

**LEISTER**

PLASTIC WELDING

Swiss  
made



General Catalog

# Plastic Welding

The only choice for professionals

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

**We know how.**



Leister Technologies AG, Corporate Center, Kaegiswil, Switzerland



Leister Technologies AG, factory, Samen, Switzerland



Leister Technologies AG, factory, Kaegiswil, Switzerland



Leister Technologies Ltd.,  
Shanghai, China



Leister Technologies GmbH,  
Hagen, Germany



Leister Technologies Benelux BV,  
Houten, Holland



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



Leister Technologies LLC,  
Itasca, USA



Leister Technologies KK,  
Yokohama, Japan



Leister Technologies India Pvt,  
Chennai, India

### Leister delivers performance.

For 70 years, Leister has been the worldwide leader in the field of plastic welding and industrial hot-air applications. In addition we also offer innovative and effective lasersystems and microsystems. Leister is proud to develop and produce all products in Switzerland – so you can always rely on the proverbial Swiss made quality.

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





**LEISTER**

#### PLASTIC WELDING

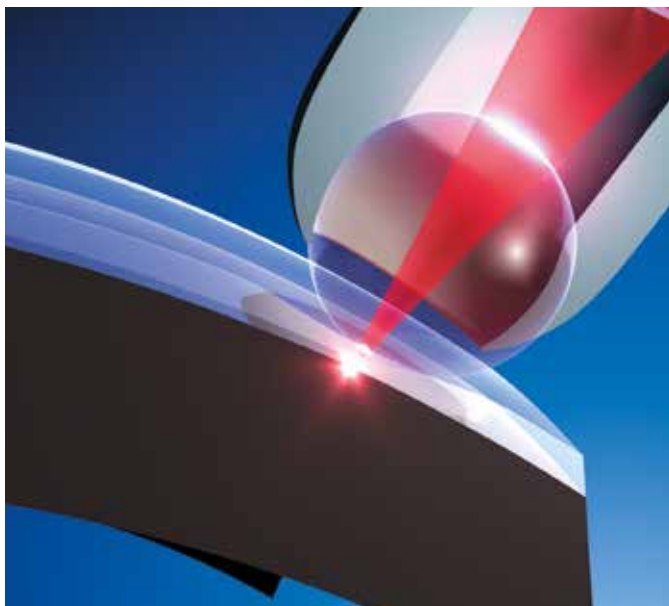
For decades now, Leister has been the worldwide market leader. The performance and reliability of our products makes Leister the first choice. Our tools are used in roofing, billboards, tarpaulins, civil engineering, tunneling, landfills, flooring, plastic fabrication, and shrinking to name a few.



**LEISTER**

#### PROCESS HEAT

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



**LEISTER**

#### LASER PLASTIC WELDING

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

### Plastic welding with Leister

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

### Research and development

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

### Quality management

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

### Testing and certification

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

### Application and laboratory testing

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

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

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













GEOSTAR G5/G7



# Contents


-  Roofing
-  Technical Textiles and industrial Fabrics
-  Civil Engineering / GEO
-  Plastic Fabrication
-  Flooring and Interior Decoration

- Hot-air hand tools 8 – 37
- Blowers
- General accessories
- Welding rods
- Special applications 
- Shrinking 



Hot-Air Hand Tools

Roofing


- Automatic welders 38 – 49
- Testing instruments 



Roofing

Technical Textiles and Industrial Fabrics

- Advertising (signs and banners)
- Tarpaulins / coverings for trucks
- Architecture
- Inflatable / hoses and filters
- Outdoor & clothing


- Automatic welders 50 – 69
- 

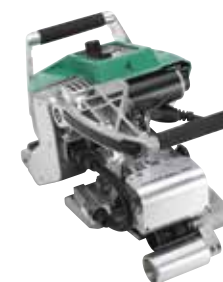


Technical Textiles and Industrial Fabrics

Civil Engineering / GEO

- Tunnelling
- Landfill construction
- Mining
- Ponds and reservoirs
- Reservoirs and fisheries

- Automatic welders 70 – 91
- Extrusion welders
- Testing instruments 



Civil Engineering / GEO

Plastic Fabrication


- Extrusion welders 92 – 109
- Welding rods 



Plastic Fabrication

Flooring and Interior Decoration

- Welding floor coverings
- Groove cutting

- Hot-air welder 110 – 119
- Grooving machine 



Flooring and Interior Decoration







TRIAC ST for use in the roughest of environments.



HOT JET S ideal for detail work on the roof.



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

### Hot-Air Hand Tools














Product overview	10 / 11
TRIAC ST	12 – 15
TRIAC AT	13 – 15
ELECTRON ST	16 / 17
HOT JET S	18 / 19
SOLANO AT	20 / 21
GHIBLI AW	22 / 23
GHIBLI	25
HOTWIND PREMIUM / SYSTEM	26
FORTE S3	27
AIRSTREAM ST	28 / 29
ROBUST	30
WELDING PEN R / WELDING PEN S	31
DIODE PID / DIODE S	32 / 33
MINOR	33
LABOR S	34
General accessories	36
Welding wires	37

## Product overview Hot-air hand tools

									
Type	TRIAC ST	TRIAC AT	ELECTRON ST	HOT JET S	SOLANO AT	GHIBLI AW	GHIBLI	HOTWIND	FORTE S3
Voltage V~	230 / 120	230 / 120	230 / 120	230 / 120	230	120/230	120/230	230	3 × 230 / 3 × 400
Max. power W	1600	1600	2400 / 3400	460	2300	1800 / 2300	1500 / 2000	3700	10 000
Temperature °C	40 – 700	40 – 620	40 – 650	40 – 600	50 - 650	65 – 620	40 – 600	20 – 650	20 – 650
Size mm (L × W × H) Handle (Ø)	338 × 90 56	338 × 90 56	338 × 90 56	235 × 70 40	270 × 75 × 240 45	280 × 90 × 220 45	195 × 85 × 160 57	332 × 106 × 179	390 × 132 85
Weight kg (without cord)~	1.0	1.0	1.1	0.4	0.75	1.1	0.9	2.2	4.4
Integrated blower	✓	✓	✓	✓	✓	✓	✓	✓	✓
Digital display		✓			✓	✓		✓ (SYSTEM)	
Conformity mark	CE	CE	CE	CE	CE	CE	CE		CE
Approval mark	CSK	CSK	CSK	CSK	CK	CS		CK	CS
Protection class	□	□	□	□	□	□	□	□	□
<b>Applications</b>									
Outdoor use	✓	✓	✓	✓		✓			✓
Roofing 	✓	✓	✓	✓					
Billboards / Tarpaulins 	✓	✓		✓	✓				
Civil engineering / Tunneling / Landfills 	✓	✓	✓						
Plastic fabrication 	✓	✓		✓					
Flooring / Interior design 	✓	✓	✓	✓					
Shrinking 	✓	✓	✓	✓	✓	✓	✓	✓	✓
Special applications 					✓	✓	✓	✓	✓
Catalog page 	12 – 15	13 – 15	16 / 17	18 / 19	20 / 21	22 / 23	25	26	27



## Product overview Hot-air hand tools and Blower

						
Type	AIRSTREAM ST	ROBUST	WELDING PEN R / S	DIODE PID / S	MINOR	LABOR S
Voltage V~	230	3 × 230 / 3 × 400	230	230	230	230
Max. power W	215	250	1000	1600 / 2000	100	800 / 900
Temperature °C			20 – 600	20 – 600		20 – 600
Size mm (L × W × H) Handle (Z)	600 × 250 × 362	255 × 221	270 × 43 32	265 × 57 40	250 × 95 64	180 × 54 32
Weight kg (without cord)~	24	8.0	1.0	1.15	1.15	0.15
Integrated blower	✓	✓			✓	
Digital display			✓ (R)	✓ (PID)		
Conformity Mark	CE		CE	CE	CE	CE
Approval mark						
Protection Class	⏏	⏏	⏏	⏏	⏏	⏏
<b>Applications</b>						
Indoor use	✓	✓	✓	✓	✓	✓
Roofing 						
Billboards / Tarpaulins 						
Civil engineering / Tunneling / Landfills 						
Plastic fabrication 	✓	✓	✓	✓	✓	✓
Flooring / Interior design 						
Shrinking 	✓			✓		✓
Catalog page 	28 / 29	30	31	32 / 33	33	34

# TRIAC ST: Design meets experience

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

## Product advantage

1



### Ergonomic handling:

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

### Perfect weight:

Weighing less than 1 kg, the TRIAC ST is even lighter than its predecessor.

2



### Always keeps a cool head:

There is an actively cooled protective tube for greater work safety.

3



### Welding power:

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

2



4



### Reliability:

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

5



### Swiss thoroughness:

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

### Optimum protection:

The filters offer active protection against moisture and dust.



# TRIAC AT: Robust and intelligent.

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

## Hot-air hand tool

### TRIAC ST



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

#### Technical data

Voltage	V~	120 / 230
Frequency	Hz	50 / 60
Power	W	1600 / 1600
Temperature	°C	40 – 700
Air volume (20°C)	l/min	240 (500 at max. temp)
Dynamic pressure	Pa	3000
Ø Nozzle holder	mm	31.5
Emission	dB(A)	67
Size (L × Ø)	mm	338 × 90, handle Ø 56
Weight	kg	<1 (without power cord)
Conformity mark	CE	
Approval mark	S I	
Protection class II	□	

#### Article No.:

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

## Hot-air hand tool

### TRIAC AT



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

#### Technical data

Voltage	V~	120 / 230
Frequency	Hz	50 / 60
Power	W	1600 / 1600
Temperature	°C	40 – 620
Air volume (20°C)	l/min	160 – 240 (500 at max. temp)
Dynamic pressure	Pa	1600 – 3000
Ø Nozzle holder	mm	31.5
Emission	dB(A)	67
Size (L × Ø)	mm	338 × 90, handle Ø 56
Weight	kg	1 (without power cord)
Conformity mark	CE	
Approval mark	S I	
Protection class II	□	

#### Article No.:

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



Overlap welding

## Accessories TRIAC ST / TRIAC AT

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

More at the new accessories catalog at


















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



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 fluoroplastics
	<b>113.666</b> Ø 3 mm drawing nozzle with tacking tip, screw-on
	<b>113.399</b> Ø 4 mm drawing nozzle with tacking tip, screw-on
	<b>113.876</b> Ø 3 mm drawing nozzle without tacking tip, screw-on
	<b>113.874</b> Ø 4 mm drawing nozzle without tacking tip, screw-on
	<b>113.670</b> Drawing nozzle triangular-shaped With tacking tip, screw-on 5.7 mm, profile A
	<b>113.877</b> Without tacking tip, screw-on 5.7 mm, profile A
	<b>106.986</b> Without tacking tip, screw-on 7 mm, profile B
	<b>106.987</b> Without tacking tip 7 x 5.5 mm
	<b>157.717</b> Protection nozzle 31.5 mm, air outlet 23 mm, protection ring 80 mm
	<b>107.344</b> 135 mm welding mirror, push-fit
	<b>143.833</b> Nozzle adapter for screw-on nozzles
	<b>143.332</b> Protection tube for screw-on nozzles (for TRIAC ST until april 2017)
	<b>156.092</b> Protection tube for screw-on nozzles (for TRIAC ST from mai 2017)
	<b>144.134</b> Protection tube for screw-on nozzles (for TRIAC AT)
	<b>141.375</b> Connection adapter M14 for Ø 21 mm nozzle with plug

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



# ELECTRON ST: Strong, compact and handy

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

## Product advantages

1



### Powerful:

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

2



### Perfekte Ergonomie:

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

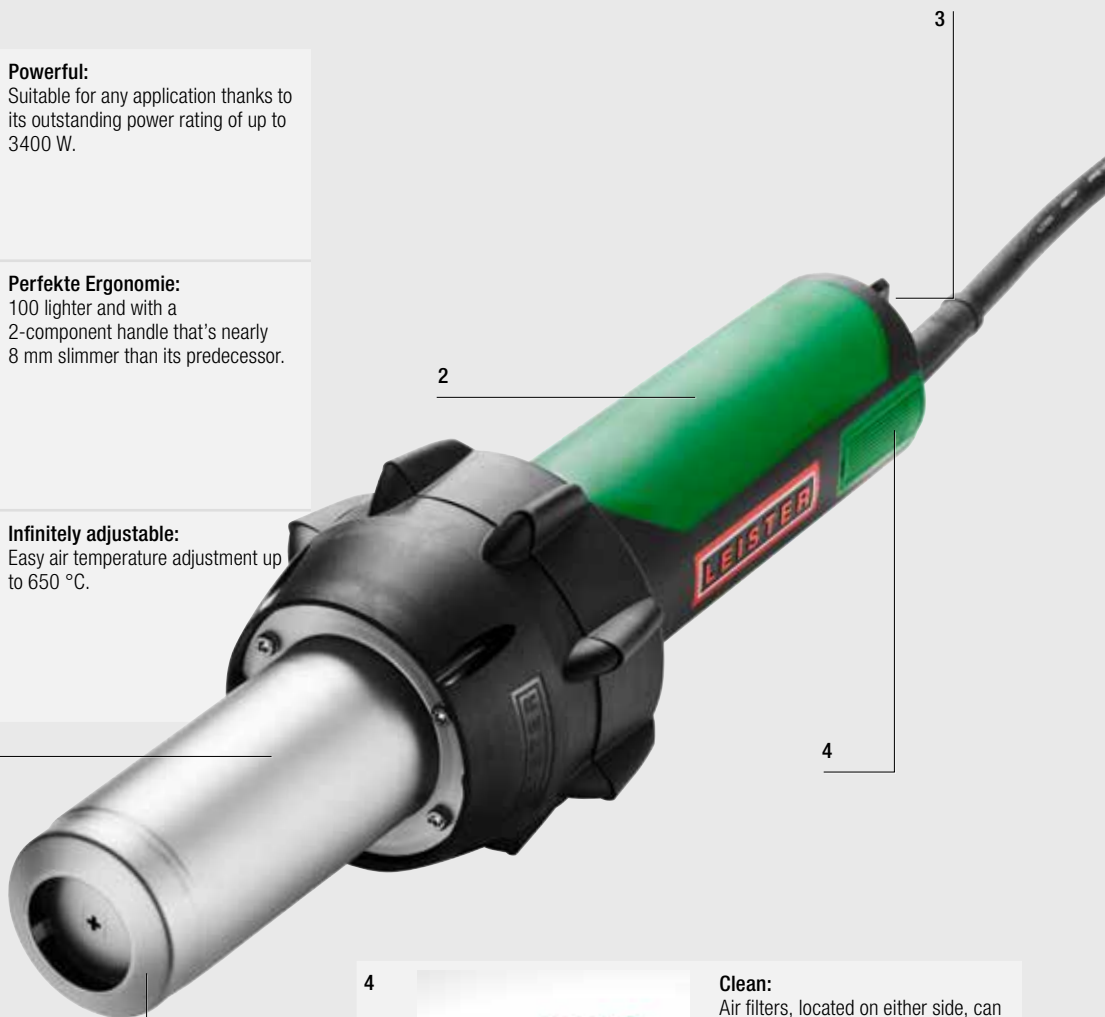
3



### Infinitely adjustable:

Easy air temperature adjustment up to 650 °C.

1



3

2

4

5

4



### Clean:

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

5



### Compatible:

All predecessor nozzles fit the ELECTRON ST.



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

## Hot-air hand tool

### ELECTRON ST



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

#### Technical data

Voltage	V~	230 / 230 / 200 / 120
Frequency	Hz	50 / 60
Power	W	2300 / 3400 / 3000 / 2400
Temperature	°C	40 – 650
Air volume (20°C)	l/min	360 (700 at max. temp)
Dynamic pressure	Pa	3400
Ø Nozzle holder	mm	50
Emission	dB(A)	67
Size (L × Ø)	mm	338 × 90, handle Ø 56
Weight	kg	1.1 (without power cord)
Conformity mark		CE
Approval mark		§ K
Protection class II		□

#### Article No.

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

### Accessories ELECTRON ST

	<b>107.258</b>	Wide slot nozzle, push-fit 70 × 10 mm, for bitumen
	<b>107.653</b>	Wide slot nozzle 75 × 2 mm, push-fit
	<b>151.068</b>	Tool stand for 107.653
	<b>107.270</b>	Wide slot nozzle 150 × 12 mm, push-fit
	<b>107.229</b>	Round nozzle 20 mm
	<b>107.331</b>	72 × 70 mm folding reflector, push-fit
	<b>107.330</b>	125 × 22 mm folding reflector, push-fit
	<b>107.327</b>	85 × 85 mm sieve reflector, push-fit
	<b>107.333</b>	130 × 150 mm sieve reflector, push-fit
	<b>106.127</b>	Ø 65 mm sieve reflector push-fit
	<b>107.340</b>	45 × 250 mm Shell reflector, push-fit
	<b>107.346</b>	270 mm welding mirror, push-fit
	<b>142.281</b>	Scraper nozzle
	<b>107.134</b>	Tape welding nozzle 40 mm
	<b>160.842</b>	Protection nozzle, air outlet 44 mm, protection ring 100 mm
	<b>148.933</b>	Protective tube
	<b>145.606</b> <b>149.675</b> <b>145.604</b>	Heating elements 230 V / 3300 W 230 V / 2200 W 120 V / 2300 W

More at the new accessories catalog at

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

General accessories

36/37



# HOT JET S: Small and powerful.

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



Especially suited for precise work.

## Hot-air hand tool

### HOT JET S



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

#### Technical data

Voltage	V~	120 / 230
Frequency	Hz	50 / 60
Power	W	460 / 460
Temperature	°C	40 – 600
Air volume (20°C)	l/min	40 – 110 (200 at max. temp)
Pressure static	Pa	230 – 1600
Ø Nozzle holder	mm	21.3
Emission	dB(A)	59
Size (L x Ø)	mm	235 x 70, handle Ø 40
Weight	kg	0.4 (without power cord)
Conformity mark	CE	
Approval mark	3 K	
Protection class II	□	

#### Article No.:

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

## Accessories HOT JET S

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

















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



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

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

	<b>131.867</b> Ø 5 mm, tubular nozzle, 90° angled, push-fit
---	---

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



# SOLANO AT: Light, quiet, durable

From our dialog with you, we know what you need. When we were developing the SOLANO AT, we focused on your requirements. This is why it is lighter, quieter and more durable than any other hot-air hand tool. Discover its unbeatable advantages – SOLANO AT.

