

**LEISTER**

PLASTIC WELDING



2015/16

General Catalog

# Plastic Welding

The only choice for professionals

Version 5.0

**We know how.**



Leister Technologies AG, Corporate Center, Kaegiswil, Switzerland



Leister Technologies AG, factory, Sarnen, Switzerland



Leister Technologies AG, factory, Kaegiswil, Switzerland



Leister Technologies Ltd., Shanghai, China



Leister Technologies GmbH, Aachen, Germany



Leister Technologies Benelux BV, Houten, Holland



Leister Technologies 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.





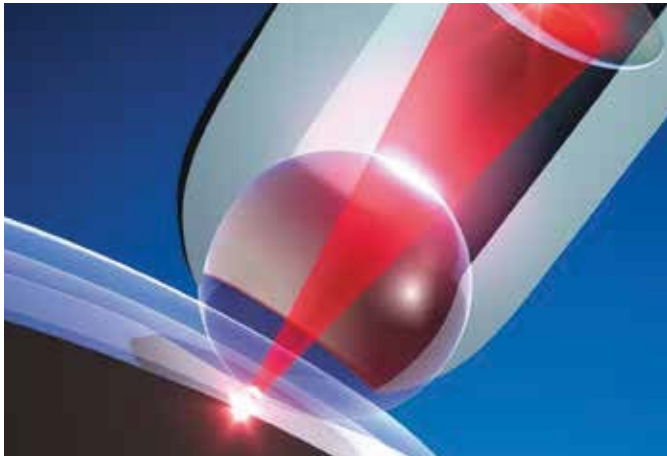
**LEISTER**  
PLASTIC WELDING

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, plastic fabrication, flooring, and shrinking to name a few.



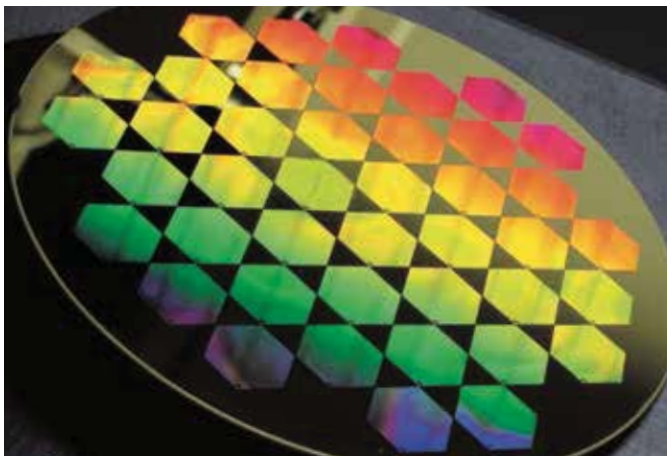
**LEISTER**  
PROCESS HEAT

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.



**axetris**  
Company of the Leister Group

Along with our experienced engineering team, advanced MEMS foundry capabilities and total quality management approach, Axetris works to ensure our customers remain ahead of their field, now and in the future. We continue to actively develop and produce next-generation sensors and optical components in our cleanroom today.

## 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

6



**LEISTER**

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



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Hot-Air Hand Tools

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Roofing

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Civil Engineering / GEO

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Plastic Fabrication

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Flooring and Interior Decoration































## 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	SONORA S1	HOTWIND	FORTE S3
Voltage V~	230	230	230	230	230 / 120	230	230	230	3 × 230 / 3 × 400
Max. power W	1600	1600	3400 / 3200	460	2300 / 1800	2000	2000	3700	10 000
Temperature °C	40 – 700	45 – 620	40 – 650	20 – 600	65 – 620	20 – 600	80 – 650	20 – 650	20 – 650
Size mm (L × Ø) Handle (Ø)	338 × 90 56	335 × 90 56	338 × 90 56	235 × 70 40	280 × 220 × 90 45	195 × 85 × 160 57	230 × 200	232 × 106 179	390 × 132 215
Weight kg (without cord)~	1.0	1.0	1.1	0.4	1.18	0.9	0.6	2.2	4.4
Integrated blower	✓	✓	✓	✓	✓	✓	✓	✓	✓
Digital display		✓			✓		✓		
Conformity mark	CE	CE	CE	CE	CE	CE	CE	CE	CE
Approval mark									
Certification scheme		CCA		CCA		CCA	CCA	CCA	CCA
Protection class									
<b>Applications</b>									
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	WELDING PEN R / S	ROBUST	DIODE PID / S	MINOR	LABOR S
Voltage V~	230	3 × 230 / 3 × 400	230	230	230
Max. power W	1000	250	1600 / 2000	100	800 / 900
Temperature °C	20 – 600		20 – 600		20 – 600
Size mm (L × Ø)	270 × 43	255 × 221	265 × 57	250 × 95	180 × 54
Handle (Ø)	32		40	64	40
Weight kg (without cord)~	1.0	8.0	1.15	1.15	0.15
Integrated blower		✓		✓	
Digital display	✓ (R)		✓ (PID)		
Conformity Mark	CE	CE	CE	CE	CE
Approval mark	Ⓢ		Ⓢ	Ⓢ	Ⓢ
Certification Scheme	CCA		CCA	CCA	CCA
Protection Class	□	⊕	□	□	□
<b>Applications</b>					
Outdoor use					
Indoor use	✓	✓	✓	✓	✓
Roofing					
Billboards / Tarpaulins					
Civil engineering / Tunneling / Landfills					
Plastic fabrication	✓	✓	✓	✓	✓
Flooring / Interior design					
Shrinking					
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# 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 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.

### Design meets experience:

The TRIAC ST is already the seventh generation of Leister's revolutionary TRIAC hot-air hand tool line. Decades of experience packed into a modern design.

2

1



3

4

3



### Swiss thoroughness:

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

4



### Plug'n Leister

Like the TRIAC S, the TRIAC ST impresses with easy operation and Swiss quality.

### Reliable partner:

The TRIAC ST has kept what is probably its predecessor's most important feature: It is and remains reliable!



## 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
- The sturdy, professional hot-air hand tool that weighs less than 1 kg/2.18 lbs
- 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
Power	W	1600 / 1600
Temperature	°C	40 – 700
Size (L × Ø)	mm	338 × 90, handle Ø 56
Weight	kg	<1 (without power cord)
Approval mark		Ⓢ
Conformity mark		CE
Protection class II		□

#### Article No.:

141.308	TRIAC ST, 120V / 1600W for push-fit nozzles with UK-plug
141.309	TRIAC ST, 230V / 1600W 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

### 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

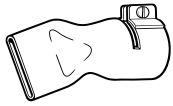



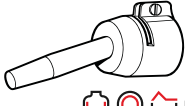



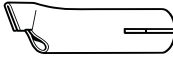

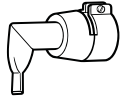




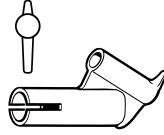

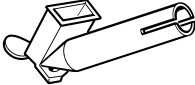

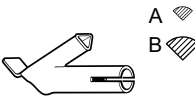



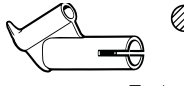



Voltage	V~	120 / 230
Power	W	1600 / 1600
Temperature	°C	45 – 620
Size (L × Ø)	mm	335 × 90, handle Ø 56
Weight	kg	1 (without 3 m cord)
Approval mark		Ⓢ
Conformity mark		CE
Protection class II		□

#### Article No.:

141.319	TRIAC AT, 120V / 1600W, with UK-plug
141.320	TRIAC AT, 230V / 1600W, with UK-plug
141.314	TRIAC AT, 230 V / 1600 W, with Euro plug
141.322	TRIAC AT, 230 V / 1600 W, with CH plug



## Accessories TRIAC ST / TRIAC AT

   	<p>Wide slot nozzle, push-fit</p> <p><b>107.123</b> 20 mm, angled  <b>107.132</b> 40 mm  <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>100.303</b> Ø 5 mm, tubular nozzle, push-fit</p>
 	<p><b>106.996</b> Tacking nozzle, push-fit on Ø 5 mm tubular nozzle</p>
 	<p><b>107.124</b> 20 mm angled nozzle, 90°, push-fit</p> <p><b>107.125</b> 20 mm angled nozzle, 60°, push-fit</p>
<p>3 </p> <p>4 </p> <p>5 </p>  	<p><b>105.431</b> 3 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle</p> <p><b>105.432</b> 4 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle</p> <p><b>105.433</b> 5 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle</p>
 	<p><b>107.139</b> 4.5 × 12 mm speed weld nozzle for fillet weld, push-fit on Ø 5 mm tubular nozzle</p> <p><b>107.137</b> 8 mm speed weld nozzle for tape welding, push-fit on Ø 5 mm tubular nozzle</p>
 <p>A </p> <p>B </p>     	<p>Speed weld nozzle, push-fit on Ø 5 mm tubular nozzle</p> <p><b>106.992</b> 5.7 mm, profile A  <b>106.993</b> 7 mm, profile B</p> <p><b>106.989</b> 3 mm  <b>106.990</b> 4 mm  <b>106.991</b> 5 mm</p>



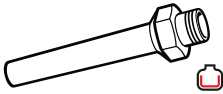
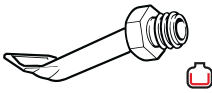

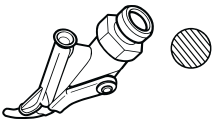
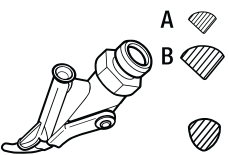
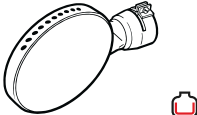

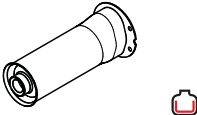

Overlap welding



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 floor 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
	<b>113.877</b> Without tacking tip, screw-on 5.7 mm, profilee A
	<b>106.986</b> Without tacking tip, screw-on 7 mm, profile B
	<b>106.987</b> 7 × 5.5 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
	<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 5 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>142.717</b> Heating element for TRIAC ST / TRIAC AT, 230 V / 1550 W
	<b>142.718</b> TRIAC ST / TRIAC AT, 120 V / 1550 W

Additional versions available upon request.  
Technical data are subject to change without prior notice.



Mirror welding



# 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

1		<b>Powerful:</b> Suitable for any application thanks to its outstanding power rating of up to 3400 W.	3
2		<b>Perfectly ergonomical:</b> 100 grams lighter and with a 2 component handle that's up to 8 mm slimmer than its predecessor.	2
3		<b>Infinitely adjustable:</b> Easy air temperature adjustment up to 650°C.	4



1

4

5



Swiss made

4		<b>Clean:</b> Air filters, located on either side, can be removed and cleaned in no time at all.
5		<b>Compatible:</b> 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
- Swiss made

### Technical data

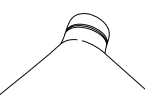
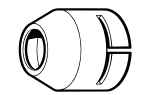

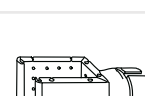




Voltage	V~	230	230	200	120
Power	W	2300	3400	3000	2400
Temperature	°C	40 – 650			
Size (L × Ø)	mm	338 × 90, handle Ø 56			
Weight	kg	1.1 without connection cable			
Approval mark					
Conformity mark					
Protection class II					

### 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 *
145.564	ELECTRON ST, 200 V / 3000 W for push-fit nozzles with JP 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

\* Please ask about availability

## 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>107.328</b> 60 × 75 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> 150 × 110 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
	Heating elements
	<b>145.604</b> 120 V / 2300 W
	<b>145.606</b> 230 V / 3300 W
	<b>145.605</b> 200 V / 3300 W
	<b>149.675</b> 230 V / 2200 W

General accessories  32/33 



# 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 to facilitate tasks in difficult to access areas.

## 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
Power	W	460 / 460
Temperature	°C	20 – 600
Size (L × Ø)	mm	235 × 70, handle Ø 40
Weight	kg	0.4 (without 3 m cord)
Conformity mark	CE	
Approval mark	UL / ENEC	
Certification Scheme	CCA	
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

## Accessories HOT JET S

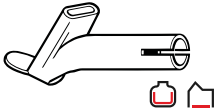
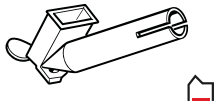
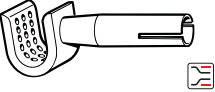
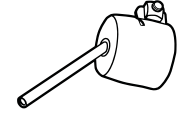
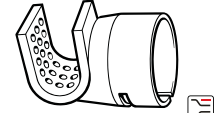

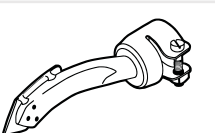


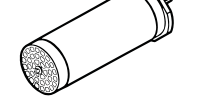
	<b>107.141</b>	15 mm wide slot nozzle, push-fit
	<b>107.142</b>	20 mm wide slot nozzle, push-fit
	<b>107.144</b>	Ø 5 mm tubular nozzle, push-fit
	<b>105.567</b>	Ø 5 × 150 mm extension nozzle, straight
	<b>105.556</b>	20 mm angled nozzle, 90° angled, push-fit
	<b>106.996</b>	Tacking nozzle, push-fit on 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>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 without base plate
	<b>100.818</b> 230 V / 435 W heating element
	<b>103.607</b> 120 V / 435 W heating element

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.
2		<b>Practical air filter</b> Regular cleaning of the air filters ensures optimum air flow and maximum power.
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.
4		<b>Fatigue-free working</b> Thanks to the integrated suspension lug, the GHIBLI AW can be suspended for fatigue-free work.



