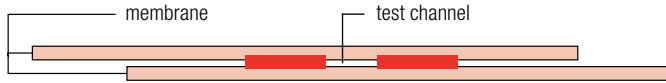
Product overview wedge welder	70
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GEOSTAR G7 LQS / GEOSTAR G5 LQS	74 / 75
COMET / COMET USB	76 / 77
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## Hot Air Tools

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## Possibilities of welding seams

Overlap seam with test channel



Overlap seam without test channel



## Product overview wedge welders for Civil Engineering / Tunnelling / Landfills

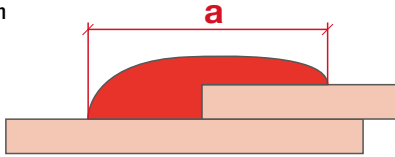
						
Device type	GEOSTAR G5	GEOSTAR G7	COMET / COMET USB	TWINNY T / TWINNY T USB	TWINNY S	TRIAC DRIVE AT
Voltage V~	120 / 230	230	120 / 230	230	120 / 230	230
Max. Power W	1800 / 2800	2800	1800 / 1500 / 1200	2300	1900 / 2900	1700
Temperature °C	80 – 460	80 – 460	80 – 420	80 – 560	80 – 600	80 – 650
Speed m/min	0.8 – 12	0.8 – 12	0.8 – 3.2	0.8 – 3.2	0.2 – 2.5 (4.0/6.0 <sup>1</sup> )	0.5 – 3.0
Max. Welding pressure N	1500	1500	1000	1000	1000 (500)	n.a.
Weld seam width mm	2 x 15	2 x 15	2 x 15	2 x 15	2 x 15	30
Material thickness mm	0.8 - 3.0	1.0 - 3.0	0.5 – 3.0	0.5 – 3.0	0.5 – 3.0	0.5 – 3.0
Max. overlap mm	150	150	125	125	125	
Data recording	- / ✓	- / ✓	- / ✓	- / ✓		
Digital display	✓	✓	✓	✓		✓
Size (L x W x H) mm	482 x 278 x 269	482 x 278 x 269	295 x 250 x 245	340 x 360 x 245	350 x 390 x 270	300 x 230 x 380
Weight kg	16.4	17.7	7.5	6.9 – 7.9	6.5 – 6.9	4.1
Conformity mark	CE	CE	CE	CE	CE	CE
Protection class	⊕	⊕	⊕	⊕	⊞	⊞
<b>Welding technologies</b>						
Hot-wedge welding	✓	✓	✓			
Combi-wedge welding				✓	✓	(✓)
<b>Applications</b>						
HDPE, LDPE, TPO, FPO, PP	0.8 - 3.0 mm	1.0 - 3.0 mm	0.5 - 2.5 mm	0.5 - 2.5 mm	0.5 - 2.5 mm	0.5 - 2.0 mm
PVC, CSPE, EIA	0.8 - 3.0 mm *(steel wedge only)	-	0.5 - 3.0 mm *(steel wedge only)	0.5 - 3.0 mm	0.5 - 3.0 mm	0.5 - 3.0 mm
Catalog page	 <b>72 - 75</b>	<b>72 - 75</b>	<b>76 / 77</b>	<b>78 / 79</b>	<b>79</b>	<b>81</b>

<sup>1</sup> For details, see page 79

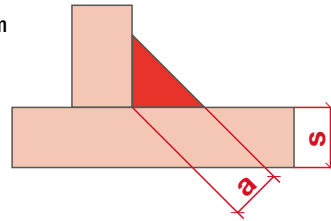
Attention these are Leister recommendations only, depending upon material specifications the possible min. thicknesses may vary. For more information please contact your Leister Distributor.

\* Please note PVC, CSPE and all Chlorinated products are only to be welded with steel wedges.







Overlap seam



Fillet welding seam



## Product comparison

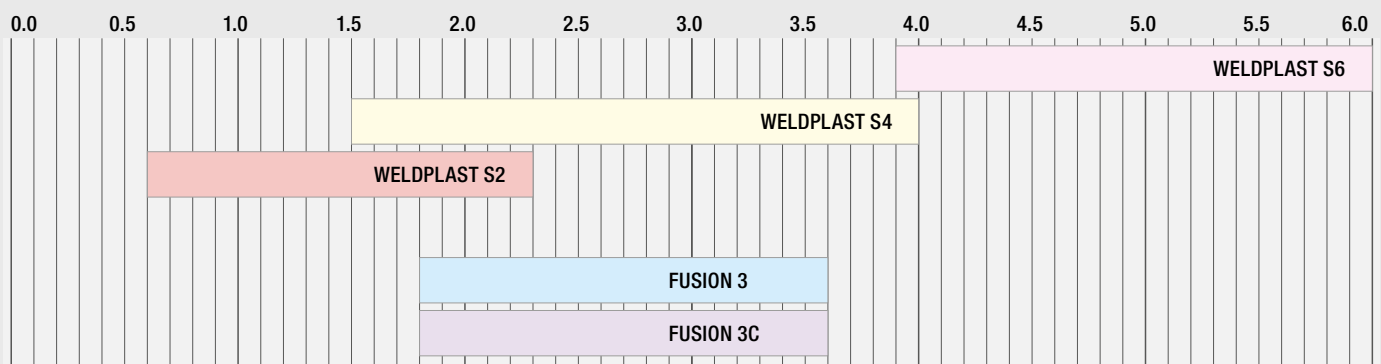
	Digitally regulated extrusion welders			Air heated extrusion welders	
					
Device type	WELDPLAST S6	WELDPLAST S4	WELDPLAST S2	FUSION 3	FUSION 3C
Output (HDPE) kg/hr	3.9 – 6	1.5 – 4	0.6 – 2.3	1.8 – 3.6	1.8 – 3.6
Material	HD-PE, PP	HD-PE, PP	HD-PE, PP, PVC	HD-PE, PP	HD-PE, PP
Wall thickness mm	15 – 40	8 – 35	4 – 20	8 – 25	8 – 25
Welding rod Ø mm	4 – 5	3 – 4 / 4 – 5	3 – 4	3 – 4 / 4 – 5	3 – 4 / 4 – 5
Weight kg	14	8.7	5.8	7.2	6.9
Length mm	821	560	450	690	588
Voltage V~	230	230	230	230	230
Screw extruder	yes	yes	yes	yes	yes
Container construction	✓✓	✓✓	✓✓	✓✓	✓✓
Pipeline construction	✓✓	✓✓	✓✓	✓✓	✓✓
Landfills / civil engineering	✓✓	✓✓	✓	✓✓	✓
Brushless blower	yes	yes	yes	no	no
Remarks	1	1	1	2	2
Catalog page	 82	83	84	85 / 86	85 / 86

✓✓ very suitable    ✓ suitable

1: Air and plast temperatures are shown via a display and can be separately and freely adjusted.

2: The air temperature is adjusted by means of a potentiometer (rotary dial). The heating of the plastic mass is performed by the pre-heating air.

## Overview of Extrusion Welders Output (kg/hr)



# GEOSTAR G5 and GEOSTAR G7 – Faster, lighter, smarter

**Wedge welding redefined:** Leister's new GEOSTAR welders change the civil engineering landscape. This mid-size, lightweight welder boasts a robust, cast aluminum frame for quality welding of geomembranes. The GEOSTAR also features a unique digital display with all key weld parameters: heat, speed, pressure and supply voltage. The new design makes field servicing a cinch—wedge can be removed and replaced in under a minute. Additional features

## Wedge welders

### GEOSTAR G5/G7



**1 Maintenance friendly:**  
The well-thought-out construction enables easy access to mechanical parts for cleaning or service.



**2 eDrive:**  
Integrated display of weld pressure, travel speed, wedge temperature and supply voltage enables constant monitoring of key weld parameters during the work process.



**3 Ergonomic:**  
The newly developed clamping mechanism enables simple, one-hand operation to engage rollers and begin welding.



**4 Shifting gears:**  
The GEOSTAR is equipped with a two-gear transmission that can be modified in accordance with work conditions in just a few steps.



**5 Weld pressure measurement:**  
Constant measurement and display of weld pressure.



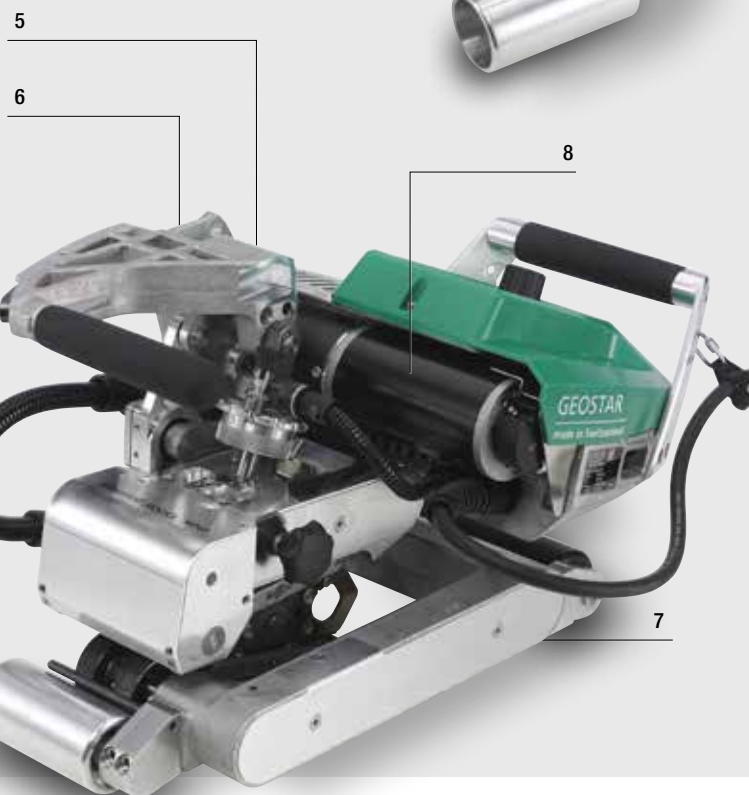
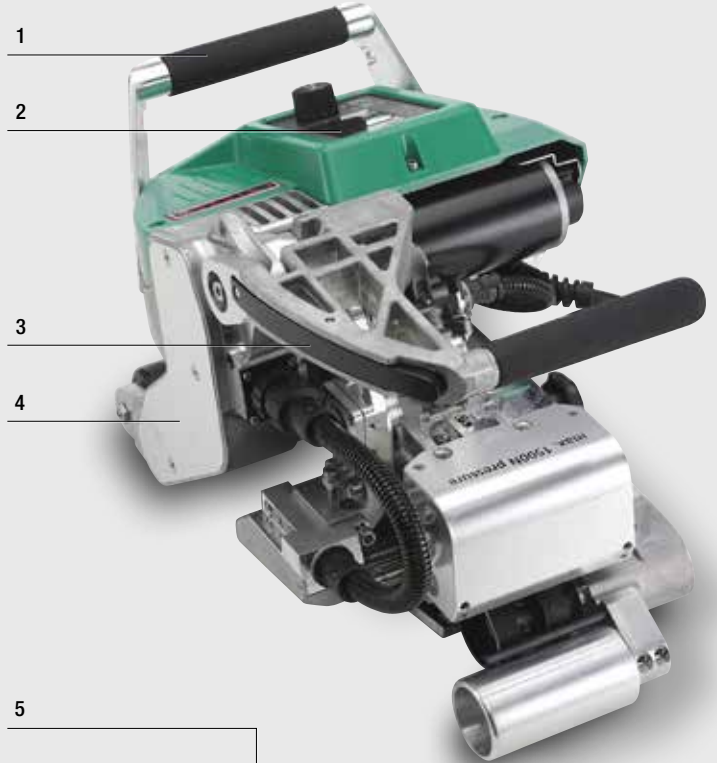
**6 Spacious:**  
Plenty of room for easy loading of material into the machine to accelerate the start of the welding process.



**7 The new wedge geometry:**  
The new geometry supports the natural flow of geomembranes over the wedge. An intelligent interface makes it possible to replace the wedge in less than one minute!



**8 Powerful Drive motor:** G7 supplies up to 100% more power than the G5



include: easy loading of material, natural flow of material through the machine and innovative handle ergonomics for easy carry and rest positions. The GEOSTAR is available in two performance classes: the standard GEOSTAR G5 and extended-wedge GEOSTAR G7.



The GEOSTAR easily welds 240 m without difficulty in a single pass during a field test (South Africa)..