Heat gun

## SOLANO AT

1



**Practical dust filter:**  
Robust, fine-mesh and easy to clean dust filter (exchangeable).

2



**Operating keys:**  
180° panorama soft-touch keypad for convenient operation.

3



**Burn protection – A.B.D (anti-burn design):**  
For a safe handling of the hot-air blower.

4



**Ergonomic:**  
due to its convenient design



Customizable temperature and air flow limit values



Customizable cooling function



Customizable direct start-up



Customizable power management





SOLANO AT – Difficult leather parts – safe and efficient processing



## Heat gun

## SOLANO AT



- **Long-lasting:** thanks to the brushless motor and sturdy LEISTER heating element
- **Light and quiet:** weighs 750 g and runs extremely smoothly at < 65 dB for efficient and effortless operation
- **Economical:** saves up to 40% energy in Eco mode
- **Safe:** due to its multi-level system to protect against overheating
- **Simple:** due to its intuitive operation
- **Controlled:** consistent performance due to the intelligent temperature controller
- **Versatile:** suitable for numerous applications in various industries

## Technical data

Voltage	V~	100	120	230
Power	W	1500	1800	2300
Temperature	°C	50 – 650		
Air volume	l/min (20°C)	160 – 300 [550 at max. temp]		
Emission	dB (A)	< 65		
Dimensions L × W × H (Ø handle)	mm	270 × 75 × 240 (45)		
Weight	g	750		
Conformity mark				CE
Approval mark				
Protection class II				

## Article No.:

162.269	SOLANO AT 230 V / 2300 W with AUS plug, box (162.270 casing)
162.271	SOLANO AT 220 V / 2100 W with KR plug, box (162.272 casing)
162.273	SOLANO AT 120 V / 1800 W with US plug, box (162.274 casing)
162.275	SOLANO AT 100 V / 1500 W with JP plug, box (162.276 casing)
Scope of delivery: SOLANO AT, box / casing	

## Accessories SOLANO AT

	<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 × 130 mm, straight
	<b>107.308</b> Sieve reflector 50 × 35 mm
	<b>107.309</b> Sieve reflector 35 × 20 mm
	<b>107.313</b> Spoon reflector 25 × 30 mm, with screw connector
	<b>107.314</b> 25 x 30 mm spoon reflector, push-fit
	<b>107.319</b> Sieve reflector Ø 65 mm
	<b>158.474</b> Protection nozzle, air outlet Ø 23 mm, protection ring Ø 80 mm
	<b>145.579</b> Heating element, 100 V / 1450 W
	<b>145.580</b> Heating element, 120 V / 1700 W
	<b>145.582</b> Heating element, 230 V / 2200 W

More at the new accessories catalog at

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

General accessories

36/37





## 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



##### Stand:

Thanks to the included stand, the GHIBLI AW can be placed in an optimum position at the workstation, thus reducing fatigue.

2



##### Practical air filter

Regular cleaning of the air filters ensures optimum air flow and maximum power.

3



##### Leister e-Drive

Temperature and air volume are easy to control and inspect with the proven "e-Drive" operating unit – for reproducible results.

4



##### Fatigue-free working

Thanks to the integrated suspension lug, the GHIBLI AW can be suspended for fatigue-free work.

5



##### Compatible

All of its predecessor's nozzles also fit on the GHIBLI AW. Comprehensive selection of compatible accessories.

6



##### Ergonomic handling

The two-component handle and the perfect device balance ensure an optimal grip and comfortable work, even under the harshest of conditions.

1

2

3

4

5

6



practical device suspension make working easier. The air filters can be readily removed and cleaned. And of course, all of the nozzles from its predecessor fit the new 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 (20°C)	l/min	230 – 330 (600 at max. temp)
Pressure static	Pa	1800 – 3200
Ø Nozzle holder	mm	36.5
Emission	dB(A)	67
Dimensions (L × W × H)	mm	280 × 90 × 220, Handle Ø 45
Weight	kg	1.1 (without power cord)
Conformity mark	CE	
Approval mark	S	
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, quick guide

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

More at the new accessories catalog at

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

General accessories

36/37







# GHIBLI: “The hot-air gun”.

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



Shrinking cable connections with the GHIBLI.

## Hot-air hand tool

### GHIBLI



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

#### Technical data

Voltage	V~	120 / 230
Frequency	Hz	50 / 60
Power	W	1500 / 2000
Temperature	°C	40 – 600
Air volume (20°C)	l/min	250 / 300 (500 at max. temp)
Ø Nozzle holder	mm	36.5
Emission	dB(A)	70
Size (L × W × H))	mm	195 × 85 × 160, Handle Ø 57
Weight	kg	0.9 (without power cord)
Conformity mark	CE	
Approval mark		
Protection class II	□	

#### Article No.:

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

Additional versions available upon request.

## Accessories GHIBLI

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

More at the new accessories catalog at

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

General accessories

36/37

# 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.



HOTWIND SYSTEM with wide slot nozzle integrated in a blow-off application.

Hot-air hand tool

## HOTWIND PREMIUM / SYSTEM



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

### Technical data

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

### Article No.:

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

Additional versions available upon request

## Accessories

### HOTWIND PREMIUM / SYSTEM

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

	Wide slot nozzle, push-fit (a × b)
	<b>106.028</b> 220 × 12 mm
	<b>107.272</b> 300 × 12 mm
	<b>106.018</b> 400 × 10 mm
	<b>106.024</b> 500 × 7 mm
	<b>107.267</b> 500 × 15 mm
	<b>106.023</b> 600 × 4 mm
	<b>106.026</b> 600 × 9 mm

Technical data			
Voltage	V~	3 × 230	3 × 400
Power	kW	10	10
Temperature	°C	650	
Size (L × Ø)	mm	390 × 132, handle Ø 85	
Weight	kg	4.4 (without power cord)	
Conformity mark	CE		
Approval mark	S		
Protection class II	□		
Article No.:			
102.027    FORTE S3, 3 × 400 V / 10 kW with 16A CEE plug			
Additional versions available upon request			



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

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

1



## Dual operation:

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

2



## The quick-change artist:

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

3



## Quality is measurable:

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

4



## Logic for a longer service life:

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

2



1

3

4



AIRSTREAM ST, the quiet air supply unit.

**Blower****AIRSTREAM ST**

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

**Technical Data**

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

**Scope of delivery:**

Air supply unit, hose transition pieces, clips, quick guide

**Article-No.:**

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

**Accessories AIRSTREAM ST****159.535** Roller set**159.481** Air hose connection set

Easy parallel operation.



A reliable companion.

## ROBUST: The powerhouse.

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



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

### Blower

## ROBUST



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

### Technische Daten

Frequency	Hz	50	60
Power	W	250	250
Air volume (20 °C )	l/min	1200	1300
Static pressure	kPa	8.0	10.5
Max. ambient temperature	°C	60	60
Max. air inlet temperature	°C	60	60
Noise emission level	dB(A)	62	62
Protection (IEC 60529)	IP 54	IP 54	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			
Protection class I		⊕	⊕

### Artikel-Nr.:

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

## Accessories ROBUST

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



# WELDING PEN: Slim and flexible.

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



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
















External air hand tool

## WELDING PEN R / WELDING PEN S



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

## Accessories WELDING PEN 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 x 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, screw-on 30°
	<b>127.727</b> 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

### Technical data

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

### Article No.:

114.275	WELDING PEN S, 120 V / 600 W, with UK-plug, 2.5 m hose
114.380	WELDING PEN R, 230 V / 1000 W, with Euro plug, 2.5 m hose
113.081	WELDING PEN S, 230 V / 1000 W, with Euro plug, 2.5 m hose
114.926	WELDING PEN R, 230 V / 1000 W, with Euro plug, 6 m hose
114.274	WELDING PEN S, 230 V / 1000 W, with Euro plug, 6 m hose
114.927	WELDING PEN R, 230 V / 1000 W, with Euro plug, 9 m hose
114.273	WELDING PEN S, 230 V / 1000 W, with Euro plug, 9 m hose

Swiveling air hose for easy working.



More at the new accessories catalog at

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

General accessories

36/37



## DIODE PID / S: The powerful pair.

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



Convenient wire welding using the powerful and lightweight DIODE PID.

### External air hand tool

#### DIODE PID / DIODE S



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

#### Technical data

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

#### Article No.:

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

Additional versions available upon request

### Hand tool and blower

#### DIODE PID / DIODE S with MINOR



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

- Ideal for assembly work

#### Technical data

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

#### Article No.:

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

Additional versions available upon request





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

## MINOR: The mobile air supplier.







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

### Accessories DIODE PID / DIODE S

#### With push-fit nozzle

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

#### With screw-on nozzle

	<b>105.622</b> Ø 5 mm tubular nozzle, screw-on
	<b>106.988</b> Tacking nozzle, screw-on
	<b>113.666</b> Ø 3 mm round drawing nozzle with tacking tip, screw-on <b>113.399</b> Ø 4 mm round drawing nozzle, with tacking tip, screw-on <b>113.876</b> Ø 3 mm round drawing nozzle without tacking tip, screw-on <b>113.874</b> Ø 4 mm round drawing nozzle, without tacking tip, screw-on
	<b>113.670</b> Triangular drawing nozzle, with tacking tip, screw-on, 5.7 mm <b>113.877</b> Without tacking tip, screw-on 5.7 mm, profile A <b>106.986</b> Without tacking tip, screw-on 7 mm, profile B <b>106.987</b> 7 × 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 × Ø)	mm	250 × 95, handle Ø 64
Weight	kg	1.15 (with 3 m cord)
Conformity mark	CE	
Protection class II	□	

#### Article No.:

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

Additional versions available upon request

More at the new accessories catalog at

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



# LABOR S: Small and handy.

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



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

## External Air Hand tool

### LABOR S



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

















#### Technical data

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

#### Article No.:

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

## Accessories LABOR S

	<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, profilee A <b>106.989</b> 7 mm, profilee B <b>106.990</b> 3 mm <b>106.991</b> 4 mm <b>156.470</b> 5 mm <b>156.470</b> 5mm bent
	<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 fluor plastics
	<b>101.581</b> 230 V / 800 W heating element

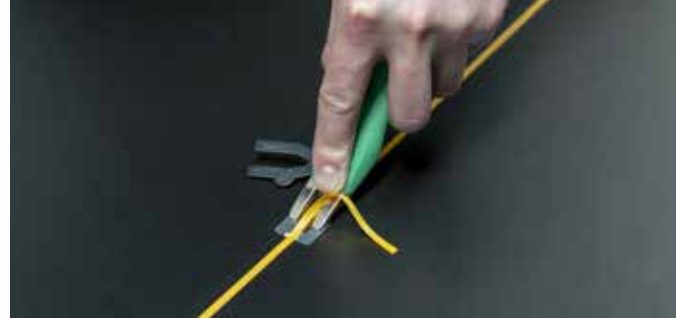
More at the new accessories catalog at

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

General accessories

36/37





Simple reworking of welding seams with the Leister trimming knife.

## Hot-air hand tools

### General accessories

	<b>106.974</b>	80 mm silicone pressure roller		<b>160.015</b>	Cable extension cord 15 m, with CEE 400V plug
	<b>140.160</b>	40 mm silicone pressure roller with ball bearings (silicone)		<b>159.239</b>	Cable extension cord 15 m, with EU plug 230V
	<b>140.599</b>	Spare roll for 140.160		<b>106.997</b>	Ø 6 mm rotary burr for drilling machine, for car repairs
	<b>140.161</b>	Pressure roller 28 mm, with ball bearings (silicone)		<b>116.798</b>	Brass brush
	<b>140.598</b>	Spare roll for 140.161		<b>142.647</b>	Brass brush Ø 3 mm
	<b>106.976</b>	28 mm pressure roller (PTFE)		<b>107.348</b>	Tool rest for TRIAC AT, TRIAC ST, ELECTRON ST, HOT JET S, LABOR S
	<b>106.972</b>	Brass pressure roller with ball bearings		<b>137.855</b>	Leister cutter with four spare blades
	<b>117.000</b>	Trimming knife with 0.6 mm spacer for vinyl and linoleum with 5 spare blades included		<b>138.902</b>	Hooked blade for LEISTER-cutter (10 dispenser with 10 pcs=100 pcs)
	<b>117.005</b>	5 spare blades		<b>138.539</b>	Straight-edge blade for LEISTER-cutter (10 dispenser with 10 pcs = 100 pcs)
	<b>117.007</b>	1 universal spacer 0.6 mm		<b>151.382</b>	Inside corner tool
	<b>138.314</b>	Seam probe tester for overlap seams		<b>153.009</b>	Plastfix
	<b>151.188</b>	Chamfer planer for T-joints for sealing sheets		<b>154.259</b>	Scraper blade
	<b>152.676</b>	Weld seam template		<b>154.026</b>	Contour scraper
	<b>157.544</b>	Leister Universal scissors 260 mm with special shaft grinding		<b>116.586</b>	Storage case for TRIAC AT, TRIAC ST, ELECTRON ST
	<b>160.353</b>	Cable cord roller 25 m, with 1 x CEE 400V and 2 x EU socket 230V			
	<b>161.152</b>	Cable cord roller 25 m, with 1 x CEE 400 V and 2 x T23 CH socket 230 V			
	<b>161.207</b>	Cable cord roller 25 m, with 1 x CEE 400 V and 2 x Typ E with ground pin socket 230 V			
	<b>164.048</b>	Cable cord roller 45 m, 4 x 230 V, EU socket			

More at the new accessories catalog at

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





## Welding rods

Article	Profile	Colour	kg
<b>Welding accessories PE</b>			
104.283 HDPE welding rod	A	Black	3
104.294 HDPE welding rod	A	White	3
104.284 HDPE welding rod	B	Black	5
104.299 HDPE welding rod	B	White	5
106.650 HDPE welding band	C	White	1
104.300 LDPE welding rod	A	Black	3
161.612 HDPE welding rod	D	Black	2
116.918 HDPE welding rod	D	Yellow	2
<b>Welding accessories PP</b>			
104.287 PP welding rod	A	Yellow	3
104.301 PP welding rod	A	Black	3
106.642 PPs welding rod, flame resistant	A	Yellow	3
104.288 PP welding rod	B	Yellow	5
126.356 PP welding band	C	White	2
161.611 PP welding rod	D	Yellow	2
<b>Welding accessories PVC</b>			
104.296 PVC-U welding rod	A	White	3
104.278 PVC-U welding rod	A	Grey	3
106.641 PVC-U welding rod	A	Brown	3
104.280 PVC-U welding rod	B	Brown	5
104.279 PVC-U welding rod	B	Grey	5
109.925 PVC-U welding rod	D	Grey	4
104.302 PVC-P welding rod (soft)	A	White	3
<b>Welding accessories ABS</b>			
104.295 ABS welding rod	A	White	3
113.587 ABS welding rod	A	Black	3
107.027 ABS welding band	C	White	1

## Profile sizes

Profile A	Profile B	Profile C	Profile D

Dimensions in mm

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





Aldi logistics center 50000m2 TPO Membrane, Switzerland



Exploration Place First, Wichita, USA



Schöni transport Centre, Switzerland



### Roofing

Roofing welders overview	40
UNIDRIVE 500	41 / 42
UNIROOF AT / ST	43 - 45
VARIMAT V2 / VARIMAT S	46 / 47
BITUMAT B2	48
EXAMO USB / Testing instrument	49

### Hot Air Tools for Roofing

TRIAC ST	12 – 15
TRIAC AT	13 – 15
ELECTRON ST	16 / 17
HOT JET S	18 / 19
General accessories	36 / 37










Simple operation in combination with high welding performance.



Flameless welding of modified bitumen with the BITUMAT. B2.

## Overview Roofing Welders

				
<b>Materials</b>	<b>Thermoplastic Single-Ply membranes</b>			<b>Modified Bitumen</b>
<b>Type of welding machine</b>	<b>UNIDRIVE 500</b>	<b>UNIROOF AT/ST</b>	<b>VARIMAT V2 / VARIMAT S</b>	<b>BITUMAT B2</b>
<b>Main application</b>	Parapets, tight spaces, pitched roofs	Parapets, edges Residential construction surfaces under 500 m2	Welding close to edges Industrial surfaces over 500 m2	First bitumen layer
<b>Roof construction</b>				
Flat roof	✓✓✓	✓✓✓	✓✓✓	✓✓✓
Sloped roof	✓✓✓	✓✓	✓	✓
Basic weld seams	✓	✓✓	✓✓✓	✓✓✓
Detail work	✓✓✓	✓✓✓	✓	✓
<b>Thickness of sealing sheets</b>	up to 1.8 mm	up to 1.8 mm	up to 2 mm / 1.8 mm	up to 6 mm
<b>Special features</b>	Welding on both sides with rotating nozzle	Ideal for roof edge welding	Double welding performance against competitors	Flameless welding
<b>Parapet spacing in mm</b>	45	100	110	200
<b>Generator operation</b>	4KW	At least 6 kW to supply a hot air hand tool	At least 10 kW to supply a hot air hand tool	
<b>Electronics</b>				
Regulated for drive and heater (closed-loop system)	UNIDRIVE 500	UNIROOF AT	VARIMAT V2	
Controlled for drive and heater (open loop)		UNIROOF ST	VARIMAT S	BITUMAT B2
<b>Speed m/min.</b>				
Drive	0.7 – 4.5	1 – 10	0.7 – 12	0.8 – 12
Welding speed (depending on material)	1 – 2.5	2 – 3	4 – 8	3 – 6
Recommended welding start parameter depending type of membrane (tested by room condition 20°C)	PVC membrane: 2.0 m/min, 480 – 520°C, air volume 100%  TPO/FPO membrane: 2.0 m/min, 420 – 470°C, air volume 100%	<b>UNIROOF AT</b> PVC: 2.0 m/min, 520°C, air volume 100% TPO: 2.5 m/min, 450°C, air volume 100%  <b>UNIROOF ST</b> PVC: 1.8 m/min, 520°C, air volume 100% TPO: 2.0 m/min, 450°C, air volume 100%	<b>VARIMAT V 2</b> PVC: 4.0 m/min, 550°C, air volume 85% TPO: 5.0 m/min., 500°C, air volume 100%  <b>VARIMAT S:</b> PVC: Temperature level 8.5–9 (550°C) TPO: No trailing roller, can only be used to limited degree	nozzle till 100 mm  Modified Bitumen: 5.0 m/min, 650°C, air volume 100%
<b>Weight kg</b>	4.5	17.5	35 / 28	40
<b>Blower technology</b>	Brushless	Brushless	Brushless / Brush motor	Brush motor
<b>Catalog page</b>	 <b>41 / 42</b>	<b>43 - 45</b>	<b>46 / 47</b>	<b>48</b>

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

## Reliable and cost-effective – everywhere – UNIDRIVE 500

The compact UNIDRIVE 500 semi-automatic hot-air welder impresses with its many advantages. Guided by two ergonomic handles, you can achieve the ideal pressure to ensure high-quality welding results. Change welding direction with ease via a rotating nozzle and reversible drive. The UNIDRIVE 500 is ideal for all roof applications, even in tight spaces, and welds two to three times faster than manual welding. Lap welding with the UNIDRIVE 500 – reliable and cost-effective – everywhere.

Semi-automatic hot-air welder

### UNIDRIVE 500

1



**Reliable:**

Ergonomic handle for balanced pressure during manual welding

2



**Safe:**

Constant parameters and reliable quality – even with undervoltage

3



**Flexible:** Stainless steel nozzle for all welding application

4



**Customized:** Reversible drive allows for welding in either direction





Whether on or at the roof parapet or welding domed skylights, connections, or small terraces – the UNIDRIVE 500 shows its worth when space is tight.