5

6

5		<b>Compatible</b> All of its predecessor's nozzles also fit on the GHIBLI AW. Comprehensive selection of compatible accessories.
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.





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 GHIBLI AW.



Shrink applications in cable manufacturing – ideal with the GHIBLI AW

Heat gun

**GHIBLI 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	l/min	140 – 270
ø Nozzle holder	mm	36.5
Emission	dB(A)	67
Dimensions (L x W x H)	mm	280 x 220 x 90
ø Handle	mm	45
Weight	kg	1.18
Mark of conformity		<b>CE</b>
Approval mark		
Protection class II		

**Article No.:**

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

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

**Accessories for GHIBLI 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>107.325</b> Solder reflector 17 x 34 mm, push-fit
	<b>107.319</b> Sieve reflector Ø 65 mm
	<b>107.345</b> Welding mirror 135 mm, push-fit
	<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

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 which 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
Power	W	1500 / 2000
Temperature	°C	20 – 600
Size (L × W × H)	mm	195 × 85 × 160, Handle Ø 57
Weight	kg	0.9 (without 3 m cord)
Conformity mark		CE
Approval mark		UL / S
Certification Scheme		CCA
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>	50 × 35 mm sieve reflector
	<b>107.309</b>	35 × 20 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>107.325</b>	17 × 34 mm soldering reflector, push-fit
	<b>107.319</b>	Ø 65 mm sieve reflector
	<b>107.007</b>	Ø 37 mm Dehorning nozzle
	<b>107.345</b>	135 mm welding mirror, push-fit
	<b>106.132</b>	45 × 250 mm Shell reflector, push-fit
	<b>115.513</b>	230 V / 1800 W heating element

# SONORA S1: Handy and quiet.

The handy, quiet and compact tool for universal use. The SONORA S1 is the perfect hot-air hand tool for shrinking, car wrapping, forming and heating. Excellent price / performance ratio.



Ergonomic design for strain-free car wrapping.

## Hot-air hand tool SONORA S1



- Lightweight and compact
- High stability for long term use
- Balanced ergonomics with soft grip
- Very quiet tool, ideal for indoor use
- Constant temperature and closed-loop controlled electronics

### Technical data

Voltage	V	230
Power	W	2000
Temperature	°C	80 – 650
Size	mm	230 × 200
Weight	kg	0.6 (without 2 m cord)
Conformity mark		CE
Approval mark		Ⓢ
Certification Scheme		CCA
Protection class II		□

### Article No.:

140.996 SONORA S1, 230 V / 2000 W, with Euro plug

Additional versions available upon request

## Accessories SONORA S1

	<b>119.269</b> Glass protection nozzle
	<b>119.270</b> 50 mm wide slot nozzle
	<b>119.314</b> Reducer nozzle (included with S1 purchase)
	<b>119.271</b> Reflector nozzle (included with S1 purchase)
	<b>119.316</b> 5 mm tubular nozzle
	<b>119.315</b> 20 mm wide slot nozzle
	<b>119.312</b> Solder sleeve reflector nozzle (included with S1 purchase)
	<b>107.324</b> 12 × 10 mm sieve reflector, push-fit on Ø 5 mm tubular nozzle
	<b>107.308</b> 50 × 35 mm sieve reflector



Included with purchase



# 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

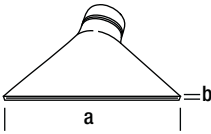
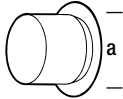
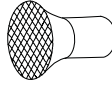

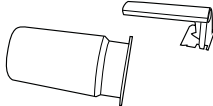
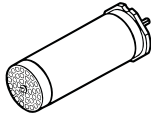
Technical data		
Voltage	V~	230
Power	W	3700
Max. Luftaustritts-Temperature	°C	650
Size (L x W x H)	mm	332 x 106 x 179
Weight	kg	2.2 (without 3 m cord)
Conformity mark		CE
Approval mark		Ⓢ
Certification Scheme		CCA
Protection class II		□

### 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 x b)	
	<p><b>107.260</b> 85 x 15 mm  <b>107.259</b> 150 x 12 mm  <b>105.977</b> 200 x 9 mm  <b>107.263</b> 250 x 12 mm  <b>107.262</b> 300 x 4 mm  <b>105.992</b> 400 x 4 mm  <b>105.991</b> 500 x 4 mm</p>
	<b>125.317</b> Flange connector, push-fit a = 90 mm
	<b>107.335</b> Ø 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 10 m cord)	
Conformity mark		CE	
Approval mark		E	
Certification Scheme		CCA	
Protection class II		□	

#### Article No.:

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

Additional versions available upon request

## 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 × Ø)	mm	270 × 43, handle Ø 32
Weight	kg	1.0 (with 3 m cord / air hose and Y-connection)
Conformity mark	CE	
Approval mark	S	
Certification Scheme	CCA	
Protection class II	□	

#### Article No.:

114.275	WELDING PEN S, 120 V / 600 W, with UK-plug
114.380	WELDING PEN R, 230 V / 1000 W, for screw-on nozzle, with Euro plug
113.081	WELDING PEN S, 230 V / 1000 W, for screw-on nozzle, with Euro plug

Additional versions available upon request

### Accessories WELDINGPEN R / S

	<b>105.622</b>	Ø 5 mm tubular nozzle, 15° 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, 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, screw-on 7 × 5.5 mm
	<b>126.552</b>	Ø 4 mm drawing nozzle, screw-on for fluoroplastics
	<b>127.726</b>	Angular adapter for screw-on nozzles, 30°
	<b>127.727</b>	Angular adapter for screw-on nozzles, 45°
	<b>141.375</b>	Connection adapter M14 for Ø 21.3 mm nozzle with plug
	<b>113.412</b>	230 V / 1000 W heating element for WELDING PEN R and WELDING PEN S

Swiveling air hose for easy working.



General accessories 32/33



## 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.




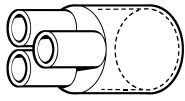
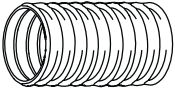
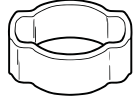
ROBUST blower, serving as the external air supply for the WELDING PEN.

### 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)

### 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

#### Technical data

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
Environmental protection (IEC 60529)	IP 54	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		CE	CE
Protection class I		⊕	⊕

#### Article No.:

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>	

## 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



Hand tool and blower

### DIODE PID / DIODE S with MINOR



- 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

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 × Ø)	mm	265 × 57, handle Ø 40
Weight	kg	1.15 kg (with 3 m cord / 3 m air hose)
Conformity mark	CE	
Approval mark	S	
Certification Scheme	CCA	
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

#### Technical data

Voltage	V~	230
Power	W	1700
Temperature	°C	20 – 600
Size (L × Ø)	mm	265 × 57, handle Ø 40
Weight	kg	2.5 kg (with 3 m cord / 1.5 air hose)
Conformity mark	CE	
Approval mark	S	
Certification Scheme	CCA	
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

General accessories

32/33



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, profilee A
	<b>106.993</b> 7 mm, profilee B
	<b>106.989</b> 3 mm <b>106.990</b> 4 mm <b>106.991</b> 5 mm
	<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	
Approval mark	S	
Certification Scheme	CCA	
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



# 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 40
Weight	kg	0.15 (without air hose and without cord)
Conformity mark	CE	
Approval mark	S	
Certification Scheme	CCA	
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

	<b>107.144</b> Ø 5 mm tubular nozzle, push-fit
	<b>106.992</b> Speed weld nozzle, push-fit on Ø 5 mm tubular nozzle <b>106.993</b> 5.7 mm, profile A 7 mm, profile B
	<b>106.989</b> 3 mm <b>106.990</b> 4 mm <b>106.991</b> 5 mm
	<b>106.996</b> Tacking nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>143.831</b> Nozzle adapter for screw-on nozzles
	<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>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 floor plastics
	<b>101.581</b> 230 V / 800 W heating element

General accessories **32/33**

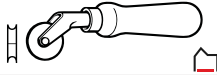
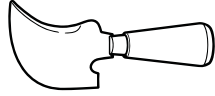
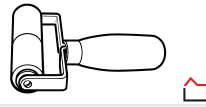
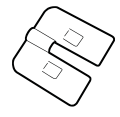
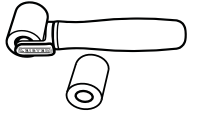
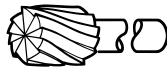



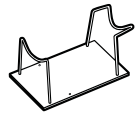




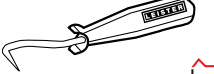
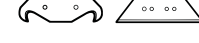
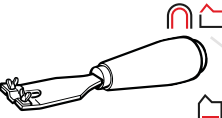

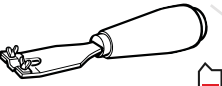
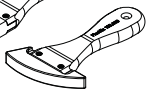
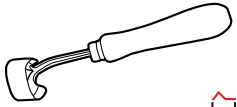







The new «Groovy» gouging tool is also perfectly suited for floor joints.

## Hot-air hand tools

### General accessories

	<b>106.970</b> Brass pressure roller, for welding rods $\varnothing$ 4 – 5 mm		<b>106.969</b> Spatula
	<b>106.974</b> 80 mm silicone pressure roller		<b>122.541</b> Trimming guide, to use with spatula (106.969)
	<b>140.160</b> 40 mm silicone pressure roller with ball bearings (silicone) <b>140.599</b> Spare roll for 140.160		<b>106.997</b> $\varnothing$ 6 mm rotary burr for drilling machine, for car repairs
	<b>140.161</b> Pressure roller 28 mm, with ball bearings (silicone) <b>140.598</b> Spare roll for 140.161		<b>116.798</b> Brass brush
	<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>137.855</b> Leister cutter with four spare blades
	<b>106.981</b> Pressure roller for custom seal		<b>138.902</b> Hooked blade for LEISTER-cutter (10 dispenser with 10 pcs=100 pcs)
	<b>138.314</b> Seam probe tester for overlap seams		<b>138.539</b> Straight-edge blade for LEISTER-cutter (10 dispenser with 10 pcs = 100 pcs)
	<b>111.346</b> Chamfer plane with seven spare blades, for sealing sheets <b>111.348</b> Spare blades kit containing ten blades		<b>151.382</b> Kehlfix
	<b>106.966</b> Hand grooving tool <b>106.968</b> Spare blades for hand grooving tool		<b>153.009</b> Plastfix
	<b>151.188</b> Chamfer plane for T-joints on		<b>116.586</b> Storage case for TRIAC AT, TRIAC ST, ELECTRON ST
	<b>150.809</b> Hand splice tool «Groovy» for flooring applications		
	<b>152.676</b> Weld seam template		





## Welding rods

Article		packaging units (kg)	Article		packaging units (kg)
<b>Welding rods PE</b>			<b>Welding rods div.</b>		
104.283	Welding rod HDPE, profile A, black	3	104.297	Welding rod PA, profile A, black	3
104.294	Welding rod HDPE, profile A, white	3	104.298	Welding rod PC, profile A, transparent	3
104.284	Welding rod HDPE, profile B, black	5	104.313	Welding rod PC / ABS / ALPHA (Honda), profile A, black	3
104.299	Welding rod HDPE, profile B, white	5	104.309	Welding rod PS, profile A, white	3
106.650	Welding band HDPE, 8x 2 mm, white	1	104.308	Welding rod PUR, profile A, black	3
104.300	Welding rod LDPE, profile A, black	3	106.654	Welding band Xenoy, 8x 2 mm, grey	2
<b>Welding rods PP</b>			106.642	Welding rod PPs, profile A, grey, flame resistant	3
104.287	Welding rod PP, profile A, grey / beige	3	104.304	Welding rod PVDF, profile A, natural	3
104.301	Welding rod PP, profile A, black	3	104.303	Welding rod POM, profile A, natural	3
104.288	Welding rod PP, profile B, grey / beige	5	<b>Test bundles</b>		
126.356	Welding band PP, 8x 2 mm, natural	2	107.036	Test bundle (bodywork) welding rods, each consisting of profile A pieces of 37 mm single marked 6x HDPE, 6x PP, 6x PA, 6x PC, 6x ABS, 6x PCABS / APLHA Honda, 6x PC / PBTP / Xenoy	
<b>Welding rods PVC</b>			107.037	Test bundles (standard) each consisting of profile A pieces of 37 mm 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	
104.296	Welding rod PVC-U (hard), profile A, transparent	3	107.040	Test bundle (welding band) each consisting of profile A pieces of 37 mm 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	
104.278	Welding rod PVC-U (hard), profile A, grey	3			
106.641	Welding rod PVC-U, profile A, brown	3			
104.280	Welding rod PVC-U (hard), profile B, brown	5			
104.279	Welding rod PVC-U (hard), profile B, grey	5			
104.302	Welding rod PVC-P (soft), profile A, transparent	3			
<b>Welding rods ABS</b>					
104.295	Welding rod ABS, profile A, white	3			
113.587	Welding rod ABS, profile A, black	3			
107.027	ABS welding band, 8x 2 mm, white	1			

## Profile sizes

	<b>Profile A</b> Diameters in mm
	<b>Profile B</b>





## Roofing

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## Hot Air Tools for Roofing

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TRIAC AT	13 – 15
ELECTRON ST	16 / 17
HOT JET S	18 / 19
General accessories	32












The VARIMAT V2 guide bar fits in tight spaces.