### Wedge welders

## GEOSTAR G5/G7

- Welding speed up to 12 m/min
- G7 Longer wedge means int welds up to 45% faster than the G5
- High heating capacity / heating power
- Digital display of weld pressure
- Integrated voltage display
- Wedge replacement in less than one minute
- Adjustable chassis height

Technical data		GEOSTAR G5 / G5 LQS	GEOSTAR G7 / G7 LQS
Voltage	V~	120 / 220 - 240	220 - 240
Frequency	Hz	50 / 60	50 / 60
Power	W	1800 / 2800	2800
Max. heating temperature	°C	460	460
Welding wedge	mm	90 x 50	130 x 50
Max. overlap	mm	150	150
Max. welding force	N	1500	1500
Weld width with test channel	mm	2 x 11 / 2 x 15	2 x 15
Drive speed*1	m/min	0.8–12 Level 1: 0.8–6 Level 2: 1.5–12	0.8–12 Level 1: 0.8–7 Level 2: 1.5–12
Dimensions (L x W x H)	mm	482 x 278 x 269	482 x 278 x 269
Weight	kg	16.4	17.7
Materials		HD-PE 0.8–3.0 mm PP, LD-PE ,TPO, FPO, PVC-P*2, CSPE*2, EIA*2 additional materials upon request	HD-PE 1.0–3.0 mm PP, LD-PE ,TPO, FPO
Mark of conformity		CE	CE
Protection Class I		⊕	⊕

\*1: Conversion of gear 1–2 using position change of sprocket wheels

\*2: Requires steel wedge

#### Article No.

- 151.035 GEOSTAR G7, 230V / 2800W, Roller width 50 mm, copper wedge with test channel, with Euro plug
- 151.683 GEOSTAR G5, 230V / 2800W, Roller width 50 mm, copper wedge with test channel, with Euro plug
- 151.618 GEOSTAR G5, 120V / 1800W, Roller width 50 mm, copper wedge with test channel, without plug

Scope of delivery: Automatic welder, transport box, 3 pcs. Allen keys, cleaning brush, Operating Instructions

## Accessories GEOSTAR G5/G7

	<b>148.489</b>	Wedge Kit GEOSTAR G7, 130 x 50 mm, 230V/2500W, copper wedge with test channel
	<b>151.684</b>	Wedge Kit GEOSTAR G5, 90 x 50 mm, 230V/2500W, copper wedge with test channel
	<b>153.557</b>	stainless steel wedge with test channel 90 x 50mm, 230V/2500W
	<b>149.174</b>	Wedge-Kit GEOSTAR G5, 90 x 50 mm 120V/1600W, copper wedge with test channel
	<b>153.560</b>	stainless steel wedge with test channel 90 x 50 mm 120V/1600W Other wedges on request
	<b>153.361</b>	Drive roll D50 mm x 50 (75) mm; Traction Step, Steel, pointed knurled, with test channel
	<b>153.338</b>	Drive roll D50 mm x 50 mm; Steel, sharp edge knurled, with test channel
	<b>153.359</b>	Steel, blunt edge knurled, with test channel Other rollers on request
	<b>155.568</b>	50mm straight profile Roller w/screw
	<b>154.272</b>	78mm Silicone Rollers w/screw
	<b>154.676</b>	50mm Silicone Rollers w/screw
	<b>146.204</b>	Prefabrication wagon for Geostar
	<b>146.346</b>	Side support for Prefabrication wagon (4 pieces required)
	<b>151.847</b>	Brass brush

For further accessories see [www.leister.com/geostar](http://www.leister.com/geostar)



# GEOSTAR G5 / G7 LQS – Leister Quality System

The Leister Quality System (LQS) allows you to compile full quality documentation for all aspects of your welding work. You can document every welding seam as a table, graphic or even with GPS coordinates. The GEOSTAR G7 / G5 LQS provides all the advantages of state-of-the-art technology. It really stands out from the crowd – helping you to win over your client!

### Article No.:

- 155.152 GEOSTAR G7 LQS data recording, 230 V / 2800 W, copper wedge with test channel, with Euro plug
- 156.135 GEOSTAR G5 LQS data recording, 230 V / 2800 W, copper wedge with test channel, with Euro plug



#### Pinpoint precision

By activating the GPS function, you can assign the welding seams precisely to the relevant location (for GPS and GLONASS format).



#### GEOSTAR G7 / G5 LQS

- Proven Geostar welding technology
- Activatable data recording
- Welding parameter monitoring via alarm function
- Data storage for 10,000 welds




#### Wireless data transfer


After the welding process, the data can be transferred conveniently via WiFi. The transfer process only takes a few seconds.




GEOSTAR G5 in field operation.



 **Data evaluation on mobile devices**  
The data is evaluated digitally via the LQS app. This app can be downloaded free of charge from the Windows or Android Store. The LQS menus are extremely easy to navigate and are adapted to users' needs.

 **Data cloud**  
The data cloud opens up lots of extra possibilities:

- Cloud function can be switched on/off
- External data backup
- Unit management
- User management
- Decentralized access to welding data, e.g., from back office

 **Welding report**  
The LQS app can be used to produce records in all standard forms:

- DVS report
- Tables and graphics
- pdf and csv format

# COMET / COMET USB: The highflyers.

This compact, heavy-duty welding machine is in use worldwide. The small powerhouse is specially designed for the demands of landfill sites, mines and tunnels. Documentation made simple: The COMET USB memory system is designed for use on construction sites. Because this compact hot-wedge welding machine records all relevant welding parameters, data transfer is mere child's play.

## Wedge welder

### COMET



- Lightweight and compact
- Digital display of temperature and velocity
- Closed loop control of temperature and drive
- Easy and user-friendly

#### Technical Data

Voltage	V~	230
Power	W	1850 / 1500 / 1200
Temperature	°C	80 – 420
Max. overlap	mm	125
Speed	m/min	0.8 – 3.2
Welding pressure	N	100 – 1000
Weld seam width	mm	2 × 15, with test channel
Material thickness	mm	0.5 – 3
Size (L × B × H)	mm	295 × 250 × 245
Weight	kg	7.5
Conformity mark		CE
Protection class I		⊕

#### Article No.

107.547	COMET, with wedge 50 mm for PE, 230 V / 1200 W *
107.538	COMET, with wedge 70 mm for PE, 230 V / 1500 W *
145.893	COMET, with wedge 95 mm for PE, 230 V / 1850 W *
107.558	COMET, with wedge 50 mm for PVC, 230 V / 1200 W *
107.553	COMET, with 50mm wedge for PE, 120 V / 1200 W *
107.539	COMET, with 70mm wedge for PE, 120 V / 1500 W *

\* with test channel, EURO plug

Included with purchase: Welder, manual, guide-bar short, storage case

## Wedge welder

### COMET USB



- Digital display of welding pressure
- Complete recording of all relevant welding parameters
- USB memory system designed for use on construction sites
- Convenient data transfer

#### Technical Data

Voltage	V~	230
Power	W	1850 / 1500 / 1200
Temperature	°C	80 – 420
Max. overlap	mm	125
Speed	m/min	0.8 – 3.2
Welding pressure	N	100 – 1000
Weld seam width	mm	2 × 15, with test channel
Material thickness	mm	0.5 – 3
Size (L × B × H)	mm	295 × 250 × 245
Weight	kg	7.5
Conformity mark		CE
Protection class I		⊕

#### Article No.

137.626	COMET USB, with wedge 50 mm for PE, 230 V / 1200 W *
138.088	COMET USB, with wedge 70 mm for PE, 230 V / 1500 W *
146.052	COMET USB, with wedge 95 mm for PE, 230 V / 1850 W *

\* with test channel, EURO plug

Included with purchase: Welder, manual, guide-bar short, memorystick, storage case






Comet operating in the tunnel ...






... or on a landfill site.

## Accessories COMET / COMET USB

	<b>112.974</b> Extremely light cross handle 145 gram, material: aluminum
	<b>129.224</b> Guide-bar, complete
	<b>144.416</b> USB memory stick



Perfectly protected in the storage case.  
**126.448**  
 (included with purchase)

	<b>100.327</b> Driving roller 50 mm, steel, sharp edge knurled, with test channel
	<b>100.328</b> Driving roller 50 mm, steel, sharp edge knurled, without test channel
	<b>100.329</b> Driving roller 50 mm, steel, blunt edge knurled, with test channel
	<b>100.330</b> Driving roller 50 mm, steel, blunt edge knurled, without test channel
	<b>100.331</b> Driving roller 50 mm, silicon, with test channel
	<b>100.332</b> Driving roller 50 mm, silicon, without test channel

Roles are compatible with COMET and TWINNY T and S welding machines.

## Fields of application COMET / COMET USB

Power	1850 W		1500 W		1200 W	
	Wedge	Material thickness	Wedge	Material thickness	Wedge	Material thickness
PE-HD, PE-C, PP	95 mm copper	1.5 – 3.0 mm	70 mm copper	1.0 – 2.5 mm	50 mm copper	0.5 – 1.5 mm
PE-LD	95 mm copper	1.5 – 3.0 mm	70 mm copper	1.0 – 2.5 mm	50 mm copper	0.5 – 1.5 mm
PVC-P			70 mm steel	2.0 – 3.0 mm	50 mm steel	1.0 – 2.0 mm

# TWINNY T / TWINNY T USB: The little all-rounders.

The TWINNY T is excellent for welding PVC and other thin or soft membranes. It is available either with or without air-test channel. The TWINNY T USB, which makes data storage and display easy with a USB flash memory system, is perfect for critical applications where constant real-time monitoring of primary weld conditions can be stored and displayed.

## Combi-wedge welder TWINNY T



- Simple operation
- High welding speed
- Digital display of temperature and velocity
- Closed-loop control of temperature and drive
- Perfect welding result even in harsh environmental conditions thanks to hot-air system.

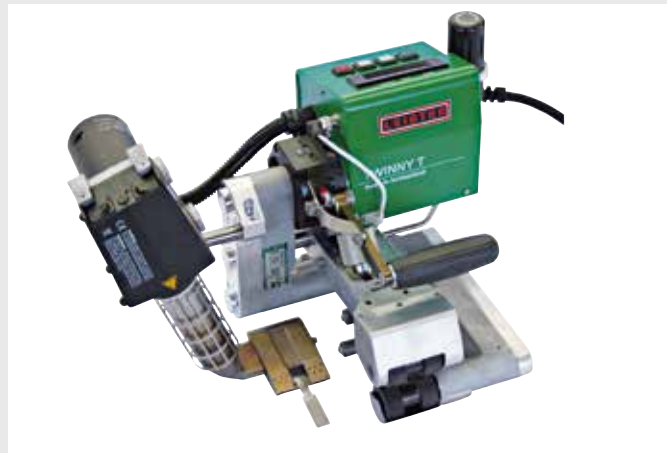
### Technical Data

Voltage	V~	230 / 120
Power	W	2300 / 1900
Temperature	°C	80 – 560
Max. overlap	mm	125
Speed	m/min	0.8 – 3.2
Welding pressure	N	100 – 1000
Size (L x W x H)	mm	340 x 360 x 245
Weight	kg	6.9 – 7.9
Conformity mark	CE	
Protection class I	⊕	

### Article No.

107.562	TWINNY T for civil engineering, 230 V / 2300 W, with test channel, with combi-wedge long, with Euro plug
107.564	TWINNY T for civil engineering, 230 V / 2300 W, with test channel, with combi-wedge short, with Euro plug
111.190	TWINNY T for tunnel construction, 230 V / 2300 W, with test channel, with combi-wedge short, with Euro plug
143.842	TWINNY T for tunnel construction, 120 V / 1900 W, with test channel, with combiwedge short, with UK plug
Civil engineering version: Welder, manual, guide-bar long (129.224), storage case	
Tunneling version: Welder, manual, guide-bar short, storage case	

## Combi-wedge welder TWINNY T USB



- Digital display of welding pressure
- Complete recording of all relevant welding parameters
- USB memory system
- Data transfer made simple

### Technical Data

Voltage	V~	230 / 120
Power	W	2300 / 1900
Temperature	°C	80 – 560
Max. overlap	mm	125
Speed	m/min	0.8 – 3.2
Welding pressure	N	100 – 1000
Size (L x W x H)	mm	340 x 360 x 245
Weight	kg	6.9 – 7.9
Conformity mark	CE	
Protection class I	⊕	

### Article No.

138.089	TWINNY T USB for civil engineering, 230 V / 2300 W, with test channel, with combi-wedge long, with Euro plug
---------	--

Additional versions (incl. 120 V) available upon request.

Civil engineering version:	Welder, manual, guide-bar long (129.224), USB-memory-stick, storage case
Tunneling version:	Welder, manual, guide-bar short, storage case

## TWINNY S: Perfect weight.

This lightweight tool is optimized for overhead welding and is ideal for thin materials used in civil engineering and tunnel construction. Leister offers a choice between replaceable combi-wedges with or without test channel.



TWINNY T, with convenient cross-handle, at work overhead welding in a tunnel.

### Combi-wedge welder

## TWINNY S



- Simple operation
- Lightweight
- High welding speed
- Stepless adjustment of temperature and drive
- Perfect welding result even in harsh environmental conditions thanks to hot-air system.

#### Technical Data

Voltage	V~	120 / 230
Power	W	2900 / 1900
Temperature	°C	80 – 600
Max. overlap	mm	125
Speed		
drive 256:1	m/min	0.2 – 2.5
drive 144:1		1.4 – 4 (6)
Welding pressure	N	1000 / 500 (256:1 / 144:1)
Size (L x W x H)	mm	350 x 390 x 270
Weight	kg	6.5 – 6.9
Conformity mark		CE
Protection class II		□

#### Article No.

119.031	TWINNY S for tunnel construction, drive 256:1, 230 V / 2900 W, with test channel, combi-wedge long, Euro plug
119.027	TWINNY S for civil engineering, drive 256:1, 230 V / 2900 W, with test channel, combi-wedge long, Euro plug
119.008	TWINNY S for civil engineering, drive 144:1, 230 V / 2900 W, with test channel, combi-wedge short, Euro plug
128.808	TWINNY S for civil engineering, drive 144:1, 6 m/min, 230 V / 2900 W, with test channel, combi-wedge short, Euro plug
119.039	TWINNY S for tunnel construction, drive 256:1, 120 V / 1900 W, with test channel, combiwedge long, w/o plug

## Accessories TWINNY T / T USB / TWINNY S

	<b>112.974</b> Extremely light cross handle 145 gram, material: aluminum
	<b>129.224</b> Guide bar, complete
	Combi-wedge short <b>100.517</b> 50 mm, with test channel <b>100.519</b> 30 mm, with test channel <b>100.518</b> 50 mm, without test channel <b>100.520</b> 30 mm, without test channel
	Combi-wedge long, complete <b>100.525</b> 50 mm, with test channel <b>100.526</b> 50 mm, without test channel, slotted, perforated
	<b>144.416</b> USB memory stick TWINNY T USB
	<b>126.448</b> Storage case (included with purchase)
	<b>103.604</b> 230 V / 2100 W heating element, TWINNY T / T USB <b>103.602</b> 120 V / 1800 W heating element, TWINNY T / T USB <b>101.905</b> 230 V / 2750 W heating element, TWINNY S <b>101.910</b> 230 V / 2100 W heating element, TWINNY S <b>101.913</b> 120 V / 1800 W heating element, TWINNY S

See COMET for roles.

Cvile engineering version: Welder, manual, guide-bar long (129.224), storage case  
 Tunneling version: Welder, manual, guide-bar short, storage case



# TRIAC DRIVE AT: The little all-rounder

This semi-automatic hot-air welder that's truly one-of-a-kind. Its flexible concept enables the TRIAC DRIVE AT to be used in all kinds of applications.



The perfect choice for welding joint sealing tape.