## Semi-automatic hot-air welder

### UNIDRIVE 500



- **Safe:** Constant parameters and reliable quality – even with undervoltage
- **Fast:** Up to three times faster than manual welding
- **Customized:** Reversible drive allows for welding in either direction
- **Practical:** Compact and lightweight semi-automatic hot-air welder: 4.5 kg, 30 cm high
- **Economical:** Maintenance-free, brushless motors

Technical data		UNIDRIVE 500 100 V	UNIDRIVE 500 100 – 120 V	UNIDRIVE 500 220 – 240 V
Voltage	V~	100	120	230
Power	W	1500	1800	2200
Temperature	°C	100 – 560		
Air volume	%	45 – 100		
Speed	m/min	0.7 – 4.5		
Emission	L <sub>pA</sub> (dB)	70 (K = 3 dB)		
Size (L × H × B)	mm	297 × 173 × 275		
Weight	kg	4.5		
Conformity mark		CE		
Protection class I		⊕		

#### Article No.:

163.144 UNIDRIVE 500, 40 mm, 220 – 240 V/2200 W, Euro plug, Silicone rollers  
 163.146 UNIDRIVE 500, 40 mm, 220 – 240 V/2200 W, CEE 3 pol. blue, Silicone rollers  
 163.148 UNIDRIVE 500, 40 mm, 100 – 120 V/1800 W, UK plug, Silicone rollers  
 163.149 UNIDRIVE 500, 40 mm, 100 V/1500 W, JP plug, Silicone rollers  
 163.150 UNIDRIVE 500, 30 mm, 220 – 240 V/2200 W, EU plug, Silicone rollers  
 163.151 UNIDRIVE 500, 40 mm, 220 – 240 V/2200 W, CEE 3 pol. blue, Steel rollers  
 163.152 UNIDRIVE 500, 15 mm, 220 – 240 V/2200 W, CEE 3 pol. blue, Steel rollers  
 Included with purchase: Welding machine, device case, hex key, quick guide

## Accessories UNIDRIVE 500

	164.586	Overlap welding nozzle 15 mm
	164.576	30 mm
	164.403	40 mm
	163.930	Pressure roller, steel 15 mm
	163.357	Pressure roller steel 40 mm
	162.551	Support wheel, silicone
	161.156	Silicone rubber roller 40 mm
	159.911	Wheel for silicon rubber roller 40 mm
	156.531	Carrying strap for Leister case

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

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

Hot-air welder

## UNIROOF AT/ST

1



### No more time consuming

**converting:** The ultra slim roof welding machine with its movable transport axle masters welding close to the edge (up to 100 mm) at or on the parapet, and wherever it gets narrow.

2



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

3



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

4



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

5

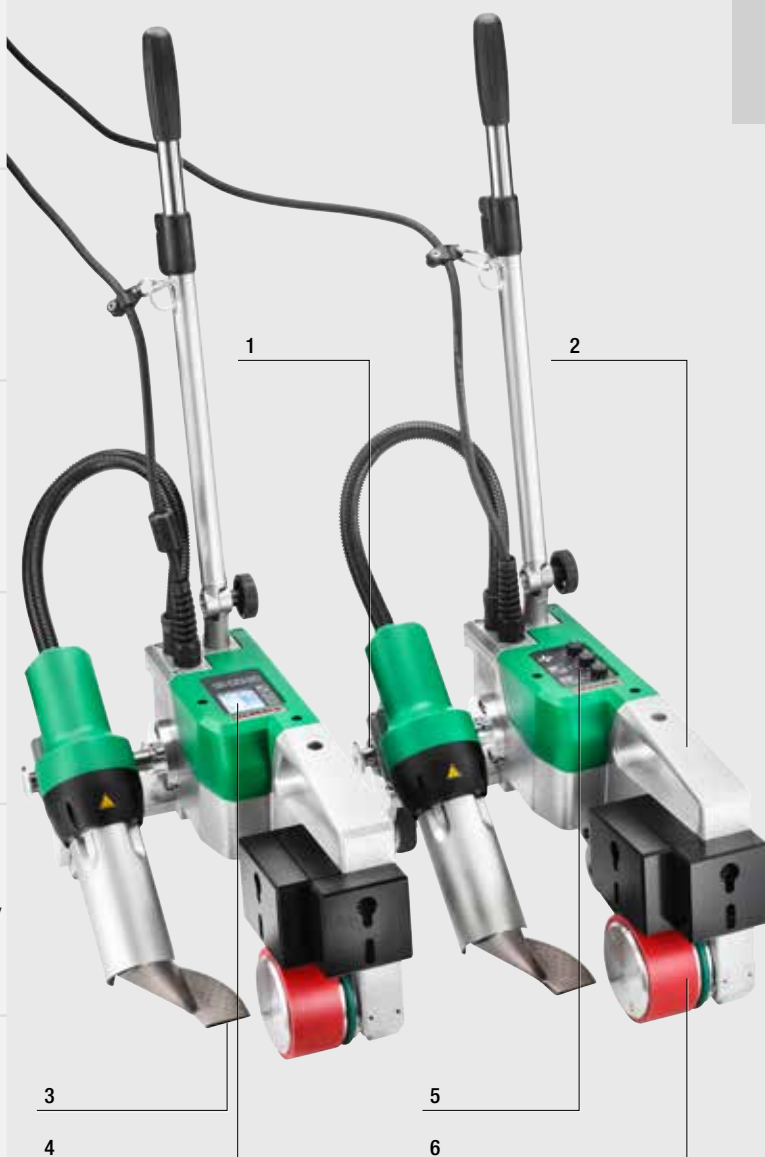


**UNIROOF ST for purists: Closed-loop controlled drive motor with open-loop technology** for the control of temperature and air blower. Simple control (regulation) with potentiometer/rotary knobs.

6



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



Roofing



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



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

Hot-air welder

## UNIROOF AT



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

### Technical Data

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

### Article No.:

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

Hot-air welder

## UNIROOF ST



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




### Technical Data




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

### Article No.:

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

## Accessories UNIROOF AT/ST

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

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



versatile, easy to maintain, efficient.

## VARIMAT V2: Fast and dependable.

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



Highly reliable in application even at undervoltage.

Hot-air welder

### VARIMAT V2



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






#### Technical data

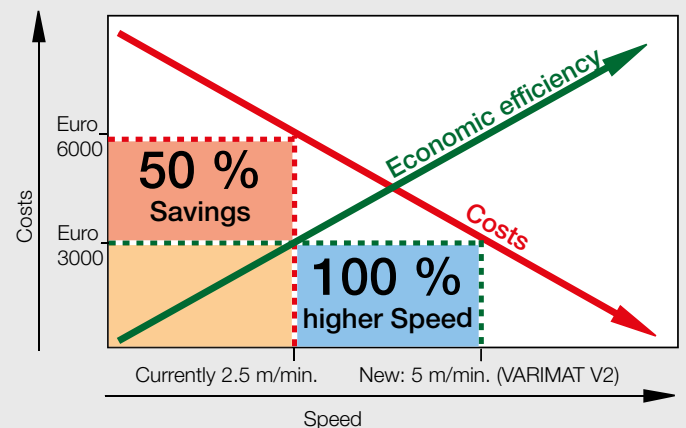
Voltage	V~	230 / 400
Power	W	3680 / 5700
Temperature	°C	100 – 600
Speed	m/min	0.7 – 12
Air flow range	%	50 – 100
Width of welding nozzle	mm	40
Size (L x W x H)	mm	640 x 430 x 330
Weight	kg	35
Conformity mark	CE	
Protection class I	⊕	

#### Article No.:

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

### Accessories VARIMAT V2

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








Welded with standard nozzle.



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

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

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



# BITUMAT B2: The flameless.

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



Easy unit guidance and clean working with the BITUMAT B2.

## Hot-air welder

### BITUMAT B2



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

#### Technical data







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

#### Article No.:

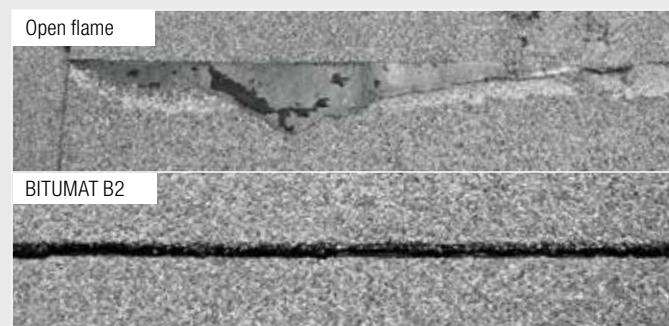
- 140.438 BITUMAT B2 400 V / 6700 W, 75 mm, 16 A-CEE-plug
- 140.437 BITUMAT B2 400 V / 6700 W, 100 mm, 16 A-CEE-plug
- 140.436 BITUMAT B2 230 V / 6700 W, 75 mm, 32 A-CEE-plug
- 138.386 BITUMAT B2 230 V / 6700 W, 100 mm, 32 A-CEE-plug

Additional versions available upon request.

## Accessories BITUMAT B2

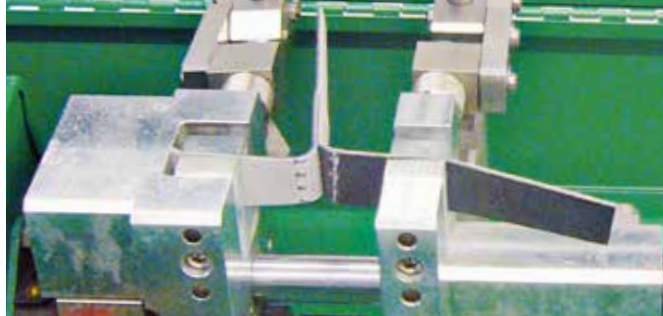
	<b>138.048</b>	75 mm bitumen nozzle
	<b>138.047</b>	100 mm bitumen nozzle
	<b>137.895</b>	100 mm pressure roller with gap
	<b>137.896</b>	75 mm pressure roller with gap
	<b>140.229</b>	100 mm pressure roller without gap
	<b>140.228</b>	75 mm pressure roller without gap
	<b>156.447</b>	80 mm silicon pressure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

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



# EXAMO: 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.



Testing a weld seam with the EXAMO USB.

## Tensiometer

### EXAMO 300F USB, 600F USB



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

#### Technical Data

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

#### Article No.:

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

### Accessories EXAMO 300F USB, 600F USB



**134.832** Testing and calibration kit to test and calibrate your EXAMO USB

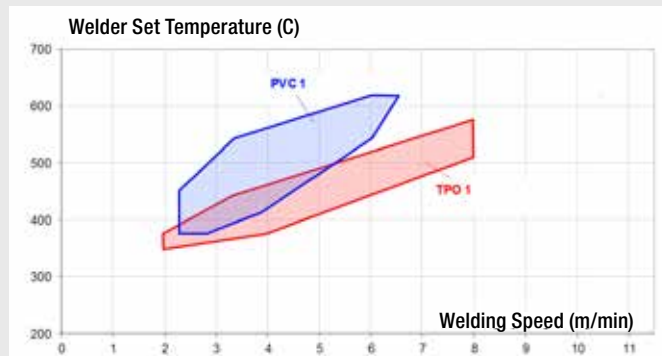


**108.185** Jaw kit 60 mm for geotextiles including two pairs of jaws



**144.416** USB memory-stick

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



Typical welding windows for TPO and PVC



#### Article No.:

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

For testing T-joints







Truck cover



Awning



Flood protection



### Technical Textiles & Industrial Fabrics

Product overview hot-air welders	52 / 53
HEMTEK ST	54 / 55
HEMTEK K-ST	56 / 57
SEAMTEK 900 AT	58 / 59 / 62
SEAMTEK W-900 AT	60 - 62
VARIANT T1	64 / 65
VARIANT T1 Overlap	65
VARIANT T1 TAPE	66
UNIPLAN 300 / 500	67 / 68
TAPEMAT / TAPEMAT SPRIEGEL	69

### Hot-Air Hand Tools

TRIAK ST	12 – 15
TRIAK AT	13 – 15
HOT JET S	18 / 19
SOLANO AT	20 / 21
GHIBLI AW	22 / 23
General accessories	36 / 37



Billboard









## Stationary welding machines

				
Device type	HEMTEK ST	HEMTEK K-ST	SEAMTEK 900 AT	SEAMTEK W-900 AT
Max. voltage V~	120 / 230	120 / 230	230 / 240	230 / 240
Max. power W	1800 / 2350 / 3450	1800 / 2350	4500	3900
Temperature °C	100 – 650	100 – 650	120 – 700	0 – 680
Speed m/min	0.8 – 12	0.8 – 12	0.1 – 30	0.8 – 30
Welding width mm	20 / 30 / 40	8	8 – 64	8 – 64
Size (L × W × H) mm	433 × 350 × 600	433 × 350 × 600	1500 × 702 × 1500	1700 × 702 × 1500
Weight kg	27.0	27.0	238.0	238.0
<b>Welding options</b>				
Overlap welding	✓		✓	✓
Hem welding	✓		✓	✓
Piping welding	✓	✓	✓	✓
Tape welding	✓		✓	✓
Prayer weld			✓	✓
Pole pocket	✓		✓	✓
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	 54 / 55	56 / 57	58 / 59 / 62	60 - 62



Tents

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

							
Device type	VARIANT T1 Overlap	VARIANT T1 TAPE 50 mm	VARIANT T1 TAPE 25 mm	UNIPLAN 300	UNIPLAN 500	TAPEMAT 50 mm	TAPEMAT SPIEGEL 100 / 125 mm
Max. voltage V~	230 / 400	230 / 400	230 / 400	120 / 230	120 / 230	3 × 400	3 × 400
Max. power W	3680 / 5700	3680 / 5700	3680 / 5700	1800 / 3450	1800 / 3450	10 000	10 000
Temperature °C	100 – 620	100 – 620	100 – 620	100 – 620	100 – 620	100 – 650	100 – 650
Speed m/min	1.5 – 18	1.5 – 18	1.5 – 18	1 – 16	1 – 16	4 – 20	4 – 20
Welding width mm	20 / 40	50	25	20 / 30 / 40	20 / 30 / 40	50	2 × 20
Size (L × W × H) mm	500 × 400 × 195	700 × 415 × 85	700 × 415 × 85	500 × 310 × 300	500 × 310 × 300	555 × 435 × 370	555 × 435 × 370
Weight kg	22.5	28.0	28.0	15.0	16.0	35.0	40.0
Conformity mark	CE	CE	CE	CE	CE	CE	CE
Certification scheme	CCA	CCA	CCA	CCA	CCA	CCA	CCA
Protection class	II	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	 64 / 65	65	66	67 / 68	67 / 68	69	69

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

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

## Hot-air Welding machine

### HEMTEK ST

1



#### Hem guide:

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

2



#### Table clamp:

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

3



#### Control panel:

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

4



#### Foot pedal:

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

5



#### Pressure roller:

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





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



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

## Hot-air Welding machine

### HEMTEK ST

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

#### Technical data

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











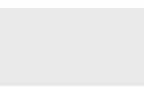
#### Included with purchase:

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

#### Article No.:

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

### Accessories HEMTEK ST

	<b>157.048</b> <b>157.047</b> <b>108.117</b>	Pressure roller, top 20 mm 30 mm 40 mm
	<b>157.070</b> <b>157.071</b> <b>161.202</b>	Pressure roller, bottom 20 mm 30 mm 40 mm
	<b>157.707</b> <b>157.706</b> <b>157.705</b>	Nozzle 20 mm 30 mm 40 mm
	<b>157.098</b>	Nozzle adjustment gauge
	<b>156.472</b>	Adjustable hemming/piping guide
	<b>157.879</b>	Adjustable hemming/piping guide for heavy materials
	<b>155.800</b>	Overlap guide
	<b>159.780</b>	Tape welding guide
	<b>160.269</b>	Contact pressure weight large
	<b>153.947</b> <b>149.675</b> <b>145.606</b>	Heating elements 120V/1800W (20/30/40 mm) 230V/2200W (20 mm) 230V/3300W (30/40 mm)
	<b>157.540</b>	Rubber stoppers
	<b>116.798</b>	Brass brush

# HEMTEK K-ST: Piping creation made easy

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

Hot-air welder

## HEMTEK K-ST

1



### Piping guide:

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

2



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

3



### Table clamp:

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

4



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





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

## Hot-air welder

### HEMTEK K-ST

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

#### Technical Data

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

#### Scope of delivery:

Hot-air welder, table fastening console, flap piping guide, quick guide, main catalog, folder

#### Article no.

162.499 HEMTEK K-ST, 230 V / 2350 W, EU plug  
162.605 HEMTEK K-ST, 120 V / 1800 W, US plug

## Accessories

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

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

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

# SEAMTEK 900 AT: Maximum flexibility for your specific application

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

## Welding machine

### SEAMTEK 900 AT

1



#### Intuitive

- All parameters can be modified via touchscreen
- Complete regulation of all parameters

2



#### Application-friendly

- Tool-free nozzle adjustment
- Rapid wheel replacement

3



#### Pedestal

- Overlap welding
- Hem and piping welding
- 3D / Inflatable welding
- Tape welding

4



#### Quickarm

- Endless welding of pipes and hoses
- Overlap welding

5



#### Sidearm

- Circumference welding
- Tape welding
- Sealing of end caps
- Strip welding

6



#### Tape Delivery System

- Application of seam sealing tape
- Welding of reinforcement tape
- Welding of hot melt adhesive tape



Leister SEAMTEK 900 AT





Easy, economical and safe welding.

## Welding machine

### SEAMTEK 900 AT



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

#### Technical data

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

#### Article No.:

155.555	SEAMTEK 900 AT Base version with pedestal, 2 steel pressure rollers 25 mm, standard nozzle 25 mm
155.777	Quick arm
155.666	Side arm
155.888	Tape Delivery System (TDS)
155.386	Monitoring unit for the SEAMTEK 900 AT

### Accessories SEAMTEK 900 AT

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



SEAMTEK 2000 AT (2 m frame). Delivery time on request.

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

The SEAMTEK W-900 AT is the first welding machine to feature the innovative hot-wedge technology from LEISTER. This new welding machine is based on the tested and trusted SEAMTEK 900 AT. It allows you to easily reduce the welding speed without interruption during critical points in the welding process, while maintaining the same level of seam quality. Discover the benefits of the SEAMTEK W-900 AT and boost your welding efficiency.