Flameless welding of modified bitumen with the BITUMAT.

## Overview Roofing Welders

				
<b>Materials</b>	Thermoplastic Single-Ply membranes			Modified Bitumen
<b>Type of welding machine</b>	<b>VARIMAT V2</b>	<b>UNIROOF E 40 mm</b>	<b>TRIAC DRIVE AT with guide</b>	<b>BITUMAT B2</b>
<b>Main application</b>	Welding close to edges Industrial surfaces over 500 m <sup>2</sup>	Parapets, edges Residential construction surfaces under 500 m <sup>2</sup>	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>Special features</b>	Double welding performance against competitors	Ideal for roof edge welding	Vertical welding	Flameless welding
<b>Parapet spacing in mm</b>	110	190 **	40	200
<b>Electronics</b>				
Regulated for drive and blowers (closed-loop system)	X	X	× (blower)	
Controlled for drive and blowers (open loop)			× (drive)	X
<b>Speed m/min.</b>				
Drive	0.7 – 12	1 – 5	0.5 – 3	0.8 – 12
Welding (depending on material)	4 – 8	2 – 3	1.5 – 3	3 – 6
<b>Weight kg</b>	35	15.4	4	40
<b>Blower technology</b>	Maintenance-free brushless	Brush motor	Brush motor	Brush motor
Catalog page	 <b>38</b>	<b>37</b>	<b>39</b>	<b>40</b>

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

\*\*No gap necessary for laminated sheets

# UNIROOF E 40 mm

Leister's UNIROOF E 40 mm, the automatic roof welding machine of the new, powerful compact class, makes it convenient and easy to work with single-ply membranes. The new 40 mm nozzle means greater safety with overlap welding. Thanks to 2900 Watt power at only 13A, the tool can be used practically anywhere while providing ample power reserves.

Hot-air welder

## UNIROOF E 40 mm



- Controlled technology with display guarantees a constant and reliable weld for a leakproof roof
- 100% swiss made quality
- Powder-coated, rust-free stainless steel housing and rustproof components
- Lightweight and compact

### Technical Data


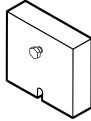
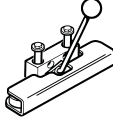

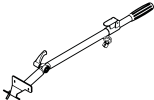
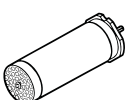
Amperage	A	13
Voltage	V~	230
Power	W	2900
Frequency	Hz	50 / 60
Temperature	°C	80 – 600
Speed	m / min	1 – 5
Welding seam width	mm	40
Size (L x W x H)	mm	420 x 280 x 210
Weight		
(incl. cable and additional weights)	kg	15.4
Weldable materials	PVC, TPO, ECB, EPDM, CSPE	
Protection class I	⊕	
Approval marks	CE, CCA	

### Article No.:

- 147.828 UNIROOF E 40 mm, 230 V with Euro-plug
- 152.947 UNIROOF E 40 mm, 120 V with US plug

Included in scope of supply: Handle, with guide bar, 2 additional weights, storage case, operating instructions and DVD

## Accessories UNIROOF E 40 mm

	<b>148.731</b> 40 mm grip-nozzle for TPO / FPO single-ply
	<b>107.067</b> Additional weight for even more pressure
	<b>115.057</b> Lifting device for simple moving to the next weld seam
	<b>126.448</b> Storage case (included with purchase)
	<b>147.836</b> Guide-bar, complete, adjustable
	<b>103.605</b> Heating element 230 V / 2750 W



Clean overlap welding of base welds.

## 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.



Due to its slimline design, welding is possible even up close to edges.

Hot-air welder

### VARIMAT V2



- 12 m/min maximum welding speed (depending on material)
- 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


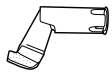
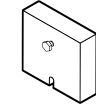
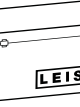
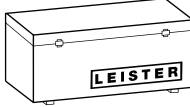


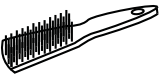
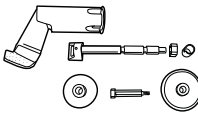

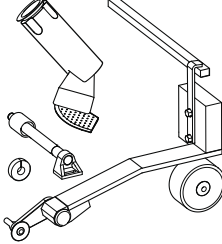
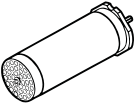
Voltage	V~	230	400
Power	W	4600	5700
Temperature	°C	100 – 620	
Speed	m/min	0.7 – 12	
Air flow range	%	50 – 100	
Width of welding nozzle	mm	40	
Size (L × W × H)	mm	640 × 430 × 330	
Weight	kg	35	
Conformity mark		CE	
Approval mark		S	
Certification scheme		CCA	
Protection class I		⊕	

#### Article No.:

138.108	VARIMAT V2, 230 V / 4600 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 / 4600W, with 80 mm nozzle for bitumen, Euro plug, device case

Additional versions available upon request.

### Accessories VARIMAT V2

	<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
	<b>143.162</b>	Gentle pressure roller for difficult ground conditions
	<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



# 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.



Greater stability and reliability in device guidance thanks to the welding guide.

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

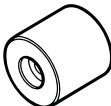



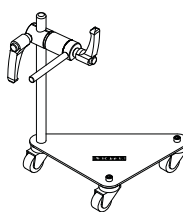
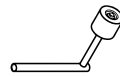



### Technical Data

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> Single supporting carrier, brass <b>107.552</b> Single supporting carrier, 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>115.285</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  <b>115.700</b> 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	
Size (L × W × H)	mm	690 × 490 × 330	
Weight	kg	40 (with cable)	
Conformity mark		<b>CE</b>	
Approval mark			
Certification scheme		<b>CCA</b>	
Protection class I			

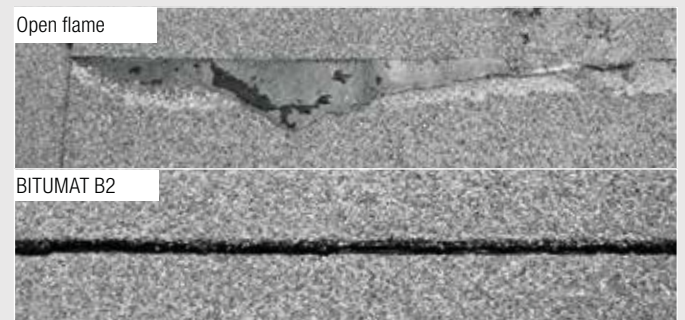
#### Article No.:

- 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

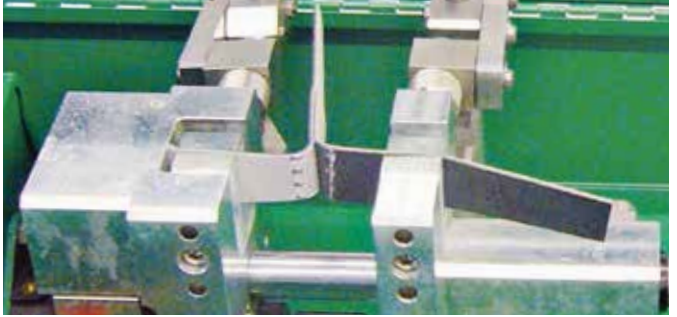
	<b>138.048</b>	75 mm bitumen nozzle
	<b>138.047</b>	100 mm bitumen nozzle
	<b>137.895</b>	100 mm pressure roller with gap
	<b>137.896</b>	75 mm pressure roller with gap
	<b>140.229</b>	100 mm pressure roller without gap
	<b>140.228</b>	75 mm pressure roller without gap
	<b>140.476</b>	Lifting device
	<b>140.489</b>	Sturdy storage case, 750 × 555 × 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
Jaw spacing	mm	5 – 300	5 – 600
Range	mm	300	600
Test speed	mm/min	10 – 300	10 – 300
Sample thickness	mm	max. 7	max. 7
Sample width	mm	max. 40 (60 optional)	max. 40 (60 optional)
Size (L × W × H)	mm	750 × 270 × 190 (storage case)	1050 × 270 × 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



**134.832** Testing and calibration kit

To test and calibrate your EXAMO USB



**115.905** USB memory stick



The memory stick ensures a verifiable evaluation of the welding results with the EXAMO USB.





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LANCIA DELTA. THE POWER TO BE DIFFERENT



LANCIA  
"IL CIELO DEI SOSPIRI"







### Technical Textiles & Industrial Fabrics

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## Applications



Example: Tents




Example: Flood protection (Picture by Beaver AG)










Example: Inflatables (picture © Marek Uliasz | Dreamstime.com)

## Stationary welding machine



<b>Device type</b>	<b>SEAMTEK 36</b>
Max. voltage V~	230 / 240
Max. power W	3500 / 3900
Temperature °C	35 – 700
Speed m/min	0.25 – 22
Welding width mm	8 - 64
Size (L × W × H) cm	170 × 80 × 170
Weight kg	330
<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	 <b>46 - 48</b>







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

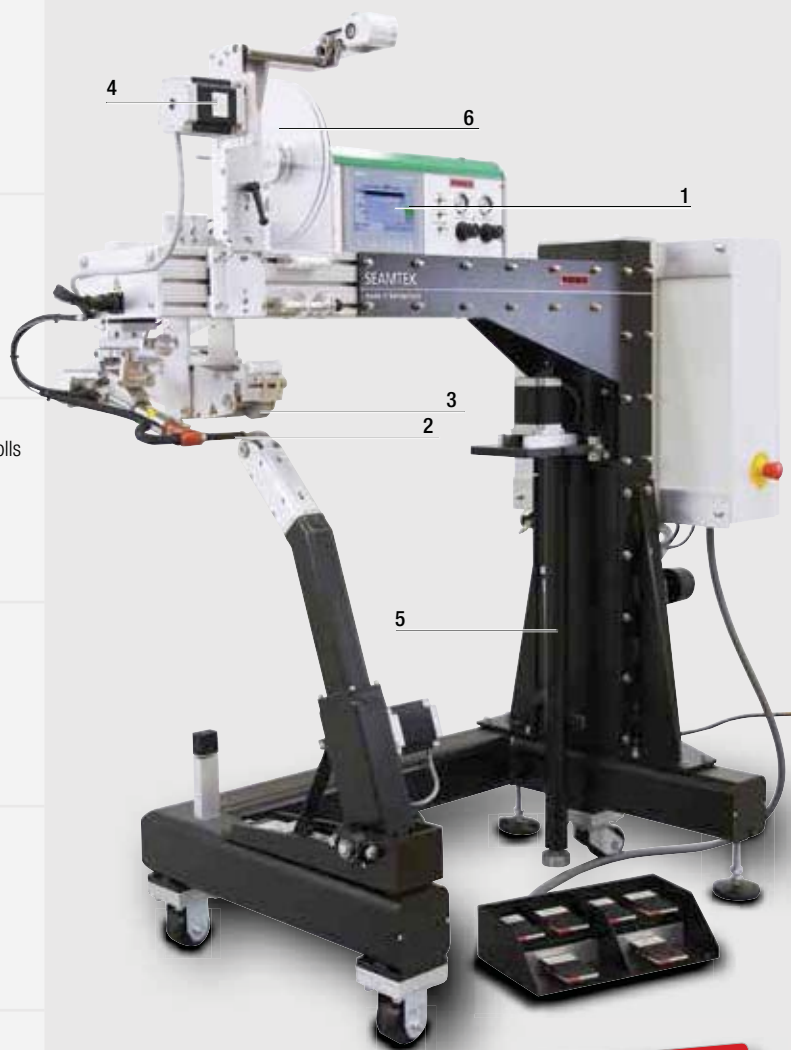
						
Device type	VARIANT T1 Overlap	VARIANT T1 TAPE 50 mm	VARIANT T1 TAPE 25 mm	UNIPLAN E / S	TAPEMAT 50 mm	TAPEMAT SPRIEGEL 100 / 125 mm
Max. voltage V~	230 / 400	230 / 400	230 / 400	230	3 × 400	3 × 400
Max. power W	3680 / 5700	3680 / 5700	3680 / 5700	2300	10 000	10 000
Temperature °C	100 – 620	100 – 620	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	 49 / 50	49 / 51	51	52	53	53



# SEAMTEK 36: Versatile and reliable

With its easily configurable, modular construction and wide range of pressure rollers and nozzle widths, the SEAMTEK 36 guarantees the greatest flexibility. The ingenious tape delivery system makes it easy to position the material and keep it taut right up to the final point. The pedestal, included in the SEAMTEK 36 Base version, is the workhorse of the system. Together with one of three additional modules almost every plastic weld technique is possible.