## Semiautomatic hot-air welder

### TRIAC DRIVE AT



- Consistent and up to 3x faster than hand welding
- Unique semi-automatic welding machine
- Can perform automatic welding in places other devices can't reach
- With guide, inside or outside nozzle for all precision work in tunnels (available as optional accessory)



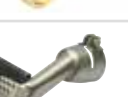




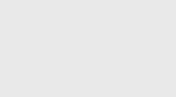
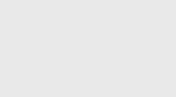
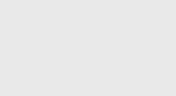

#### Technical Data

Voltage	V~	230
Power	W	1700
Temperature	°C	80 – 650
Speed	m/min	0.5 – 3
Air flow	l / min	(20 °C) 120 – 240
Size (L x W x H)	mm	340 x 360 x 245
Weight	kg	4.1 (with 3 m cable)
Conformity mark	CE	
Protection class II	□	

#### Article No.

- 117.331 TRIAC DRIVE AT 230 V / 1700 W, inside, without guide, width of welding nozzle 30 mm, without grip, pressure roller silicone, EURO-plug
- 148.606 TRIAC DRIVE AT 230 V / 1700 W, inside, without guide, width of welding nozzle 12 mm, with grip, pressure roller steel, EURO-plug
- 148.605 TRIAC DRIVE AT 230 V / 1700 W, inside, without guide, width of welding nozzle 38 mm, without grip, pressure roller steel, EURO-plug
- Additional versions available upon request.

### Accessories TRIAC DRIVE AT

	<b>115.274</b>	12 mm pressure roller, steel
	<b>115.176</b>	30 mm pressure roller, steel
	<b>115.712</b>	40 mm pressure roller, steel
	<b>115.857</b>	30 mm pressure roller, silicone
	<b>115.921</b>	40 mm pressure roller, silicone
	<b>115.276</b>	Single supporting carrier, brass
	<b>138.570</b>	Silicone roller
		Overlap welding nozzle, inside, push-fit
	<b>115.281</b>	38 mm, with grip
	<b>115.279</b>	30 mm, with grip
	<b>115.699</b>	12 mm, without grip
	<b>115.703</b>	38 mm, without grip
	<b>115.701</b>	30 mm, without grip
		Overlap welding nozzle, outside, push-fit
	<b>115.280</b>	38 mm, with grip
	<b>115.278</b>	30 mm, with grip
	<b>115.702</b>	38 mm, without grip
	<b>115.700</b>	30 mm, without grip
	<b>108.985</b>	Storage case (included with purchase)
	<b>142.717</b>	230 V / 1550 W heating element for TRIAC AT

# WELDPLAST S6: The workhorse.

WELDPLAST S6 is the world's highest rated handheld extrusion welder. With an output of 6 kg/h, it is surprisingly maneuverable. It features a brushless, preheat motor, multifunction display and comfortable ergo-grip, making the S6 Leister's flagship extrusion welder.



WELDPLAST S6, Gold Mine Mexico.

Digitally regulated extrusion welder

## WELDPLAST S6



- 6 kg output per hour
- Highest possible preheating capacity
- Adjustable control wheel
- Maintenance-free hot-air blower
- Multifunctional display

### Technical Data

Voltage	V~	230
Power	W	4600
Material		PE / PP
Welding rod	mm	Ø 4 – 5
Output	kg/h	3.9 – 6.0
Size (L × W × H)	mm	821 × 116 × 240
Weight	kg	14
Conformity mark		CE
Protection class I		⊕

### Article No.

134.318 Extrusion Welder WELDPLAST S6, 230 V / 4600 W, with CEE 32A plug

Included with purchase: WELDPLAST S6, overlap welding shoe, storage case

## Accessories WELDPLAST S6

		<b>146.239</b> Welding shoe complete
		<b>146.240</b> 54 × 40 × 52 mm blank welding shoe
		<b>146.241</b> 25 mm overlap
		<b>146.242</b> 35 mm overlap
		<b>145.899</b> 40 mm overlap
		<b>146.245</b> 20 mm V-seam
		<b>146.246</b> 25 mm V-seam
		<b>146.247</b> 30 mm V-seam
		<b>146.232</b> 20 mm fillet weld seam (a = 14 mm*)
		<b>146.233</b> 25 mm fillet weld seam (a = 17.5 mm*)
		<b>146.234</b> 30 mm fillet weld seam (a = 21 mm*)
		<b>146.230</b> Corner seam Ø 14 mm
		<b>146.218</b> Corner seam Ø 20 mm
		<b>117.055</b> 35 mm preheat nozzle, large
		<b>136.859</b> 50 mm preheat nozzle, XL large
		<b>117.790</b> Side hot-air guide (Position 9h/3h)
		<b>116.367</b> Ultra strong storage case WELDPLAST S6 (included with purchase)
		<b>149.744</b> Insulation sleeve

\* a = welding seam thickness

General accessories



# WELDPLAST S4

The WELDPLAST S4 is the first extrusion welder of its kind with brushless, maintenance-free motor for generating preheated air. Output of up to four kilograms per hour is made possible thanks to the S4's powerful drive system.



The powerful WELDPLAST S4 at work.

Digitally regulated extrusion welder

## WELDPLAST S4



- Compact housing design reduces noise and guarantees optimal cooling for the electronics and drive.
- Microprocessor to regulate the welding process and to monitor the tool
- Menu with function programs
- Dual-sided twist-free wire intake
- Maintenance-free blower

### Technical Data

Voltage	V~	230
Power	W	3680
Material		PE /PP
Welding rod	mm	Ø 3 – 4 / Ø 4 – 5
Output	kg/h	1.5 – 4.0
Size (L x W x H)	mm	560 x 110 x 300
Weight	kg	8.7
Conformity mark		CE
Protection class I		⊕

### Article No.

- 146.812 WELDPLAST S4, 230 V / 3680 W, 4–5 mm, top hot-air guide, overlap welding shoe 40 mm, preheat nozzle large, with Euro plug, storage case
- 116.948 WELDPLAST S4, 230 V / 3680 W, 3–4 mm, side hot-air guide, blank welding shoe, preheat nozzle large, medium and small, with Euro plug, storage case

## Accessories WELDPLAST S4

	<b>146.239</b>	Welding shoe complete
	<b>146.240</b>	54 x 40 x 52 mm blank welding shoe
		74 x 50 x 58 mm blank welding shoe
	<b>146.241</b>	25 mm overlap
	<b>146.242</b>	35 mm overlap
	<b>145.899</b>	40 mm overlap
	<b>146.243</b>	12 mm V-seam
	<b>146.244</b>	15 mm V-seam
	<b>146.245</b>	20 mm V-seam
	<b>146.246</b>	25 mm V-seam
	<b>146.247</b>	30 mm V-seam
	<b>146.231</b>	15 mm fillet weld seam (a = 10 mm*)
	<b>146.232</b>	20 mm fillet weld seam (a = 14 mm*)
	<b>146.233</b>	25 mm fillet weld seam (a = 17.5 mm*)
	<b>146.234</b>	30 mm fillet weld seam (a = 21 mm*)
	<b>146.230</b>	Corner seam Ø 14 mm
	<b>146.218</b>	Corner seam Ø 20 mm
	<b>144.904</b>	45° angled adapter
	<b>145.704</b>	90° angled adapter
		Caution: You must use welding shoes with an integrated air guide for this
	<b>117.064</b>	Side hot-air guide
	<b>117.065</b>	Top hot-air guide
	<b>117.053</b>	preheat nozzle small, 20 mm
	<b>117.518</b>	medium, 25 mm
	<b>141.177</b>	large, 35 mm
	<b>136.231</b>	Pre-heat reflector
	<b>149.723</b>	Insulation sleeve

\* a = welding seam thickness

# WELDPLAST S2: The masterpiece.

The WELDPLAST S2 is a compact, ergonomically designed workhorse. The handy size extruder puts out two kilograms per hour and can even weld TPO materials without difficulty.



The robust WELDPLAST S2 welding a patch in a tunneling application.

Digitally regulated extrusion welder

## WELDPLAST S2 / S2 TPO



- Maintenance-free blower
- Perfect weld seam quality
- Multifunctional display
- Ergonomic and handy
- Successfully operated worldwide

### Technical Data

Voltage	V~	230
Power	W	3000
Material standard version		PE /PP
Welding rod	mm	∅ 3 – ∅ 4
Output ∅ 3 mm	kg/h	PE: 0.6 – 1.3 PP: 0.5 – 1.2
Output ∅ 4 mm	kg/h	PE: 1.0 – 2.3 PP: 0.9 – 2.0
Size (L × W × H)	mm	450 × 98 × 260
Weight	kg	5.8
Conformity mark		CE
Protection class I		⊕

### Article No.

127.215 WELDPLAST S2, 230 V / 3000 W, with Euro plug  
 Included with purchase: WELDPLAST S2, blank welding shoe, storage case  
 136.602 WELDPLAST S2, 230 V / 3000 W, TPO, with Euro plug  
 Included with purchase: WELDPLAST S2, UBL-blank welding shoe, storage case

## Accessories WELDPLAST S2 / S2 TPO

	145.945	Welding shoe complete
	145.946	45 × 30 × 54 mm blank welding shoe
	145.896	74 × 50 × 58 mm blank welding shoe
	145.947	25 mm overlap
	145.897	30 mm overlap
	145.915	35 mm overlap
	145.907	8 / 10 mm V-seam
	145.903	12 mm V-seam
	145.909	15 mm V-seam
	145.944	20 mm V-seam
	145.812	8 / 10 mm fillet weld (a = 7 mm*)
	145.940	15 mm fillet weld (a = 10*)
	146.645	20 mm fillet weld (a = 14 mm*)
	146.649	Corner outside seam 10 mm
	146.651	Corner outside seam 12 mm
	145.811	Corner outside seam 15 mm
	145.488	Corner seam ∅ 14 mm
		Corner seam ∅ 20 mm
	139.460	45° angled adapter
	139.461	90° angled adapter
	134.361	Air filter (included with purchase)
	143.776	Textile dust filter (not included with purchase)
	155.829	Air filter
	131.451	Tool rest
	136.231	Preheat reflector
	154.002	Insulation sleeve

\* a = welding seam thickness

General accessories



## FUSION 3 / 3C: THE slim twins.

With its long and narrow shape, the FUSION 3 enables comfortable work, even on the ground. The slightly shorter 3C also provides an astounding output volume of up to eight pounds per hour.



Due to its length, the FUSION 3 is especially suited for civil engineering applications.

Air heated extrusion welder

### FUSION 3



- High welding performance
- Compact and handy
- Motor start-up protection prevents cold start
- Dual-sided twist-free wire intake
- 360° rotatable welding shoe

Air heated extrusion welder

### FUSION 3C



- High welding performance
- Compact and handy
- Motor start-up protection prevents cold start
- Dual-sided twist-free wire intake
- 360° rotatable welding shoe

#### Technical Data

Welding rod Ø	mm	Version Ø 3 – 4		Version Ø 4 – 5	
		3	4	4	5
Output PE	kg/h	2.0 – 2.5	2.7 – 3.6	2.1 – 2.6	2.7 – 3.6
Output PP	kg/h	1.8 – 2.3	2.5 – 3.4	1.8 – 2.4	2.5 – 3.4
Voltage	V~	230			
Power	W	3500			
Material		PE / PP			
Size (L x W x H)	mm	670 x 90 x 180			
Weight	kg	7.2			
Conformity mark		CE			
Protection class II		□			

#### Artikel-Nr.

118.300 FUSION 3, 230 V / 3500 W, Welding rod Ø 3 – 4 mm, Euro plug  
144.615 FUSION 3, 230 V / 3500 W, Welding rod Ø 4 – 5 mm, Euro plug

Included with purchase: FUSION 3, blank welding shoe, storage case

#### Technical Data

Welding rod Ø	mm	Version Ø 3 – 4		Version Ø 4 – 5	
		3	4	4	5
Output PE	kg/h	2.0 – 2.5	2.7 – 3.6	2.1 – 2.6	2.7 – 3.6
Output PP	kg/h	1.8 – 2.3	2.5 – 3.4	1.8 – 2.4	2.5 – 3.4
Voltage	V~	230			
Power	W	3200			
Material		PE / PP			
Size (L x W x H)	mm	588 x 98 x 225			
Weight	kg	6.9			
Conformity mark		CE			
Protection class II		□			

#### Artikel-Nr.

123.866 FUSION 3C, 230 V / 3200 W, Welding rod Ø 3 – 4 mm, Euro plug  
144.826 FUSION 3C, 230 V / 3200 W, Welding rod Ø 4 – 5 mm, Euro plug

Included with purchase: FUSION 3C, blank welding shoe, storage case



The FUSION 3 for comfortable working in upright positions.

## Accessories FUSION 3 / FUSION 3C

		<b>145.945</b> Welding shoe complete 45 × 30 × 54 mm blank welding shoe
		<b>145.946</b> 74 × 50 × 58 mm blank welding shoe
		<b>145.896</b> 25 mm overlap
		<b>145.947</b> 30 mm overlap
		<b>145.897</b> 35 mm overlap
		<b>145.915</b> 8 / 10 mm V-seam
		<b>145.907</b> 12 mm V-seam
		<b>145.903</b> 15 mm V-seam
		<b>145.909</b> 20 mm V-seam
		<b>145.916</b> 25 mm V-seam
		<b>145.905</b> 30 mm V-seam
		<b>145.944</b> 8 / 10 mm fillet weld (a = 7 mm*)
		<b>145.812</b> 15 mm fillet weld (a = 10 mm*)
		<b>145.940</b> 20 mm fillet weld (a = 14 mm*)
		<b>145.816</b> 25 mm fillet weld (a = 17.5 mm*)
		<b>145.817</b> 30 mm fillet weld (a = 21 mm*)
		<b>146.643</b> Corner outside seam 8 mm
		<b>146.645</b> Corner outside seam 10 mm
		<b>146.649</b> Corner outside seam 12 mm
		<b>146.651</b> Corner outside seam 15 mm
		<b>145.811</b> Corner seam $\varnothing$ 14 mm
		<b>145.488</b> Corner seam $\varnothing$ 20 mm
		<b>148.817</b> 45° angled adapter
		<b>148.816</b> 90° angled adapter
		<b>135.082</b> Air filter in stainless steel FUSION 3C
		<b>131.451</b> <b>Tool rest</b> WELDPLAST S2 / S2 PVC / FUSION 2 FUSION 3C
		<b>160.454</b> WELDPLAST S4 / S6 / FUSION 3
		<b>136.231</b> Preheat reflector
		<b>149.421</b> Insulation sleeve FUSION 3
		<b>149.420</b> Insulation sleeve FUSION 3C

## General accessories

	<b>144.095</b> Welding rod de-reeler
	<b>123.173</b> Storage case WELDPLAST S4 / FUSION 3 <b>119.540</b> WELDPLAST S2 / S2 TPO / FUSION 3C (included with purchase)
	<b>134.567</b> Heating element, 230 V / 2600 W, for WELDPLAST S6 <b>109.984</b> 230 V / 2200 W, for WELDPLAST S4 / S2 <b>113.268</b> 230 V / 1100 + 1100 W, for FUSION 3 <b>123.561</b> 230 V / 1750 W, for FUSION 3C

FUSION 3C with heat blanket.