## Welding machine

### SEAMTEK W-900 AT

1



#### Innovation

- The speed can be changed during the welding process, just like when using a sewing machine
- Temperature is automatically adjusted to your speed
- Highly efficient, up to 680 °C

2



#### Significant potential for savings

- Virtually no energy consumption in standby mode
- Significantly lower energy consumption than comparable machines
- Inexpensive replacement wedges

3



#### Ready for use in just a few seconds

- No preheating required
- Hot wedge heats up immediately at the start of the welding process

4



#### Safe and easy

- Reduce the speed easily during the welding process without affecting the seam quality
- The hot wedge cools down as soon as it is swiveled out (or in standby mode). This reduces the risk of burns

5



#### Outstanding seam results

- Flat, precise seams, even when welding curves
- Better welding results with fewer waves and wrinkles in the case of delicate materials



LEISTER SEAMTEK W-900 AT



Dinghies © Marek Uliasz | Dreamstime.com



Innovative hot-wedge technology

## Welding machine

### SEAMTEK W-900 AT



- Easy to change wedge bracket
- Multi-arm system with pedestal and quickarm
- Welding parameters digitally regulated
- Intuitive user interface
- Practically silent
- Compressed air connection not required
- Welding parameters can be saved
- Virtually no smoke
- Low-maintenance
- Digital wizard to adjust the wedge position

#### Technical data

Voltage	V~	230 / 240
Power	W	3900
Temperature	°C	0 – 680
Speed	m/min	0.8 – 30
Dimensions (L × B × H)	mm	1700 × 702 × 1500
Weight	kg	238
Welding seam width	mm	8 – 64

#### Article No.:

159.159	SEAMTEK W-900 AT with pedestal and a power supply (without wheels and wedge bracket)
160.330	Additional power supply
155.777	Quickarm
155.888	Tape delivery system














### SEAMTEK W-900 AT accessories

	162.854	8 mm
	162.847	13 mm
	162.846	19 mm
	162.700	25 mm
	162.809	38 mm
	162.818	50 mm
	162.829	57 mm
	162.837	64 mm
	163.172	8 mm
	163.173	13 mm
	163.174	19 mm
	163.175	25 mm
	163.176	38 mm
	163.177	50 mm
	163.178	57 mm
	163.179	64 mm
	163.419	8 mm
	163.420	13 mm
	163.421	19 mm
	163.422	25 mm
	163.423	38 mm
	163.424	50 mm
	163.425	57 mm
	163.426	64 mm
	163.427	8 mm
	163.428	13 mm
	163.429	19 mm
	163.430	25 mm
	163.431	38 mm
	163.432	50 mm
	163.433	57 mm
	163.434	64 mm



Aircraft hangar / angarstroy.com

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

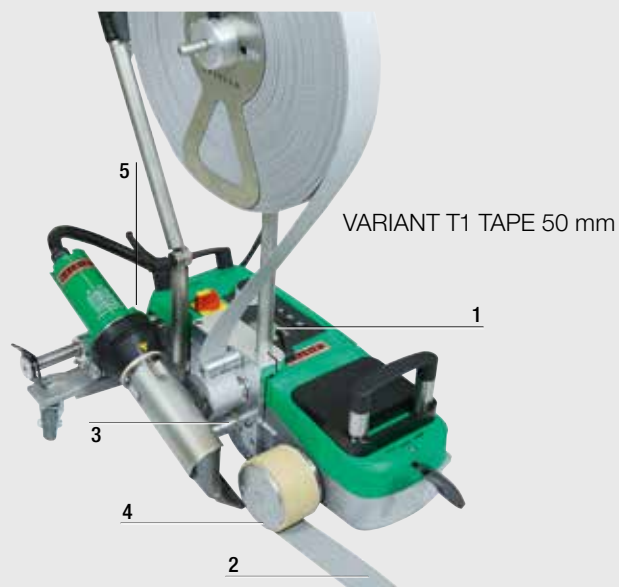
	<p>Wheel, Silicone, 50A, Ø 63.5 mm</p> <p><b>155.401</b> 13 mm</p> <p><b>155.402</b> 19 mm</p> <p><b>155.403</b> 25 mm</p> <p><b>155.404</b> 38 mm</p> <p><b>155.405</b> 50 mm</p> <p><b>155.406</b> 57 mm</p> <p><b>155.407</b> 64 mm</p>		<p><b>155.400</b> Holder system for guides</p>
	<p><b>155.660</b> Adjustable overlap guide, 0 – 64 mm</p>		<p><b>156.780</b> Overlap guide for quick arm</p>
	<p><b>155.530</b> Adjustable hem-/ piping guide 0 – 50 mm</p>		<p><b>155.410</b> Connection adapter for fume extraction</p>
	<p><b>155.760</b> Adjustable hem-/ piping guide 0 – 60 mm, for heavy materials</p>		<p><b>158.789</b> Tape cutting unit 18 – 25 mm (Compressed air needed)</p>
	<p><b>155.380</b> Open Hem/Pocket Guide up to 110 mm</p>		<p><b>158.928</b> Puller unit (Compressed air needed)</p>
	<p><b>155.540</b> Modular 3D guide</p>		<p><b>159.389</b> Adjustable Pedestal table</p>
	<p><b>156.760</b> Overlap guide from the left</p>		<p><b>158.139</b> LED gooseneck work lamp</p>
	<p><b>156.770</b> Adjustable acrylic tape guide</p>		





## VARIANT T1: Quality, productivity, ergonomic.

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

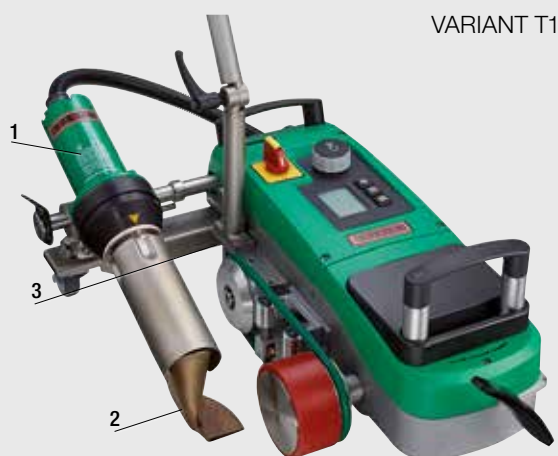


### VARIANT T1

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

### VARIANT T1 TAPE

1		<b>User-friendly:</b> Clear display plus "e-Drive" and storable welding parameters.
2		<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).
3		<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.
4		<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.
5		<b>Optional:</b> The laser guide keeps the VARIANT T1 TAPE firmly on course.



## VARIANT T1: Compact, fast and reliable.

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



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

Hot-air welder

### VARIANT T1 Overlap



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

#### Technical data

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

#### Article No.:

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

Additional versions available upon request.

### Accessories VARIANT T1 Overlap

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





An economical, ergonomic tool for welding reinforcement tapes.

## Tape hot-air welder

### VARIANT T1 TAPE



VARIANT T1 TAPE 25 mm,  
anti-vandalism

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

#### Technical data











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

#### Article No.:

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

Additional versions available upon request.

### Accessories VARIANT T1 TAPE

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



# Automatic, practical, safe – UNIPLAN 300 / UNIPLAN 500

Whether you are welding truck tarpaulins, tents, or banners, the UNIPLAN 300 and UNIPLAN 500 automatic welders are the ideal choice. Integrated lifting of the tarpaulins and automatic swiveling-in of the nozzle make the work easier for you and increases reliability. Thanks to the moveable swivel castor wheel, it is easy to get around obstacles such as grommets, hooks, or other accessories. Automatic, practical, safe – UNIPLAN 300 / UNIPLAN 500.

Hot-air welder

## UNIPLAN 300 / UNIPLAN 500



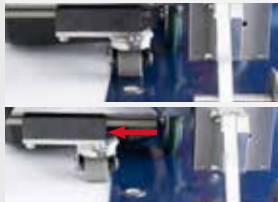
**automatic and safe:**  
swiveling in of the nozzle



**practical:**  
integrated lifting of the tarpaulin



**quick modification:**  
users can change from overlap welding to hem or pipe welding in one, easy step



**moveable swivel castor wheel:**  
to avoid obstacles such as grommets and hooks



**reliable:**  
controlled temperature and speed



Technical Textiles and Industrial Fabrics



UNIPLAN 300/UNIPLAN 500: ideal for lap, hem, and piping welding either on a table or on the ground.

## Hot-air welder

### UNIPLAN 300 / UNIPLAN 500



UNIPLAN 300



UNIPLAN 500

- Blower motor with brushes
- Hot-air blower welding capacity of 12,500 rpm
- Display for setting the welding parameters
- Low-maintenance, brushless motor
- Hot-air blower for higher welding capacity of 18,000 rpm
- Display for setting and saving the welding parameters

#### Technical data

Technical data		UNIPLAN 300		UNIPLAN 500	
Voltage	V~	120	230	120	230
Frequency	Hz	50 / 60			
Power	W	1800	3450	1800	3450
Temperature, stepless	°C	100 – 620			
Drive, stepless	m/min	1 – 16			
Nozzle width	mm	20 / 30 / 40			
Blower speed	rpm	12'500		18'000	
Blower motor		brushed		brushless (maintenance-free)	
Emission level	LpA (dB)	70 (K = 3 dB)			
Size (L × W × H)	mm	500 x 310 x 300			
Weight (without cable)	kg	15		16	
Conformity marking		CE			
Protection class II		□			

#### Article No.:

	40 mm	30 mm	20 mm
UNIPLAN 300, 230 V, with EU plug	164.545	164.546	164.547
UNIPLAN 300, 230 V, with UK plug	164.551	164.552	164.553
UNIPLAN 300, 120 V, with US plug	164.557	164.558	164.559
UNIPLAN 500, 230 V, with EU plug	164.548	164.549	164.550
UNIPLAN 500, 230 V, with UK plug	164.554	164.555	164.556
UNIPLAN 500, 120 V, with US plug	164.560	164.561	164.562

#### Included with purchase:

UNIPLAN 300: Automatic welder, overlap guide, quick guide, transportation box  
 UNIPLAN 500: Automatic welder, overlap guide, hem guide, material lifting device, 2 weights (1.25 kg each), weight holder base, weight holder extension, brass brush, short handle, nozzle adjustment gauge, quick guide, transportation box

### Accessories UNIPLAN 300 / UNIPLAN 500

	<b>165.083</b>	Pressure roller kit 20 mm
	<b>165.403</b>	Pressure roller kit 30 mm
	<b>165.082</b>	Pressure roller kit 40 mm
	<b>164.315</b>	Nozzle 20 mm
	<b>164.314</b>	Nozzle 30 mm
	<b>160.421</b>	Nozzle 40 mm
	<b>166.187</b>	Hem guide
	<b>165.791</b>	Nozzle adjustment gauge
	<b>160.351</b>	Additional weight 1.25kg
	<b>164.497</b>	Weight holder base
	<b>164.498</b>	Weight holder extension
	<b>157.000</b>	Material lifting device
	<b>163.878</b>	Swivel castor wheel
	<b>165.542</b>	Handle console
	<b>159.000</b>	Long handle
	<b>165.562</b>	Short handle
	<b>116.798</b>	Brass brush
	<b>155.473</b>	Heating element 230 V
	<b>145.604</b>	Heating element 120 V

# TAPEMAT: The power pack.

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



Welding tape at maximum speed.

Tape hot-air welder

## TAPEMAT



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

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

<b>Article No.:</b>	
129.757	TAPEMAT 50 mm, 400 V / 10 kW, with 16A CEE plug
138.229	TAPEMAT Spriegel 100 mm, 400 V / 10 kW, with 16A CEE plug
133.597	TAPEMAT Spriegel 125 mm, 400 V / 10 kW, with 16A CEE plug

Spriegel hot-air welder

## TAPEMAT SPRIEGEL



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

## Accessories TAPEMAT / TAPEMAT SPRIEGEL

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









Shrimp Farm HDPE 0.5 mm



Tunnel PVC 2.5 mm



Water Reservoir HDPE 2.0 mm



Civil Engineering / Tunneling / Landfills

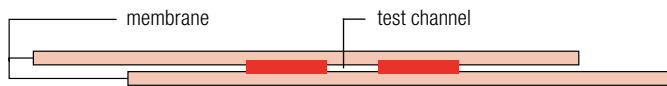
Product overview wedge welder	72
Product overview extrusion welder	73
GEOSTAR G7 / GEOSTAR G5	74 / 75
GEOSTAR G7 LQS / GEOSTAR G5 LQS	74 / 75
LQS - Leister Quality System	76 / 77
COMET / COMET USB	78 / 79
TWINNY T7 / TWINNY T5	80 / 81
TWINNY S	82
UNIDRIVE 500	83
WELDPLAST S6	84
WELDPLAST S4	85
WELDPLAST S2 / S2 TPO	86
FUSION 3 / FUSION 3C	87 / 88
EXAMO F300 USB / F600 USB	89
Vacuum test system	90
Compressed air testing system	91

Hot Air Tools

TRIAC ST	12 – 15
TRIAC AT	13 – 15
ELECTRON ST	16 / 17
General accessories	36 / 37

## Possibilities of welding seams








Overlap seam with test channel



Overlap seam without test channel



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

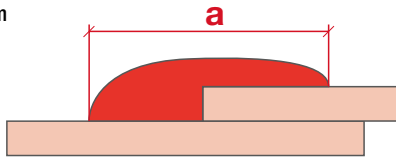
							
<b>Device type</b>	<b>GEOSTAR G7 / G7 LQS</b>	<b>GEOSTAR G5 / G5 LQS</b>	<b>COMET / COMET USB</b>	<b>TWINNY T7</b>	<b>TWINNY T5</b>	<b>TWINNY S</b>	<b>UNIDRIVE 500</b>
Voltage V~	230	120 / 230	120 / 230	230	120 / 230	120 / 230	120 / 230
Max. Power W	2800	1800 / 2800	1800 / 1500 / 1200	3450	1800 / 3450	1900 / 2900	2300
Temperature °C	80 – 460	80 – 460	80 – 420	560	560	80 – 600	20 – 600
Speed m/min	0.8 – 12	0.8 – 12	0.8 – 3.2	0.8 – 8	0.8 – 8	0.2 – 2.5 (4.0/6.0 <sup>1</sup> )	0.5 – 5
Max. Welding pressure N	1500	1500	1000	1000	1000	1000 (500)	
Weld seam width mm	2 × 15	2 × 15	2 × 15	2 × 15	2 × 15	2 × 15	15 / 30 / 40
Max. overlap mm	150	150	125	125	125	125	
Data recording	– / ✓	– / ✓	– / ✓	– / ✓			
Digital display	✓	✓	✓	✓			
Size (L × W × H) mm	482 × 278 × 269	482 × 278 × 269	295 × 250 × 245	323 × 360 × 259	323 × 360 × 259	350 × 390 × 270	297 × 173 × 275
Weight kg	17.7	16.4	7.5	10.5	9.9	6.5 – 6.9	4
Conformity mark	CE	CE	CE	CE	CE	CE	CE
Protection class	⚡	⚡	⚡	⚡	⚡	⚡	⚡
<b>Welding technologies</b>							
Hot-wedge welding	✓	✓	✓				
Combi-wedge welding				✓	✓	✓	✓
<b>Applications</b>							
HDPE, LDPE, TPO, FPO, PP	1.0 – 3.0 mm	0.8 – 3.0 mm	0.5 – 2.5 mm	0.5 – 2.5 mm	0.5 – 2.5 mm	0.5 – 2.5 mm	0.5 – 2.5 mm
PVC, CSPE, EIA	-	0.8 – 3.0 mm *(steel wedge only)	0.5 – 3.0 mm *(steel wedge only)	-	-	0.5 – 3.0 mm	-
Catalog page	 <b>74 / 75</b>	<b>74 / 75</b>	<b>78 / 79</b>	<b>80 / 81</b>	<b>80 / 81</b>	<b>82</b>	<b>83</b>

<sup>1</sup> For details, see page 82

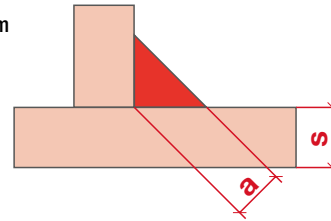
Attention these are Leister recommendations only, depending upon material specifications the possible min. thicknesses may vary.  
For more information please contact your Leister Distributor.

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







Overlap seam



Fillet welding seam



## Product comparison

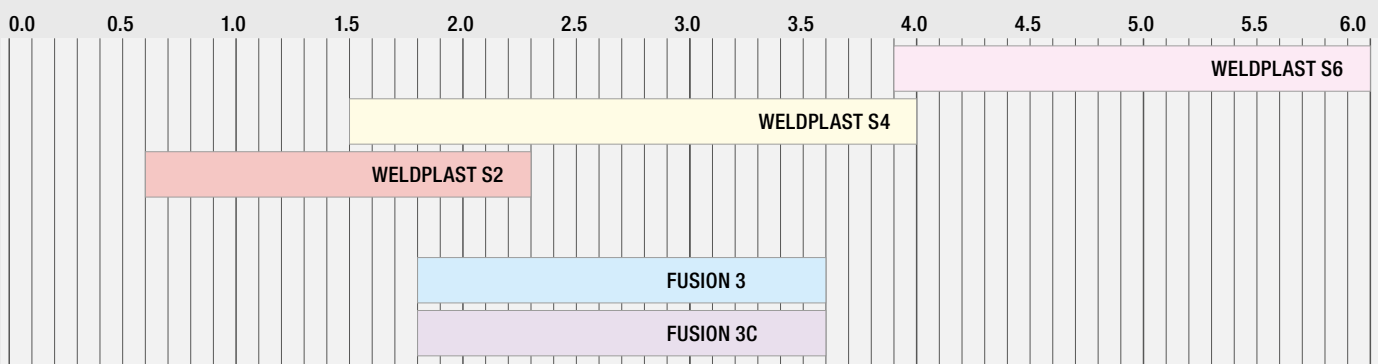
	Digitally regulated extrusion welders			Air heated extrusion welders	
					
Device type	WELDPLAST S6	WELDPLAST S4	WELDPLAST S2	FUSION 3	FUSION 3C
Output (HDPE) kg/hr	3.9 – 6	1.5 – 4	0.6 – 2.3	1.8 – 3.6	1.8 – 3.6
Material	HD-PE, PP	HD-PE, PP	HD-PE, PP, PVC	HD-PE, PP	HD-PE, PP
Wall thickness mm	15 – 40	8 – 35	4 – 20	8 – 25	8 – 25
Welding rod Ø mm	4 – 5	3 – 4 / 4 – 5	3 – 4	3 – 4 / 4 – 5	3 – 4 / 4 – 5
Weight kg	14	8.7	5.8	7.2	6.9
Length mm	821	560	450	690	588
Voltage V~	230	230	230	230	230
Screw extruder	yes	yes	yes	yes	yes
Container construction	✓✓	✓✓	✓✓	✓✓	✓✓
Pipeline construction	✓✓	✓✓	✓✓	✓✓	✓✓
Landfills / civil engineering	✓✓	✓✓	✓	✓✓	✓
Brushless blower	yes	yes	yes	no	no
Remarks	1	1	1	2	2
Catalog page	 84	85	86	87 / 88	87 / 88

✓✓ very suitable    ✓ suitable

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

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

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



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

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

## Wedge welders

### GEOSTAR G7 / G7 LQS, G5 / G5 LQS



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

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

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

#### Article No.

- 151.035 GEOSTAR G7, 230V / 2800W, Roller width 50 mm, copper wedge with test channel, with Euro plug
- 155.152 GEOSTAR G7 LQS data recording, 230 V / 2800 W, copper wedge with test channel, with Euro plug

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

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

\*2: Requires steel wedge

#### Article No.

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

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



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)..