1		<p><b>User-friendly</b></p> <ul style="list-style-type: none"> <li>•Welding parameters always under control</li> <li>•Multilingual touch-screen with 99 memory settings</li> </ul>
2		<p><b>Clearly arranged</b></p> <p>Easy access to the welding process</p>
3		<p><b>Easy</b></p> <p>Modular, quickly changeable drive rolls</p>
4		<p><b>Quick arm</b></p> <ul style="list-style-type: none"> <li>•Overlap welding</li> <li>•Hose welding</li> </ul>
5		<p><b>Side arm</b></p> <ul style="list-style-type: none"> <li>•Circumference welding</li> <li>•Taping/welding end caps</li> <li>•Overlap welding</li> </ul>
6		<p><b>Tape Delivery System (TDS)</b></p> <p>For welding of tapes</p>



Leister SEAMTEK 36





Easy, economical and safe welding.

## Welding machine SEAMTEK 36



- Suitable for seam or tape welding
- For different weld types like overlap, butt joints, any hem pipe, tape and prayer welds
- Test program to optimize weld parameters
- Easy access to welding process
- Quickly changeable accessories for many applications
- Easy operation multilingual touch-screen with 99 memory settings

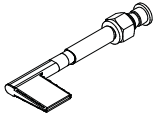
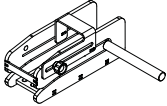
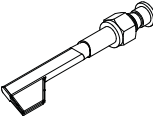
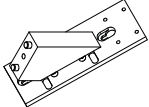
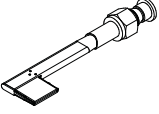
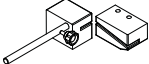
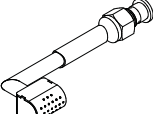

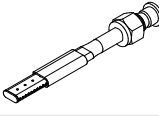
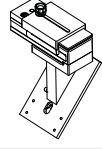

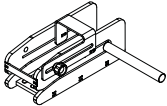
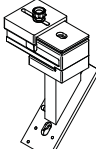
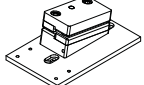
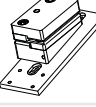
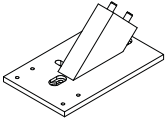
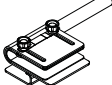
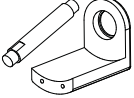
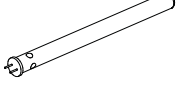
Technical data		
Voltage	V~	230 / 240
Power	W	3500 with small pump 3900 with big pump
Temperature	°C	35 – 700
Speed	m/min	0.25 – 22
Dimensions (L × W × H)	cm	170 × 80 × 170
Weight	kg	330
Regulated weld pressure	bar	1 – 6.2
Maintained air pressure	bar	6.2
Welding seam width	mm	8 – 64
Article No.:		
151.162	SEAMTEK Base version with pedestal, 2 steel pressure rollers 25 mm, standard nozzle 25 mm	
150.887	Quick arm	
150.774	Side arm	
151.161	Tape Delivery System (TDS)	
124.200	Transport Box	

	Wheel, Steel, Ø 63.5 mm
	151.777 8 mm
	151.611 13 mm
	151.549 19 mm
	150.502 25 mm
	152.269 38 mm
	151.548 50 mm (big ped head optional)
	Wheel, Silicone, 50A, Ø 63.5 mm
	153.406 8 mm
	151.609 13 mm
	151.604 19 mm
	150.487 25 mm
	153.401 38 mm
	151.603 50 mm (big ped head optional)
<td>153.420 55 mm (big ped head optional)</td>	153.420 55 mm (big ped head optional)
	151.602 64 mm (big ped head optional)

Additional versions available upon request



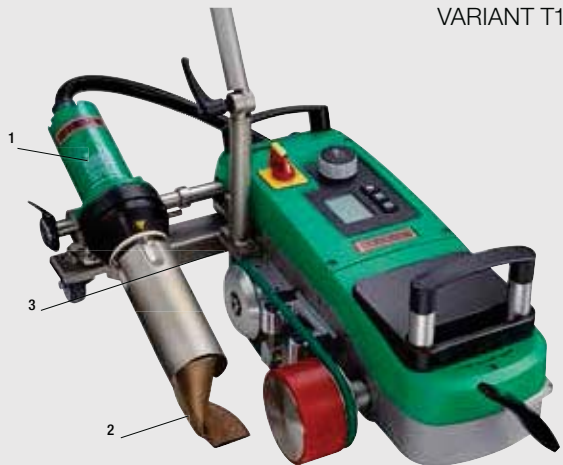
Example: Clothes

	<p>SEAMTEK Nozzle</p> <p><b>152.175</b> 8 mm (Low Flow)</p> <p><b>152.183</b> 13 mm (Low Flow)</p> <p><b>151.598</b> 13 mm</p> <p><b>151.601</b> 19 mm</p> <p><b>151.597</b> 25 mm</p> <p><b>151.608</b> 38 mm</p> <p><b>151.599</b> 50 mm (big air pump/big ped head optional)</p> <p><b>151.850</b> 55 mm (big air pump/big ped head optional)</p> <p><b>151.600</b> 64 mm (big air pump/big ped head optional)</p>		<b>153.580</b> Open Hem/Pocket Guide up to 110 mm (without guide holder 152.415 for standard ped head)
	<b>152.941</b> Closing nozzle with angle		<b>152.415</b> Guide holder set for standard ped head (wheels 8-38 mm)
	<b>152.956</b> Hem nozzle		<b>151.952</b> Overlap guide for quick arm
	<b>153.730</b> Taping Nozzle 25 mm		<b>151.486</b> Big ped head Seamtek (for wheels 8-64 mm/ wheel not included)
	<b>152.931</b> Adjustable taping nozzle 50 mm		<b>152.034</b> Adjustable overlap guide for big ped head (with guide holder set 153.331)
	<b>150.791</b> Standard ped head		<b>153.580</b> Hem-Open Hem Guide up to 110mm (without guide holder 153.331 for big ped head)
	<b>151.723</b> Adjustable overlap guide, 5-40 mm (with guide holder set 152.415)		<b>153.334</b> Butt weld guide with ground plate for big ped head
	<b>151.724</b> Butt welding guide with ground plate		<b>153.331</b> Guide holder set for big ped head (wheels 8-64 mm)
	<b>152.435</b> Adjustable hem-/ piping guide (without guide holder set 152.415)		<b>153.664</b> Large Wheel Holder Set for Quickarm (wheels >25mm) wheel not included
			<b>150.581</b> Heating Element 230V/3600W

# 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



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>

Technical Textiles and Industrial Fabrics

## 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 TAPE 50 mm





# 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 18 m/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

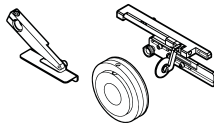
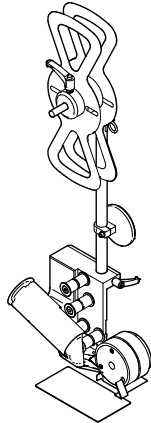
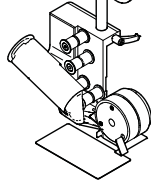
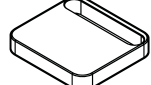




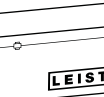
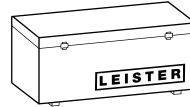
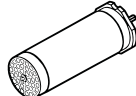
Voltage	V~	230 / 400 (2LNPE)
Power	W	3680 / 5700
Temperature	°C	100 – 620
Speed	m/min	1.5 – 18
Air flow range	%	40 – 100
Welding seam width	mm	20 or 40
Size (L × W × H)	mm	500 × 400 × 195
Weight	kg	22 (without 1.5 m cord)
Conformity mark		CE
Protection class I		⊕

### 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)

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>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
	Heating elements <b>107.612</b> 230 V <b>107.613</b> 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 or 25	
Size (L × W × H)	mm	700 × 415 × 85	
Weight	kg	28 (with 1.5 m cord)	
Conformity mark		<b>CE</b>	
Approval mark		<b>S</b>	
Certification scheme		<b>CCA</b>	
Protection class I		<b>⊕</b>	

**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>107.612</b> Heating elements 230V <b>107.613</b> 400V

Technical Textiles and Industrial Fabrics

# 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



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

### Technical Data

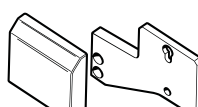
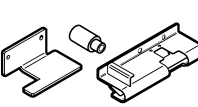
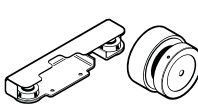





Voltage	V~	230
Power	W	2300
Temperature	°C	20 – 620
Speed	m/min	1.0 – 7.5
Air flow range	%	50 – 100 (for UNIPLAN E steplessly)
Welding seam width	mm	20 or 30
Size (L × W × H)	mm	420 × 270 × 210
Weight	kg	11,5 (with 3 m cord)
Conformity mark		CE
Certification scheme		CCA
Protection class I		⊕

### Article No.:

114.221	UNIPLAN E 20 mm, 230V / 2300 W, with Euro plug
114.318	UNIPLAN E 30 mm, 230V / 2300 W, with Euro plug
115.049	UNIPLAN S 20 mm, 230V / 2300 W, with Euro plug
115.050	UNIPLAN S 30 mm, 230V / 2300 W, with Euro 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 2004)
	<b>122.016</b> Hem cord welding kit without lifting (for units built from 2004 on)
	<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



## Spiegel hot-air welder TAPEMAT SPIEGEL



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

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

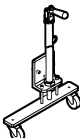


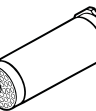

### Technical Data

		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 x 435 x 370
Weight	kg	35	40
Conformity mark		CE	CE
Approval mark		§	§
Certification scheme		CCA	CCA
Protection class I		⊕	⊕

### Article No.:

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

## Accessories TAPEMAT / TAPEMAT SPIEGEL

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







## Civil Engineering / Tunneling / Landfills

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

							
Device type	GEOSTAR G5	GEOSTAR G7	ASTRO / ASTRO USB	COMET / COMET USB	TWINNY T / TWINNY T USB	TWINNY S	TRIAC DRIVE AT
Voltage V~	120 / 200 / 230	230	230	120 / 230	230	120 / 230	230
Max. Power W	1800 / 2800	2800	1800	1800 / 1500 / 1200	2300	1900 / 2900	1700
Temperature °C	80 – 460	80 – 460	80 – 420	80 – 420	80 – 560	80 – 600	80 – 650
Speed m/min	0.8 – 12	0.8 – 12	0.8 – 5.0	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	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	2 x 15	30
Material thickness mm	0.8 - 3.0	1.0 - 3.0	1.5 – 3.0	0.5 – 3.0	0.5 – 3.0	0.5 – 3.0	0.5 – 3.0
Max. overlap mm	150	150	150	125	125	125	
Size (L x W x H) mm	482 x 278 x 269	482 x 278 x 269	430 x 270 x 310	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	23.0	7.5	6.9 – 7.9	6.5 – 6.9	4.1
Conformity mark	CE	CE	CE	CE	CE	CE	CE
Protection class	⊕	⊕	⊕	⊕	⊕	⊕	⊕
<b>Welding technologies</b>							
Hot-wedge welding	✓	✓	✓	✓			
Combi-wedge welding					✓	✓	
Hot-air welding							✓
<b>Features</b>							
Temperature regulation	✓	✓	✓	✓	✓	(✓)	✓
Drive regulation	✓	✓	✓	✓	✓	✓	✓
Temperature and drive infinitely adjustable	✓	✓	✓	✓	✓	✓	✓
USB data recording			- / ✓	- / ✓	- / ✓		
Digital display	✓	✓	✓	✓	✓		✓
Catalog page	 58/59	58/59	60/61	62/63	64	65	67

<sup>1</sup>For details, see page 67

## Product overview – manual extrusion welders

					
Device type	WELDPLAST S6	WELDPLAST S4	WELDPLAST S2	FUSION 3	FUSION 3C
Max. Voltage V~	230	230	230	230	230
Max. Power W	4600	3680	3000	3500	2800
Material	PE / PP	PE / PP	PE / PP / TPO <sup>2</sup>	PE / PP	PE / PP
Welding rod mm	Ø 4 – Ø 5	Ø 3 – 4 / Ø 4 – 5	Ø 3 – Ø 4	Ø 3 – 4 / Ø 4 – 5	Ø 3 – 4 / Ø 4 – 5
Output kg/hr	3.9 – 6.0	1.5 – 4.0	0.5 – 2.3	1.8 – 3.6	1.8 – 3.6
Size (L × W × H) mm	821 × 116 × 240	560 × 110 × 300	450 × 98 × 260	670 × 90 × 180	588 × 98 × 225
Weight kg	14.0	8.7	5.8	7.2	6.9
Conformity mark	CE	CE	CE	CE	CE
Protection class II	⊕	⊕	⊕	⊞	⊞
<b>Features</b>					
Maintenance-free blower	✓	✓	✓		
Multifunction display	✓	✓	✓		
Adjustable grip	✓	✓	✓	✓	✓
Catalog page	 <b>68</b>	<b>69</b>	<b>70</b>	<b>71/72</b>	<b>71/72</b>