## EXAMO: The inspector.

Is your seam sealed? Can it withstand the specified peel, tensile and shear forces? EXAMO performs tests at the construction site – quick, reliable and uncomplicated.



Blank in uniform size, quickly produced with the Coupon Cutter.

### Tensiometer

## EXAMO 300F USB, 600F USB



- Construction-site approved
- Handy, robust and reliable
- Testing of elongation, peak force, tear force, test speed and position
- With jaws also suitable for geo textiles (see accessories)
- Electronic recording of the measurement data

#### Technical Data

Type		300F USB	600F USB
Voltage	V~	230	230
Power	W	200	200
Tensile load	N	4000	4000
Jaw spacing	mm	5 – 300	5 – 600
Range	mm	300	600
Test speed	mm/min	20 – 550	20 – 550
Sample thickness	mm	max. 7	max. 7
Sample width	mm	max. 40 (60 optional)	max. 40 (60 optional)
Size (L x W x H)	mm	750 x 270 x 190 (case)	1050 x 270 x 190 (case)
Weight	kg	14	17.5
Conformity mark		CE	CE
Protection class I		⊕	⊕

#### Article No.:

- 139.059 EXAMO 300F USB, 230 V / 200 W, incl. USB memory stick, Euro plug  
 139.060 EXAMO 600F USB, 230 V / 200 W, incl. USB memory stick, Euro plug

## Accessories EXAMO 300F USB, 600F USB

	<b>134.832</b>	Testing and calibration kit to test and calibrate your EXAMO USB
	<b>108.185</b>	Jaw kit 60 mm for geotextiles including two pairs of jaws
	<b>144.416</b>	USB memory-stick
	<b>145.813</b>	COUPON CUTTER 20 x 150 mm
	<b>146.449</b>	COUPON CUTTER 25 x 150 mm
	<b>163.003</b>	Holder Cutting knife complete (Retro fitting of 20 and 25 mm Blade cutters) Cutting plate
	<b>163.004</b>	Spare Blade set (20 and 25 mm )
	<b>143.828</b>	Cutting plate
	<b>137.855</b>	Leister cutter with four spare blades
	<b>138.902</b>	Hooked blade for LEISTER-cutter (10 dispenser with 10 pcs=100 pcs)
	<b>138.539</b>	Straight-edge blade for LEISTER-cutter (10 dispenser with 10 pcs = 100 pcs)

## VACUUM PUMP / VACUUM BOX: Fast and reliable.

The simple, safe and non-destructive way to test the tightness of overlap weld seams, using the Leister VACUUM BOX/BELL. Soapy water is applied to the welding zone to be checked. After connection to the VACUUM PUMP, a vacuum is generated above the zone with the VACUUM BOX/BELL. Thanks to its generous dimensions, and the practical drain valve, even longer weld seams can be tested quickly and reliably.

### Testing instruments

#### VACUUM BELL



- Simple and precise tightness testing
- Round structural form, ideal for details and uneven surfaces.
- Manometer bar/psi

### Testing instruments

#### VACUUM BOX



- Large testing area
- Simple handling
- Clear arrangement of the fittings
- Manometer bar/psi

### Testing instruments

#### VACUUM PUMP



- Durable VACUUM PUMP
- Perfectly packaged and handy
- Flexible, robust hose

#### Article No.:

153.026 VACUUM BELL Ø 320 mm

152.981 VACUUM BOX 830 x 320 x 150 mm

153.024 VACUUM PUMP 230V

153.025 VACUUM PUMP 120V

Caution: The complete testing system is made up from a combination of one VACUUM BOX or VACUUM BELL to be operated with one VACUUM PUMP.

# Compressed air testing device.

The reliable and handy compressed air testing device from Leister is the perfect solution for testing the tightness of double tap seams with test channels. The revised model now offers even more reliable results – not only during operation but also for the discovery of leaks.



Testing the leak-tightness of lap seams with test channel.

## Testing instrument Compressed air testing device with thin testing needle



- Thin, flexible needle
- Simple and precise tightness testing
- High user safety through hand and needle protection
- Manometer with bar and psi scale
- Practical device case



Manometer standard (bar/psi)

**Article No.:**

142.475 Flexible injection needle with manometer

## Accessories



**142.569** Flexible spare needle (fits also to 150.720)

## Testing instrument Compressed air testing device with thick testing needle



- Very strong, tapered needle
- Simple and precise tightness testing
- High user safety through hand and needle protection
- Manometer with bar and psi scale
- Practical device case



Manometer ASTM (psi/kPa)

**Article No.:**

150.720 Tapered injection needle with manometer (standard)  
158.374 Tapered injection needle with manometer PSI (ASTM)

## Accessories



**150.142** Tapered Spare needle (fits also to 142.475)





Air purification system, Spain. Material: HD-PE



The Wave House, San Diego. Material: PVC



Electroplating tank, Turkey. Material: PP

## Plastic Fabrication

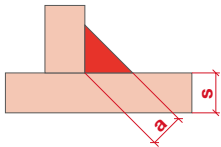
Overview of hand extruders	92
FUSION 1	94 / 95
WELDPLAST S6	96
WELDPLAST S4	97
WELDPLAST S2 / S2 PVC	98 / 99
WELDPLAST 1	100
FUSION 3 / 3C	101 / 102
FUSION 2	103
General accessories hand extruders	104
Welding rods	105

## Hot-Air Hand Tools

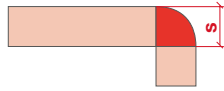
TRIAK ST	12 – 15
TRIAK AT	13 – 15
HOT JET S	18 / 19
AIRSTREAM ST	26 / 27
ROBUST	28
WELDING PEN R / WELDING PEN S	29
DIODE PID / DIODE S	30 / 31
MINOR	31
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General accessories	34 / 35

## Possibilities of welding seams

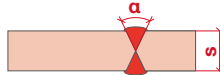
a = seam size s = material thickness α = milling angle



Fillet welding seam

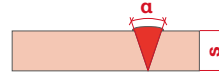


Corner outside seam



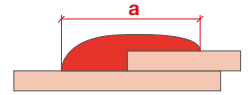
X-seam

s = 10 – 40 mm = α 60°  
s = 50 – 60 mm = α 50°












V-seam

s = 5 – 20 mm = α 60°  
s = 25 – 30 mm = α 50°



Overlap seam

## Product comparison

	Digitally regulated extrusion welders				Air heated extrusion welders			
								
Device type	WELDPLAST S6	WELDPLAST S4	WELDPLAST S2	WELDPLAST S1	FUSION 3	FUSION 3C	FUSION 2	FUSION 1
Output (HDPE) kg/hr	3.9 – 6	1.5 – 4	0.6 – 2.3	0.2 – 0.8	1.8 – 3.6	1.8 – 3.6	1.3 – 1.8	0.2 – 0.8
Material	HD-PE, PP	HD-PE, PP	HD-PE, PP, PVC	PE, PP, PVC, etc.	HD-PE, PP	HD-PE, PP	HD-PE, PP	PE, PP
Wall thickness mm	15 – 40	8 – 35	4 – 20	4 – 10	8 – 25	8 – 25	6 – 15	4 – 10
Welding rod Ø mm	4 – 5	3 – 4 / 4 – 5	3 – 4	3 – 4	3 – 4 / 4 – 5	3 – 4 / 4 – 5	4	3 – 4
Weight kg	14	8.7	5.8	4.7	7.2	6.9	5.9	3.4
Length mm	821	560	450	435	690	588	450	435
Voltage V~	230	230	230	230 / 120	230	230	230	230
Screw extruder	yes	yes	yes	yes	yes	yes	yes	yes
Container construction	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓
Pipeline construction	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓
Landfills / civil engineering	✓✓	✓✓	✓	○	✓✓	✓	○	○
Brushless blower	yes	yes	yes	yes	no	no	no	no
Remarks	1	1	1	1	2	2	2	3
Catalog page	 96	97	98 / 99	100	101 / 102	101 / 102	103	94 / 95

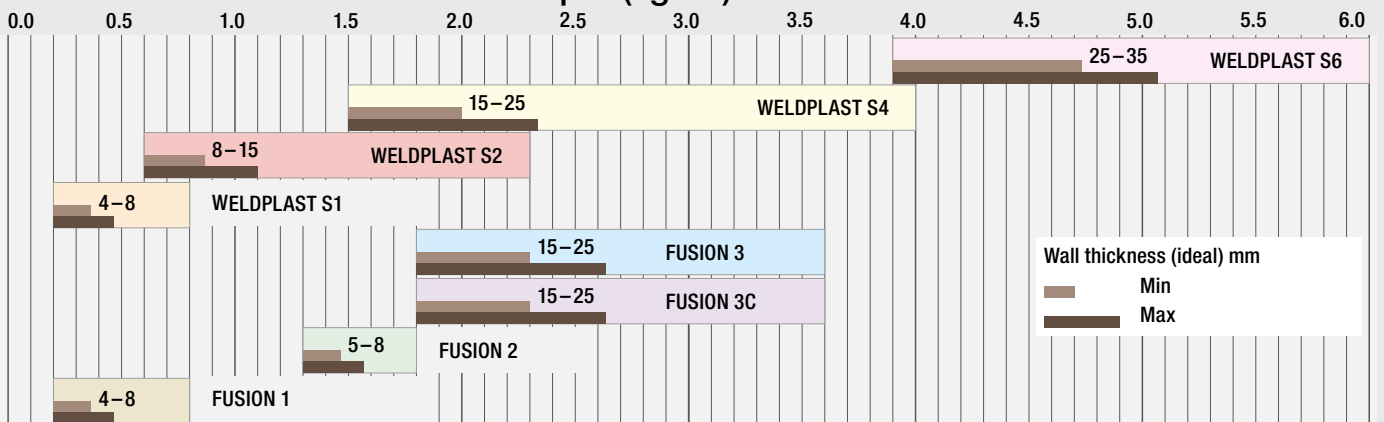
✓✓ very suitable ✓ suitable ○ unsuitable

1: Air and Plast temperatures electronically controlled with integrated display.

2: Hot air heated extruder temperature controlled manually.

3: Warm air heated extruder, air temperature electronically controlled with integrated display.

## Overview of Extrusion Welders Output (kg/hr)





# Ingeniously simple – FUSION 1

Your satisfaction is our goal. Which is why we are developing welding devices to meet your requests and requirements. And with the usual LEISTER quality, of course. The reduced design of the FUSION 1 offers increased maneuverability when welding. Flexibility guarantees an optimally mountable handle. Ingeniously simple extrusion welding – FUSION 1.

Digitally regulated extrusion welder

## FUSION 1

1		<b>Rod shape:</b> Reduced design for increased maneuverability in small spaces
2		<b>Double-sided wire intake:</b> For more flexibility when welding
3		<b>LED light:</b> To illuminate the welding area
4		<b>Handle:</b> Can be mounted for one-handed welding





FUSION 1 – More flexibility during welding thanks to its slim design.

Digitally regulated extrusion welder

## FUSION 1



- **Controlled:** Automatically controlled air temperature
- **Suspension device:** Effortlessly weld longer by hanging up the device
- **Compact and slimline:** Thanks to integrated air guide

### Technical data

Voltage	V~	230
Power	W	1200
Materials		PE, PP
Welding rod Ø	mm	3 – 4
Output Ø 3 HD-PE	kg/h	0.2 – 0.5
Output Ø 4 HD-PE	kg/h	0.3 – 0.8
Size (L × B × H)	mm	435 × 92 × 133 (236 with handle)
Weight	kg	3.4
Conformity marking		CE
Protection class II		□

### Article No.:

- 162.799 FUSION 1, 120 V / 1450 W, with US-plug
- 162.800 FUSION 1, 230 V / 1200 W, with EU-plug
- 163.165 FUSION 1, 230 V / 1200 W, with CEE-plug

Included with purchase: FUSION 1, case, welding shoe, Allen key, instruction manual, handle

## Accessories FUSION 1

	<b>163.793</b> Welding shoe CL14 IA
	<b>163.778</b> Welding shoe K5/6 IA
	<b>163.780</b> Welding shoe K8/10 IA
	<b>163.779</b> Welding shoe K12 IA
	<b>163.782</b> Angled welding shoe AK-10 70°
	<b>163.784</b> Angled welding shoe AK-10 30°
	<b>163.785</b> Angled welding shoe AV-10 30°
	<b>163.786</b> Welding shoe Rohling IA
	<b>162.665</b> Insulation sleeve

# WELDPLAST S6: The workhorse.

WELDPLAST S6 is the world's highest rated handheld extrusion welder. With an output of 6 kg/hr, it is surprisingly maneuverable. It features a brushless, preheat motor, multifunction display and comfortable ergo-grip – making the S6 Leister's flagship extrusion welder.



The WELDPLAST S6 is guided easily with the practical control wheel grip.