## Accessories

### GEOSTAR G7/G7 LQS, G5/G5 LQS

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

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

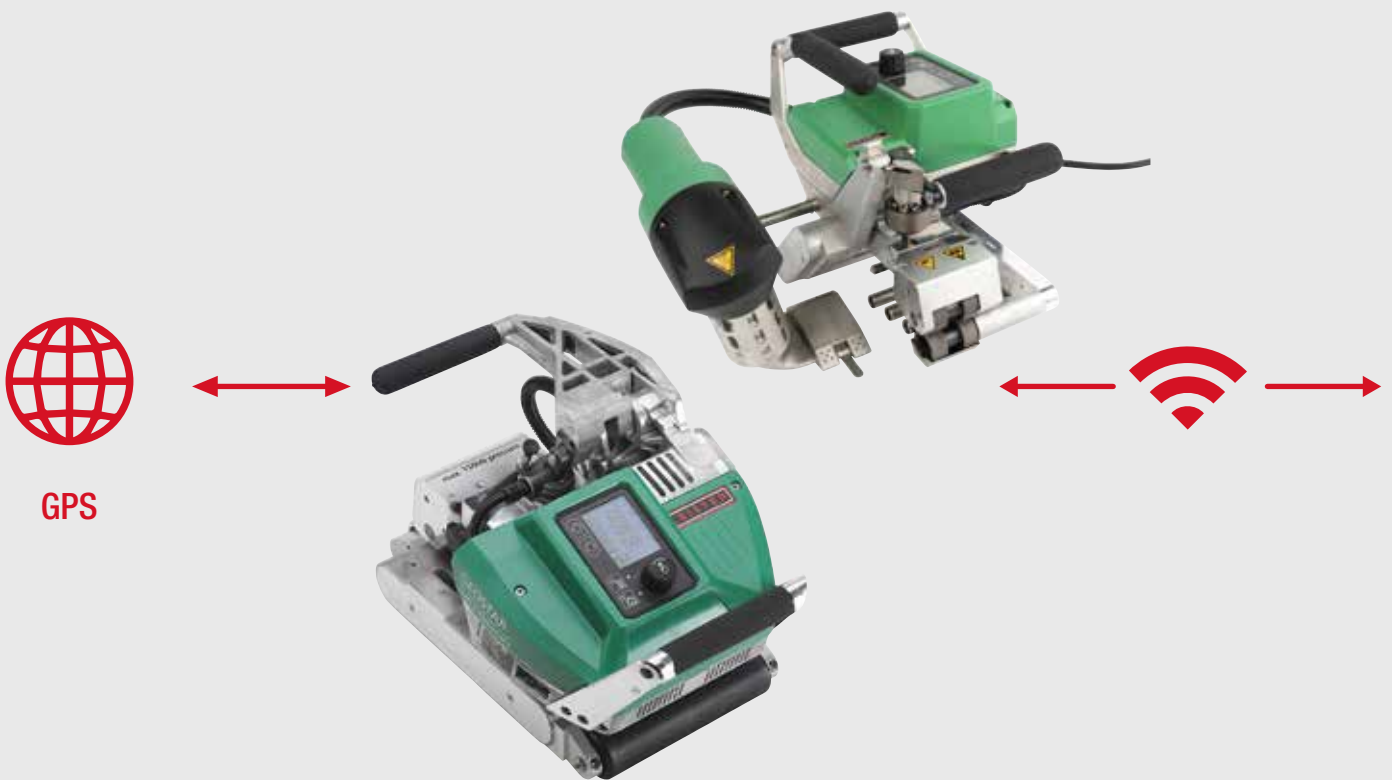




## LQS – Leister Quality System

The Leister Quality System (LQS) allows you to compile full quality documentation for all aspects of your welding work. You can document every welding seam as a table, graphic or even with GPS coordinates. The Leister Quality System provides all the advantages of state of the art technology, helping installers enhance on site QC/QA and installation standards overall.

TWINNY T7 LQS / T5



GEOSTAR G7 LQS / G5 LQS



### Pinpoint precision

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



### LQS

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



### Wireless data transfer

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



GEOSTAR LQS in field operation.



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



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

- Cloud function can be switched on/off
- External data backup
- Unit management
- User management
- Decentralized access of welding data for remote team members



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

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

# COMET / COMET USB: The highflyers.

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

## Wedge welder

### COMET



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

#### Technical Data

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

#### Article No.

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

\* with test channel, EURO plug

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

## Wedge welder

### COMET USB



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

#### Technical Data

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

#### Article No.

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

\* with test channel, EURO plug

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








Comet operating in the tunnel ...



... or on a landfill site.

## Accessories COMET / COMET USB

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



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

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

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

## Fields of application COMET / COMET USB

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

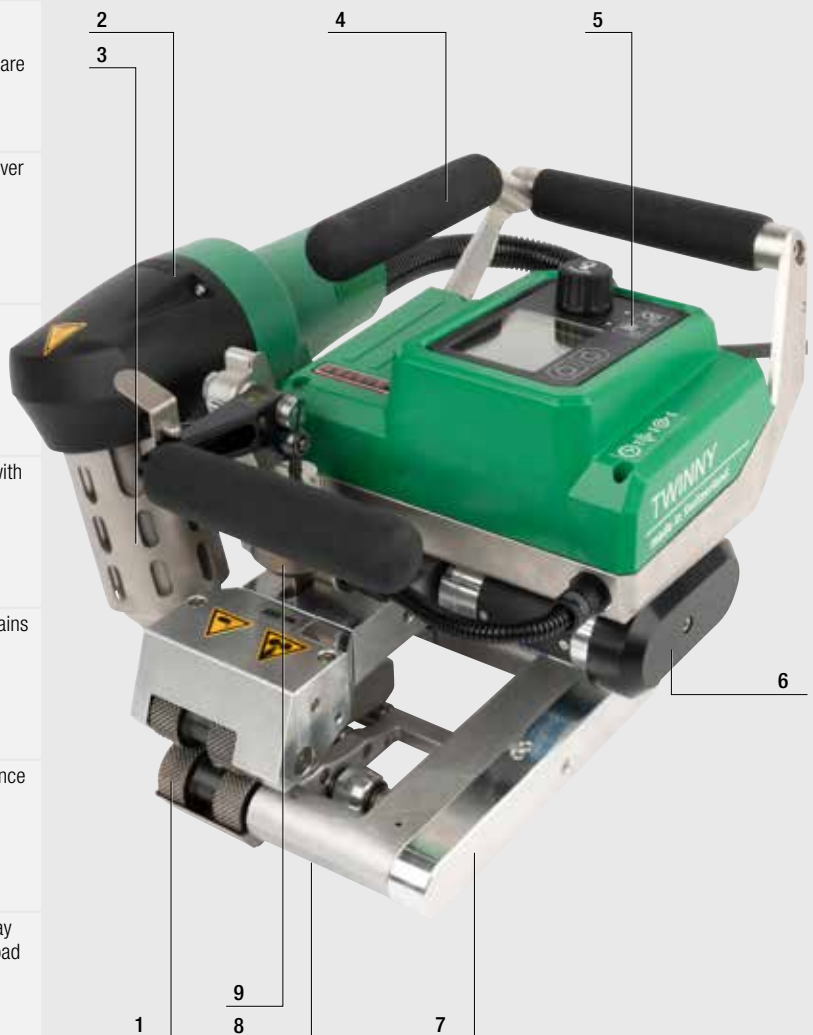
## Plug and weld – TWINNY T7 und TWINNY T5

If you want to weld thin or thick geomembranes (0.5 to 2.5 mm) 20-100 mls quickly, easily and safely, the TWINNY T7 or TWINNY T5 are your go-to automatic welders. Both tools are well-rounded, thanks to their practical design and intuitive operation. The TWINNY T7 comes equipped with highly-efficient data recording ability thanks to the LQS function, GPS, Wi-Fi and connection to the myLeister app are guaranteed. Plug and weld – TWINNY T7 and T5.

### Hot-air welder

### TWINNY T7/T5

- |   |   |   |
|---|---|---|
| 1 |    | <b>quick</b><br>drive speed of 0.8 to 8 m/min   |
| 2 |    | <b>T7: brushless blower motor</b><br>significantly greater air volume   |
| 3 |   | <b>dry and clean</b><br>the hot air dries moisture in no time at all, while dust and sand are blown away                                    |
| 4 |  | Optimum handling thanks to clever grip options  |
| 5 |  | <b>a. T7:</b> Communication module myLeister with WiFi, GPS, LQS, voltmeter, e-Drive<br><b>b. T5:</b> Basic functions with digital accuracy |
| 6 |  | Gearbox and motor separated with service-friendly timing belt   |
| 7 |  | Reinforced double-row drive chains  |
| 8 |  | Field kit for more ground clearance   |
| 9 |  | <b>a. T7:</b> digital joining force display<br><b>b. T5:</b> Force module with overload protection  |





Display TWINNY T7



Display TWINNY T5

## Hot-air welder

### TWINNY T7/T5



- **powerful:** 3300 watts, enabling more heating power
- **sustainable:** TWINNY T7 and T5 are durable and easy to service

Technical data		TWINNY T7	TWINNY T5
Voltage	V~	230	230 / 120
Frequency	Hz	50 / 60	50 / 60
Power	W	3450	3450 (1800 @ 120V)
Max. Temperature	°C	560	560
Blower Motor	rpm	Maintenance free Brushless Motor max.18'000	Brushed Motor max. 12'000
Air volume	%	45 – 100	
Max. Overlap	mm	125	
Max. Welding pressure	N	1000	
Drive speed	m/min	0.8 – 8	
LQS, WIFI, GPS		Yes	No
Digital Pressure display		Yes	No
Digital Voltage display		Yes	No
Audible / Visual Alarms		Yes	No
Welding pressure overload protection		Visual and acoustical warning	Mechanical
Size (L x W x H)	mm	350 x 360 x 260	
Weight	kg	10.5	9.9
Conformity		CE	
Protection class		⚡	

### Accessories TWINNY T7/T5

	<b>155.629</b>	Combi-wedge long, 50 mm, with test channel
	<b>155.630</b>	Combi-wedge long, 50 mm, without test channel
	<b>155.634</b>	Combi-wedge short, 50 mm, with test channel
	<b>155.637</b>	Combi-wedge short, 50 mm, without test channel
	<b>159.135</b>	Long handle complete
	<b>164.025</b>	Indoor roller kit

#### Article No.:

CEE blue plug

164.198 164.197 TWINNY T7 230 V / 3450 W CWL w/TC Ro 50 mm sharp Field kit  
 164.215 164.214 TWINNY T7 230 V / 3450 W CWS w/TC Ro 50 mm sharp Field kit  
 164.217 164.216 TWINNY T7 230 V / 3450 W CWL wo/TC Ro 50 mm blunt Field kit  
 164.219 164.218 TWINNY T7 230 V / 3450 W CWS wo/TC Ro 50 mm blunt Field kit  
 164.221 164.220 TWINNY T7 230 V / 3450 W CWS wo/TC Ro 50 mm Silicone Indoor kit

164.223 164.222 TWINNY T5 230 V / 3450 W CWL w/TC Ro 50 mm sharp Field kit  
 164.225 164.224 TWINNY T5 230 V / 3450 W CWS w/TC Ro 50 mm sharp Field kit  
 164.227 164.226 TWINNY T5 230 V / 3450 W CWL wo/TC Ro 50 mm blunt Field kit  
 164.229 164.228 TWINNY T5 230 V / 3450 W CWS wo/TC Ro 50 mm blunt Field kit  
 164.231 164.230 TWINNY T5 230 V / 3450 W CWS wo/TC Ro 50 mm Silicone Indoor kit

CEE yellow plug

164.232 TWINNY T5 120 V / 1800 W CWS w/TC Ro 50 mm sharp Field kit  
 164.233 TWINNY T5 120 V / 1800 W CWS wo/TC Ro 50 mm blunt Field kit

CWL = Combi wedge long / CWS=Combi wedge short / W/TC = with Test channel / wo/TC = without Test Channel / Ro = Roller width

**Scope of delivery:** Machine, storage case, cleaning brush, Instruction manual

## TWINNY S: Perfect weight.

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



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

### Combi-wedge welder

## TWINNY S



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

#### Technical Data

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






#### Article No.

- 119.031 TWINNY S for tunnel construction, drive 256:1, 230 V / 2900 W, with test channel, combi-wedge long, Euro plug
- 119.039 TWINNY S for tunnel construction, drive 256:1, 120 V / 1900 W, with test channel, combi-wedge long, w/o plug

Included with purchase:

Tunneling version: Welder, quick guide, guide-bar short, storage case

## Accessories TWINNY S

	<b>112.974</b> Extremely light cross handle 145 gram, material: aluminum
	Combi-wedge short <b>100.517</b> 50 mm, with test channel <b>100.518</b> 50 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>126.448</b> Storage case (included with purchase)
	<b>101.905</b> 230 V / 2750 W heating element, TWINNY S <b>101.910</b> 230 V / 2100 W heating element, TWINNY S <b>101.913</b> 120 V / 1800 W heating element, TWINNY S

See COMET for roles.



# UNIDRIVE 500: safe and economical – everywhere

Guided by two ergonomic handles, you can achieve the ideal pressure to ensure high-quality welding results. Changing direction – via key combination and dual drive, it couldn't be easier!



The perfect choice for welding joint sealing tape.

Semi-automatic hot-air welder

## UNIDRIVE 500



- **Safe:** Constant parameters and reliable quality – even with undervoltage
- **Fast:** Up to three times faster than manual welding
- **Customized:** Reversible drive allows for welding in either direction
- **Practical:** Compact and lightweight semi-automatic hot-air welder: 4.5 kg, 30 cm high
- **Economical:** Maintenance-free, brushless motors

Technical data		UNIDRIVE 500 100 V	UNIDRIVE 500 100-120 V	UNIDRIVE 500 220-240 V
Voltage	V~	100	120	230
Power	W	1500	1800	2200
Temperature	°C	100 – 580		
Air volume	%	45 – 100		
Speed	m/min	0.7 – 4.5		
Emission	L <sub>pA</sub> (dB)	70 (K = 3 dB)		
Size (L × H × B)	mm	297 × 173 × 275		
Weight	kg	4.5		
Conformity mark		CE		
Protection class I		⊕		

### Article No.:

- 163.144 UNIDRIVE 500, 40 mm, 220-240 V / 2200 W, Euro plug, Silicone rollers  
 163.146 UNIDRIVE 500, 40 mm, 220-240 V / 2200 W, CEE 3 pol. blue, Silicone rollers  
 163.148 UNIDRIVE 500, 40 mm, 100-120 V / 1800 W, UK plug, Silicone rollers  
 163.149 UNIDRIVE 500, 40 mm, 100 V / 1500 W, JP plug, Silicone rollers  
 163.150 UNIDRIVE 500, 30 mm, 220-240 V / 2200 W, EU plug, Silicone rollers  
 163.151 UNIDRIVE 500, 40 mm, 220-240 V / 2200 W, CEE 3 pol. blue, Steel rollers  
 163.152 UNIDRIVE 500, 15 mm, 220-240 V / 2200 W, CEE 3 pol. blue, Steel rollers  
 Included with purchase: Welding machine, device case, hex key, quick guide

## Accessories UNIDRIVE 500

	<b>164.586</b>	Overlap welding nozzle 15 mm
	<b>164.576</b>	30 mm
	<b>164.403</b>	40 mm
	<b>163.930</b>	Pressure roller, steel 15 mm
	<b>163.357</b>	Pressure roller steel 40 mm
	<b>162.551</b>	Support wheel, silicone
	<b>161.156</b>	Silicone rubber roller 40 mm
	<b>159.911</b>	Wheel for silicon rubber roller 40 mm
	<b>156.531</b>	Carrying strap for Leister case

# WELDPLAST S6: The workhorse.

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



WELDPLAST S6, Gold Mine Mexico.

Digitally regulated extrusion welder

## WELDPLAST S6



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

### Technical Data

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

### Article No.

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

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

## Accessories WELDPLAST S6

	<b>146.239</b>	Welding shoe complete
	<b>146.240</b>	54 × 40 × 52 mm blank welding shoe
	<b>146.241</b>	25 mm overlap
	<b>146.706</b>	35 mm overlap
	<b>146.242</b>	35 mm overlap
	<b>145.899</b>	40 mm overlap
	<b>146.245</b>	20 mm V-seam
	<b>146.246</b>	25 mm V-seam
	<b>146.247</b>	30 mm V-seam
	<b>146.232</b>	20 mm fillet weld seam (a = 14 mm*)
	<b>146.233</b>	25 mm fillet weld seam (a = 17.5 mm*)
	<b>146.234</b>	30 mm fillet weld seam (a = 21 mm*)
	<b>146.230</b>	Corner seam Ø 14 mm
	<b>146.218</b>	Corner seam Ø 20 mm
		* a = welding seam thickness
	<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

General accessories



# WELDPLAST S4

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

Digitally regulated extrusion welder

## WELDPLAST S4



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

Technical Data		
Voltage	V~	230
Power	W	3680
Material		PE /PP
Welding rod	mm	Ø 3 – 4 / Ø 4 – 5
Output	kg/h	1.5 – 4.0
Size (L x W x H)	mm	560 x 110 x 300
Weight	kg	8.7
Conformity mark		CE
Protection class I		⊕
<b>Article No.</b>		
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	



The powerful WELDPLAST S4 at work.

## Accessories WELDPLAST S4

	<b>146.239</b>	Welding shoe complete
	<b>146.240</b>	54 x 40 x 52 mm blank welding shoe
	<b>146.241</b>	74 x 50 x 58 mm blank welding shoe
	<b>146.706</b>	25 mm overlap
	<b>146.242</b>	30 mm overlap
	<b>145.899</b>	35 mm overlap
	<b>146.243</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>146.525</b>	12 mm fillet weld seam (a = 8.5 mm*)
	<b>146.231</b>	15 mm fillet weld seam (a = 10 mm*)
	<b>146.232</b>	20 mm fillet weld seam (a = 14 mm*)
	<b>146.233</b>	25 mm fillet weld seam (a = 17.5 mm*)
	<b>146.234</b>	30 mm fillet weld seam (a = 21 mm*)
	<b>146.230</b>	Corner seam Ø 14 mm
	<b>146.218</b>	Corner seam Ø 20 mm
* a = welding seam thickness		
	<b>144.904</b>	45° angled adapter
	<b>145.704</b>	90° angled adapter
	Caution: You must use welding shoes with an integrated air guide for this	
	<b>117.064</b>	Side hot-air guide
	<b>117.065</b>	Top hot-air guide
	<b>117.053</b>	preheat nozzle
	<b>117.518</b>	small, 20 mm
	<b>141.177</b>	medium, 25 mm
	<b>136.231</b>	large, 35 mm
	<b>136.231</b>	Pre-heat reflector
	<b>149.723</b>	Insulation sleeve

## 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	Ø 3 – Ø 4
Output Ø 3 mm	kg/h	PE: 0.6 – 1.3 PP: 0.5 – 1.2
Output Ø 4 mm	kg/h	PE: 1.0 – 2.3 PP: 0.9 – 2.0
Size (L x W x H)	mm	450 x 98 x 260
Weight	kg	5.8
Conformity mark		CE
Protection class I		⊕

#### Article No.

127.215 WELDPLAST S2, 230 V / 3000 W, 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 x 30 x 54 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>145.815</b>	12 mm fillet weld (a = 8.5*)
		<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 Ø 14 mm
		<b>145.488</b>	Corner seam Ø 20 mm
		* a = welding seam thickness	
		<b>139.460</b>	45° angled adapter
		<b>139.461</b>	90° angled adapter
		<b>134.361</b>	Air filter (included with purchase)
		<b>143.776</b>	Textile dust filter (not included with purchase)
		<b>155.829</b>	Air filter
		<b>131.451</b>	Tool rest
		<b>136.231</b>	Preheat reflector
		<b>154.002</b>	Insulation sleeve

General accessories





# FUSION 3 / 3C: THE slim twins.

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



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

Air heated extrusion welder

## FUSION 3



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

Technical Data					
		Version Ø 3 – 4		Version Ø 4 – 5	
Welding rod Ø	mm	3	4	4	5
Output PE	kg/h	2.0 – 2.5	2.7 – 3.6	2.1 – 2.6	2.7 – 3.6
Output PP	kg/h	1.8 – 2.3	2.5 – 3.4	1.8 – 2.4	2.5 – 3.4
Voltage	V~	230			
Power	W	3500			
Material		PE / PP			
Size (L × W × H)	mm	670 × 90 × 180			
Weight	kg	7.2			
Conformity mark		CE			
Protection class II		□			
Artikel-Nr.					
118.300	FUSION 3, 230 V / 3500 W, Welding rod Ø 3 – 4 mm, Euro plug				
144.615	FUSION 3, 230 V / 3500 W, Welding rod Ø 4 – 5 mm, Euro plug				
Included with purchase: FUSION 3, Welding shoe overlap 30 mm, storage case					

Air heated extrusion welder

## FUSION 3C



































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

Technical Data					
		Version Ø 3 – 4		Version Ø 4 – 5	
Welding rod Ø	mm	3	4	4	5
Output PE	kg/h	2.0 – 2.5	2.7 – 3.6	2.1 – 2.6	2.7 – 3.6
Output PP	kg/h	1.8 – 2.3	2.5 – 3.4	1.8 – 2.4	2.5 – 3.4
Voltage	V~	230			
Power	W	3200			
Material		PE / PP			
Size (L × W × H)	mm	588 × 98 × 225			
Weight	kg	6.9			
Conformity mark		CE			
Protection class II		□			
Artikel-Nr.					
123.866	FUSION 3C, 230 V / 3200 W, Welding rod Ø 3 – 4 mm, Euro plug				
144.826	FUSION 3C, 230 V / 3200 W, Welding rod Ø 4 – 5 mm, Euro plug				
Included with purchase: FUSION 3C, blank welding shoe, storage case					



The FUSION 3 for comfortable working in upright positions.