<sup>2</sup> WELDPLAST S2 TPO variant

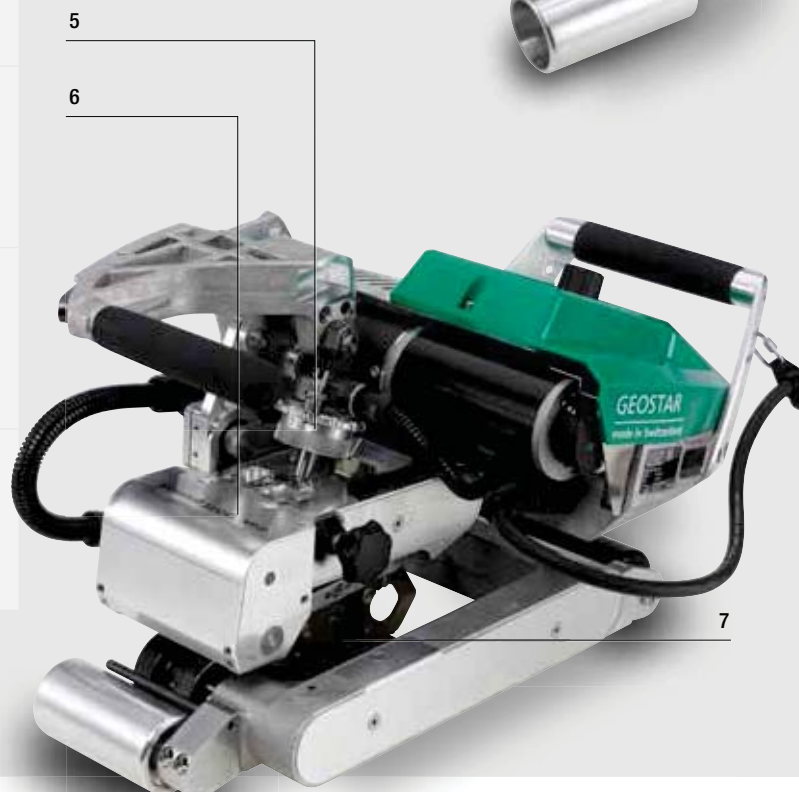
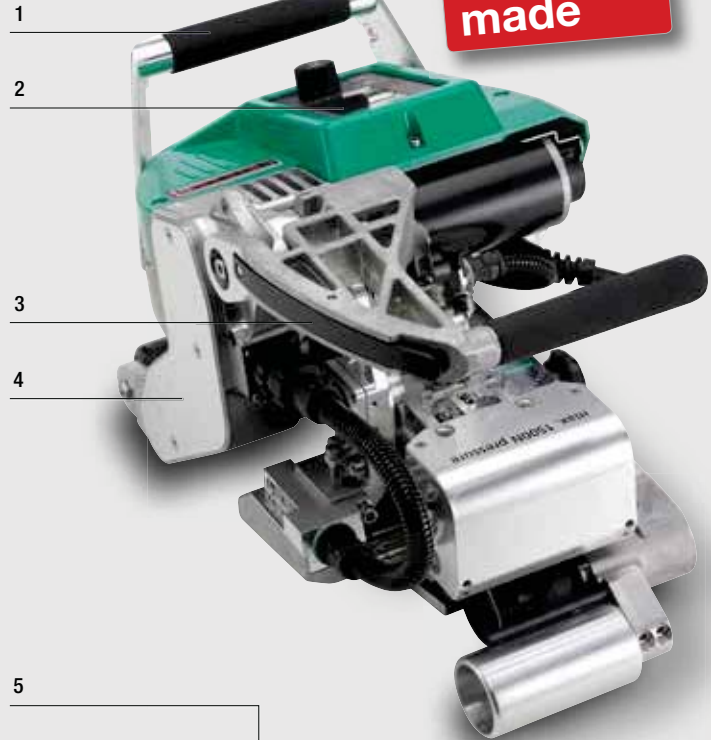


# GEOSTAR G5 and GEOSTAR G7 – Faster, lighter, smarter

**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		<b>Maintenance friendly:</b> The well-thought-out construction enables easy access to mechanical parts for cleaning or service.
2		<b>eDrive:</b> Integrated display of weld pressure, travel speed, wedge temperature and supply voltage enables constant monitoring of key weld parameters during the work process.
3		<b>Ergonomic:</b> The newly developed clamping mechanism enables simple, one-hand operation to engage rollers and begin welding.
4		<b>Shifting gears:</b> The GEOSTAR is equipped with a two-gear transmission that can be modified in accordance with work conditions in just a few steps.
5		<b>Weld pressure measurement:</b> Constant measurement and display of weld pressure.
6		<b>Spacious:</b> Plenty of room for easy loading of material into the machine to accelerate the start of the welding process.
7		<b>The new wedge geometry:</b> 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!



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
- At 16.4 kg (G5) and 17.7 kg (G7) ~20-50% lighter than comparable machines
- High heating capacity / heating power
- Digital display of weld pressure
- Wedge replacement in less than one minute
- Integrated voltage display
- Adjustable chassis height

Technical data		GEOSTAR G5		GEOSTAR G7
Voltage	V~	120	230	230
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 15 mm		2 x 15 mm
Drive speed*1	m/min	0.8–12		0.8–12
		Level 1: 0.8–6	Level 1: 0.8–7	
		Level 2: 1.5–12	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,	HD-PE 1.0–3.0 mm	
		PP, LD-PE, TPO, FPO	PP, LD-PE, TPO, FPO	
		PVC-P*2, CSPE*2, EIA*2		
		additional materials upon request		
Mark of conformity		CE		
Protection Class I		⊕		

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

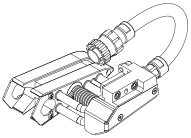
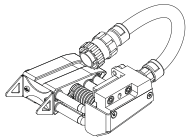
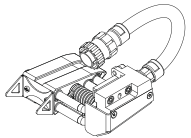

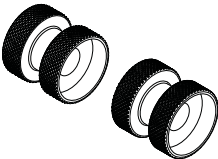
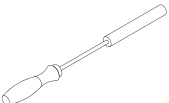
\*2: Requires steel wedge

Scope of delivery: Automatic welder, transport box, 3 pcs. hexagon socket wrenches, cleaning brush, Operating Instructions

#### 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

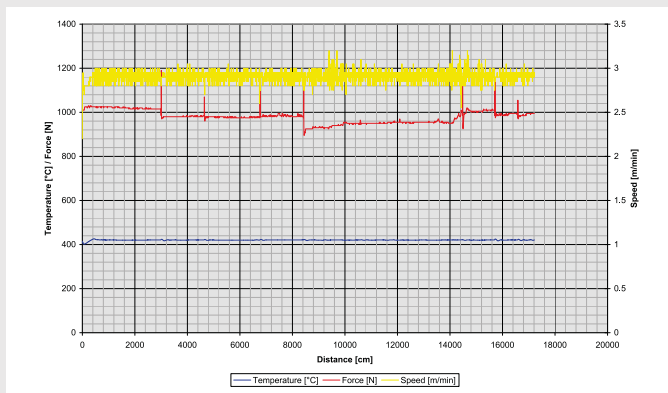
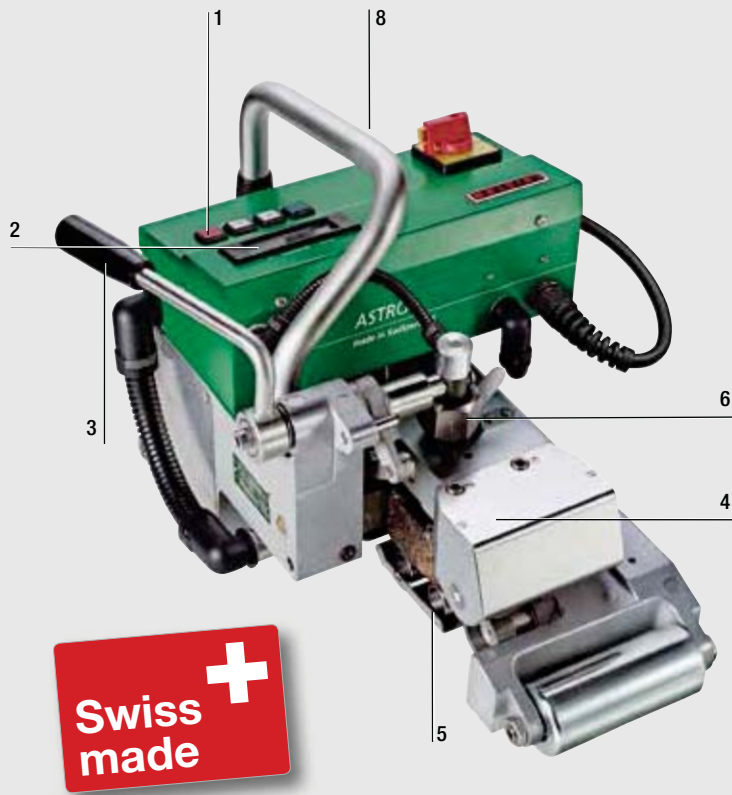
## Accessories GEOSTAR G5/G7

	<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
	<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
		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>	Steel, sharp edge knurled, with test channel
	<b>153.359</b>	Steel, blunt edge knurled, with test channel
		Other rollers on request
	<b>151.847</b>	Brass brush

# ASTRO / ASTRO USB: The thoroughbred.

The ASTRO and ASTRO USB are used anywhere all over the world. They weld up to five meters per minute. Its robust design and easy handling make it the perfect workhorse. The ASTRO USB allows for the consistent recording of all relevant welding parameters.

## Wedge welder ASTRO USB



Graphical evaluation of a weld seam (length 170 m).

1		<b>Simple operation</b> All functions can be accessed and controlled by just a few buttons.
2		<b>Display</b> Allows the user to control and monitor all the parameters at any given time!
3		<b>One-handle operation</b> Simultaneous operation of clamping lever and hot-wedge.
4		<b>Pendulum head</b> Perfect pressure distribution of both welding tracks.
5		<b>Hot wedge</b> Sufficient capacity reserve and optimal welding speed due to high capacity cartridge type heaters.
6		<b>Pressure sensor</b> Precise pressure sensor for optimal process control.
7		<b>Acoustic alarm</b> Safer working with limit value monitoring.
8		<b>USB memory system</b> Recording all relevant welding parameters becomes child's play with the USB memory system.
9		<b>Handy storage case</b> Convenient transport – perfect protection. (Included with purchase)





Fast and perfect!



ASTRO CPL special version for concrete protective liners.

### Wedge welder ASTRO



- High welding capacity
- Digital display of temperature, velocity and mains voltage
- Stepless adjustment of welding pressure
- Closed-loop control of temperature and drive

#### Technical Data

Voltage	V~	230
Power	W	1800
Temperature	°C	80 – 420
Max. overlap	mm	150
Speed	m/min	0.8 – 5.0
Welding pressure	N	100 – 1500
Weld seam width	mm	2 × 15
Material thickness	mm	1.5 – 3.0
Size (L × W × H)	mm	430 × 270 × 310
Weight	kg	23.0
Conformity mark		CE
Protection class I		⊕

#### Article No.:

117.100 ASTRO, 230 V / 1800 W, roller 50 mm, with test channel, with Euro plug, sturdy storage case

Included with purchase: Welder, manual, storage case

### Wedge welder ASTRO USB



- Digital display of pressure
- Acoustic alarm if limit value is exceeded
- USB memory system
- Easy handling

#### Technical Data

Voltage	V~	230
Power	W	1800
Temperature	°C	80 – 420
Max. overlap	mm	150
Speed	m/min	0.8 – 5.0
Welding pressure	N	100 – 1500
Weld seam width	mm	2 × 15
Material thickness	mm	1.5 – 3.0
Size (L × W × H)	mm	430 × 270 × 310
Weight	kg	23.0
Conformity mark		CE
Protection class I		⊕

#### Article No.

141.126 ASTRO USB, 230 V / 1800 W, roller 50 mm, with test channel, with Euro plug, sturdy storage case

Included with purchase: Welder, manual, memorstick, storage case



# 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



## Wedge welder COMET USB



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

- 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 / 120
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 × W × 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 *

Additional versions available upon request.

Included with purchase: Welder, manual, guide-bar short, storage case  
\* = with test channel, EURO plug

### 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 × W × 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 *

Additional versions available upon request.

Included with purchase: Welder, manual, guide-bar short, memorystick, storage case  
\* = with test channel, EURO plug

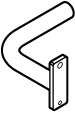
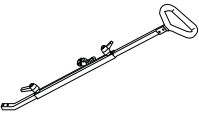
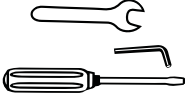



Comet operating in the tunnel ...



... 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>110.715</b> Tool set consists of hexagon spanner 8 / 10 / 13 / 17 mm and Allen keys 3 / 4 / 6 mm
	<b>115.905</b> USB memory stick



Perfectly protected in the storage case.