Digitally regulated extrusion welder

## WELDPLAST S6



- 6 kg output per hour
- Highest possible preheating capacity
- Adjustable control wheel
- Maintenance-free hot-air blower
- Multifunctional display

### Technical Data

Voltage	V~	230
Power	W	4600
Material		PE / PP
Welding rod	mm	Ø 4 or Ø 5
Output	kg/h	3.9 – 6.0
Size (L × W × H)	mm	821 × 116 × 240
Weight	kg	14
Conformity mark		CE
Protection class I		⊕

### Article No.:

134.318 WELDPLAST S6, 230 V / 4600 W, CEE 32A plug

Included with purchase: WELDPLAST S6, overlap welding shoe, storage case

## Accessories WELDPLAST S6

	<b>Welding shoe complete</b>
	<b>146.239</b> 54 × 40 × 52 mm blank welding shoe
	<b>146.240</b> 74 × 50 × 58 mm blank welding shoe
	<b>146.241</b> 25 mm overlap
	<b>146.242</b> 35 mm overlap
	<b>145.899</b> 40 mm overlap
	<b>146.245</b> 20 mm V-seam
	<b>146.246</b> 25 mm V-seam
	<b>146.247</b> 30 mm V-seam
	<b>146.232</b> 20 mm fillet weld seam (a = 14 mm*)
	<b>146.233</b> 25 mm fillet weld seam (a = 17.5 mm*)
	<b>146.234</b> 30 mm fillet weld seam (a = 21 mm*)
	<b>146.644</b> Corner outside seam 10 mm
	<b>146.646</b> Corner outside seam 12 mm
	<b>146.652</b> Corner outside seam 15 mm
	<b>146.230</b> Corner seam Ø 14 mm
	<b>146.218</b> Corner seam Ø 20 mm
	<b>117.055</b> 35 mm preheating nozzle, large
	<b>136.859</b> 50 mm preheat nozzle, XL Large
	<b>117.790</b> Side hot-air guide
	<b>149.744</b> Insulation sleeve WELDPLAST S6

\*a = Welding seam thickness

# WELDPLAST S4: The workmate.

The WELDPLAST S4 is the first extruder of its kind with a brushless, maintenance-free motor for generating pre-heated air. Output of up to four kilograms per hour is made possible thanks to the S4's powerful drive system.



The powerful WELDPLAST S4 in use.

Digitally regulated extrusion welder

## WELDPLAST S4



- Compact housing design reduces noise and guarantees optimal cooling for the electronics and drive.
- Microprocessor regulates the welding process and monitors the tool
- Menu with function programs
- Dual-sided, twist-free wire intake
- Maintenance-free blower

### Technical Data

Voltage	V~	230
Power	W	3680
Material		PE / PP
Welding rod	mm	Ø 3 – 4 / Ø 4 – 5 mm
Output	kg/h	1.5 – 4.0
Size (L x W x H)	mm	560 x 110 x 300
Weight	kg	8.7
Conformity mark		CE
Protection class I		⊕

### Article No.:

- 116.948 WELDPLAST S4, 230 V / 3680 W, 3 – 4 mm, Euro plug, blank welding shoe
- 146.813 WELDPLAST S4, 230 V / 3680 W, 4 – 5 mm, Euro plug, welding shoe K 15
- Included with purchase: WELDPLAST S4, preheat nozzle large, medium and small, storage case

## Accessories WELDPLAST S4

		<b>146.239</b>	<b>Welding shoe complete</b> 54 x 40 x 52 mm blank welding shoe
		<b>146.240</b>	74 x 50 x 58 mm blank welding shoe
		<b>146.241</b>	25 mm overlap
		<b>146.242</b>	35 mm overlap
		<b>145.899</b>	40 mm overlap
		<b>146.243</b>	12 mm V-seam
		<b>146.244</b>	15 mm V-seam
		<b>146.245</b>	20 mm V-seam
		<b>146.246</b>	25 mm V-seam
		<b>146.247</b>	30 mm V-seam
		<b>146.231</b>	15 mm fillet weld seam (a = 10 mm*)
		<b>146.232</b>	20 mm fillet weld seam (a = 14 mm*)
		<b>146.233</b>	25 mm fillet weld seam (a = 17.5 mm*)
		<b>146.234</b>	30 mm fillet weld seam (a = 21 mm*)
		<b>146.642</b>	Corner outside seam 8 mm
		<b>146.644</b>	Corner outside seam 10 mm
		<b>146.646</b>	Corner outside seam 12 mm
		<b>146.652</b>	Corner outside seam 15 mm
		<b>146.230</b>	Corner seam Ø 14 mm
		<b>146.218</b>	Corner seam Ø 20 mm
		<b>144.904</b>	Angled adapter 45°
		<b>145.704</b>	Angled adapter 90°
		Caution: You must use welding shoes with an integrated air guide for this.	
		<b>117.064</b>	Side hot-air guide
		<b>117.065</b>	Top hot-air guide
		<b>117.053</b>	Preheat nozzle 20 mm, small
		<b>117.518</b>	25 mm, medium
		<b>141.177</b>	35 mm, large
		<b>149.723</b>	Insulation sleeve WELDPLAST S4

\* a = Welding seam thickness

Plastic Fabrication

# WELDPLAST S2 / S2 PVC: The masterpieces.

WELDPLAST S2 and S2 PVC are masterpieces of modern technology. While externally they fulfill the highest requirements of functionality and design, their interior satisfies the highest expectations concerning the material to be processed. The WELSDPLAST S2 PVC has integrated corrosion protection and has been especially designed to satisfy the high requirements of PVC extrusion welding. Their perfect seam quality makes both – WELDPLAST S2 and S2 PVC – reliable partners for today and tomorrow.

Digitally regulated extrusion welder

## WELDPLAST S2



- Maintenance-free blower
- Perfect weld seam quality
- Multifunctional display
- Ergonomic and handy
- Successfully operated worldwide

### Technical Data

Voltage	V~	230
Power	W	3000
Material		PE / PP Other materials on request
Welding rod	mm	Ø 3 oder Ø 4
Output Ø 3 mm	kg/h	PE: 0.6 – 1.3   PP: 0.5 – 1.2
Output Ø 4 mm	kg/h	PE: 1.0 – 2.0   PP: 0.9 – 2.0
Size (L x W x H)	mm	450 x 98 x 260
Weight	kg	5.8
Conformity mark		CE
Protection class I		⊕

### Article No.:

127.215 WELDPLAST S2, 230 V / 3000 W, Euro plug

Included with purchase: WELDPLAST S2, welding shoe raw part, storage case  
Included with purchase: WELDPLAST S4, preheat nozzle large, medium and small, storage case

Digitally regulated extrusion welder

## WELDPLAST S2 PVC



- Optimized for PVC-U
- Perfect weld seam quality
- PVC specific extrusion menu
- Corrosion protection
- Standby mode

### Technical Data

Voltage	V~	230
Power	W	3000
Material		PVC-U, PE, PP Other materials on request
Welding rod	mm	Ø 3 oder Ø 4
Output Ø 3 mm	kg/h	PVC-U: 0.9 – 1.7   PE: 0.6 – 1.3
Output Ø 4 mm	kg/h	PVC-U: 1.5 – 2.7   PE: 1.0 – 2.3
Size (L x W x H)	mm	450 x 98 x 260
Weight	kg	5.8
Conformity mark		CE
Protection class I		⊕

### Article No.:

135.724 WELDPLAST S2 PVC, 230 V / 3000 W, Euro plug

Included with purchase: WELDPLAST S2 PVC, 3 preheati nozzles, welding shoe K 8 / 10 mm (Art. no. 146.236), storage case



The handy WELDPLAST S2 in action.



Even inside radiuses are easy to weld.

## Accessories WELDPLAST S2

		<b>Welding shoe complete</b>
<b>145.945</b>	45 × 30 × 54 mm blank welding shoe	
<b>145.946</b>	74 × 50 × 58 mm blank welding shoe	
		<b>145.896</b> 25 mm overlap
		<b>145.947</b> 30 mm overlap
		<b>145.897</b> 35 mm overlap
		<b>145.912</b> 5 / 6 V-seam
		<b>145.915</b> 8 / 10 V-seam
		<b>145.907</b> 12 mm V-seam
		<b>145.903</b> 15 mm V-seam
		<b>145.909</b> 20 mm V-seam
		<b>145.916</b> 25 mm V-seam
		<b>145.943</b> 5 / 6 mm fillet weld (a = 4.2 mm*)
		<b>145.944</b> 8 / 10 mm fillet weld (a = 7 mm*)
		<b>145.812</b> 15 mm fillet weld (a = 10*)
		<b>145.940</b> 20 mm fillet weld (a = 14 mm*)
		<b>145.816</b> 25 mm fillet weld (a = 17.5 mm*)
		<b>146.643</b> Corner outside seam 8 mm
		<b>146.645</b> Corner outside seam 10 mm
		<b>146.649</b> Corner outside seam 12 mm
		<b>146.651</b> Corner outside seam 15 mm
		<b>145.811</b> Corner seam $\varnothing$ 14 mm
		<b>145.488</b> Corner seam $\varnothing$ 20 mm
		<b>139.460</b> 45° angled adapter
		<b>139.461</b> 90° angled adapter
		<b>154.002</b> Insulation sleeve WELDPLAST S2
		<b>161.119</b> Support clamp WELDPLAST S2

\* a = Welding seam thickness



With the WELDPLAST S2 perfect welds are possible

## Accessories WELDPLAST S2 PVC

		<b>Welding shoe complete</b>
<b>146.239</b>	54 × 40 × 52 mm blank welding shoe	
<b>146.240</b>	74 × 50 × 58 mm blank welding shoe	
		<b>146.241</b> 25 mm overlap
		<b>146.242</b> 35 mm overlap
		<b>146.248</b> 5 / 6 mm V-seam
		<b>146.249</b> 8 / 10 mm V-seam
		<b>146.243</b> 12 mm V-seam
		<b>146.244</b> 15 mm V-seam
		<b>146.235</b> 5/6 mm fillet weld seam (a = 4.2 mm*)
		<b>146.236</b> 8/10 mm fillet weld seam (a = 7 mm*)
		<b>146.231</b> 15 mm fillet weld seam (a = 10 mm*)
		<b>146.642</b> Corner outside seam 8 mm
		<b>146.644</b> Corner outside seam 10 mm
		<b>146.646</b> Corner outside seam 12 mm
		<b>146.652</b> Corner outside seam 15 mm
		<b>146.230</b> Corner seam $\varnothing$ 14 mm
		<b>146.218</b> Corner seam $\varnothing$ 20 mm
		<b>133.850</b> Top hot-air guide

\* a = Welding seam thickness



The 45° angled adapter for the WELDPLAST S2 facilitates welding in difficult positions. (accessory)

General accessories 104

# WELDPLAST S1: Outstandingly compact.

With the new WELDPLAST S1 compact extruder, you can achieve perfect seam quality



Unattainable is weldable with the new 45° and 90°angled adapters.

Digitally regulated extrusion welder

## WELDPLAST S1



- Functional, ergonomic design with comfort grip areas
- Extremely high output power of 0.8 kg/h (HD-PE)
- Integrated LED lighting and hanging point
- Can work with all typical kinds of plastic
- Multifunction panel with predefined welding parameters
- BL blower, adjustable air volume

### Technical Data

Voltage	V~	230 / 120 / 100
Power	W	1600 / 1800 / 1500
Material		HD-PE, LD-PE, PP, PVC-U PVC-C, PVDF, ECTFE, PA
Welding rod	mm	Ø 3 – 4
Output	kg/h	0.2 – 0.8 (PVC up to 1.15 kg/h)
Size (L × W × H)	mm	435 × 91 × 264
Integrated welding profiles		HD-PE, PP, PVC-U, PVC-C, PVDF 10 free profile storage spaces
Weight	kg	4.7
Conformity mark		CE
Protection class I		⊕

### Article No.:

- 148.396 WELDPLAST S1, 230 V / 1600 W, Ø 3 – 4 mm, Euro plug
- 148.395 WELDPLAST S1, 120 V / 1800 W, Ø 3 – 4 mm, without plug
- 148.394 WELDPLAST S1, 100 V / 1500 W, Ø 3 – 4 mm, Euro plug

Included with purchase: WELDPLAST S1, user manual, 4 pre-heating nozzles Ø 14 mm, welding shoe K10, storage case

## Accessories WELDPLAST S1

	<b>149.430</b>	<b>Welding shoe complete</b> Blank
	<b>149.402</b>	Fillet weld 5 / 6
	<b>148.627</b>	Fillet weld 8 / 10
	<b>149.401</b>	Fillet weld 12
	<b>149.388</b>	V-seam 3 / 4
	<b>149.383</b>	V-seam 5 / 6
	<b>149.385</b>	V-seam 8 / 10
	<b>149.364</b>	Corner <b>For additional welding shoes, see Weldplast S2 PVC</b>
	<b>152.720</b>	Nozzle extension
	<b>153.143</b>	Angled adapter 45°
	<b>153.236</b>	Angled adapter 90°
	<b>149.600</b>	Top hot-air guide
	<b>149.456</b>	Hot-air tube, position 6h Ø 14 mm
	<b>149.461</b>	Hot-air tube, position 6h Ø 16 mm
	<b>149.467</b>	Hot-air tube, position 9h/3h Ø 14 mm (standard)
	<b>149.469</b>	Hot-air tube, position 9h/3h Ø 16 mm
	<b>154.107</b>	Air nozzle set Ø 14 mm (standard)
	<b>154.106</b>	Air nozzle set Ø 16 mm
	<b>154.002</b>	Insulation sleeve WELDPLAST S1/S2

## FUSION 3: Long and slim.

With its long and narrow shape, the FUSION 3 enables comfortable work, even on the floor.

## FUSION 3C: Short and handy.

The somewhat shorter FUSION 3C provides an astounding output volume of up to 3.6 kilograms per hour.