## Accessories FUSION 3 / FUSION 3C

		<b>145.945</b>	Welding shoe complete
		<b>145.946</b>	45 × 30 × 54 mm blank welding shoe
		<b>145.896</b>	74 × 50 × 58 mm blank welding shoe
		<b>145.947</b>	25 mm overlap
		<b>145.897</b>	30 mm overlap
		<b>145.915</b>	35 mm overlap
		<b>145.907</b>	8 / 10 mm V-seam
		<b>145.903</b>	12 mm V-seam
		<b>145.909</b>	15 mm V-seam
		<b>145.916</b>	20 mm V-seam
		<b>145.905</b>	25 mm V-seam
		<b>145.944</b>	30 mm V-seam
		<b>145.815</b>	8 / 10 mm fillet weld (a = 7 mm*)
		<b>145.812</b>	12 mm fillet weld (a = 8.5 mm*)
		<b>145.940</b>	15 mm fillet weld (a = 10 mm*)
		<b>145.816</b>	20 mm fillet weld (a = 14 mm*)
		<b>145.817</b>	25 mm fillet weld (a = 17.5 mm*)
		<b>146.643</b>	30 mm fillet weld (a = 21 mm*)
		<b>146.645</b>	Corner outside seam 8 mm
		<b>146.649</b>	Corner outside seam 10 mm
		<b>146.651</b>	Corner outside seam 12 mm
		<b>145.811</b>	Corner outside seam 15 mm
		<b>145.488</b>	Corner seam Ø 14 mm
			Corner seam Ø 20 mm
		* a = welding seam thickness	
		<b>148.817</b>	45° angled adapter
		<b>148.816</b>	90° angled adapter
		<b>135.082</b>	Air filter in stainless steel FUSION 3C
		<b>131.451</b>	<b>Tool rest</b> WELDPLAST S2 / S2 PVC / FUSION 2
		<b>160.454</b>	FUSION 3C WELDPLAST S4 / S6 / FUSION 3
		<b>136.231</b>	Preheat reflector
		<b>149.421</b>	Insulation sleeve FUSION 3
		<b>149.420</b>	Insulation sleeve FUSION 3C

## General accessories

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

FUSION 3C with heat blanket.



# EXAMO: The inspector.

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



Blank in uniform size, quickly produced with the COUPON CUTTER 500.

## Tensiometer

### EXAMO 300F USB, 600F USB



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

Technical Data			
Type		300F USB	600F USB
Voltage	V~	230	230
Power	W	200	200
Tensile load	N	4000	4000
Jaw spacing	mm	5 – 300	5 – 600
Range	mm	300	600
Test speed	mm/min	20 – 550	20 – 550
Sample thickness	mm	max. 7	max. 7
Sample width	mm	max. 40 (60 optional)	max. 40 (60 optional)
Size (L x W x H)	mm	750 x 270 x 190 (case)	1050 x 270 x 190 (case)
Weight	kg	14	17.5
Conformity mark		CE	CE
Protection class I		⊕	⊕
Article No.:			
139.059	EXAMO 300F USB, 230 V / 200 W, incl. USB memory stick, Euro plug		
139.060	EXAMO 600F USB, 230 V / 200 W, incl. USB memory stick, Euro plug		

### Accessories EXAMO 300F USB, 600F USB

	<b>134.832</b>	Testing and calibration kit to test and calibrate your EXAMO USB
	<b>108.185</b>	Jaw kit 60 mm for geotextiles including two pairs of jaws
	<b>144.416</b>	USB memory-stick
	<b>161.540</b>	COUPON CUTTER 500, for standard-compliant specimens: 15/20/25 x 150 mm
	<b>160.576</b>	Cutting plate
	<b>137.855</b>	Leister cutter with four spare blades
	<b>138.902</b>	Hooked blade for LEISTER-cutter (10 dispenser with 10 pcs=100 pcs)
	<b>138.539</b>	Straight-edge blade for LEISTER-cutter (10 dispenser with 10 pcs = 100 pcs)
	<b>163.140</b>	MEMBRANE PULLER Pull handle for membranes 1.0 – 3.0 mm

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

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

### Testing instruments

#### VACUUM BELL



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

### Testing instruments

#### VACUUM BOX



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

### Testing instruments

#### VACUUM PUMP



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

#### Article No.:

153.026 VACUUM BELL Ø 320 mm

152.981 VACUUM BOX 830 × 320 × 150 mm

153.024 VACUUM PUMP 230V

153.025 VACUUM PUMP 120V

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



# Compressed air testing device.

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



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

Testing instrument

## Compressed air testing device with thin testing needle



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



Manometer standard (bar/psi)

Article No.:

142.475 Flexible injection needle with manometer

Testing instrument

## Compressed air testing device with thick testing needle



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



Manometer ASTM (psi/kPa)

Article No.:

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

## Accessories



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



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







Air purification system, Spain. Material: HD-PE



The Wave House, San Diego. Material: PVC



Electroplating tank, Turkey. Material: PP

## Plastic Fabrication

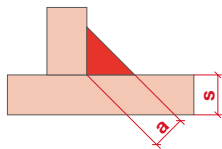
Overview of hand extruders	94
FUSION 1	96 / 97
WELDPLAST S6	98
WELDPLAST S4	99
WELDPLAST S2 / S2 PVC	100 / 101
WELDPLAST 1	102
FUSION 3 / 3C	103 / 104
FUSION 2	105
WELDPLAST 200-i / 600-i	106 / 107
General accessories hand extruders	108
Welding rods	109

## Hot-Air Hand Tools

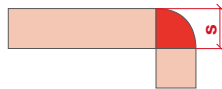
TRIAC ST	12 – 15
TRIAC AT	13 – 15
HOT JET S	18 / 19
AIRSTREAM ST	28 / 29
ROBUST	30
WELDING PEN R / WELDING PEN S	31
DIODE PID / DIODE S	32 / 33
MINOR	33
LABOR S	34
General accessories	36 / 37

## Possibilities of welding seams

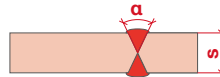
a = seam size s = material thickness α = milling angle



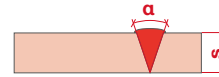
Fillet welding seam



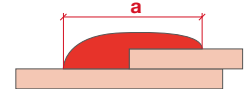
Corner outside seam



X-seam  
s = 10 – 40 mm = α 60°  
s = 50 – 60 mm = α 50°












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



Overlap seam

## Product comparison

	Digitally regulated extrusion welders				Air heated extrusion welders			
								
Device type	WELDPLAST S6	WELDPLAST S4	WELDPLAST S2	WELDPLAST S1	FUSION 3	FUSION 3C	FUSION 2	FUSION 1
Output (HDPE) kg/hr	3.9 – 6	1.5 – 4	0.6 – 2.3	0.2 – 0.8	1.8 – 3.6	1.8 – 3.6	1.3 – 1.8	0.2 – 0.8
Material	HD-PE, PP	HD-PE, PP	HD-PE, PP, PVC	PE, PP, PVC, etc.	HD-PE, PP	HD-PE, PP	HD-PE, PP	PE, PP
Wall thickness mm	15 – 40	8 – 35	4 – 20	4 – 10	8 – 25	8 – 25	6 – 15	4 – 10
Welding rod Ø mm	4 – 5	3 – 4 / 4 – 5	3 – 4	3 – 4	3 – 4 / 4 – 5	3 – 4 / 4 – 5	4	3 – 4
Weight kg	14	8.7	5.8	4.7	7.2	6.9	5.9	3.4
Length mm	821	560	450	435	690	588	450	435
Voltage V~	230	230	230	230 / 120	230	230	230	230
Screw extruder	yes	yes	yes	yes	yes	yes	yes	yes
Container construction	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓
Pipeline construction	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓
Landfills / civil engineering	✓✓	✓✓	✓	○	✓✓	✓	○	○
Brushless blower	yes	yes	yes	yes	no	no	no	no
Remarks	1	1	1	1	2	2	2	3
Catalog page	 98	99	100 / 101	102	103 / 104	103 / 104	105	96 / 97

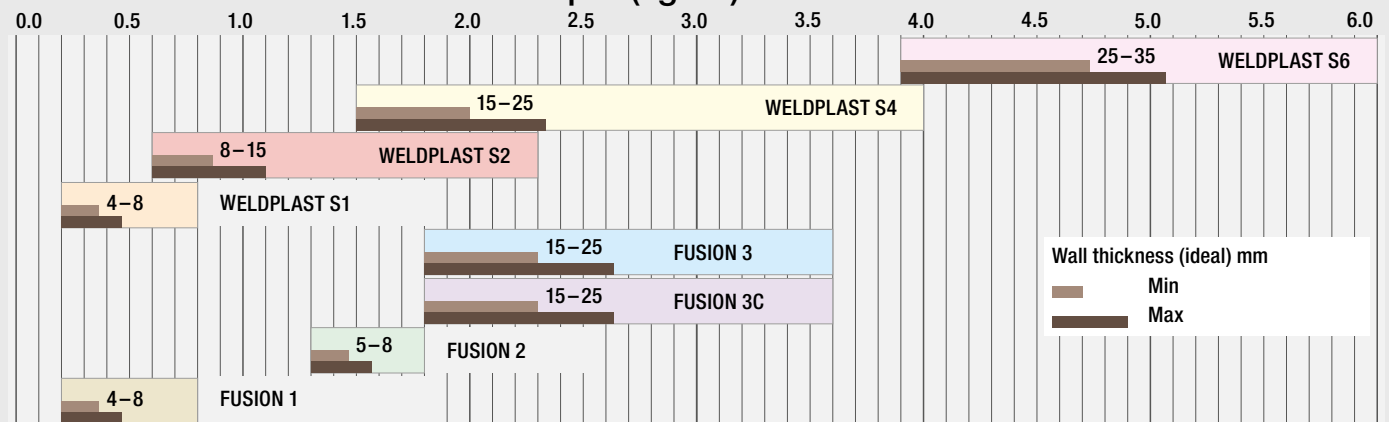
✓✓ very suitable ✓ suitable ○ unsuitable

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

2: Hot air heated extruder temperature controlled manually.

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

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







# Ingeniously simple – FUSION 1

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

Digitally regulated extrusion welder

## FUSION 1

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





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

Digitally regulated extrusion welder

## FUSION 1



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

### Technical data

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

### Article No.:

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

Included with purchase: FUSION 1, case, welding shoe, Allen key, quick guide, handle

## Accessories FUSION 1

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

# WELDPLAST S6: The workhorse.

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



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

Digitally regulated extrusion welder

## WELDPLAST S6



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

### Technical Data

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

### Article No.:

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

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

## Accessories WELDPLAST S6

Welding shoe complete	
	<b>146.239</b> 54 x 40 x 52 mm blank welding shoe
	<b>146.240</b> 74 x 50 x 58 mm blank welding shoe
	<b>146.241</b> 25 mm overlap
	<b>146.706</b> 30 mm overlap
	<b>146.242</b> 35 mm overlap
	<b>145.899</b> 40 mm overlap
	<b>146.245</b> 20 mm V-seam
	<b>146.246</b> 25 mm V-seam
	<b>146.247</b> 30 mm V-seam
	<b>146.232</b> 20 mm fillet weld seam (a = 14 mm*)
	<b>146.233</b> 25 mm fillet weld seam (a = 17.5 mm*)
	<b>146.234</b> 30 mm fillet weld seam (a = 21 mm*)
	<b>146.644</b> Corner outside seam 10 mm
	<b>146.646</b> Corner outside seam 12 mm
	<b>146.652</b> Corner outside seam 15 mm
	<b>146.230</b> Corner seam Ø 14 mm
	<b>146.218</b> Corner seam Ø 20 mm
*a = Welding seam thickness	
	<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

General accessories





# WELDPLAST S4: The workmate.

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



The powerful WELDPLAST S4 in use.

Digitally regulated extrusion welder

## WELDPLAST S4



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

### Technical Data

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

### Article No.:

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

## Accessories WELDPLAST S4

	<b>146.239</b>	<b>Welding shoe complete</b>	54 x 40 x 52 mm blank welding shoe
	<b>146.240</b>		74 x 50 x 58 mm blank welding shoe
	<b>146.241</b>	25 mm overlap	
	<b>146.706</b>	35 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>146.525</b>	12 mm fillet weld seam (a = 8.5 mm*)	
	<b>146.231</b>	15 mm fillet weld seam (a = 10 mm*)	
	<b>146.232</b>	20 mm fillet weld seam (a = 14 mm*)	
	<b>146.233</b>	25 mm fillet weld seam (a = 17.5 mm*)	
	<b>146.234</b>	30 mm fillet weld seam (a = 21 mm*)	
	<b>146.642</b>	Corner outside seam 8 mm	
	<b>146.644</b>	Corner outside seam 10 mm	
	<b>146.646</b>	Corner outside seam 12 mm	
	<b>146.652</b>	Corner outside seam 15 mm	
	<b>146.230</b>	Corner seam Ø 14 mm	
	<b>146.218</b>	Corner seam Ø 20 mm	
* a = Welding seam thickness			
	<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	

# WELDPLAST S2 / S2 PVC: The masterpieces.

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

Digitally regulated extrusion welder

## WELDPLAST S2



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

### Technical Data

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

### Article No.:

127.215 WELDPLAST S2, 230 V / 3000 W, Euro plug  
 156.131 WELDPLAST S2, 230 V / 3000 W, Industrial CEE-plug  
 Included with purchase: WELDPLAST S2, welding shoe raw part, storage case  
 Included with purchase: WELDPLAST S4, preheat nozzle large, medium and small, storage case

Digitally regulated extrusion welder

## WELDPLAST S2 PVC



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

### Technical Data

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

### Article No.:

135.724 WELDPLAST S2 PVC, 230 V / 3000 W, Euro plug  
 156.804 WELDPLAST S2 PVC, 230 V / 3000 W, Industrial CEE-plug

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


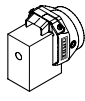



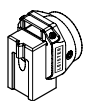



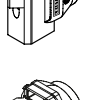

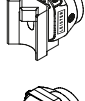










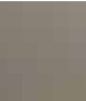






The handy WELDPLAST S2 in action.



Easy welding of contours.


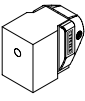









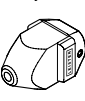




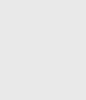
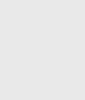
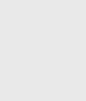

## Accessories WELDPLAST S2

Welding shoe complete	
	<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 mm 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>145.815</b> 12 mm fillet weld (a = 8.5 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
* a = Welding seam thickness	
	<b>139.460</b> 45° angled adapter
	<b>139.461</b> 90° angled adapter
	<b>154.002</b> Insulation sleeve WELDPLAST S2
	<b>161.119</b> Support clamp WELDPLAST S2



With the WELDPLAST S2 perfect welds are possible

## Accessories WELDPLAST S2 PVC

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>146.706</b> 30mm 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>146.525</b> 12 mm fillet weld seam (a = 8.5 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
* a = Welding seam thickness	
	<b>133.850</b> Top hot-air guide



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

General accessories  108 

# WELDPLAST S1: Outstandingly compact.

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



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

Digitally regulated extrusion welder

## WELDPLAST S1



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

### Technical Data

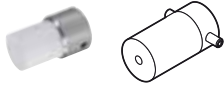
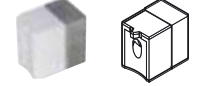







Voltage	V~	230 / 120 / 100
Power	W	1600 / 1800 / 1500
Material		HD-PE, LD-PE, PP, PVC-U PVC-C, PVDF, ECTFE, PA
Welding rod	mm	Ø 3 – 4
Output	kg/h	0.2 – 0.8 (PVC up to 1.15 kg/h)
Size (L × W × H)	mm	435 × 91 × 264
Integrated welding profiles		HD-PE, PP, PVC-U, PVC-C, PVDF 10 free profile storage spaces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

### Article No.:

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

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

## Accessories WELDPLAST S1

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

General accessories





# 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



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

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

Article No.:  
118.300 FUSION 3, 230 V / 3500 W, welding rod Ø 3 – 4 mm, Euro plug  
144.615 FUSION 3, 230 V / 3500 W, welding rod Ø 4 – 5 mm, Euro plug

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

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

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

Article No.:  
123.866 FUSION 3C, 230 V / 3200 W, welding rod Ø 3 – 4 mm, Euro plug  
144.826 FUSION 3C, 230 V / 3200 W, welding rod Ø 4 – 5 mm, Euro plug

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

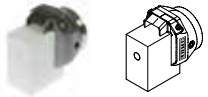


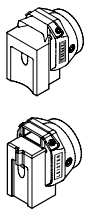

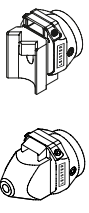






Perfectly stored in the case.



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

## Accessories FUSION 3 / 3C

		<b>Welding shoe complete</b>
		<b>145.945</b> 45 × 30 × 54 mm blank welding shoe <b>145.946</b> 74 × 50 × 58 mm blank welding shoe
		<b>145.896</b> 25 mm overlap <b>145.947</b> 30 mm overlap <b>145.897</b> 35 mm overlap
		<b>145.912</b> 5 / 6 V-seam <b>145.915</b> 8 / 10 mm V-seam <b>145.907</b> 12 mm V-seam <b>145.903</b> 15 mm V-seam <b>145.909</b> 20 mm V-seam <b>145.916</b> 25 mm V-seam
		<b>145.943</b> 5 / 6 mm fillet weld (a = 4.2 mm*) <b>145.944</b> 8 / 10 mm fillet weld (a = 7 mm*) <b>145.815</b> 12 mm fillet weld (a = 8.5 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
		* a = Welding seam thickness
		<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

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



# FUSION 2: The small powerhouse.

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



In operation during container construction in China.

Air heated extrusion welder

## FUSION 2



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

### Technical Data

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

### Artikel-Nr.

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

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

## Accessories FUSION 2

<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>145.943</b>	5 / 6 mm fillet weld (a = 4.2 mm*)
<b>145.944</b>	8 / 10 mm fillet weld (a = 7 mm*)
<b>145.815</b>	12 mm fillet weld (a = 8.5 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
* a = Welding seam thickness	
<b>147.602</b>	45° angled adapter
<b>147.601</b>	90° angled adapter
<b>166.524</b>	Insulation sleeve FUSION 2

# Automated, modular, customized – WELDPLAST 200-i / 600-i

LEISTER offers you two modules for automated extrusion welding and 3D printing. WELDPLAST 200-i and 600-i are set up to allow both simple and fully automated expansion and can be mounted on robots or integrated into machines. This modular design allows you to bring your projects to fruition without making any compromises.