**126.448**  
(included with purchase)

## 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 – 2.0 mm	70 mm copper	1.5 – 2.0 mm	50 mm copper	0.5 – 1.5 mm
PE-LD	95 mm copper	2.0 – 3.0 mm	70 mm copper	2.0 – 3.0 mm	50 mm copper	1.0 – 2.0 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



Swiss  
made

- 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	20 – 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
113.362	TWINNY T for tunnel construction, 120 V / 1900 W, with test channel, with combiwedge short, with UK plug

Included with purchase:

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



Swiss  
made

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

### Technical Data

Voltage	V~	230
Power	W	2300
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.

Included with purchase:

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.

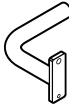

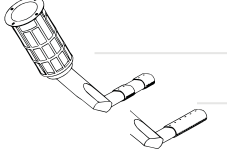
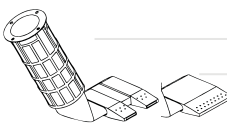
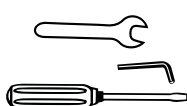


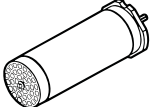
### Technical Data

Voltage	V~	120 / 230
Power	W	2900 / 1900
Temperature	°C	80 – 600
Max. overlap	mm	125
Speed	m/min (drive 256:1)	0.2 – 2.5
	(drive 144:1)	1.4 – 4 (6)
Welding pressure	N (256:1 / 144:1)	1000 / 500
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>110.715</b> Tool set consists of hexagon spanner 8 / 10 / 13 / 17 mm and hexagon bolt 3 / 4 / 6 mm
	<b>115.905</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

Included with purchase:  
Civil 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

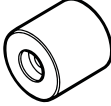


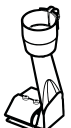

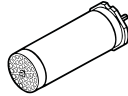
Voltage	V~	230
Power	W	1700
Temperature	°C	80 – 650
Speed	m/min	0.5 – 3
Air flow	l / min	(20 °C) 120 – 240
Size (L × W × H)	mm	300 × 230 × 380
Weight (with 3 m cable)	kg	4.1
Conformity mark		CE
Protection class II		□

### Article No.:

- 117.331 TRIAC DRIVE AT 230 V / 1700 W, 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> Single supporting carrier, silicone
	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 undertaking assembly applications on a landfill site.

## 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	∅ 4 – ∅ 5
Output	kg/hr	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>146.644</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 ∅ 14 mm
	<b>146.218</b> Corner seam ∅ 20 mm
	<b>144.905</b> 45° angled adapter
	<b>145.705</b> 90° angled adapter
	Caution: You must use welding shoes with an integrated air guide for this.
	<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



# 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/hr	1.5 – 4.0
Size (L × W × H)	mm	560 × 110 × 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 × 40 × 52 mm blank welding shoe
	<b>146.241</b>	74 × 50 × 58 mm blank welding shoe
	<b>146.242</b>	25 mm overlap
	<b>145.899</b>	35 mm overlap
	<b>146.243</b>	40 mm overlap
	<b>146.244</b>	12 mm V-seam
	<b>146.245</b>	15 mm V-seam
	<b>146.246</b>	20 mm V-seam
	<b>146.247</b>	25 mm V-seam
	<b>146.231</b>	30 mm V-seam
	<b>146.232</b>	15 mm fillet weld seam (a = 10 mm*)
	<b>146.233</b>	20 mm fillet weld seam (a = 14 mm*)
	<b>146.234</b>	25 mm fillet weld seam (a = 17.5 mm*)
	<b>146.642</b>	30 mm fillet weld seam (a = 21 mm*)
	<b>146.644</b>	146.642 Corner outside seam 8 mm
	<b>146.646</b>	146.644 Corner outside seam 10 mm
	<b>146.652</b>	146.646 Corner outside seam 12 mm
	<b>146.230</b>	146.652 Corner outside seam 15 mm
	<b>146.218</b>	146.230 Corner seam Ø 14 mm
	<b>144.904</b>	146.218 Corner seam Ø 20 mm
	<b>145.704</b>	144.904 45° angled adapter
		145.704 90° angled adapter
		Caution: You must use welding shoes with an integrated air guide for this
	<b>117.064</b>	117.064 Side hot-air guide
	<b>117.065</b>	117.065 Top hot-air guide
	<b>117.053</b>	preheat nozzle small, 20 mm
	<b>117.518</b>	117.518 medium, 25 mm
	<b>141.177</b>	141.177 large, 35 mm
	<b>118.804</b>	118.804 Tool rest
	<b>136.231</b>	136.231 Pre-heat reflector
	<b>149.723</b>	149.723 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

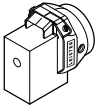

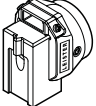



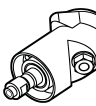
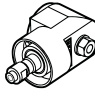




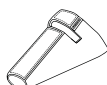
### Technical Data

Voltage	V~	230
Power	W	3000
Material standard version		PE / PP
Welding rod	mm	∅ 3 – ∅ 4
Output ∅ 3 mm	kg/hr	PE: 0.6 – 1.3 PP: 0.5 – 1.2
Output ∅ 4 mm	kg/hr	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

	<b>145.945</b> Welding shoe complete <b>145.946</b> 45 × 30 × 54 mm blank welding shoe 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>145.944</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>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 ∅ 14 mm <b>145.488</b> Corner seam ∅ 20 mm
	<b>139.460</b> 45° angled adapter
	<b>139.461</b> 90° angled adapter
	<b>134.361</b> Air filter set (included with purchase)
	<b>143.776</b> Textile dust filter (not included with purchase)
	<b>131.451</b> Tool rest WELDPLAST S2
	<b>136.231</b> Preheat reflector
	<b>154.002</b> Insulation sleeve

\* a = welding seam thickness

## 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



### 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

- 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

	mm	Version Ø 3 – 4		Version Ø 4 – 5	
		3	4	4	5
Welding rod Ø	mm	3	4	4	5
Output PE	kg/hr	2.0 – 2.5	2.7 – 3.6	2.1 – 2.6	2.7 – 3.6
Output PP	kg/hr	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 × W × H)	mm	670 × 90 × 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, blank welding shoe, storage case

#### Technical Data

	mm	Version Ø 3 – 4		Version Ø 4 – 5	
		3	4	4	5
Welding rod Ø	mm	3	4	4	5
Output PE	kg/hr	2.0 – 2.5	2.7 – 3.6	2.1 – 2.6	2.7 – 3.6
Output PP	kg/hr	1.8 – 2.3	2.5 – 3.4	1.8 – 2.4	2.5 – 3.4
Voltage	V~	230			
Power	W	2800			
Material		PE / PP			
Size (L × W × H)	mm	588 × 98 × 225			
Weight	kg	6.9			
Conformity mark		CE			
Protection class II		□			

#### Article No.:

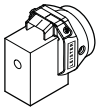




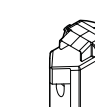
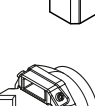


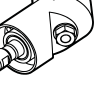


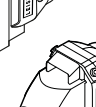

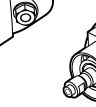


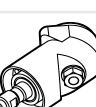



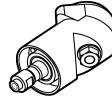
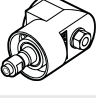

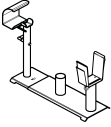


123.866 FUSION 3C, 230 V / 2800 W, Welding rod Ø 3 – 4 mm, Euro plug  
 144.826 FUSION 3C, 230 V / 2800 W, Welding rod Ø 4 – 5 mm, Euro plug

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



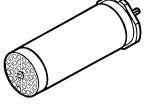
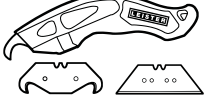
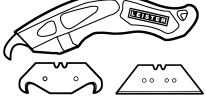
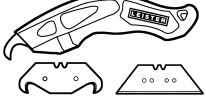


The FUSION 3 for comfortable working in upright positions.

## Accessories FUSION 3 / FUSION 3C

	<b>145.945</b> Welding shoe complete <b>145.946</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>145.915</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 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>135.082</b> Air filter in stainless steel FUSION 3C
	<b>118.804</b> Tool rest
	<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 <b>119.540</b> WELDPLAST S4 / FUSION 3 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
	<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)



# 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


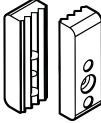

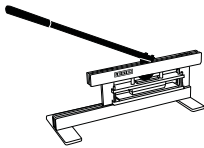
#### Technical Data

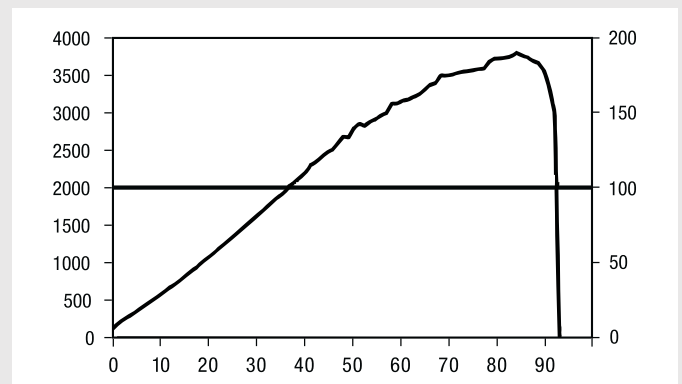
		300F USB	600F USB
Type		300F USB	600F USB
Voltage	V~	230	230
Power	W	200	200
Tensile load	N	4000	4000
Jaw spacing	mm	5 – 300	5 – 600
Range	mm	300	600
Test speed	mm/min	10 – 300	10 – 300
Sample thickness	mm	max. 7	max. 7
Sample width	mm	max. 40 (60 optional)	max. 40 (60 optional)
Size (L x W x H)	mm	750x270x190 (case)	1050x270x190 (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>115.905</b> USB memory-stick
	<b>145.813</b> COUPON CUTTER 20 x 150 mm <b>143.824</b> Spare blade 150 x 20 mm
	<b>146.449</b> COUPON CUTTER 1" x 6" (25 x 150 mm) <b>146.468</b> Spare blade 150 x 25 mm
	<b>143.828</b> Cutting plate



Visualization of an EXAMO USB report.

## 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 810 x 310 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

Article No.:

142.475 Flexible injection needle with manometer

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

Article No.:

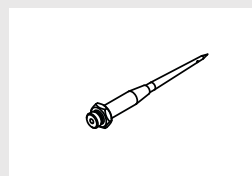
150.720 Tapered injection needle with manometer

## Accessories



142.569 Flexible spare needle

## Accessories



150.142 Tapered Spare needle









## Plastic Fabrication

Overview of hand extruders	78
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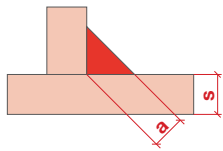
## Hot-Air Hand Tools

TRIAC ST	12 – 15
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WELDING PEN R / WELDING PEN S	26
ROBUST	27
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LABOR S	30
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## Possibilities of welding seams

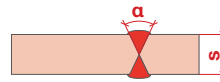
a = seam size s = material thickness  $\alpha$  = milling angle



Fillet welding seam

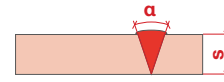


Corner outside seam



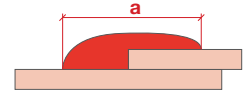
X-seam

s = 10 – 40 mm =  $\alpha$  60°  
s = 50 – 60 mm =  $\alpha$  50°











V-seam

s = 5 – 20 mm =  $\alpha$  60°  
s = 25 – 30 mm =  $\alpha$  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
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
Material	HD-PE, PP	HD-PE, PP	HD-PE, PP, PVC	PE, PP, PVC, etc.	HD-PE, PP	HD-PE, PP	HD-PE, PP
Wall thickness mm	15 – 40	8 – 35	4 – 20	4 – 10	8 – 25	8 – 25	6 – 15
Welding rod $\varnothing$ mm	4 – 5	3 – 4 / 4 – 5	3 – 4	3 – 4	3 – 4 / 4 – 5	3 – 4 / 4 – 5	4
Weight kg	14	8.7	5.8	4.7	7.2	6.9	5.9
Length mm	821	560	450	435	690	588	450
Voltage V~	230	230	230	230 / 120	230	230	230
Screw extruder	yes	yes	yes	yes	yes	yes	yes
Container construction	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓
Pipeline construction	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓
Landfills / civil engineering	✓✓	✓✓	✓	○	✓✓	✓	○
Brushless blower	yes	yes	yes	yes	no	no	no
Remarks	1	1	1	1	2	2	2
Catalog page	 81	82	83 / 84	79 / 80	85 / 86	85 / 86	87

✓✓ very suitable

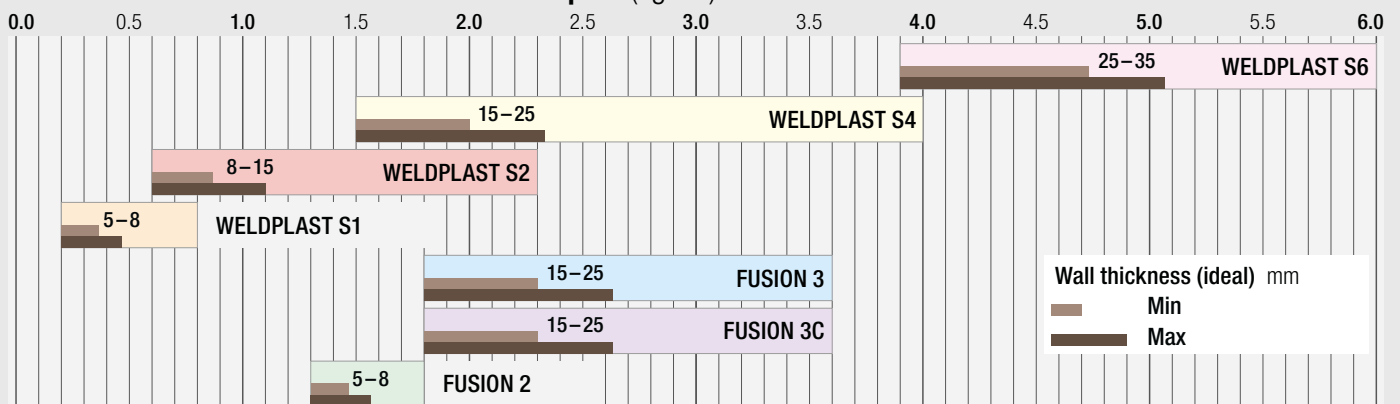
✓ suitable

○ unsuitable

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)



# WELDPLAST S1: Outstandingly compact.

With the new WELDPLAST S1 compact extruder, you can achieve perfect seam quality. The double-sided, twist-free wire intake can work with 3 to 4 mm welding rod. Integrated LED lighting, plus the innovative operating panel, combine to provide the perfect way to monitor the process of welding—all typical kinds of materials including PVC, PE, PP, PA, PVDF or ECTFE—at all times.