Air heated extrusion welder

### FUSION 3



Air heated extrusion welder

### FUSION 3C



- High-quality welding performance
- Compact and handy
- Motor start-up protection prevents cold start
- Simple operation
- Dual-sided twist-free wire intake
- 360° rotating welding shoe

- High-quality welding performance
- Compact and handy
- Motor start-up protection prevents cold start
- Simple operation
- Dual-sided, twist-free wire intake
- 360° rotating welding shoe

#### Technical Data

		Version Ø 3 – 4		Version Ø 4 – 5	
Welding rod Ø	mm	3	4	4	5
Output PE	kg/h	2.0 - 2.5	2.7 – 3.6	2.1 – 2.6	2.7 – 3.6
Output PP	kg/h	1.8 – 2.3	2.5 – 3.4	1.8 – 2.4	2.5 – 3.4
Voltage	V~	230			
Power	W	3500			
Material		PE / PP			
Size (L x W x H)	mm	670 x 90 x 180			
Weight	kg	7.2			
Conformity mark		CE			
Protection class II		□			

#### Article No.:

118.300 FUSION 3, 230 V / 3500 W, welding rod Ø 3 – 4 mm, Euro plug  
 144.615 FUSION 3, 230 V / 3500 W, welding rod Ø 4 – 5 mm, Euro plug

Included with purchase: FUSION 3, welding shoe overlap 30 mm, storage case

#### Technical Data

		Version Ø 3 – 4		Version Ø 4 – 5	
Welding rod Ø	mm	3	4	4	5
Output PE	kg/h	2.0 - 2.5	2.7 – 3.6	2.1 – 2.6	2.7 – 3.6
Output PP	kg/h	1.8 – 2.3	2.5 – 3.4	1.8 – 2.4	2.5 – 3.4
Voltage	V~	230			
Power	W	3200			
Material		PE / PP			
Size (L x W x H)	mm	588 x 98 x 225			
Weight	kg	6.9			
Conformity mark		CE			
Protection class II		□			

#### Article No.:

123.866 FUSION 3C, 230 V / 3200 W, welding rod Ø 3 – 4 mm, Euro plug  
 144.826 FUSION 3C, 230 V / 3200 W, welding rod Ø 4 – 5 mm, Euro plug

Included with purchase: FUSION 3C, blank welding shoe, storage case


















Perfectly stored in the case.



FUSION 3C during the welding of a V-seam.

## Accessories FUSION 3 / 3C

		<b>Welding shoe complete</b>
		<b>145.945</b> 45 × 30 × 54 mm blank welding shoe
		<b>145.946</b> 74 × 50 × 58 mm blank welding shoe
		<b>145.896</b> 25 mm overlap
		<b>145.947</b> 30 mm overlap
		<b>145.897</b> 35 mm overlap
		<b>145.912</b> 5 / 6 V-seam
		<b>145.915</b> 8 / 10 mm V-seam
		<b>145.907</b> 12 mm V-seam
		<b>145.903</b> 15 mm V-seam
		<b>145.909</b> 20 mm V-seam
		<b>145.916</b> 25 mm V-seam
		<b>145.943</b> 5 / 6 mm fillet weld (a = 4.2 mm*)
		<b>145.944</b> 8 / 10 mm fillet weld (a = 7 mm*)
		<b>145.812</b> 15 mm fillet weld (a = 10 mm*)
		<b>145.940</b> 20 mm fillet weld (a = 14 mm*)
		<b>145.816</b> 25 mm fillet weld (a = 17.5 mm*)
		<b>146.643</b> Corner outside seam 8 mm
		<b>146.645</b> Corner outside seam 10 mm
		<b>146.649</b> Corner outside seam 12 mm
		<b>146.651</b> Corner outside seam 15 mm
		<b>145.811</b> Corner seam Ø 14 mm
		<b>145.488</b> Corner seam Ø 20 mm
		<b>148.817</b> 45° angled adapter
		<b>148.816</b> 90° angled adapter
		<b>149.421</b> Insulation sleeve FUSION 3
		<b>149.420</b> Insulation sleeve FUSION 3C

\* a = Welding seam thickness

The insulation sleeve protects the machine from heat loss, as well as protects the operator from direct contact with the extruder.



# FUSION 2: The small powerhouse.

The FUSION 2 convinces with its ergonomic design. The simple operation and first-class welding quality have helped it to become the breakthrough product.



In operation during container construction in China.

Air heated extrusion welder

## FUSION 2



- At 450 mm, it is the shortest in its performance class!
- Motor start-up protection prevents cold start
- Simple operation
- Dual-sided, twist-free wire intake
- 360° rotating welding shoe
- Integrated electronics for stepless adjustment of the preheating temperature and output quantity

### Technical Data

Voltage	V~	230 / 120
Power	W	2800
Material		PE / PP
Air temperature	°C	up to 340
Plastification temperature	°C	up to 300
Welding rod	mm	∅ 4
Output PE	kg/h	1.3 – 1.8
Size (L × W × H)	mm	450 × 98 × 225
Weight	kg	5.9
Conformity mark		CE
Protection class II		□

### Artikel-Nr.

- 119.200 FUSION 2, 230 V / 2800 W, Euro plug  
150.102 FUSION 2, 120 V / 2800 W, CEE plug

Included with purchase: FUSION 2, blank welding shoe, storage case

## Accessories FUSION 2

Welding shoe complete	
145.945	45 × 30 × 54 mm blank welding shoe
145.946	74 × 50 × 58 mm blank welding shoe
145.896	25 mm overlap
145.947	30 mm overlap
145.897	35 mm overlap
145.912	5 / 6 V-seam
145.915	8 / 10 mm V-seam
145.907	12 mm V-seam
145.903	15 mm V-seam
145.943	5 / 6 mm fillet weld (a = 4.2 mm*)
145.944	8 / 10 mm fillet weld (a = 7 mm*)
145.812	15 mm fillet weld (a = 10 mm*)
146.643	Corner outside seam 8 mm
146.645	Corner outside seam 10 mm
146.649	Corner outside seam 12 mm
146.651	Corner outside seam 15 mm
145.811	Corner seam ∅ 14 mm
145.488	Corner seam ∅ 20 mm
147.602	45° angled adapter
147.601	90° angled adapter

\* a = Welding seam thickness



Draw welding on a PE-container with the DIODE PID.



The WELDPLAST S4 during outdoor use in Spain.

## General accessories hand extruder

	<p><b>Tool rest</b>  <b>131.451</b> WELDPLAST S2 / S2 PVC / FUSION 2 / FUSION 3C  <b>148.923</b> WELDPLAST S1  <b>160.454</b> WELDPLAST S4 / WELDPLAST S6 / FUSION 3</p>		<p><b>154.259</b> Scrapper blade</p>
	<p><b>Pre-heat reflector</b>  <b>136.231</b> WELDPLAST S1/S2 / S2 PVC / S4 / S6 / FUSION 2 / 3 / 3C</p>		<p><b>154.026</b> Contour scrapper</p>
	<p><b>134.361</b> Air filter WELDPLAST S1 / S2 / S2 PVC (included with purchase)  <b>143.776</b> Textile dust filter WELDPLAST S1 / S2 PVC (in combination with Air filter) (not included with purchase)  <b>135.082</b> Air filter FUSION 2 / 3C  <b>155.829</b> Air filter WELDPLAST S2</p>		<p><b>Heating element</b>  <b>134.567</b> 230 V / 2600 W, WELDPLAST S6  <b>109.984</b> 230 V / 2200 W, WELDPLAST S4 / S2 / S2 PVC  <b>113.268</b> 230 V / 1100 + 1100 W, FUSION 3  <b>123.561</b> 230 V / 1750 W, FUSION 2 / 3C  <b>149.265</b> 230 V / 1000 W, WELDPLAST S1  <b>149.529</b> 120 V / 1100 W, WELDPLAST S1  <b>149.530</b> 100 V / 1050 W, WELDPLAST S1  <b>151.026</b> 120 V / 1750 W, FUSION 2</p>
	<p><b>153.009</b> Corner Press Tool</p>		
	<p><b>152.676</b> Welding Gauge</p>		
	<p><b>144.095</b> Welding rod de-reeler</p>		
	<p><b>Storage case</b>  (included with purchase)  <b>116.367</b> WELDPLAST S6  <b>123.173</b> WELDPLAST S4 / FUSION 3  <b>119.540</b> WELDPLAST S2 / S2 PVC / S1 / FUSION 2 / 3C</p>		

PLASTFIX lends the weld seam the necessary holding pressure.





## Welding rods

Article		Profile	Colour	kg
<b>Welding accessories PE</b>				
104.283	HDPE welding rod	A	■	3
104.294	HDPE welding rod	A	□	3
104.284	HDPE welding rod	B	■	5
104.299	HDPE welding rod	B	□	5
106.650	HDPE welding band	C	□	1
104.300	LDPE welding rod	A	■	3
161.612	HDPE welding rod	D	■	2
116.918	PE100 welding rod	D	■	2
<b>Welding accessories PP</b>				
104.287	PP welding rod	A	■	3
104.301	PP welding rod	A	■	3
104.288	PP welding rod	B	■	5
126.356	PP welding band	C	□	2
161.611	PP welding rod	D	■	2
<b>Welding accessories PVC</b>				
104.296	PVC-U welding rod (hard)	A	□	3
104.278	PVC-U welding rod (hard)	A	■	3
106.641	PVC-U welding rod	A	■	3
104.280	PVC-U welding rod (hard)	B	■	5
104.279	PVC-U welding rod (hard)	B	■	5
104.302	PVC-P welding rod (soft)	A	□	3
<b>Welding accessories ABS</b>				
104.295	ABS welding rod	A	□	3
113.587	ABS welding rod	A	■	3
107.027	ABS welding band	C	□	1

## Profile sizes

Dimensions in mm

Profile A	Profile B	Profile C	Profile D

Article		Profile	Colour	kg
<b>Welding accessories div.</b>				
104.297	PA welding rod	A	■	3
104.298	PC welding rod	A	□	3
104.313	PC welding rod / ABS / ALPHA (Honda)	A	■	3
104.308	PUR welding rod	A	■	3
106.654	Xenoy welding band	C	■	2
106.642	PPs welding rod, flame resistant	A	■	3
104.304	PVDF welding rod	A	□	3
104.303	POM welding rod	A	□	3
<b>Test bundles</b>				
107.036	Test bundle bodywork welding rods, each consisting of profile A pieces of 37 cm single marked 6x HDPE, 6x PP, 6x PA, 6x PC, 6x ABS, 6x PCABS / ALPHA Honda, 6x PC / PBTP / Xenoy	A		
107.037	Test bundles standard each consisting of profile A pieces of 37 cm single marked 5x PVC-U, 5x PVC-P, 5x PP, 5x ABS, 5x HDPE, 3x PC, 3x PA, 3x POM, 3x LDPE, 3x PC / ABS / ALPHA Honda, 3x PC / PBTP / Xenoy	A		
107.040	Test bundle welding band each consisting of profile A pieces of 37 cm single marked 9x HDPE, 8x 2 mm white, 9x PP, 8x 2 mm natural, 9x ABS, 8x 2 mm white, 9x PC / PBTP / Xenoy grey	C		





Promotes the life of the floor.



For aseptic applications.



Suitable for frequent cleaning.

## Flooring / Interior Decoration

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## Hot-Air Hand Tools

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TRIAK AT	13 – 15
ELECTRON ST	16 / 17
HOT JET S	18 / 19
GHIBLI AW	20 / 21
General accessories	34 / 35

## Overview Flooring



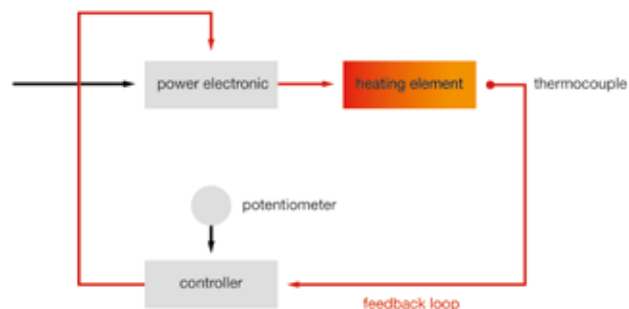
Typ		GROOVY	GROOVER	MINIFLOOR	UNIFLOOR
Area of application		Gouging tool for elastic floor coverings	Grooving machine for elastic floor coverings	Drive unit for welding elastic floor coverings	Welder for welding elastic floor coverings
Groove wide	mm	2.5 / 3.5	2.5 / 2.8 / 3.5 / 4.0	2.5 - 4.0	2.5 - 4.0
Groove depth	mm	0.5 - 2.5	0.0 - 4.0	2.5 - 4.0	2.5 - 4.0
Speed	m/min	-	Phase 1 (Linoleum) 4 - 6 Phase 2 (PVC, TPU, PU) 8 - 12	0.5 - 4.5	1.0 - 7.5
Temperature	°C	-	-	40 - 620 (with TRIAC AT)	80 - 620
Air flow range	%	-	-	20 - 100 (with TRIAC AT)	50 - 100
Voltage	V	-	120 / 230	100 - 230	120 / 230
Frequenz	Hz	-	50 / 60	50 / 60	50 / 60
Power	W	-	Phase 1 (Linoleum) 350 Phase 2 (PVC, TPU, PU) 700	drive unit 5 with TRIAC AT 1605	2300
Weight	kg	0.29	6.7	5.3	11.5
Size	mm	180 x 42 x 92	240 x 205 x 255	310 x 225 x 245	495 x 225 x 295
Cable length	m	-	3	3	3
<b>Startup parameters*</b>					
Materials			Linoleum (Phase 1) / PVC, TPU, PU (Phase 2)	Linoleum / PVC, TPU, PU	Linoleum / PVC, TPU, PU
Speed	m/min	-	5 / 10	1.5 / 1.5	3 / 3
Temperature	°C	-	- / -	400 - 450 / 500 - 550	400 - 450 / 500 - 550
Air flow range	%	-	- / -	100% / 100%	100% / 100%
<b>Catalog page</b>		<b>114</b>	<b>113</b>	<b>110 / 111</b>	<b>112</b>

\*The parameters listed are purely reference values (room temperature 20°C). A test weld which takes into account the information provided by the material manufacturer is absolutely essential.

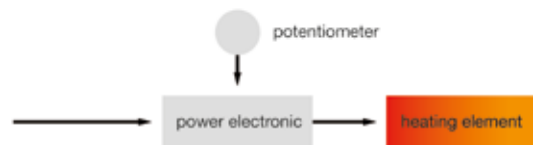
## Closed-loop system

The closed-loop technology means that the parameters are kept constant at all times, even in the event of voltage fluctuations, enabling reliable welding in the building site environment.

Closed loop System



Open loop System



## Procedures for welding floor coverings



**Step 1:**  
Milling the groove  
with the GROOVER.



**Step 2:**  
Inserting the welding rod into  
the groove with the  
UNIFLOOR E hot-air welder.



**Step 3:**  
Removing the excess welding  
rod with trimmer guide and  
spatula



**Step 4:**  
Levelling the protruding  
welding rod with the spatula.

# MINIFLOOR – efficient and affordable for everyone!

The MINIFLOOR turns your hot-air hand tool into an automatic welder within seconds; increases the weld quality, facilitates work, and reduces time considerably. Its use is worthwhile from weld lengths of 1.20 m/4 ft., and thanks to its lightweight design of 5.3 kg/12 lbs., the MINIFLOOR can be transported effortlessly.

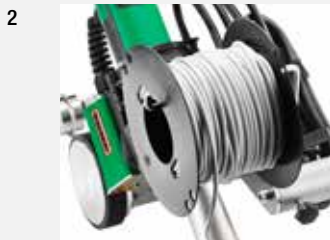
Hot-air welder

## MINIFLOOR



1

**Reverse compatibility:** Thanks to the interchangeable inserts, even older TRIAC models can be connected without a hitch.



2

**Tool-free assembly of the de-reeler:** even if the de-reeler is missing you may count on hassle-free handling, as well as smooth feeding of the welding rod into the "air-slide" of the speed welding nozzle.



3

**Incredibly fast:** Despite its lightweight design, the MINIFLOOR offers a welding speed of about 2 m/6.5 ft per minute, nearly double the speed of manual welding.



4

**The quick-lock fastening system at the clamp allows for assembling / dismantling of the TRIAC** in a matter of seconds. The power supply for the hand tool is integrated in the MINIFLOOR drive unit and you have the possibility to securely fasten the cable.



5

**The individually-adjustable, start-up delay** of the MINIFLOOR drive unit enables modification of the startup according to individual needs. The long guide ensures outstanding precision along the seam.



6

**The 51 mm/2 inches minimum distance from the wall**, ensures trouble-free welding around construction pipes and L-skirts. Due to its compact height, the MINIFLOOR seamlessly welds beneath obstacles with a minimum clearance of 295 mm /12 inches.



The MINIFLOOR is ideal for short joints and small projects.



**Professional, inexpensive, incredibly versatile:** The new MINIFLOOR (TRIAC plus drive unit) for smart professionals.

Hot-air welder / drive unit

## MINIFLOOR Drive Unit



- The only automatic welder with the possibility of connecting a hot-air hand tool in the simplest manner.
- Worthwhile from weld lengths of 1.20 m/4 ft.
- Swiss Quality you can rely on.
- Due to (51 mm/2 inches) minimum distance from the wall, there is only one required joint along the weld seam, and THAT saves time!
- Weighting in at 6.6 kg / 15 lbs (incl. TRIAC AT / nozzles) the MINIFLOOR is a lightweight and easily transportable solution.
- **NEW:** Improved directional stability!

## Accessories MINIFLOOR Drive Unit

	TRIAC AT / TRIAC ST All models and part numbers can be found at chapter Hot-Air Hand Tools
	<b>154.266</b> Storage case MINIFLOOR
	<b>156.531</b> Carrying strap for Leister Case
	<b>154.723</b> Rubber pads for TRIAC-bracket (old generation Ø 64 mm)
	<b>100.303</b> Ø 5 mm, tubular nozzle, push-fit
	Speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle
	<b>105.432</b> Ø 4 mm <b>105.433</b> Ø 5 mm ( <b>recommended</b> )
	<b>154.425</b> Replacement Guide wheel <b>159.436</b> Guide wheel 0.5 mm Guide wheel 2.0 mm
	<b>163.870</b> Additional weight, increases the directional stability. Compatible with previous models

Technical Data		Drive Unit only	with TRIAC AT
<b>MINIFLOOR</b>			
Voltage	V~	100 – 230	100 / 120 / 230
Frequency	Hz	50/60	50/60
Power	W	5	1600
Temperature	°C		40 – 620
Air flow range	%		20 – 100%
Drive speed	m/min	0.5 – 4.5	0.5 – 4.5
Control		Closed-loop	Closed-loop/Display
Blower			Brush motor
Welding seam	mm		2.5 / 3.5
Size (L × W × H)	mm	310 × 225 × 245	495 × 225 × 295
Weight	kg	5.3	6.6 (incl. Nozzles)
Conformity marks		CE	CE
Protection class I		⊕	⊕   □

### MINIFLOOR Drive Unit

#### Article No.:

154.330 MINIFLOOR drive unit, with EU-plug; 230V  
 154.334 MINIFLOOR drive unit, with CH-plug; 230V  
 154.337 MINIFLOOR drive unit, with UK-plug; 110V  
 154.338 MINIFLOOR drive unit, with AUS-plug; 230V  
 Scope of delivery: Plastic case, Roller Holder, Rubber pad set Ø 57 - Ø 60 mm, Velcro fastener 2 pcs, Operating Manual

154.335 MINIFLOOR drive unit, with US/JP-plug; 120V  
 154.336 MINIFLOOR drive unit, without plug; 230V  
 Scope of delivery: Plastic case, Roller Holder, Rubber pad set Ø 57 - Ø 60 mm, Rubber pad set Ø 64 - Ø 65 mm, Velcro fastener 2 pcs, Operating Manual

General accessories



# UNIFLOOR E / S: A jack of all trades.

With the UNIFLOOR E you can weld floor coverings made of PVC-P, PE, linoleum and modified thermoplastics without any reconfiguration, up to 7.5 meters per minute.



UNIFLOOR E, the reliable partner for welding floor coverings.

Hot-air welder

## UNIFLOOR E / UNIFLOOR S

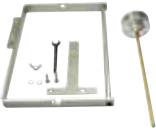






- Reproducible results thanks to permanent regulation of the NOMINAL and ACTUAL values
- Heater and drive electronically regulated
- Steplessly controlled air flow (only UNIFLOOR E)
- All floor coverings welded without reconfiguration
- Automatic start
- Integrated wall switch

### Technical Data

Voltage	V~	120 / 230
Power	W	2300
Temperature	°C	80 – 620
Speed	m/min	1.0 – 7.5
Air flow range	%	50 – 100
Size (L x W x H)	mm	420 x 270 x 215
Weight (without de-reeler)	kg	11.5 (with 3 m cable)
Conformity marking	CE	
Protection class I	⊕	

## Accessories UNIFLOOR E / UNIFLOOR S

	<b>115.054</b> Welding rod de-reeler
	<b>115.057</b> Trolley attachment
	<b>114.224</b> Floor welding nozzle, optimized for PVC material
	<b>115.342</b> Floor welding squeezed nozzle, for PVC + PUR material
	<b>103.394</b> Floor welding nozzle air-knife, optimized for PUR material
	<b>115.216</b> 3/3 air flap for Linoleum welding rod
	<b>117.235</b> 2/3 air flap, optimized for PUR material and linoleum welding rod
	<b>126.448</b> Storage case 605 x 486 x 312 mm plastic, green (included with purchase)
	<b>103.604</b> Heating element, 230 V / 2100 W
	<b>103.602</b> Heating element, 120 V / 1800 W

### Article No.:

138.493	UNIFLOOR E, 230 V, including rod de-reeler, squeezed nozzle (PVC and PUR), with Euro plug, storage case
115.345	UNIFLOOR E, 230 V, squeezed nozzle (PVC and PUR), with Euro plug, storage case
138.494	UNIFLOOR S, 230 V, including rod de-reeler, squeezed nozzle (PVC and PUR), with Euro plug, storage case
115.032	UNIFLOOR S, 230 V, squeezed nozzle (PVC and PUR), with Euro plug, storage case
139.217	UNIFLOOR E, 230 V, including rod de-reeler, Air-Knife nozzle, 2/3 air flap (PUR), with Euro plug, storage case
115.024	UNIFLOOR E, 120 V, squeezed nozzle (PVC and PUR), without plug, storage case

General accessories



# GROOVER: Dust-free milling.

The GROOVER grooving machine cuts welding grooves into thick, tough floor coverings made of PVC-P, PE and linoleum. The tool glides on three rollers and cuts a uniform groove depth, even at high speeds.



Strong drive suitable for PVC, PUR and linoleum materials.

Grooving machine

## GROOVER



- Cuts grooves into of all types of floor coverings
- Extremely high, two stage cutting speeds
- Adjustable guide roller for tracking accuracy
- Reduced dust particles when used with dust bag
- Cutting close to the edge possible

Technical Data		
Voltage	V~	120 / 230
Power	W	350 / 700 (2 levels)
Cutting speeds	rpm	Level 1: 14 500 (350 W) Level 2: 18 500 (700 W)
Groove depth adjustment	mm	0 – 4
Size (L × W × H)	mm	240 × 205 × 255
Weight	kg	6.7 (with 3 m cable)
Conformity marking		CE
Approval mark		Ⓢ
Protection class II		□

## Accessories GROOVER

	<b>102.401</b> Ø 110 × 3.5 mm, tungsten carbide-tipped blade, trapezium profile
	<b>102.402</b> Ø 110 × 4 mm, tungsten carbide-tipped blade, round profile
	<b>102.404</b> Ø 110 × 2.5 mm, tungsten carbide-tipped blade, round profile
	<b>102.403</b> Ø 110 × 2.8 mm, tungsten carbide-tipped blade, round profile
	<b>102.405</b> Ø 110 × 3.5 mm, tungsten carbide-tipped blade, round profile
	<b>102.406</b> Ø 110 × 3.5 mm, diamond cutting blade, semi-round profile
	<b>126.448</b> Storage case (included with purchase)

### Article No.:

- 108.393 GROOVER 230 V, tungsten carbide tipped blade Ø 110 x 3.5 mm, trapezium profile, with Euro plug, storage case
- 111.032 GROOVER 230 V, tungsten carbide tipped blade Ø 110 x 3.5 mm, round profile, with Euro plug, storage case
- 108.397 GROOVER 120 V, tungsten carbide tipped blade Ø 110 x 3.5 mm, trapezium profile, with UK plug yellow, storage case
- 108.395 GROOVER 120 V, tungsten carbide tipped blade Ø 110 x 3.5 mm, trapezium profile, with US plug polarized, storage case
- 108.396 GROOVER 120 V, tungsten carbide tipped blade Ø 110 x 2.5 mm, round profile, with US plug nonpolarized, storage case

# GROOVY: Lightweight and handy.

The new “GROOVY” gouging tool is the lightweight, handy tool for the experienced layer of plastic floor coverings made of PVC or linoleum. Its ergonomic shape makes it possible to achieve the desired groove width and depth up to the connecting walls, defined and clean-cut, with little pressure.

## Gouging tool GROOVY



- Lightweight and handy
- Groove preparation without milling
- Clean transition from machine-milled groove to the closure
- Ideal for surfaces that are small and difficult to access
- Precise work thanks to roller guide
- Groove gouging up to connecting walls
- Adjustable groove depth




### Technical Data

Groove wide	mm	3.5
Groove depth	mm	0.5 – 2.5
Size (L x W x H)	mm	180 x 42 x 92
Weight	kg	0.290

### Article number:

150.809 Gouging tool “GROOVY” 3.5 mm for elastic floor coverings

## Accessories GROOVY

	<b>151.394</b> Protective plug
	<b>150.815</b> Blade Ø 3.5 mm
	<b>154.717</b> Blade Ø 2.5 mm
	Replacement Guide wheel
	<b>154.279</b> Guide wheel 1.8 mm
	<b>151.453</b> Guide wheel pointed

Ideal for surfaces that are small and difficult of access



Executing clean grooves up to connecting walls











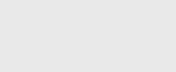
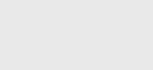



Precise and simple guidance thanks to integrated guide rollers



## General accessories

	<b>100.303</b> Ø 5 mm, tubular nozzle, 15° angled, push-fit (TRIAC)
	<b>107.144</b> Ø 5 mm, tubular nozzle, 15° angled, push-fit (HOT JET S)
	<b>105.576</b> Ø 5 mm, tubular nozzle, 90° angled, push-fit (TRIAC)
	<b>131.867</b> Ø 5 mm, tubular nozzle, 90° angled, push-fit (HOT JET S)
	<b>105.567</b> Ø 5 mm, tubular nozzle, 150 mm, straight (HOT JET S)
	<b>105.575</b> Ø 5 mm, tubular nozzle, 100 mm, straight (TRIAC)
	<b>105.431</b> 3 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle
	<b>105.432</b> 4 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle
	<b>105.433</b> 5 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle
	<b>107.139</b> 4.5 × 12 mm speed weld nozzle for fillet weld, push-fit on Ø 5 mm tubular nozzle
	<b>107.137</b> 8 mm speed weld nozzle for tape welding, push-fit on Ø 5 mm tubular nozzle
	<b>159.848</b> speed weld nozzle 5 mm, with small air-slide, curved, push-fit on 5 mm tubular nozzle
	<b>160.550</b> speed weld nozzle 3 mm, with small air-slide, curved, push-fit on 5 mm tubular nozzle
	<b>107.270</b> Wide slot nozzle 150 × 12 mm, push-fit (ELECTRON)
	<b>142.281</b> Scraper nozzle (ELECTRON)

	<b>148.933</b> Protective tube (ELECTRON)
	<b>106.970</b> Pressure roller for welding rods Ø 4 – 5 mm
	<b>106.971</b> for welding rods Ø 2 – 4 mm
	<b>106.966</b> Hand grooving tool
	<b>106.968</b> Spare blades for hand grooving tool
	<b>150.809</b> Hand splice tool «Groovy» for flooring applications
	<b>157.544</b> Leister Universal scissors 260 mm with special shaft grinding
	<b>106.969</b> Quarter Moon Knife including leather case, 100 mm stainless steel blade
	<b>122.541</b> Trimming guide, to use with spatula (106.969)
	<b>137.855</b> Leister cutter with four spare blades
	<b>138.902</b> Hooked blade for LEISTER-cutter (10 dispenser with 10 pcs=100 pcs)
	<b>138.539</b> Straight-edge blade for LEISTER-cutter (10 dispenser with 10 pcs = 100 pcs)
	<b>116.798</b> Brass brush
	<b>142.647</b> Brass brush Ø 3 mm

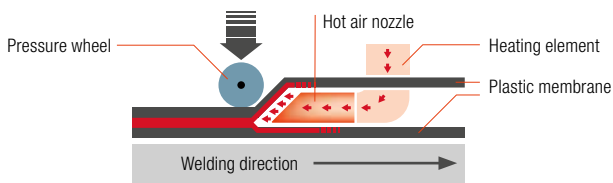
# Leister. We know how.

Leister is a world leader in the industry and one of the pioneers in the fields of hot-air, hot-wedge and extrusion welding processes.