## Built-in extruder module

### WELDPLAST 200-i / 600-i



#### Customized

Depending on requirements – choose between extruder modules which can be extended to meet specific needs



#### Modular

Select an extruder module and simply add the relevant hot air and communication components



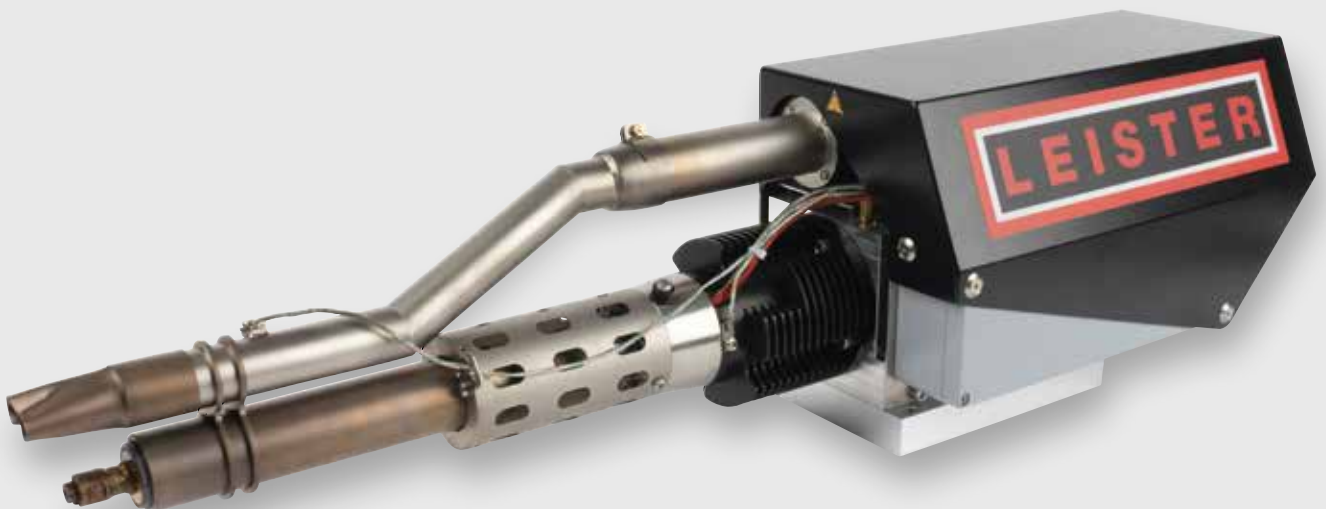
#### Controlled

Monitor and control all parameters such as temperatures and emissions

The drive and communication components of both extruder modules, which can be freely chosen by the user, can be tailored fully to meet individual needs. By incorporating additional sensors, the process can be controlled and monitored as required.

Electrical and mechanical adaptation points are already set up so that the modules for various processes such as those requiring preheated air can be integrated.

State-of-the-art industrial interfaces or similar interfaces can be installed to aid communication.







WELDPLAST 200-i / 600-i – robotic extrusion welding and 3D printing designed for automated continuous operation

#### Built-in extruder module

### WELDPLAST 200-i / 600-i







- **Automated:** Designed for automated continuous operation
- **Up to date:** All components are compliant with current industry standards

### WELDPLAST 200-i

	<b>163.322</b> Extruder module 200-i
	<b>163.575</b> Connection kit 200-i / 600-i
	<b>164.414</b> Preheated air kit 200-i
	<b>139.869</b> LHS 21S Classic <b>140.455</b> LHS 21S Premium <b>140.459</b> LHS 21S System

### WELDPLAST 600-i

	<b>163.326</b> Extruder module 600-i
	<b>163.575</b> Connection kit 200-i / 600-i
	<b>164.415</b> Preheated air kit 600-i
	<b>139.872</b> LHS 21L Classic <b>140.457</b> LHS 21L Premium <b>140.461</b> LHS 21L System

Technical data		WELDPLAST 200-i	WELDPLAST 600-i
Heating voltage	V~	230	230
Heating power	W	600	800
Welding rods / filament Ø	mm	3 – 4	4 – 5
Output Ø 4 HD-PE	kg/h	2	6
Plastic		HD-PE, LD-PE, PP, PVC-U, PVC-C, PVDF, ECTFE, ABS, PC, PA, PS, PUR	HD-PE, LD-PE, PP
Weight full disassembly	kg	15	22
Dimensions full disassembly (L x W x H)	mm	660 x 191 x 220	876 x 191 x 210
Protection class I		⊕	⊕
Included with purchase: Extrusion module, CAD data, parts list, operating manual, suggested electrical diagram			



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



The WELDPLAST S4 during outdoor use in Spain.

## General accessories hand extruder

	<b>131.451</b> <b>Tool rest</b> WELDPLAST S2 / S2 PVC / FUSION 2 FUSION 3C
	<b>148.923</b> WELDPLAST S1
	<b>160.454</b> WELDPLAST S4 / WELDPLAST S6 / FUSION 3
	<b>136.231</b> <b>Pre-heat reflector</b> WELDPLAST S1/S2 / S2 PVC / S4 / S6 FUSION 2 / 3 / 3C
	<b>134.361</b> Air filter WELDPLAST S1 / S2 / S2 PVC (included with purchase)
	<b>143.776</b> Textile dust filter WELDPLAST S1 / S2 PVC (in combination with Air filter) (not included with purchase)
	<b>135.082</b> Air filter FUSION 2 / 3C
	<b>155.829</b> Air filter WELDPLAST S2
	<b>153.009</b> Corner Press Tool
	<b>152.676</b> Welding Gauge
	<b>144.095</b> Welding rod de-reeler
	<b>116.367</b> <b>Storage case</b> (included with purchase) WELDPLAST S6
	<b>123.173</b> WELDPLAST S4 / FUSION 3
	<b>119.540</b> WELDPLAST S2 / S2 PVC / S1 / FUSION 2 / 3C
	<b>162.060</b> FUSION 1

	<b>154.259</b> Scraper blade
	<b>154.026</b> Contour scraper
	<b>165.734</b> Spare blade set of 3 pcs
	<b>Heating element</b>
	<b>134.567</b> 230 V / 2600 W, WELDPLAST S6
	<b>109.984</b> 230 V / 2200 W, WELDPLAST S4 / S2 / S2 PVC
	<b>113.268</b> 230 V / 1100 + 1100 W, FUSION 3
	<b>123.561</b> 230 V / 1750 W, FUSION 2 / 3C
	<b>149.265</b> 230 V / 1000 W, WELDPLAST S1
	<b>149.529</b> 120 V / 1100 W, WELDPLAST S1
	<b>149.530</b> 100 V / 1050 W, WELDPLAST S1
	<b>151.026</b> 120 V / 1750 W, FUSION 2
	<b>161.941</b> 230 V / 900 W, FUSION 1
	<b>112.963</b> 120 V / 1150 W, FUSION 1

PLASTFIX lends the weld seam the necessary holding pressure.





## Welding rods

Article	Profile	Colour	kg
<b>Welding accessories PE</b>			
104.283 HDPE welding rod	A	Black	3
104.294 HDPE welding rod	A	White	3
104.284 HDPE welding rod	B	Black	5
104.299 HDPE welding rod	B	White	5
106.650 HDPE welding band	C	White	1
104.300 LDPE welding rod	A	Black	3
161.612 HDPE welding rod	D	Black	2
116.918 HDPE welding rod	D	White	2
<b>Welding accessories PP</b>			
104.287 PP welding rod	A	Light green	3
104.301 PP welding rod	A	Black	3
106.642 PPs welding rod, flame resistant	A	Light green	3
104.288 PP welding rod	B	Light green	5
126.356 PP welding band	C	White	2
161.611 PP welding rod	D	Light green	2
<b>Welding accessories PVC</b>			
104.296 PVC-U welding rod	A	White	3
104.278 PVC-U welding rod	A	Grey	3
106.641 PVC-U welding rod	A	Brown	3
104.280 PVC-U welding rod	B	Brown	5
104.279 PVC-U welding rod	B	Grey	5
109.925 PVC-U welding rod	D	Grey	4
104.302 PVC-P welding rod (soft)	A	White	3
<b>Welding accessories ABS</b>			
104.295 ABS welding rod	A	White	3
113.587 ABS welding rod	A	Black	3
107.027 ABS welding band	C	White	1

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

## Profile sizes

<b>Profile A</b> 	<b>Profile B</b> 	<b>Profile C</b> 	<b>Profile D</b> 
----------------------	----------------------	----------------------	----------------------

Dimensions in mm







Promotes the life of the floor.



For aseptic applications.



Suitable for frequent cleaning.

## Flooring / Interior Decoration

Product overview	112
Flooring welding procedures	113
MINIFLOOR Drive Unit	114 / 115
UNIFLOOR E / UNIFLOOR S	116
GROOVER	117
GROOVY	118
General accessories	119

## Hot-Air Hand Tools

TRIAC ST	12 – 15
TRIAC AT	13 – 15
ELECTRON ST	16 / 17
HOT JET S	18 / 19
GHIBLI AW	22 / 23
General accessories	36 / 37

## Overview Flooring



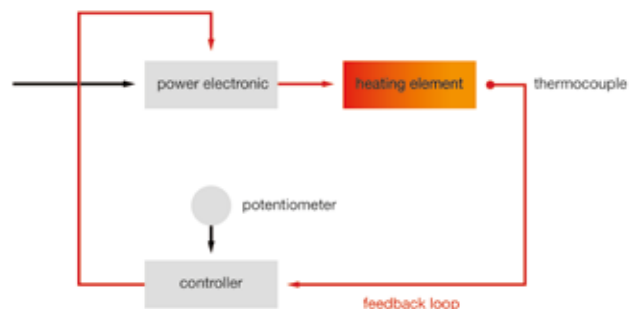
Typ		GROOVY	GROOVER	MINIFLOOR	UNIFLOOR
Area of application		Gouging tool for elastic floor coverings	Grooving machine for elastic floor coverings	Drive unit for welding elastic floor coverings	Welder for welding elastic floor coverings
Groove wide	mm	2.5 / 3.5	2.5 / 2.8 / 3.5 / 4.0	2.5 – 4.0	2.5 – 4.0
Groove depth	mm	0.5 – 2.5	0.0 – 4.0	2.5 – 4.0	2.5 – 4.0
Speed	m/min	-	Phase 1 (Linoleum) 4 – 6 Phase 2 (PVC, TPU, PU) 8 – 12	0.5 – 4.5	1.0 – 7.5
Temperature	°C	-	-	40 – 620 (with TRIAC AT)	80 – 620
Air flow range	%	-	-	20 – 100 (with TRIAC AT)	50 – 100
Voltage	V	-	120 / 230	100 – 230	120 / 230
Frequenz	Hz	-	50 / 60	50 / 60	50 / 60
Power	W	-	Phase 1 (Linoleum) 350 Phase 2 (PVC, TPU, PU) 700	drive unit 5 with TRIAC AT 1605	2300
Weight	kg	0.29	6.7	5.3 6.6	11.5
Size	mm	180 × 42 × 92	240 × 205 × 255	310 × 225 × 245 495 × 225 × 295	420 × 270 × 215
Cable length	m	-	3	3	3
<b>Startup parameters*</b>					
Materials			Linoleum (Phase 1)PVC, TPU, PU (Phase 2)	LinoleumPVC, TPU, PU	LinoleumPVC, TPU, PU
Speed	m/min	-	510	1.51.5	33
Temperature	°C	-	-	400 – 450500 – 550	400 – 450500 – 550
Air flow range	%	-	-	100%100%	100%100%
Catalog page		118	117	114 / 115	116

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

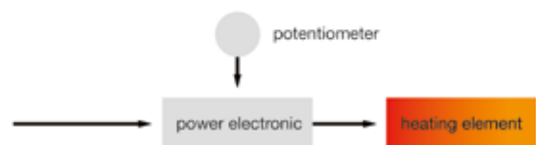
## Closed-loop system

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

Closed loop System



Open loop System



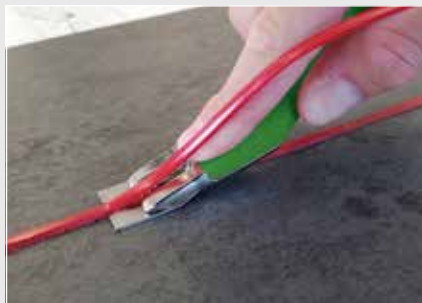
## Procedures for welding floor coverings



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



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



**Step 3:**  
Removing the excess welding  
rod with Quarter Moon Knife  
or Trimming knife.










**Step 4:**  
Levelling the protruding  
welding rod with Quarter  
Moon Knife or Trimming  
knife.

# MINIFLOOR – efficient and affordable for everyone!

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

Hot-air welder

## MINIFLOOR

<p>1</p> 	<p><b>Reverse compatibility:</b> Thanks to the interchangeable inserts, even older TRIAC models can be connected without a hitch.</p>	
<p>2</p> 	<p><b>Tool-free assembly of the de-reeler:</b> even if the de-reeler is missing you may count on hassle-free handling, as well as smooth feeding of the welding rod into the "air-slide" of the speed welding nozzle.</p>	
<p>3</p> 	<p><b>Incredibly fast:</b> Despite its lightweight design, the MINIFLOOR offers a welding speed of about 2 m/6.5 ft per minute, nearly double the speed of manual welding.</p>	
<p>4</p> 	<p><b>The quick-lock fastening system at the clamp allows for assembling / dismantling of the TRIAC</b> in a matter of seconds. The power supply for the hand tool is integrated in the MINIFLOOR drive unit and you have the possibility to securely fasten the cable.</p>	
<p>5</p> 	<p><b>The individually-adjustable, start-up delay</b> of the MINIFLOOR drive unit enables modification of the startup according to individual needs. The long guide ensures outstanding precision along the seam.</p>	
<p>6</p> 	<p><b>The 51 mm/2 inches minimum distance from the wall</b>, ensures trouble-free welding around construction pipes and L-skirts. Due to its compact height, the MINIFLOOR seamlessly welds beneath obstacles with a minimum clearance of 295 mm /12 inches.</p>	





The MINIFLOOR is ideal for short joints and small projects.

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

Hot-air welder / drive unit

## MINIFLOOR Drive Unit



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

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

## Accessories MINIFLOOR Drive Unit

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

### MINIFLOOR Drive Unit

#### Article No.:

154.330 MINIFLOOR drive unit, with EU-plug; 230V

154.334 MINIFLOOR drive unit, with CH-plug; 230V

154.337 MINIFLOOR drive unit, with UK-plug; 110V

154.338 MINIFLOOR drive unit, with AUS-plug; 230V

Scope of delivery: Plastic case, Roller Holder, additional weight, Rubber pad set Ø 57 – Ø 60 mm, Velcro fastener 2 pcs, quick guide

154.335 MINIFLOOR drive unit, with US/JP-plug; 120V

154.336 MINIFLOOR drive unit, without plug; 230V

Scope of delivery: Plastic case, Roller Holder, additional weight, Rubber pad set Ø 57 – Ø 60 mm, Rubber pad set Ø 64 – Ø 65 mm, Velcro fastener 2 pcs, quick guide

General accessories



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

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



UNIFLOOR E, the reliable partner for welding floor coverings.

Hot-air welder

## UNIFLOOR E / UNIFLOOR S

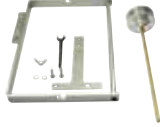







- Reproducible results thanks to permanent regulation of the NOMINAL and ACTUAL values
- Heater and drive electronically regulated
- Steplessly controlled air flow (only UNIFLOOR E)
- All floor coverings welded without reconfiguration
- Automatic start
- Integrated wall switch

### Technical Data

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

## Accessories UNIFLOOR E / UNIFLOOR S

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

### Article No.:

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

General accessories



# GROOVER: Dust-free milling.

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



Strong drive suitable for PVC, PUR and linoleum materials.

## Grooving machine

### GROOVER



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

## 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)

### Technical Data

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

### Article No.:

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

## GROOVY: Lightweight and handy.

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

### Gouging tool

#### GROOVY



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




#### Technical Data

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

#### Article number:

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

### Accessories GROOVY

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

Ideal for surfaces that are small and difficult of access



Executing clean grooves up to connecting walls



Precise and simple guidance thanks to integrated guide rollers





## General accessories

	<b>100.303</b> <b>107.144</b>	Tubular nozzle Ø 5 mm, 15° angled, push-fit (TRIAC) Ø 5 mm, 15° angled, push-fit (HOTJET)
	<b>105.576</b> <b>131.867</b>	Tubular nozzle Ø 5 mm, 90° angled, push-fit (TRIAC) Ø 5 mm, 90° angled, push-fit (HOTJET)
	<b>105.567</b> <b>105.575</b>	Tubular nozzle Ø 5 mm, 150 mm, straight (HOTJET) Ø 5 mm, 100 mm, straight (TRIAC)
	<b>105.431</b> <b>105.432</b> <b>105.433</b>	Speed weld nozzle 3 mm, with small air-slide, push-fit on Ø 5 mm tubular nozzle 4 mm, with small air-slide, push-fit on Ø 5 mm tubular nozzle 5 mm, with small air-slide, push-fit on Ø 5 mm tubular nozzle
	<b>107.139</b> <b>107.137</b>	Speed weld nozzle 4.5 x 12 mm for fillet weld, push-fit on Ø 5 mm tubular nozzle 8 mm welding, push-fit on Ø 5 mm tubular nozzle
	<b>159.848</b> <b>160.550</b>	Speed weld nozzle 5 mm, with small air-slide, curved, push-fit on 5 mm tubular nozzle 3 mm, with small air-slide, curved, push-fit on 5 mm tubular nozzle
	<b>106.992</b> <b>106.993</b>	Speed welding nozzle, push-fit on Ø 5 mm tubular nozzle 5.7 mm, profile A 7 mm, profile B
	<b>165.937</b>	Smoothing Nozzle push-fit on Ø 5 mm tubular nozzle
	<b>107.270</b>	Wide slot nozzle 150 x 12 mm, push-fit (ELECTRON ST)
	<b>142.281</b>	Scraper nozzle (ELECTRON ST)
	<b>148.933</b>	Protective tube (ELECTRON ST)
	<b>151.068</b>	Tool stand (ELECTRON ST) (recommen- ded)
	<b>106.970</b> <b>106.971</b>	Pressure roller for welding rods Ø 4 – 5 mm for welding rods Ø 2 – 4 mm
	<b>106.966</b> <b>106.968</b>	Hand grooving tool Spare blades for hand grooving tool

	<b>150.809</b>	Gouging tool "GROOVY" 3.5 mm for elastic floor coverings
	<b>150.815</b> <b>154.717</b>	Blade Ø 3.5 mm Blade Ø 2.5 mm
	<b>157.544</b>	Leister Universal scissors 260 mm with special shaft grinding
	<b>117.000</b>	Trimming knife with 0.6 mm spacer for vinyl and linoleum with 5 spare blades included
	<b>117.005</b>	5 spare blades
	<b>117.007</b>	1 universal spacer 0.6 mm
	<b>106.969</b>	Quarter Moon Knife including leather case, 100 mm stainless steel blade
	<b>122.541</b>	Trimming guide, to use with spatula (106.969)
	<b>137.855</b>	Leister cutter with four spare blades
	<b>138.902</b>	Hooked blade for LEISTER-cutter (10 dispenser with 10 pcs=100 pcs)
	<b>138.539</b>	Straight-edge blade for LEISTER-cutter (10 dispenser with 10 pcs = 100 pcs)
	<b>116.798</b>	Brass brush
	<b>142.647</b>	Brass brush Ø 3 mm
	<b>160.353</b>	Cable cord roller 25 m PUR 5 x 2.5 mm², with 1 x CEE 400 V and 2 x EU socket 230 V
	<b>161.152</b>	Cable cord roller 25 m PUR 5 x 2.5 mm², with 1 x CEE 400 V and 2x T23 CH socket 230 V
	<b>161.207</b>	Cable cord roller 25 m PUR 5 x 2.5 mm², with 1 x CEE 400 V and 2 x Typ E with ground pin socket 230 V
	<b>164.048</b>	Cable cord roller 45 m, 4 x 230 V, EU socket
	<b>160.015</b>	Cable extension cord 15 m PUR 5 x 2.5 mm², with CEE 400 V plug
	<b>159.239</b>	Cable extension cord 15 m PUR 3 x 2.5 mm², with EU plug 230 V

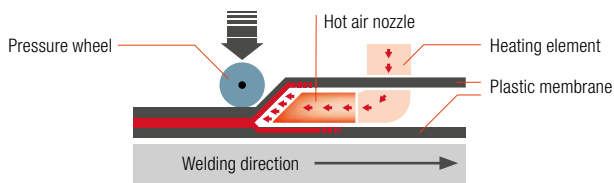
# Leister. We know how.