## Digitally regulated extrusion welder WELDPLAST S1



1		<p><b>Full control:</b> The multifunctional operating unit gives you perfect control over the welding parameters, ensures reproducible results, and guarantees more efficiency during work.</p>
2		<p><b>Smart features:</b> Thanks to the integrated hanging point, the WELDPLAST S1 can be hung on a balancer so that it is always ready at hand – preventing fatigue work.</p>
3		<p><b>Versatile:</b> The WELDPLAST S1 can work with all typical kinds of plastic, such as HD-PE, LD-PE, PP, PVC-U, PVC-C, ECTFE, PVDF or PA.</p>
4		<p><b>Bright spot:</b> The integrated LED operating lights provides you with a perfect view of the welding process.</p>
5		<p><b>More options:</b> Double-sided, twist-free wire intake for wires of 3 to 4 mm.</p>
6		<p><b>Flexible:</b> The welder can alter the plastic output easily during welding. The Leister BL blower allows stepless adjustment of the air volume.</p>
7		<p><b>Ergonomic handling:</b> The compact, ergonomic design allows you to work in comfort while in any welding position.</p>



Plastic Fabrication





Full control, even in cramped conditions with very little light.

## 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

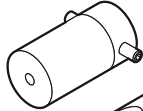
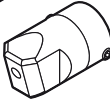
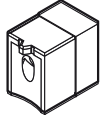
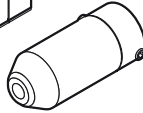
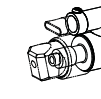




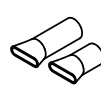




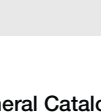
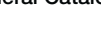
Voltage	V~	230 / 120 / 100
Power	W	1600 / 1800 / 1500
Material		HD-PE, LD-PE, PP, PVC-U PVC-C, PVDF, ECTFE, PA
Welding rod	mm	∅ 3 – 4
Output	kg/hr	0.2 – 0.8 (PVC up to 1.15 kg/h)
Size (L × W × H)	mm	435 × 91 × 264
Integrated welding profiles		HD-PE, PP, PVC-U, PVC-C, PVDF 10 free profile storage spaces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

### Article No.:

148.396	WELDPLAST S1, 230 V / 1600 W, ∅ 3 – 4 mm, Euro plug
148.395	WELDPLAST S1, 120 V / 1800 W, ∅ 3 – 4 mm, Euro plug
148.394	WELDPLAST S1, 100 V / 1500 W, ∅ 3 – 4 mm, Euro plug

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

## Accessories WELDPLAST S1

	<b>149.430</b> Welding shoe complete 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 For additional welding shoes, see Weldplast S2 PVC page 84
	<b>152.720</b> Nozzle extension
	<b>149.600</b> Top hot-air guide
	<b>149.456</b> Hot-air tube, position 6h ∅ 14 mm
	<b>149.461</b> Hot-air tube, position 6h ∅ 16 mm
	<b>149.467</b> Hot-air tube, position 9h/3h ∅ 14 mm (standard)
	<b>149.469</b> Hot-air tube, position 9h/3h ∅ 16 mm
	<b>154.107</b> Air nozzle set ∅ 14 mm (standard)
	<b>154.106</b> Air nozzle set ∅ 16 mm



General accessories  **88** 

# 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	∅ 4 or ∅ 5
Output	kg/hr	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 / 5300 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 ∅ 14 mm
	<b>146.218</b> Corner seam ∅ 20 mm
	<b>144.905</b> 45° angled adapter
	<b>145.705</b> 90° angled adapter
	<b>Caution:</b> You must use welding shoes with an integrated air guide for this
	<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

General accessories



# WELDPLAST S4: The workmate.

The WELDPLAST S4 is the first extruder of its kind with a 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 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

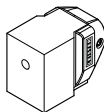
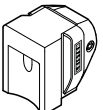
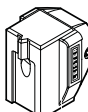
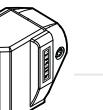

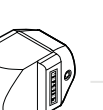

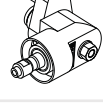
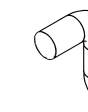



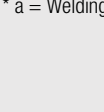

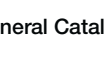
Voltage	V~	230
Power	W	3680
Material		PE / PP
Welding rod	mm	∅ 3 – 4    ∅ 4 – 5
Output	kg/hr	1.5 – 4.0
Size (L × W × H)	mm	560 × 110 × 300
Weight	kg	8.7
Conformity mark		CE
Approval mark		Ⓢ
Certification scheme		CCA
Protection class I		Ⓢ

### 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

Welding shoe complete	
	<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>146.243</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 ∅ 14 mm
	<b>146.218</b> Corner seam ∅ 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
	Preheat nozzle
	<b>117.053</b> 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



# 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	∅ 3 or ∅ 4
Output ∅ 3 mm	kg/hr	PE: 0.6 – 1.3   PP: 0.5 – 1.2
Output ∅ 4 mm	kg/hr	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
Approval mark		Ⓢ
Certification scheme		CCA
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

## 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	∅ 3 or ∅ 4
Output ∅ 3 mm	kg/hr	PVC-U: 0.9 – 1.7   PE: 0.6 – 1.3
Output ∅ 4 mm	kg/hr	PVC-U: 1.5 – 2.7   PE: 1.0 – 2.3
Size (L × W × H)	mm	450 × 98 × 260
Weight	kg	5.8
Conformity mark		CE
Approval mark		Ⓢ
Certification scheme		CCA
Protection class I		Ⓢ

### Article No.:

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

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

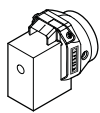
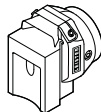
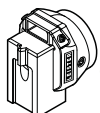



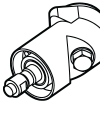
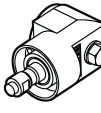
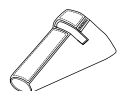


The handy WELDPLAST S2 in action.



Even inside radiuses are easy to weld.

## Accessories WELDPLAST S2

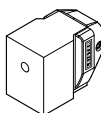
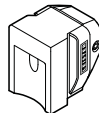



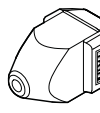

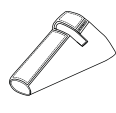
	<b>145.945</b> 45 × 30 × 54 mm blank welding shoe <b>145.946</b> 74 × 50 × 58 mm blank welding shoe
	<b>145.896</b> 25 mm overlap <b>145.947</b> 30 mm overlap <b>145.897</b> 35 mm overlap
	<b>145.912</b> 5 / 6 V-seam <b>145.915</b> 8 / 10 V-seam <b>145.907</b> 12 mm V-seam <b>145.903</b> 15 mm V-seam <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 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>139.460</b> 45° angled adapter
	<b>139.461</b> 90° angled adapter
	<b>154.002</b> Insulation sleeve WELDPLAST S2

\* a = Welding seam thickness



With the WELDPLAST S2 perfect welds are possible

## Accessories WELDPLAST S2 PVC

	<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 Ø 14 mm <b>146.218</b> Corner seam Ø 20 mm
	<b>133.850</b> Top hot-air guide
	<b>154.002</b> Insulation sleeve WELDPLAST S2

\* a = Welding seam thickness



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

General accessories  88 

## 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

	mm	Version Ø 3 – 4		Version Ø 4 – 5	
		3	4	4	5
Welding rod Ø	mm	3	4	4	5
Output PE	kg/hr	2.0 – 2.5	2.7 – 3.6	2.1 – 2.6	2.7 – 3.6
Output PP	kg/hr	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 × W × H)	mm	670 × 90 × 180			
Weight	kg	7.2			
Conformity mark		CE			
Approval mark		S			
Certification scheme		CCA			
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, blank welding shoe, storage case

#### Technical Data

	mm	Version Ø 3 – 4		Version Ø 4 – 5	
		3	4	4	5
Welding rod Ø	mm	3	4	4	5
Output PE	kg/hr	2.0 – 2.5	2.7 – 3.6	2.1 – 2.6	2.7 – 3.6
Output PP	kg/hr	1.8 – 2.3	2.5 – 3.4	1.8 – 2.4	2.5 – 3.4
Voltage	V~	230			
Power	W	2800			
Material		PE / PP			
Size (L × W × H)	mm	588 × 98 × 225			
Weight	kg	6.9			
Conformity mark		CE			
Approval mark		S			
Certification scheme		CCA			
Protection class II		□			

#### Article No.:

123.866 FUSION 3C, 230 V / 2800 W, welding rod Ø 3 – 4 mm, Euro plug  
144.826 FUSION 3C, 230 V / 2800 W, welding rod Ø 4 – 5 mm, Euro plug

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



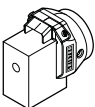


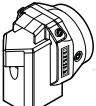


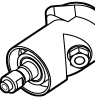
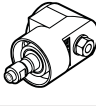
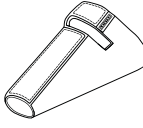


Perfectly stored in the case.



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

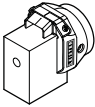

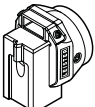

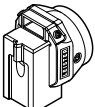
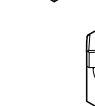

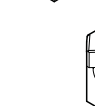

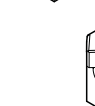

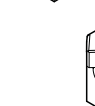

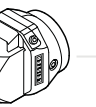

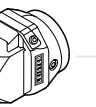

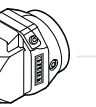
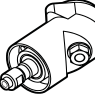

Voltage	V~	230 / 120
Power	W	2800
Material		PE / PP
Air temperature	°C	up to 340
Plastification temperature	°C	up to 300
Welding rod	Ø mm	4
Output PE	kg/hr	1.3 – 1.8
Size (L x W x H)	mm	450 x 98 x 225
Weight	kg	5.9 (without cable)
Conformity mark		CE
Approval mark		Ⓢ
Certification scheme		CCA
Protection class II		□

#### Article No.:

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	
	<b>145.945</b> 45 x 30 x 54 mm blank welding shoe
	<b>145.946</b> 74 x 50 x 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>145.943</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>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>147.602</b> 45° angled adapter
	<b>147.601</b> 90° angled adapter

\* a = Welding seam thickness






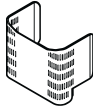

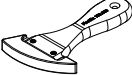
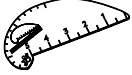







Draw welding on a PE-container with the DIODE PID.



The WELDPLAST S4 during outdoor use in Spain.

## General accessories hand extruder

	<p><b>131.451</b> <b>Tool rest</b> WELDPLAST S2 / S2 PVC / FUSION 2</p>
	<p><b>148.923</b> WELDPLAST S1</p>
	<p><b>118.804</b> WELDPLAST S4 / FUSION 3 / FUSION 3C</p>
	<p><b>136.231</b> <b>Pre-heat reflector</b> WELDPLAST S2 / S2 PVC / S4 / S6 FUSION 2 / 3 / 3C</p>
	<p><b>134.361</b> Air filter WELDPLAST S2 / S2 PVC (included with purchase)</p>
	<p><b>143.776</b> Textile dust filter WELDPLAST S2 / S2 PVC (not included with purchase)</p>
	<p><b>135.082</b> Air filter FUSION 2 / 3C</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>116.367</b> <b>Storage case</b> (included with purchase) WELDPLAST S6</p>
	<p><b>123.173</b> WELDPLAST S4 / FUSION 3</p>
	<p><b>119.540</b> WELDPLAST S2 / S2 PVC / S1 / FUSION 2 / 3C</p>
	<p><b>134.567</b> <b>Heating element</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</p>

PLASTFIX lends the weld seam the necessary holding pressure.



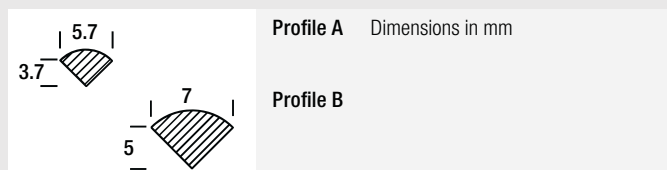


## Welding rods

Article		packaging units (kg)
<b>Welding accessories PE</b>		
104.283	HDPE welding rod, profile A, black	3
104.294	HDPE welding rod, profile A, white	3
104.284	HDPE welding rod, profile B, black	5
104.299	HDPE welding rod, profile B, white	5
106.650	HDPE welding rod, 8x 2 mm, white	1
104.300	LDPE welding rod, profile A, black	3
<b>Welding accessories PP</b>		
104.287	PP welding rod, profile A, grey / beige	3
104.301	PP welding rod, profile A, black	3
104.288	PP welding rod, profile B, grey / beige	5
126.356	PP welding rod, 8x 2 mm, natural	2
<b>Welding accessories PVC</b>		
104.296	PVC-U welding rod (hard), profile A, transparent	3
104.278	PVC-U welding rod (hard), profile A, grey	3
106.641	PVC-U welding rod, profile A, brown	3
104.280	PVC-U welding rod (hard), profile B, brown	5
104.279	PVC-U welding rod (hard), profile B, grey	5
104.302	PVC-P welding rod (soft), profile A, transparent	3
<b>Welding accessories ABS</b>		
104.295	ABS welding rod, profile A, white	3
113.587	ABS welding rod, profile A, black	3
107.027	ABS welding band, 8x 2 mm, white	1

Article		packaging units (kg)
<b>Welding accessories div.</b>		
104.297	PA welding rod, profile A, black	3
104.298	PC welding rod, profile A, transparent	3
104.313	PC welding rod / ABS / ALPHA (Honda), profile A, black	3
104.309	PS welding rod, profile A, white	3
104.308	PUR welding rod, profile A, black	3
106.654	Xenoy welding band, 8x 2 mm, grey	2
106.642	PPs welding rod, profile A, grey, flame resistant	3
104.304	PVDF welding rod, profile A, natural	3
104.303	POM welding rod, profile A, natural	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	
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	
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	

## Profile sizes











## Flooring / Interior Decoration

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# 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

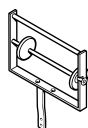
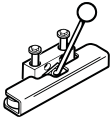


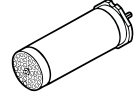


- Reproducible results thanks to permanent regulation of the NOMINAL and ACTUAL values
- Heater and drive electronically regulated
- Steplessly controlled air flow (only UNIFLOOR E)
- All floor coverings welded without reconfiguration
- Automatic start
- Integrated wall switch

### 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 × W × H)	mm	420 × 270 × 215
Weight (without de-reeler)	kg	11.5 (with 3 m cable)
Conformity marking		CE
Certification scheme		CCA
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

# 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.

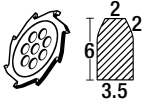
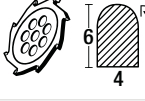


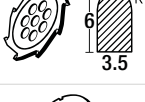


## Grooving machine GROOVER



- 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: 14500 (350 W) Level 2: 18500 (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		Ⓢ
Certification scheme		CCA
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



# 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 × W × H)	mm	180 × 42 × 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

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



## 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.

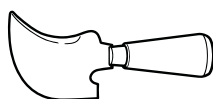


Step 3:  
Removing the excess welding  
rod with trimmer guide and  
spatula

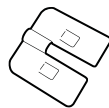


Step 4:  
Levelling the protruding  
welding rod with the spatula.

## General accessories



**106.969** Spatula



**122.541** Trimming guide,  
to use with spatula (106.969)



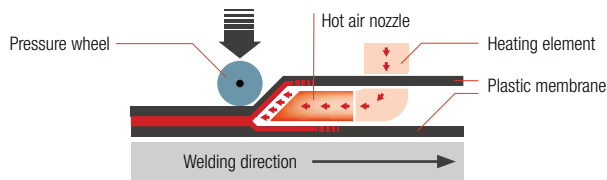
# Leister. We know how.

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

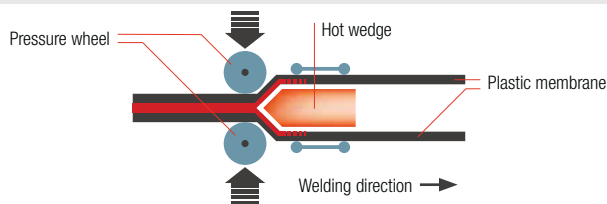
### Welding Methods



#### Hot-air welding

Hand tools, automatic welders, stationary welding machines

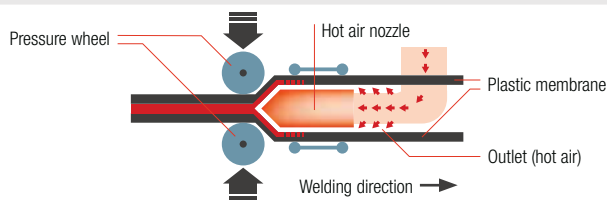
In hot gas welding, the thermal energy is controlled. Heated air is fed into the workpiece and the required amount of pressure is exerted onto the wheels.



#### Hot-wedge welding

Wedge welders

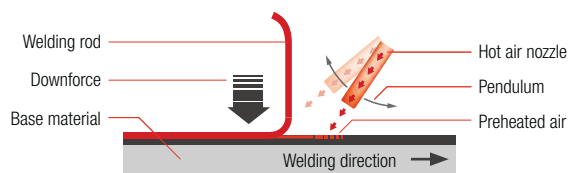
The process where the wedge is heated directly by heating cartridges. The generated heat is transferred directly onto the workpiece. This method also is suitable for thicker materials.



#### Combi-wedge welding

Combi-wedge welding machines

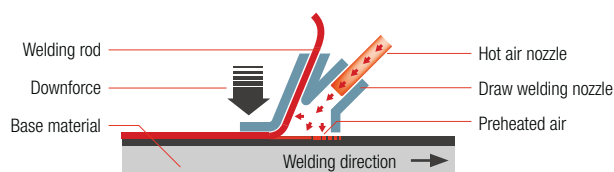
When Combi-wedge welding (combination of a heated wedge and hot air), preheating of the air and the actual welding process is carried out over a wedge. The preheated air also takes partial cleaning of the workpieces.



#### Pendulum Welding

Hand tools

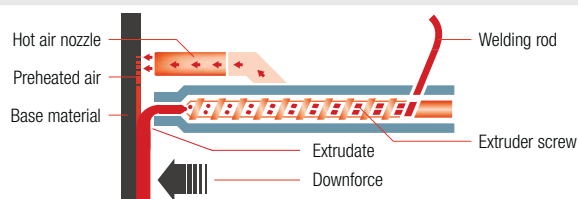
Pendulum welding requires a welding rod similar to the base material. Both surfaces are then heated using hot air. Using an up and down, pendulum-like motion and consistent downward pressure, the two are joined.



#### 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.

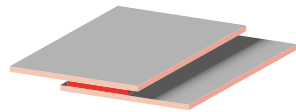
Know-how

## Weld Types / Weld Geometries

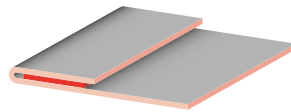
### Welding without filler material

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

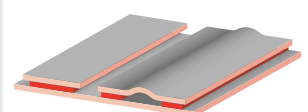
Overlap



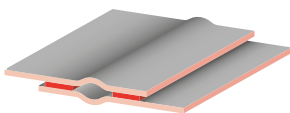
Hem



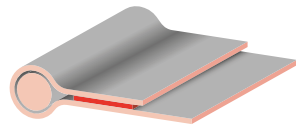
Tape



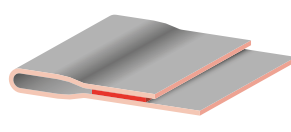
Double seam w/test channel



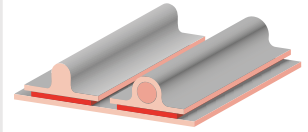
Keder / Piping



Pole pockets

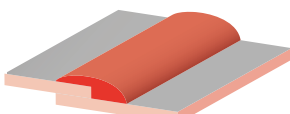


Antivandalism

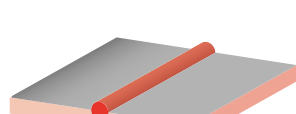


### Welding with additional material

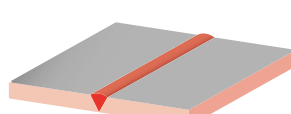
Overlap seam



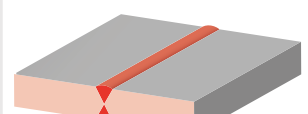
Floor seam



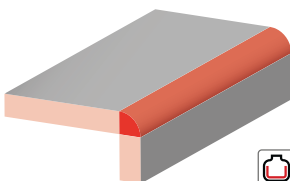
V-seam



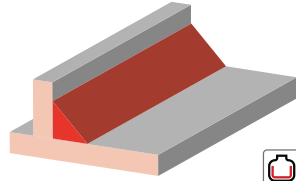
X-seam



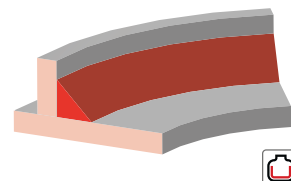
Outside corner seam



Fillet weld seam

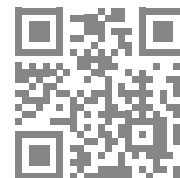


Corner seam



For more information, visit:  
[leister.com/knowhow](http://leister.com/knowhow)





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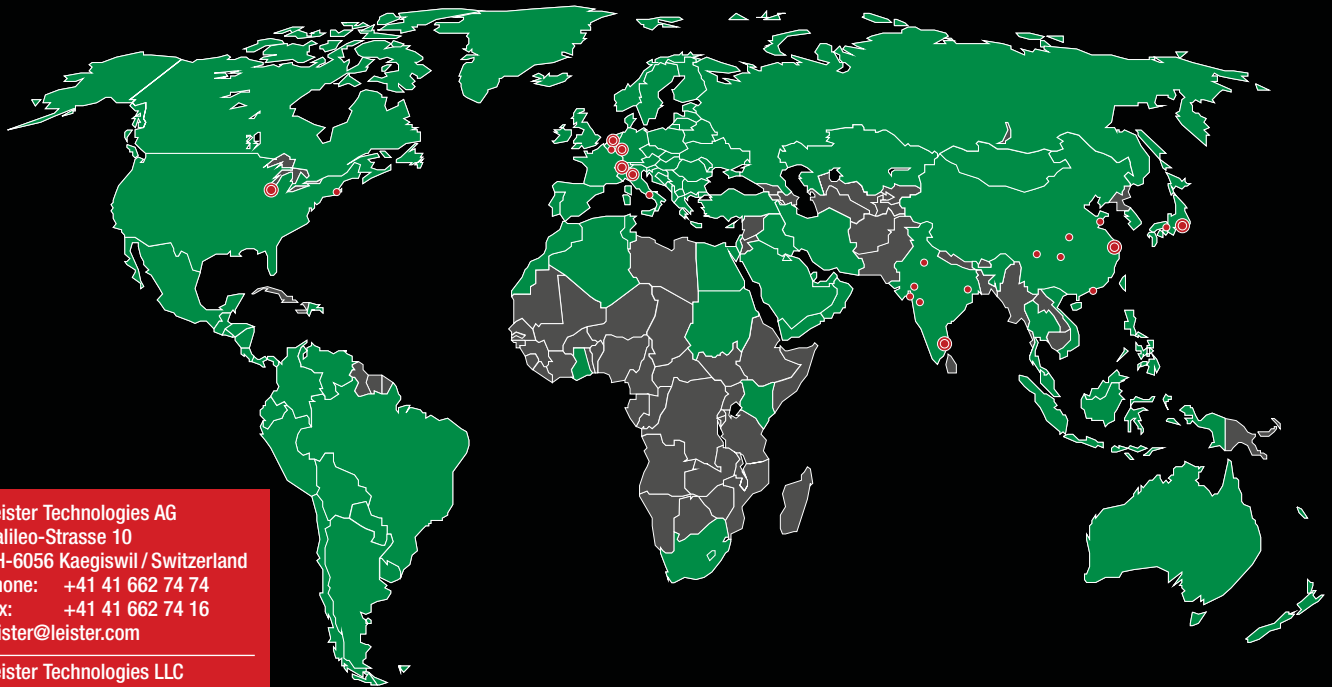
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