Leister Technologies AG manufactures high-quality welding machines for demanding work for all industries, in which plastic is processed.

## Know-how

### Welding Methods

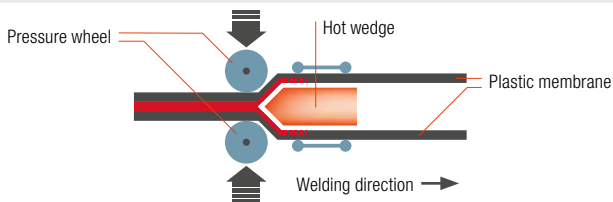


#### Hot-air welding

Hand tools, automatic welders, stationary welding machines



In hot gas welding, the thermal energy is controlled. Heated air is fed into the workpiece and the required amount of pressure is exerted onto the wheels.

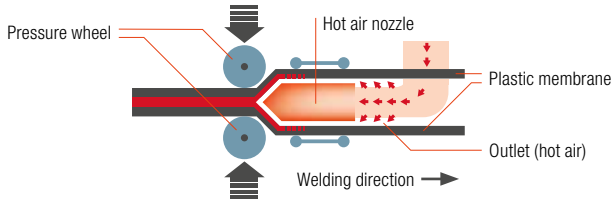


#### Hot-wedge welding

Wedge welders



The process where the wedge is heated directly by heating cartridges. The generated heat is transferred directly onto the workpiece. This method also is suitable for thicker materials.

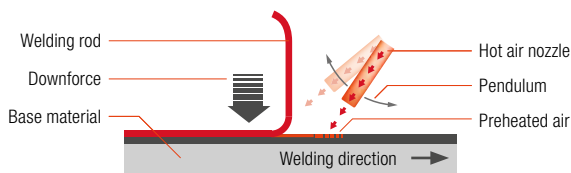


#### Combi-wedge welding

Combi-wedge welding machines



When Combi-wedge welding (combination of a heated wedge and hot air), preheating of the air and the actual welding process is carried out over a wedge. The preheated air also takes partial cleaning of the workpieces.

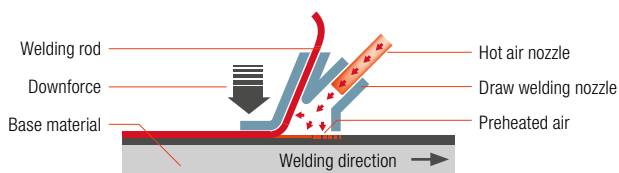


#### Pendulum Welding

Hand tools



Pendulum welding requires a welding rod similar to the base material. Both surfaces are then heated using hot air. Using an up and down, pendulum-like motion and consistent downward pressure, the two are joined.

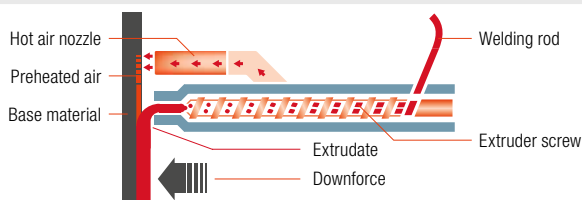


#### Draw Welding (Speed Welding)

Hand tools



This welding method requires the use of a speed welding nozzle. Preheat the surfaces to the appropriate temperature. The surfaces are plasticized by hot air and joined under consistent downward pressure.



#### Extrusion Welding

Extrusion Welders (FUSION & WELDPLAST)



In extrusion welding, the substrate is preheated with hot air and connected by adding the extrudate. The welding rod is fed into the heater barrel and the plast is processed by the extruder screw.







# Plastic welding with Leister

In plastic welding, thermoplastic materials are joined through the combination of thermal energy, pressure and welding speed. Combined, these key factors are the main considerations in the welding of many types of applications including: roofing, civil engineering, tunneling, tents & tarps, signs & banners, floor coverings, vehicle repairs, plastic fabrication and many more.

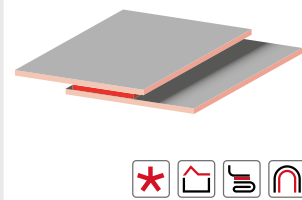
Know-how

## Weld Types / Weld Geometries

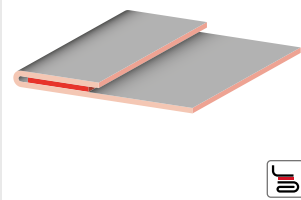
### Welding without filler material

-  Special applications
-  Roofing
-  Technical Textiles
-  Civil Engineering / GEO
-  Plastic Fabrication
-  Flooring

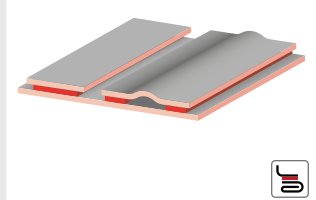
Overlap



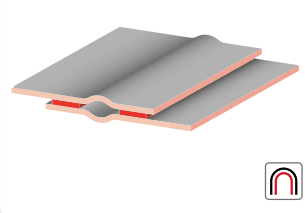
Hem



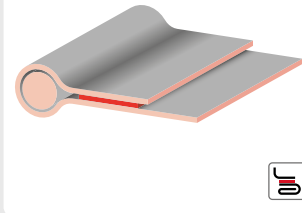
Tape



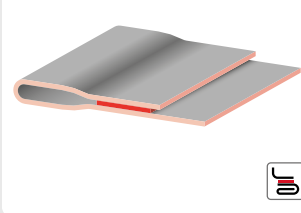
Double seam w/test channel



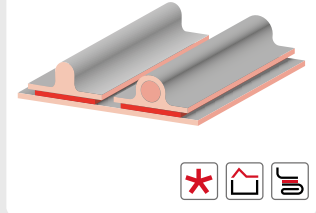
Keder / Piping



Pole pockets

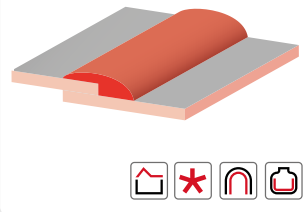


Antivandalism

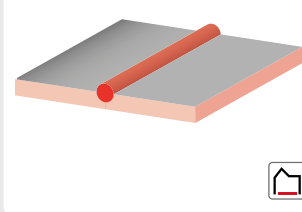


### Welding with additional material

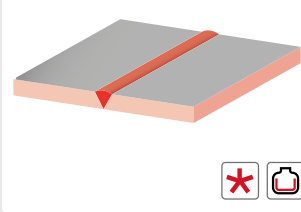
Overlap seam



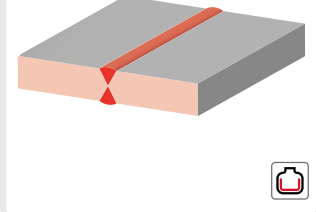
Floor seam



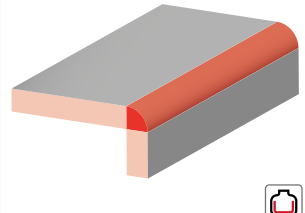
V-seam



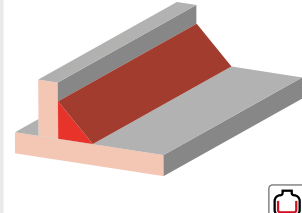
X-seam



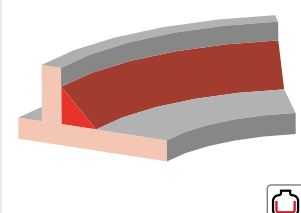
Outside corner seam



Fillet weld seam



Corner seam



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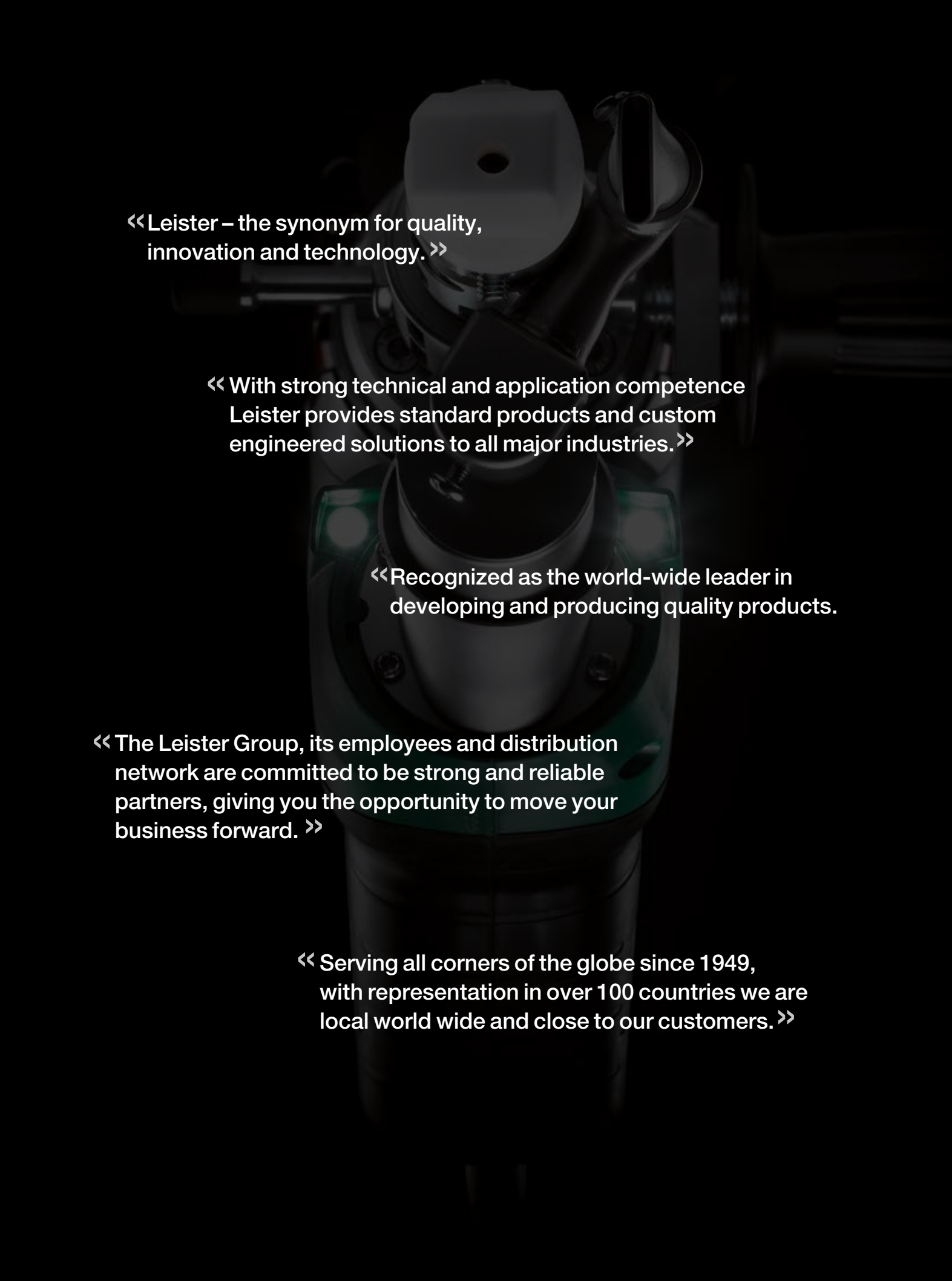
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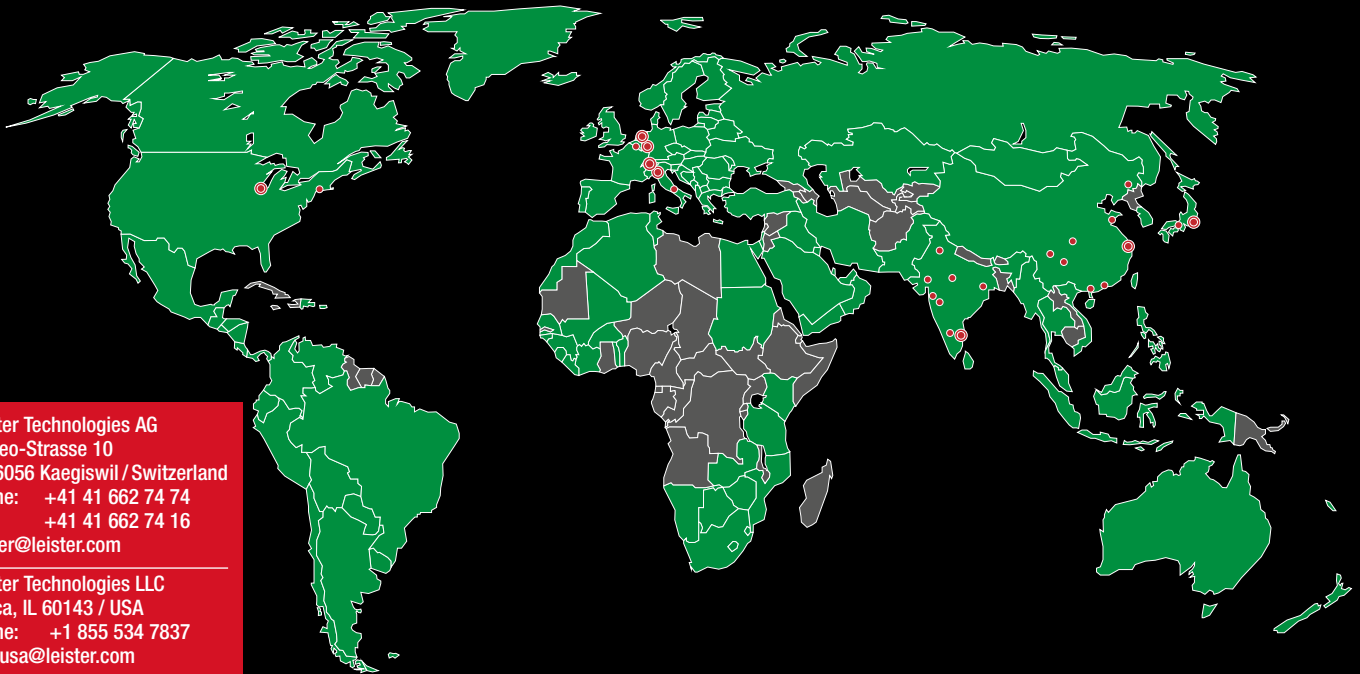
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