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

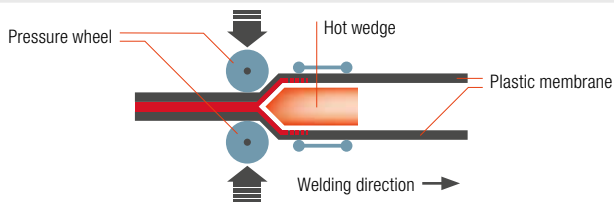
### Welding Methods



#### Hot-air welding

Hand tools, automatic welders, stationary welding machines

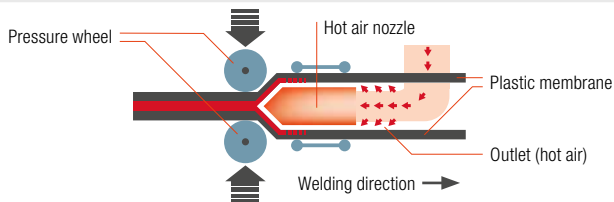
In hot gas welding, the thermal energy is controlled. Heated air is fed into the workpiece and the required amount of pressure is exerted onto the wheels.



#### Hot-wedge welding

Wedge welders

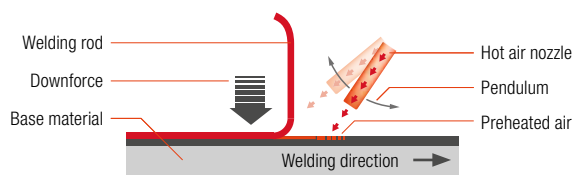
The process where the wedge is heated directly by heating cartridges. The generated heat is transferred directly onto the workpiece. This method also is suitable for thicker materials.



#### Combi-wedge welding

Combi-wedge welding machines

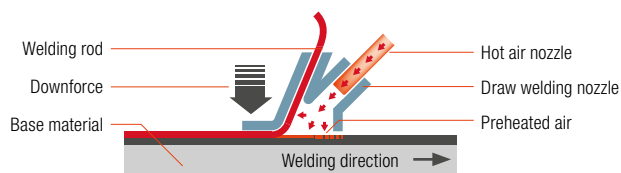
When Combi-wedge welding (combination of a heated wedge and hot air), preheating of the air and the actual welding process is carried out over a wedge. The preheated air also takes partial cleaning of the workpieces.



#### Pendulum Welding

Hand tools

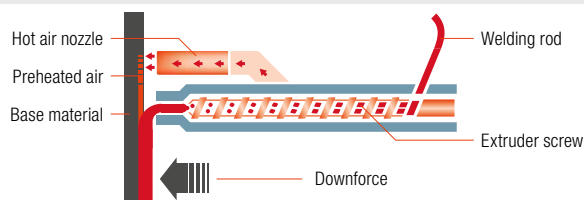
Pendulum welding requires a welding rod similar to the base material. Both surfaces are then heated using hot air. Using an up and down, pendulum-like motion and consistent downward pressure, the two are joined.



#### 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.

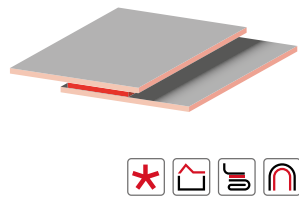
## Know-how

### Weld Types / Weld Geometries

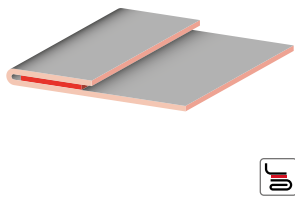
#### Welding without filler material

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

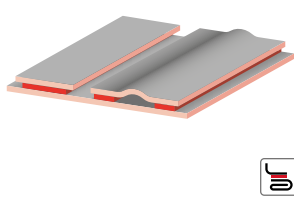
Overlap



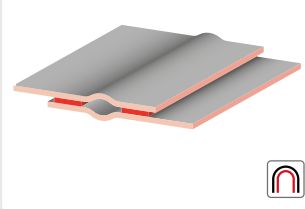
Hem



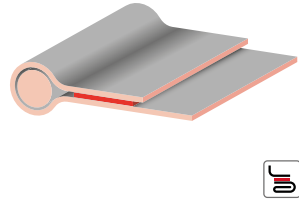
Tape



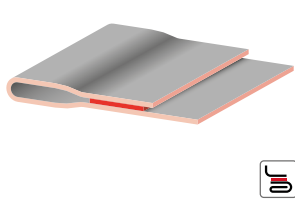
Double seam w/test channel



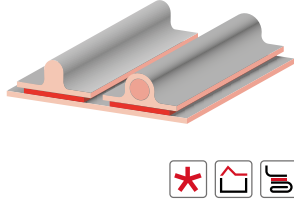
Keder / Piping



Pole pockets

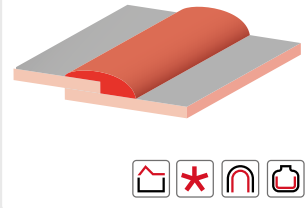


Antivandalism

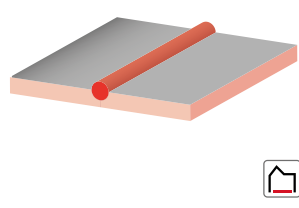


#### Welding with additional material

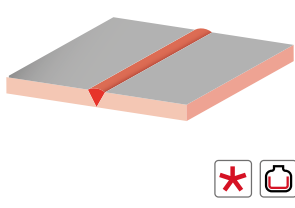
Overlap seam



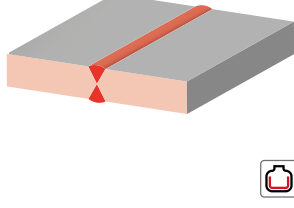
Floor seam



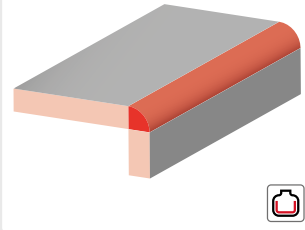
V-seam



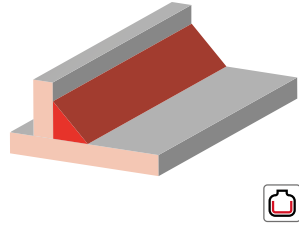
X-seam



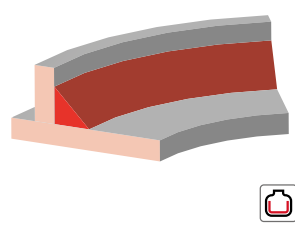
Outside corner seam



Fillet weld seam



Corner seam



## Legal Information

### Contents

We take the greatest care in presenting correct, complete and up-to-date information. However, we can assume no responsibility whatsoever for the information offered in this catalog. We reserve the right to modify or update all information at any time without prior notice.

### Copyrights and trademarks

All text, images, graphics as well as their arrangement are subject to copyright protection and other laws on the protection of intellectual property. The reproduction, alteration, transmission or publication of this catalog in part or in its entirety, except for personal, non-commercial use, is prohibited in all possible forms.

All the marks featured in this catalog (protected all brand marks, logos and business names) are the property of Leister Technologies AG or third parties and may not be used, permanently downloaded, copied or distributed without prior written consent.

### Specifications

Specifications are subject to change at any time without prior notice.

© Copyright by Leister.



**Have a look on:**

[www.youtube.com/user/leisterswitzerland](http://www.youtube.com/user/leisterswitzerland)



**Like and share us on:**

[www.facebook.com/leisterworld](http://www.facebook.com/leisterworld)



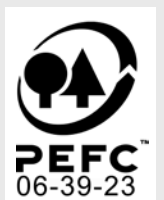
**Follow us on Twitter:**

[twitter.com/leisterworld](https://twitter.com/leisterworld)

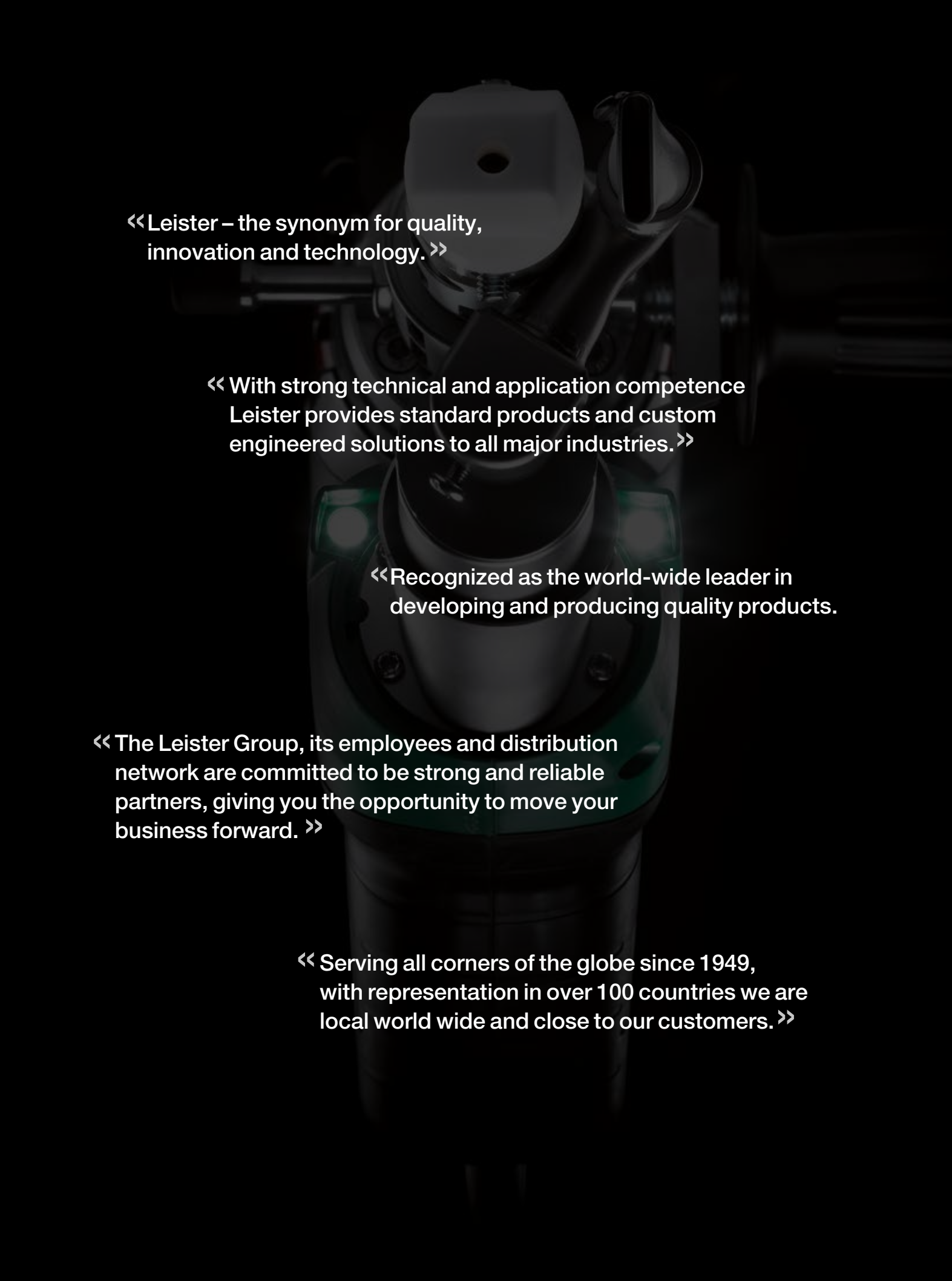


**join us on LinkedIn:**

[www.linkedin.com/company/leister-technologies-ag](http://www.linkedin.com/company/leister-technologies-ag)







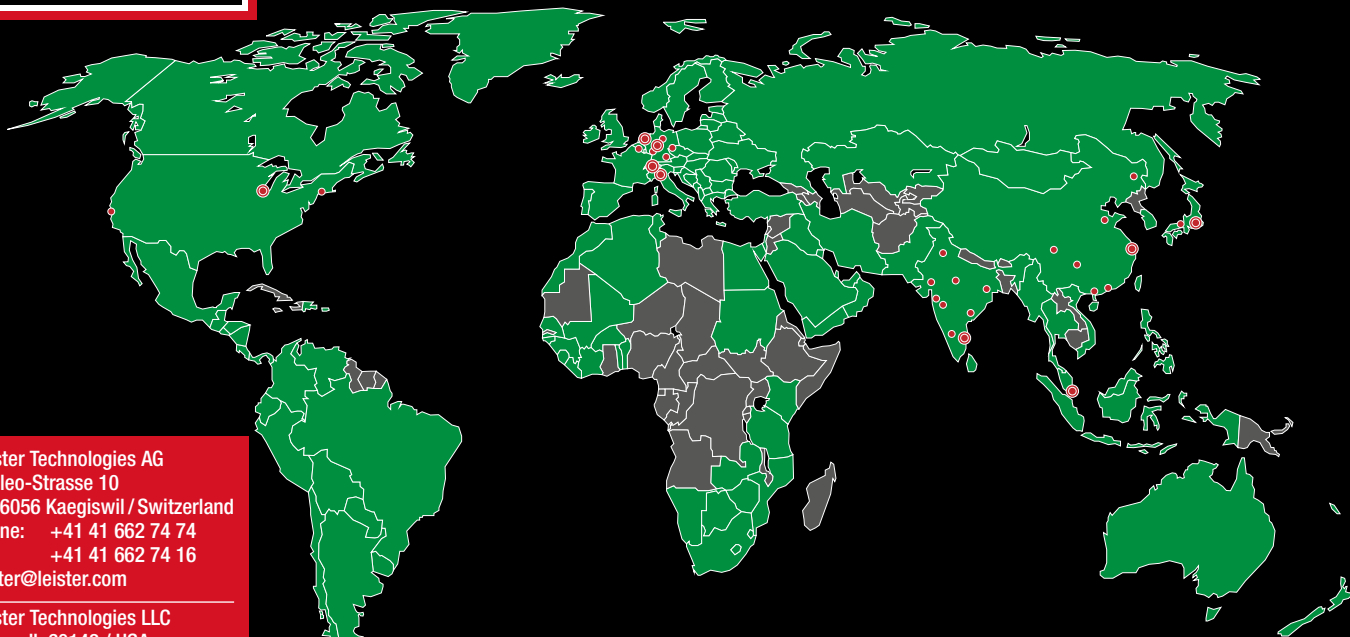
«Leister – the synonym for quality,  
innovation and technology.»

« With strong technical and application competence  
Leister provides standard products and custom  
engineered solutions to all major industries.»

«Recognized as the world-wide leader in  
developing and producing quality products.

« The Leister Group, its employees and distribution  
network are committed to be strong and reliable  
partners, giving you the opportunity to move your  
business forward. »

« Serving all corners of the globe since 1949,  
with representation in over 100 countries we are  
local world wide and close to our customers. »



Leister Technologies AG  
Galileo-Strasse 10  
CH-6056 Kaegiswil / Switzerland  
phone: +41 41 662 74 74  
fax: +41 41 662 74 16  
leister@leister.com

Leister Technologies LLC  
Itasca, IL 60143 / USA  
phone: +1 855 534 7837  
info.usa@leister.com

Leister Technologies Ltd.  
Shanghai 201 109 / PRC  
phone: +86 21 6442 2398  
leister@leister.cn

Leister Technologies KK  
Osaka 564-0051 / Japan  
phone: +81 6 6310 62 00  
sales-japan@leister.com

Leister Technologies Benelux BV  
3991 CE Houten / Nederland  
phone: +31 (0)30 2199888  
info@leister.nl

Leister Technologies Italia s.r.l.  
20090 Segrate / Italia  
phone: +39 02 2137647  
sales@leister.it

Leister Technologies India Pvt  
600 041 Chennai / India  
phone: +91 44 2454 3436  
info@leister.in

Leister Technologies  
Deutschland GmbH  
D-58093 Hagen / Germany  
phone: +49-(0)2331-95940  
info.de@leister.com

## Our close worldwide network of more than 130 Sales and Service Centres in more than 100 countries.

### Europe:

Andorra  
Austria  
Belgium  
Cyprus  
Denmark  
Finland  
France  
Germany  
Greece  
Iceland  
Ireland  
Italy  
Luxembourg  
Malta  
Monaco  
Netherlands  
Norway  
Portugal  
Liechtenstein  
San Marino  
Spain

Sweden  
Switzerland  
Turkey  
United Kingdom  
Vatican  
Albania  
Armenia  
Azerbaijan  
Belarus  
Bosnia-Herzegovina  
Bulgaria  
Croatia  
Czech Republic  
Estonia  
Georgia  
Hungary  
Kosovo  
Latvia  
Lithuania  
Macedonia  
Moldova  
Montenegro

Poland  
Romania  
Russia  
Serbia  
Slovakia  
Slovenia  
Ukraine

### Americas:

Canada  
Mexico  
USA  
Belize  
Costa Rica  
El Salvador  
Guatemala  
Honduras  
Nicaragua  
Panama  
Argentina  
Bolivia  
Brazil

Chile  
Colombia  
Ecuador  
Peru  
Venezuela

### Central Asia:

Kazakhstan  
Kyrgyzstan  
Tajikistan  
Turkmenistan  
Uzbekistan

### Middle East:

Bahrain  
Iraq  
Israel  
Jordan  
Qatar  
Saudi Arabia  
U.A.E

### Africa:

Algeria  
Botswana  
Egypt  
Ivory Coast  
Kenya  
Lesotho  
Libya  
Malawi  
Morocco  
Mozambique  
Namibia  
North Sudan  
South Africa  
Swaziland  
Tunisia  
Zambia  
Zimbabwe

### Asia Pacific:

Bangladesh  
China  
Hong Kong  
India  
Indonesia  
Japan  
Korea  
Macao  
Malaysia  
Mongolia  
Philippines  
Singapore  
Sri Lanka  
Taiwan  
Thailand  
Vietnam

### Oceania:

Australia  
New Zealand

© Copyright by Leister, Switzerland

Your Leister Sales and Service Center:

