

LEISTER

PLASTIC WELDING

Swiss
made



2017/18

General Catalog

Plastic Welding

The only choice for professionals

www.leister.com

We know how.



Leister Technologies AG, Corporate Center, Kaegiswil, Switzerland



Leister Technologies AG, factory, Sarnen, Switzerland



Leister Technologies AG, factory, Kaegiswil, Switzerland



Leister Technologies Ltd.,
Shanghai, China



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

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



LEISTER

PLASTIC WELDING

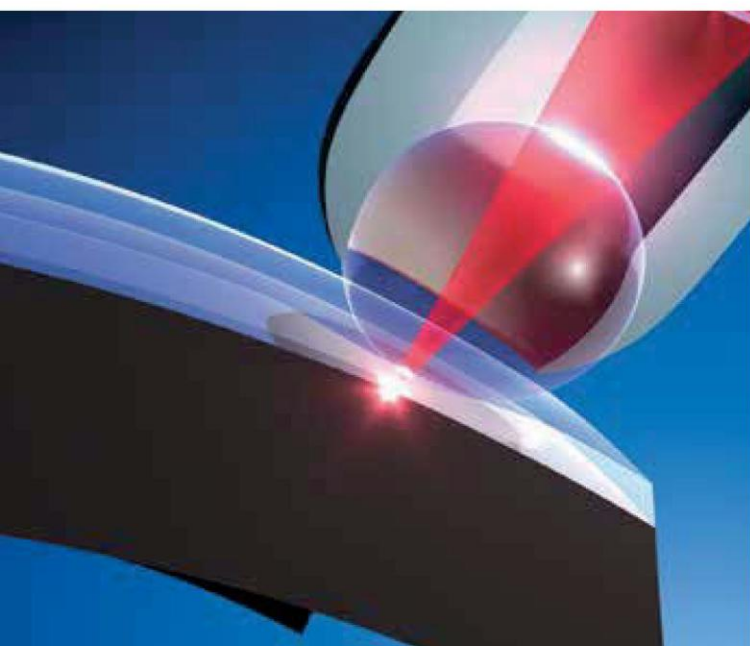
For decades now, Leister has been the worldwide market leader. The performance and reliability of our products makes Leister the first choice. Our tools are used in roofing, billboards, tarpaulins, civil engineering, tunneling, landfills, flooring, plastic fabrication, and shrinking to name a few.



LEISTER

PROCESS HEAT

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



LEISTER

LASER PLASTIC WELDING

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

Plastic welding with Leister

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

Research and development

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

Quality management

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

Testing and certification

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

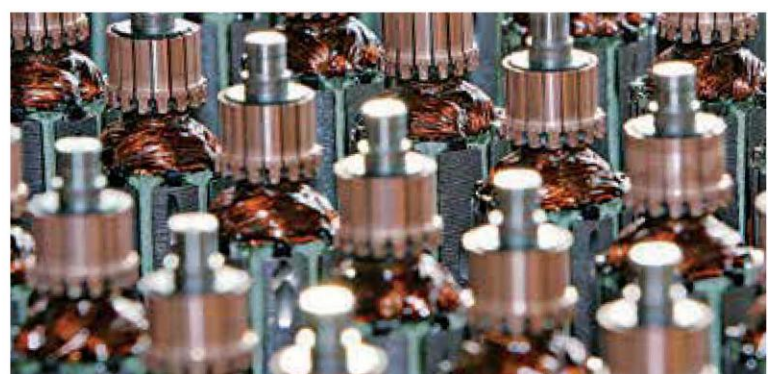
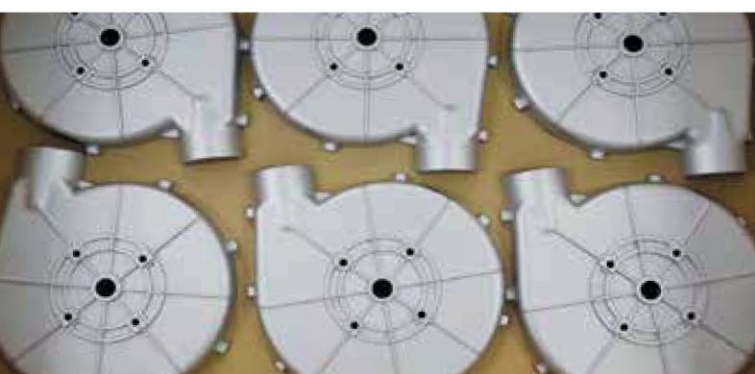
Application and laboratory testing

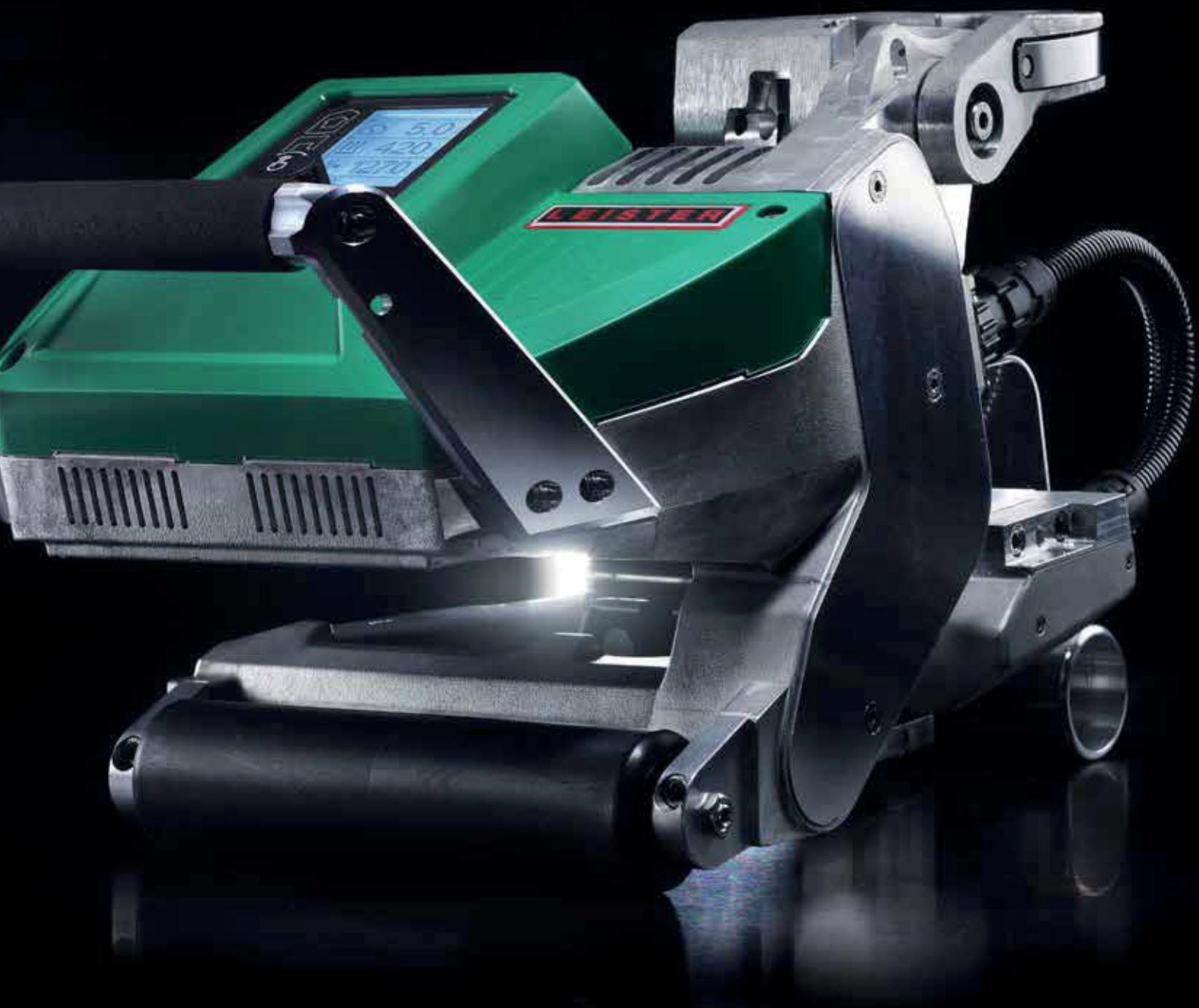
Our team of experts will assist you in choosing the right equipment for your application process. Running test series on your applications will help optimize processes. The equipment of the application laboratory allows comprehensive testing for process analysis and documentation of the results.

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








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








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 Technical Textiles and industrial Fabrics	Blowers	
 Civil Engineering / GEO	General accessories	
 Plastic Fabrication	Welding rods	
 Flooring and Interior Decoration	Special applications 	
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Hot-Air Hand Tools

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Roofing

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Civil Engineering / GEO

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Plastic Fabrication

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Flooring and Interior Decoration





TRIAC ST for use in the roughest of environments.



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



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










Hot-Air Hand Tools

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Product overview Hot-air hand tools

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

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

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

Product advantage

1



Ergonomic handling:

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

Perfect weight:

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

2



Always keeps a cool head:

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

3



Welding power:

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

2



1

3

4

5

4



Reliability:

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

5



Swiss thoroughness:

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

Optimum protection:

The filters offer active protection against moisture and dust.

TRIAC AT: Robust and intelligent.

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

Hot-air hand tool

TRIAC ST



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

Technical data		
Voltage	V~	120 / 230
Frequency	Hz	50 / 60
Power	W	1600 / 1600
Temperature	°C	40 – 700
Air volume (20°C)	l/min	240 (550 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	
Protection class II	□	

Article No.:	
141.308	TRIAC ST, 120V / 1600W for push-fit nozzles with UK-plug
141.309	TRIAC ST, 230V / 1600W for push-fit nozzles with UK-plug
141.311	TRIAC ST, 230 V / 1600 W for push-fit nozzles with CH plug
141.227	TRIAC ST, 230 V / 1600 W for push-fit nozzles with Euro plug
144.013	TRIAC ST, 230 V / 1600 W for screw-on nozzles with Euro plug

Hot-air hand tool

TRIAC AT



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


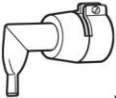

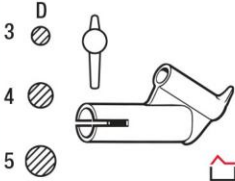

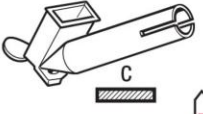

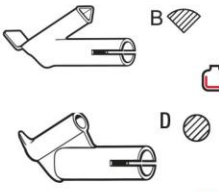




Technical data		
Voltage	V~	120 / 230
Frequency	Hz	50 / 60
Power	W	1600 / 1600
Temperature	°C	40 – 620
Air volume (20°C)	l/min	120 - 240 (550 at max. temp)
Dynamic pressure	Pa	3000
Ø Nozzle holder	mm	31.5
Emission	dB(A)	67
Size (L × Ø)	mm	338 × 90, handle Ø 56
Weight	kg	1 (without power cord)
Conformity mark	CE	
Approval mark	S	
Protection class II	□	

Article No.:	
141.319	TRIAC AT, 120V / 1600W, with UK-plug
141.320	TRIAC AT, 230V / 1600W, with UK-plug
141.314	TRIAC AT, 230 V / 1600 W, mit Euro-Stecker
141.322	TRIAC AT, 230 V / 1600 W, mit CH-Stecker



Overlap welding

Accessories TRIAC ST / TRIAC AT

	<p>Wide slot nozzle, push-fit</p> <p>107.123 20 mm, 15° angled 107.132 40 mm, 15° angled 107.133 40 mm, perforated 107.135 40 mm, PTFE-coated 107.129 60 mm for bitumen 107.131 80 mm for bitumen</p> <p>(more: www.leister.com/downloads)</p>		<p>107.124 20 mm angled nozzle, 70°, push-fit</p>
	<p>Wide slot nozzle</p> <p>105.475 20 mm, straight 105.485 25 mm, straight 105.494 30 mm, 15° angled</p>		<p>105.431 3 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle</p> <p>105.432 4 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle</p> <p>105.433 5 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle</p>
	<p>105.487 Wide slot nozzle 20 mm, curved and angular, with clamping angle inwards</p>		<p>107.139 4.5 x 12 mm speed weld nozzle for fillet weld, push-fit on Ø 5 mm tubular nozzle</p> <p>107.137 8 mm speed weld nozzle for tape welding, push-fit on Ø 5 mm tubular nozzle</p>
	<p>105.500 Wide slot nozzle 20 mm, 120° angled (right) 30° slanted forward openly</p>		<p>Speed weld nozzle, push-fit on Ø 5 mm tubular nozzle</p> <p>106.992 5.7 mm, profile A 106.993 7 mm, profile B</p> <p>106.989 Ø 3 mm 106.990 Ø 4 mm 106.991 Ø 5 mm</p>
	<p>107.130 Wide slot nozzle (Ø 32mm) 40mm, 60° bent 107.125 20 mm angled nozzle, 60°, push-fit, for right hander 105.503 20 mm angled nozzle, 60°, push-fit</p>		<p>100.303 Ø 5 mm, tubular nozzle, push-fit</p> <p>105.575 Ø 5 x 100 mm, tubular nozzle, push-fit</p> <p>106.982 Ø 5 x 150 mm, extension nozzle, push-fit</p>
	<p>105.576 tubular nozzle Ø 5 mm, 90° curved</p>		<p>106.996 Tacking nozzle, push-fit on Ø 5 mm tubular nozzle</p>



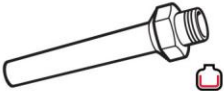
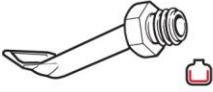
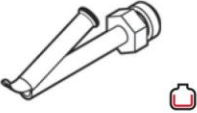
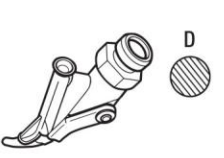










Mirror welding

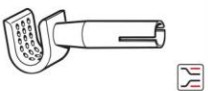

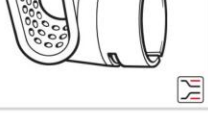
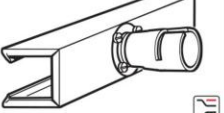

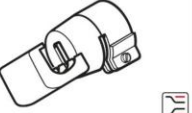





Draw welding



Shrinking

	105.622 Ø 5 mm, tubular nozzle, screw-on
	106.988 Tacking nozzle, screw-on
	126.552 Ø 4 mm drawing nozzle, screw-on for fluoroplastics
	113.666 Ø 3 mm drawing nozzle with tacking tip, screw-on
	113.399 Ø 4 mm drawing nozzle with tacking tip, screw-on
	113.876 Ø 3 mm drawing nozzle without tacking tip, screw-on
	113.874 Ø 4 mm drawing nozzle without tacking tip, screw-on
	113.670 Drawing nozzle triangular-shaped With tacking tip, screw-on 5.7 mm, profile A
	113.877 Without tacking tip, screw-on 5.7 mm, profile A
	106.986 Without tacking tip, screw-on 7 mm, profile B
	106.987 Without tacking tip 7 x 5.5 mm
	107.344 135 mm welding mirror, push-fit
	143.833 Nozzle adapter for screw-on nozzles
	143.332 Protection tube for screw-on nozzles (for TRIAC ST only)
	141.375 Connection adapter M14 for Ø 21 mm nozzle with plug

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

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

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



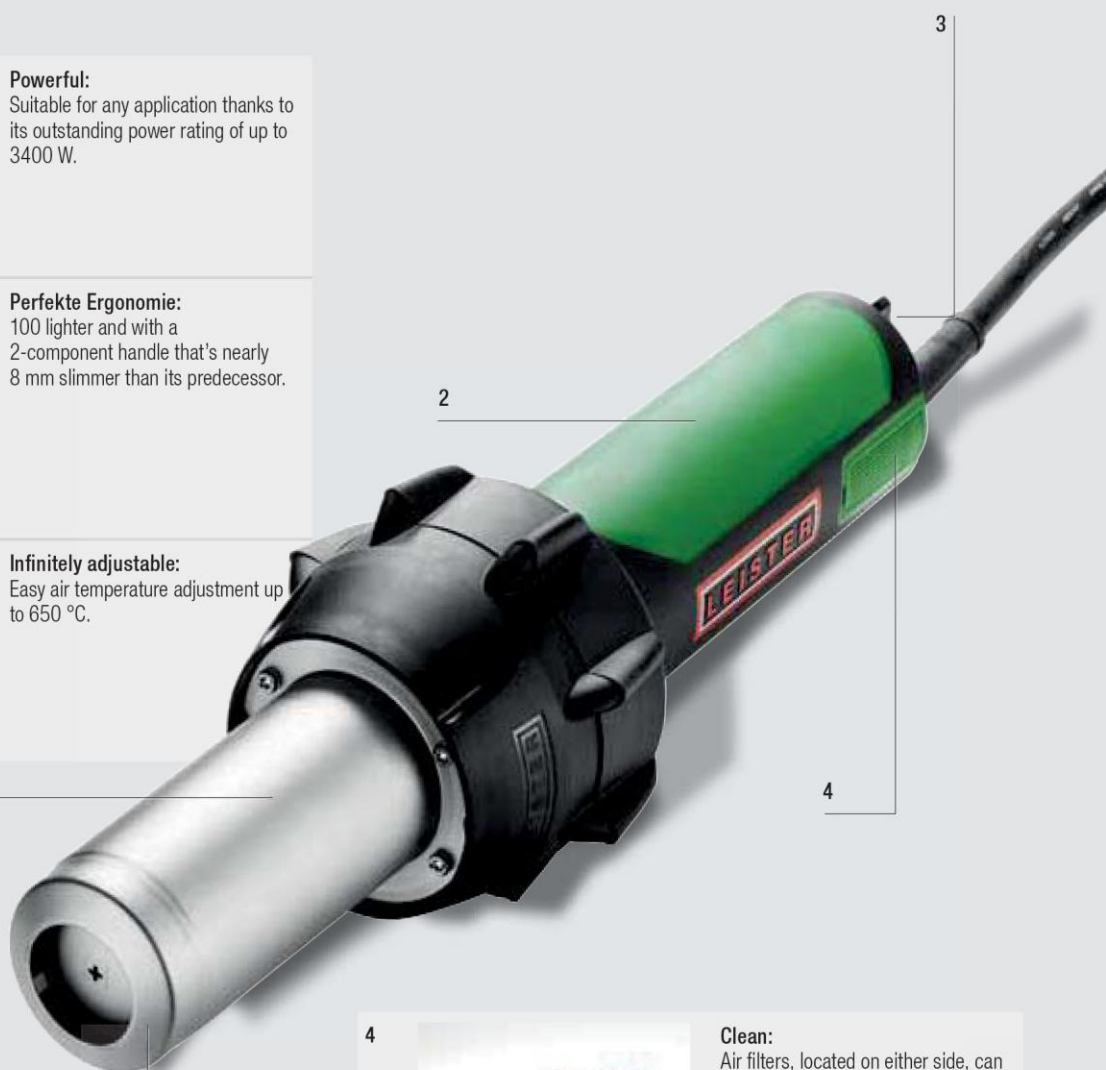
Infinitely adjustable:

Easy air temperature adjustment up to 650 °C.

1

2

4



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

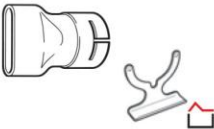

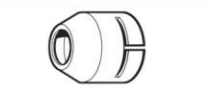


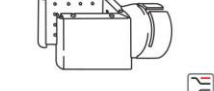





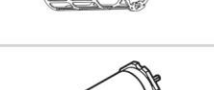

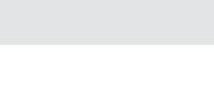


Technical data

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	320 (750 at max. temp)
Dynamic pressure	Pa	3000
Ø Nozzle holder	mm	50
Emission	dB(A)	67
Size (L × Ø)	mm	338 × 90, handle Ø 56
Weight	kg	1.1 (without power cord)
Conformity mark		CE
Approval mark		§
Protection class II		□

Article No.

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

Accessories ELECTRON ST

	107.258	Wide slot nozzle, push-fit 70 × 10 mm, for bitumen
	107.653	Wide slot nozzle 75 × 2 mm, push-fit
	151.068	Tool stand for 107.653
	107.270	Wide slot nozzle 150 × 12 mm, push-fit
	107.229	Round nozzle 20 mm
	107.331	72 × 70 mm folding reflector, push-fit
	107.328	60 × 75 mm folding reflector, push-fit
	107.330	125 × 22 mm folding reflector, push-fit
	107.327	85 × 85 mm sieve reflector, push-fit
	107.333	130 × 150 mm sieve reflector, push-fit
	106.127	Ø 65 mm sieve reflector push-fit
	107.340	45 × 250 mm Shell reflector, push-fit
	107.346	270 mm welding mirror, push-fit
	142.281	Scraper nozzle
	107.134	Tape welding nozzle 40 mm
	148.933	Protective tube
	145.606 145.604	Heating elements 230 V / 3300 W 230 V / 2200 W 120 V / 2300 W

General accessories

34/35

HOT JET S: Small and powerful.

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



Especially suited for precise work.

Hot-air hand tool

HOT JET S



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


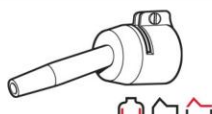
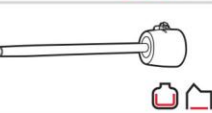

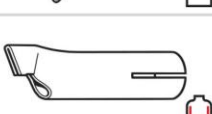
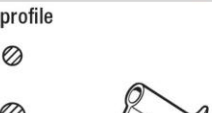





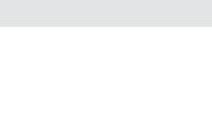

Technical data

Voltage	V~	120 / 230
Frequency	Hz	50 / 60
Power	W	460 / 460
Temperature	°C	20 – 600
Air volume (20°C)	l/min	20 – 80 (180 at max. temp)
Pressure static	Pa	1500
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	S	
Protection class II	□	

Article No.:

100.648	HOT JET S, 230 V / 460 W, with Euro plug
100.862	HOT JET S, 120 V / 460 W, without plug
100.854	HOT JET S, 230 V / 460 W, with AUS plug

Accessories HOT JET S

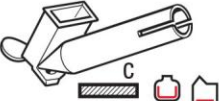
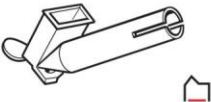
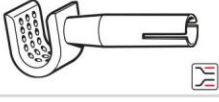





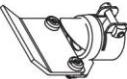

	107.141 15 mm wide slot nozzle, push-fit
	107.142 20 mm wide slot nozzle, push-fit
	105.549 10 x 2 mm wide slot nozzle
	107.144 Ø 5 mm tubular nozzle, push-fit
	105.567 Ø 5 x 150 mm extension nozzle, straight
	105.566 Ø 8 mm tubular nozzle, straight
	105.575 Ø 5 mm tubular nozzle, straight
	105.556 20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

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

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



GHIBLI AW: Robust and ergonomic.

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

Heat gun

GHIBLI AW

1



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 GIBLI AW.



Shrink applications in cable manufacturing – ideal with the GIBLI AW

Heat gun

GIBLI AW



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

Technical data

Voltage	V~	230 / 120
Frequency	Hz	50 / 60
Power	W	2300 / 1800
Temperature	°C	65 – 620
Air volume (20°C)	l/min	140 – 270 (600 at max. temp)
Pressure static	Pa	3000
Ø Nozzle holder	mm	36.5
Emission	dB(A)	67
Dimensions (L × W × H)	mm	280 × 220 × 90, Handle Ø 45
Weight	kg	1.1 (without power cord)
Conformity mark		CE
Approval mark		Ⓢ
Protection class II		□

Article No.:

148.061	GIBLI AW, 230 V / 2300 W, Euro plug
150.168	GIBLI AW, 230 V / 2300 W, UK plug
150.169	GIBLI AW, 230 V / 2300 W, CH plug
150.170	GIBLI AW, 120 V / 1800 W, CEE plug
148.079	GIBLI AW, 100 V / 1500 W, JP plug
Scope of delivery: GIBLI AW, case, stand, Operating Instructions	

Accessories for GIBLI AW

	106.998	Wide slot nozzle 20 mm, push-fit
	106.999	Wide slot nozzle 40 mm, push-fit
	107.154	Tubular nozzle Ø 5 mm, push-fit
	107.006	Extension nozzle Ø 5 × 130 mm, straight
	107.308	Sieve reflector 50 × 35 mm
	107.309	Sieve reflector 35 × 20 mm
	107.313	Spoon reflector 25 × 30 mm, with screw connector
	107.325	Solder reflector 17 × 34 mm, push-fit
	107.319	Sieve reflector Ø 65 mm
	107.345	Welding mirror 135 mm, push-fit
	107.007	Ø 37 mm Dehorning nozzle
	106.132	45 × 250 mm Shell reflector, push-fit
	145.582	Heating element, 230 V / 2200 W
	145.580	Heating element, 120 V / 1700 W

General accessories

34/35



GHIBLI: “The hot-air gun”.

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



Shrinking cable connections with the GHIBLI.

Hot-air hand tool

GHIBLI



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

Technical data

Voltage	V~	120 / 230
Frequency	Hz	50 / 60
Power	W	1500 / 2000
Temperature	°C	20 – 600
Air volume (20°C)	l/min	300 + 350 (800 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	UL, S	
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

	106.998	20 mm wide slot nozzle, push-fit
	106.999	40 mm wide slot nozzle
	107.154	Ø 5 mm tubular nozzle, push-fit
	107.006	Ø 5 × 130 mm extension nozzle, straight
	107.308	34 × 50 mm sieve reflector
	107.309	20 × 35 mm sieve reflector
	107.313	25 × 30 mm spoon reflector, with screw connector
	107.314	25 × 30 mm spoon reflector, push-fit
	107.325	17 × 34 mm soldering reflector, push-fit
	107.319	Ø 65 mm sieve reflector
	107.007	Ø 37 mm Dehorning nozzle
	107.345	135 mm welding mirror, push-fit
	106.132	150 × 25 mm Shell reflector, push-fit
	115.513	230 V / 1800 W heating element
	101.850	120 V / 1500 W heating element

General accessories

HOTWIND: The new dimension.

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



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

Hot-air hand tool

HOTWIND PREMIUM / SYSTEM



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

Technical data

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

Article No.:

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

Additional versions available upon request

Accessories

HOTWIND PREMIUM / SYSTEM

	Wide slot nozzle, push-fit (a × b)
	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 bulky goods.



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

Hot-air hand tool

FORTE S3



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

Technical data			
Voltage	V~	3 × 230	3 × 400
Power	kW	10	10
Temperature	°C	650	
Size (L × W × H)	mm	390 × 132 × 215	
Weight	kg	4.4 (without power cord)	
Conformity mark		CE	
Approval mark		Ⓢ	
Protection class II		□	
Article No.:			
102.027 FORTE S3, 3 × 400 V / 10 kW with 16A CEE plug			
Additional versions available upon request			

AIRSTREAM ST: The quiet and efficient air supply unit.

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



Dual operation:

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



The quick-change artist:

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



Quality is measurable:

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



Logic for a longer service life:

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

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 _{pA} (dB)	< 48 (with 3 m hose)
Size (L × B × H)	mm	600 × 250 × 362 (with handle)
Weight	kg	24
Conformity mark		CE
Protection class I		⊕

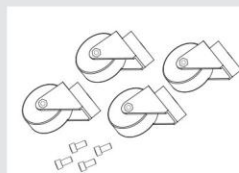
Scope of delivery:

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

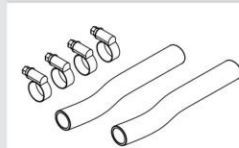
Article-No.:

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

Accessories AIRSTREAM ST



159.535 Roller set



159.481 Air hose connection set



Easy parallel operation.



A reliable companion.

ROBUST: The powerhouse.

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



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

Blower

ROBUST



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


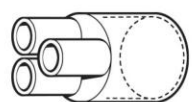
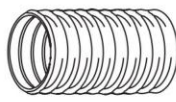

Technische Daten

Frequency	Hz	50	60
Power	W	250	250
Air volume (20 °C)	l/min	1200	1300
Static pressure	kPa	8.0	10.5
Max. ambient temperature	°C	60	60
Max. air inlet temperature	°C	60	60
Noise emission level	dB(A)	62	62
Protection (IEC 60529)		IP 54	IP 54
Outside diameter air inlet	Ø mm	38	38
Outside diameter air outlet	Ø mm	38	38
Weight	kg	8.0	8.0
Conformity mark		CE	CE
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.:	103.434		103.429
3 m cord / Euro plug	Article No.:		103.432	

Accessories ROBUST

	107.354 Stainless steel filter, push-fit on air intake
	107.281 Ø 38 mm hose connection adapter, 3 output each 14 mm
	113.859 Ø 14 mm air hose
	101.031 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.

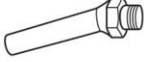









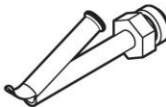




External air hand tool

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

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

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
 114.380 WELDING PEN R, 230 V / 1000 W, for screw-on nozzle, with Euro plug
 113.081 WELDING PEN S, 230 V / 1000 W, for screw-on nozzle, with Euro plug
 Additional versions available upon request

Swiveling air hose for easy working.



General accessories

DIODE PID / S: The powerful pair.

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



Convenient wire welding using the powerful and lightweight DIODE PID.

External air hand tool

DIODE PID / DIODE S



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

Technical data

Voltage	V~	120 / 230
Power	W	1600
Temperature	°C	20 – 600
Size (L × Ø)	mm	265 × 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 × Ø)	mm	265 × 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

General accessories





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

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

With screw-on nozzle

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

Blower

MINOR



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

Technical data

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

Article No.:

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

Additional versions available upon request

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

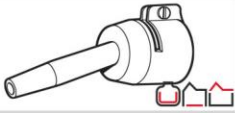
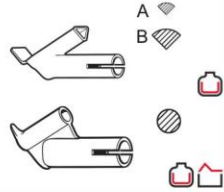







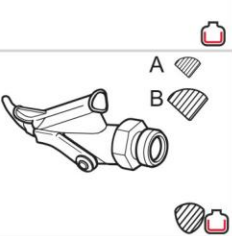

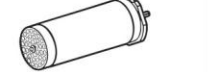
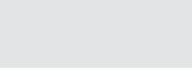
Technical data

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	S	
Protection class II	□	

Article No.:

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

Accessories LABOR S

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

General accessories

34/35

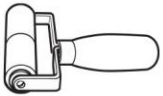

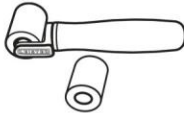
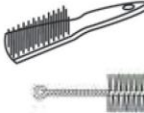








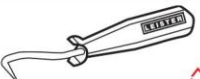

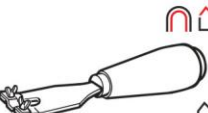
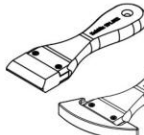


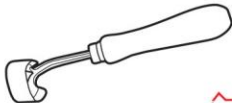

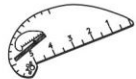
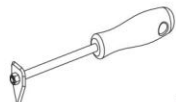






The new «Groovy» gouging tool is also perfectly suited for floor joints.

Hot-air hand tools

General accessories

	106.974 80 mm silicone pressure roller		106.997 Ø 6 mm rotary burr for drilling machine, for car repairs
	140.160 40 mm silicone pressure roller with ball bearings (silicone) 140.599 Spare roll for 140.160		116.798 Brass brush
	140.161 Pressure roller 28 mm, with ball bearings (silicone) 140.598 Spare roll for 140.161		142.647 Brass brush Ø 3 mm
	106.976 28 mm pressure roller (PTFE)		107.348 Tool rest for TRIAC AT, TRIAC ST, ELECTRON ST 103.401 Tool rest for HOT JET, LABOR S
	106.972 Brass pressure roller with ball bearings		137.855 Leister cutter with four spare blades
	106.981 Pressure roller for custom seal		138.902 Hooked blade for LEISTER-cutter (10 dispenser with 10 pcs=100 pcs)
	138.314 Seam probe tester for overlap seams		138.539 Straight-edge blade for LEISTER-cutter (10 dispenser with 10 pcs = 100 pcs)
	111.346 Chamfer plane with seven spare blades, for sealing sheets 111.348 Spare blades kit containing ten blades		151.382 Kehlfix
	106.966 Hand grooving tool 106.968 Spare blades for hand grooving tool		153.009 Plastfix
	151.188 Chamfer plane for T-joints on		154.259 Contour scraper
	152.676 Weld seam template		154.026 Scraper blade
	157.544 Leister Universal scissors 260 mm with special shaft grinding		116.586 Storage case for TRIAC AT, TRIAC ST, ELECTRON ST



Welding rods

Article	Profile	Colour	kg
Welding accessories PE			
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
128.726 HDPE welding rod	D	Black	2
Welding accessories PP			
104.287 PP welding rod	A	Light Green	3
104.301 PP welding rod	A	Black	3
104.288 PP welding rod	B	Light Green	5
126.356 PP welding band	C	White	2
128.725 PP welding rod	D	Light Green	2
Welding accessories PVC			
104.296 PVC-U welding rod (hard)	A	White	3
104.278 PVC-U welding rod (hard)	A	Grey	3
106.641 PVC-U welding rod	A	Brown	3
104.280 PVC-U welding rod (hard)	B	Brown	5
104.279 PVC-U welding rod (hard)	B	Grey	5
104.302 PVC-P welding rod (soft)	A	White	3
Welding accessories ABS			
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
Welding accessories div.			
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
106.642 PPs welding rod, flame resistant	A	Grey	3
104.304 PVDF welding rod	A	White	3
104.303 POM welding rod	A	White	3
Test bundles			
107.036	Test bundle bodywork welding rods, each consisting of profile A pieces of 37 cm single marked 6x HDPE, 6x PP, 6x PA, 6x PC, 6x ABS, 6x PCABS / ALPHA Honda, 6x PC / PBTP / Xenoy		
107.037	Test bundles standard each consisting of profile A pieces of 37 cm single marked 5x PVC-U, 5x PVC-P, 5x PP, 5x ABS, 5x HDPE, 3x PC, 3x PA, 3x POM, 3x LDPE, 3x PC / ABS / ALPHA Honda, 3x PC / PBTP / Xenoy		
107.040	Test bundle welding band each consisting of profile A pieces of 37 cm single marked 9x HDPE, 8x 2 mm white, 9x PP, 8x 2 mm natural, 9x ABS, 8x 2 mm white, 9x PC / PBTP / Xenoy grey		

Profile sizes

Dimensions in mm

Profile A	Profile B	Profile C	Profile D





Aldi logistics center 50000m2 TPO Membrane, Switzerland



Exploration Place First, Wichita, USA



Schöni transport Centre, Switzerland



Roofing

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Hot Air Tools for Roofing

TRIAC ST	12 – 15
TRIAC AT	13 – 15
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General accessories	34








Simple operation in combination with high welding performance.



Flameless welding of modified bitumen with the BITUMAT. B2.

Overview Roofing Welders

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

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

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

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

Hot-air welder

UNIROOF AT/ST

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, 230 V/3450 W, 30 mm with Euro-plug

Hot-air welder

UNIROOF ST



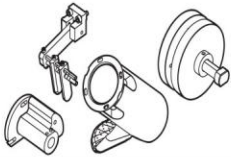
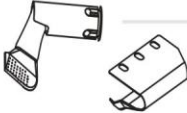

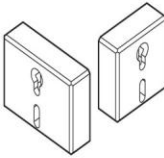
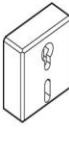
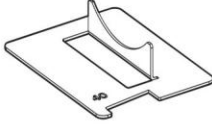

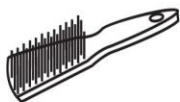
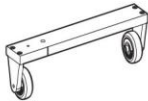
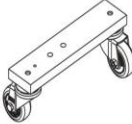


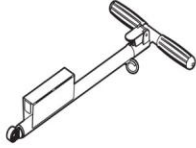
- No retooling, thanks to movable transportation axle
- Maintenance-free direct drive and open-loop technology
- Ergonomic handling, flexible relocating and optimal machine guiding
- 38% higher welding performance compared to similar machines
- Welding roof structure profiles


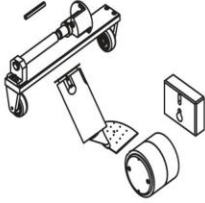

Technical Data		UNIROOF ST
Voltage	V~	100 / 220 – 240
Frequenz	Hz	50/60
Power	W	1500 / 3450
Temperature, stepless	°C	100 – 620
Air flow range	%	45 – 100
Drive speed, stepless	m/min	1.0 – 10.0
Size (L × B × H)	mm	475 × 244 × 260
Weight	kg	17.5 (incl. 3 additional weights)
Materials		PP, PVC, TPO, ECB, EPDM, EVA, FPO, PO, PIB (other materials upon request)
Conformity mark		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, 230 V / 3450 W, 30 mm with Euro-plug
 153.601 UNIROOF ST, 120 V/1800 W, 40 mm (1.6 inch), with US-plug

Accessories UNIROOF AT/ST

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

	108.129 T-shape guide bar upper part
	156.446 UNIROOF AT/ST 80 mm bitumen kit
	155.473 Heating element 230 V / 3300 W 153.947 Heating element 120 V / 1800 W 154.231 Heating element 100 V / 1500 W 145.604 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

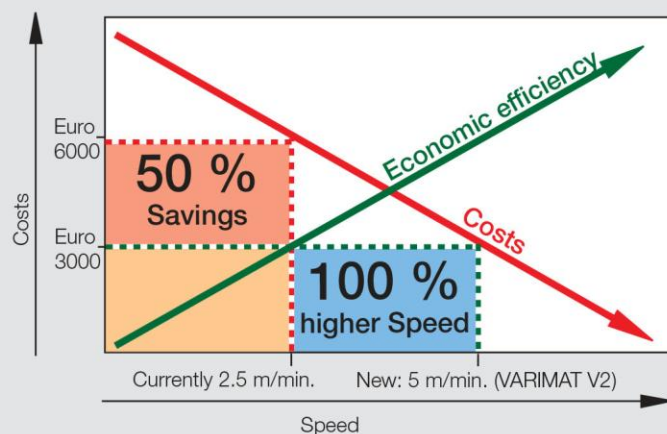
Voltage	V~	230 / 400
Power	W	3680 / 5700
Temperature	°C	100 – 600
Speed	m/min	0.7 – 12
Air flow range	%	50 – 100
Width of welding nozzle	mm	40
Size (L x W x H)	mm	640 x 430 x 330
Weight	kg	35
Conformity mark	CE	
Protection class I	⊕	

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


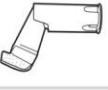


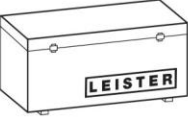

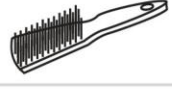
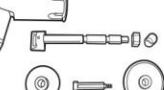



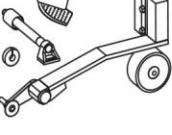
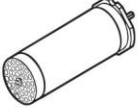



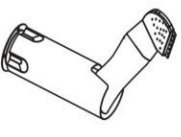

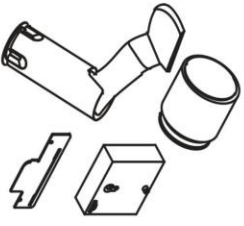
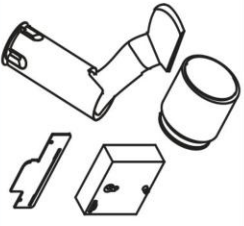
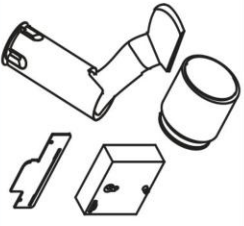
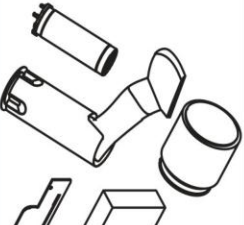
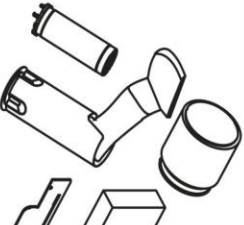
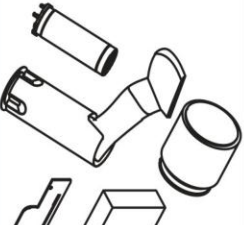
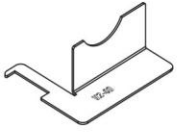


Welded with standard nozzle.



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

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

	143.179 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.
	116.323 Rake nozzle, 40 mm
	143.163 Pressure roller, soft, 40 mm (silicone only)
	108.923 Welding unit bitumen-kit 80 mm, 230 V
	108.924 Welding unit bitumen-kit 100 mm, 230 V
	108.925 Welding unit bitumen-kit 120 mm, 230 V
	108.927 Welding unit bitumen-kit 100 mm, 400 V / 6100 W
	108.928 Welding unit bitumen-kit 120 mm, 400 V / 6100 W
	115.892 Welding unit bitumen-kit 80 mm, 400 V / 6100 W
	159.408 Nozzle positioning gauge VARIMAT V2



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

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

Semi-automatic hot-air tool

TRIAC DRIVE AT



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

Technical data

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

Article No.:

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

Accessories TRIAC DRIVE AT

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

BITUMAT B2: The flameless.

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



Easy unit guidance and clean working with the BITUMAT B2.

Hot-air welder

BITUMAT B2



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




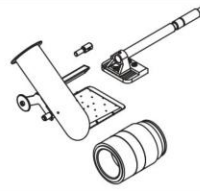


Technical data

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

Article No.:

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

Accessories BITUMAT B2

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

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



EXAMO USB: The inspector.

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



Testing a weld seam with the EXAMO USB.

Testing instrument EXAMO USB



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

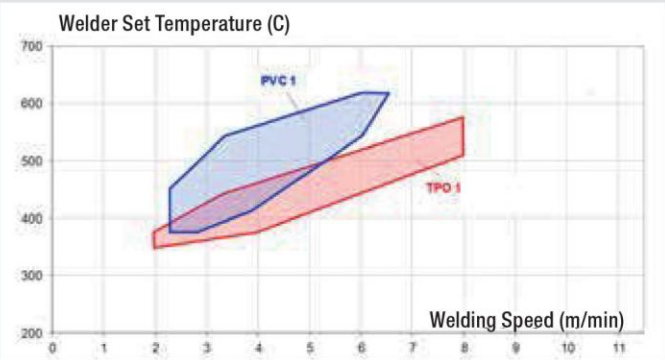
Technical Data			
Type		300F	600F
Voltage	V~	230	230
Power	W	200	200
Tensile load	N	4000	4000
Jaw spacing	mm	5 – 300	5 – 600
Range	mm	300	600
Test speed	mm/min	10 – 300	10 – 300
Sample thickness	mm	max. 7	max. 7
Sample width	mm	max. 40 (60 optional)	max. 40 (60 optional)
Size (L x W x H)	mm	750 x 270 x 190 (storage case)	1050 x 270 x 190 (storage case)
Weight	kg	14	17.5
Conformity mark		CE	CE
Approval mark		§	§
Protection class I		⊕	⊕

Article No.:	
139.059	EXAMO 300F USB, 230 V / 200 W, incl. USB memory stick, Euro plug
139.060	EXAMO 600F USB, 230 V / 200 W, incl. USB memory stick, Euro plug

Accessory EXAMO USB

	134.832 Testing and calibration kit To test and calibrate your EXAMO USB

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



Typical welding windows for TPO and PVC



For testing T-joints

Article No.:	
153.026	VACUUM BELL Ø 320 mm
153.024	VACUUM PUMP 230V
153.025	VACUUM PUMP 120V





Truck cover



Awning



Flood protection

Technical Textiles & Industrial Fabrics

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Applications



Tents






Billboard










Inflatables (picture © Marek Uliasz | Dreamstime.com)

Stationary welding machine

		
Device type	HEMTEK ST	SEAMTEK 900 AT
Max. voltage V~	120 / 230	230 / 240
Max. power W	1800 / 2350 / 3450	4500
Temperature °C	100 - 650	120 - 700
Speed m/min	0.8 - 12	0.1 - 30
Welding width mm	20 / 30 / 40	8 - 64
Size (L x W x H) cm	433 x 350 x 600	150 x 70.2 x 150
Weight kg	27	268
Welding options		
Overlap welding	✓	✓
Hem welding	✓	✓
Piping welding	✓	✓
Tape welding	✓	✓
Prayer weld		✓
Hem pipe	✓	✓
Butt joint with tape		✓
Welding technologies		
Hot-air welding	✓	✓
Hot-wedge welding		
Features		
Temperature regulation		✓
Drive regulation		✓
Temperature and drive infinitely adjustable	✓	✓
Digital display		✓
Catalog page	 52 / 53	54 - 56

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

						
Device type	VARIANT T1 Overlap	VARIANT T1 TAPE 50 mm	VARIANT T1 TAPE 25 mm	UNIPLAN E / S	TAPEMAT 50 mm	TAPEMAT SPRIEGEL 100 / 125 mm
Max. voltage V~	230 / 400	230 / 400	230 / 400	230	3 × 400	3 × 400
Max. power W	3680 / 5700	3680 / 5700	3680 / 5700	2300	10 000	10 000
Temperature °C	100 – 620	100 – 620	100 – 620	80 – 620	100 – 650	100 – 650
Speed m/min	1.5 – 18	1.5 – 18	1.5 – 18	1.0 – 7.5	4.0 – 20	4.0 – 20
Welding width mm	20 / 40	50	25	20 / 30	50	2 × 20
Size (L × W × H) mm	500 × 400 × 195	700 × 415 × 85	700 × 415 × 85	420 × 270 × 210	555 × 435 × 370	555 × 435 × 370
Weight kg	22.5	28.0	28.0	11.5	35.0	40.0
Conformity mark	CE	CE	CE	CE	CE	CE
Certification scheme	CCA	CCA	CCA	CCA	CCA	CCA
Protection class	II	II	II	II	II	II
Welding options						
Overlap welding	✓			✓		
Hem welding	✓			✓		
Piping welding	✓			✓		
Tape welding		✓	✓		✓	✓
Prayer weld	✓	✓	✓	✓	✓	✓
Hem pipe	✓	✓	✓	✓	✓	✓
Welding technologies						
Hot-air welding	✓	✓	✓	✓	✓	✓
Hot-wedge welding						
Features						
Temperature regulation	✓	✓	✓	✓		
Drive regulation	✓	✓	✓	✓		
Temperature and drive infinitely adjustable	✓	✓	✓	✓	✓	✓
Digital display	✓	✓	✓	✓		
Catalog page	 57 / 58	59	59	60	61	61

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	220 – 240 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		
Width of nozzle	mm	20/30/40	30/40	20
Emission	L _{pA} (dB)	70 (K = 3 dB)		
Size (L × W × H)	mm	433 × 350 × 600		
Weight	kg	27 (Including table mount)		
Conformity mark		CE	CE	CE
Protection class I		⊕	⊕	⊕




Included with purchase:

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

Article No.:

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

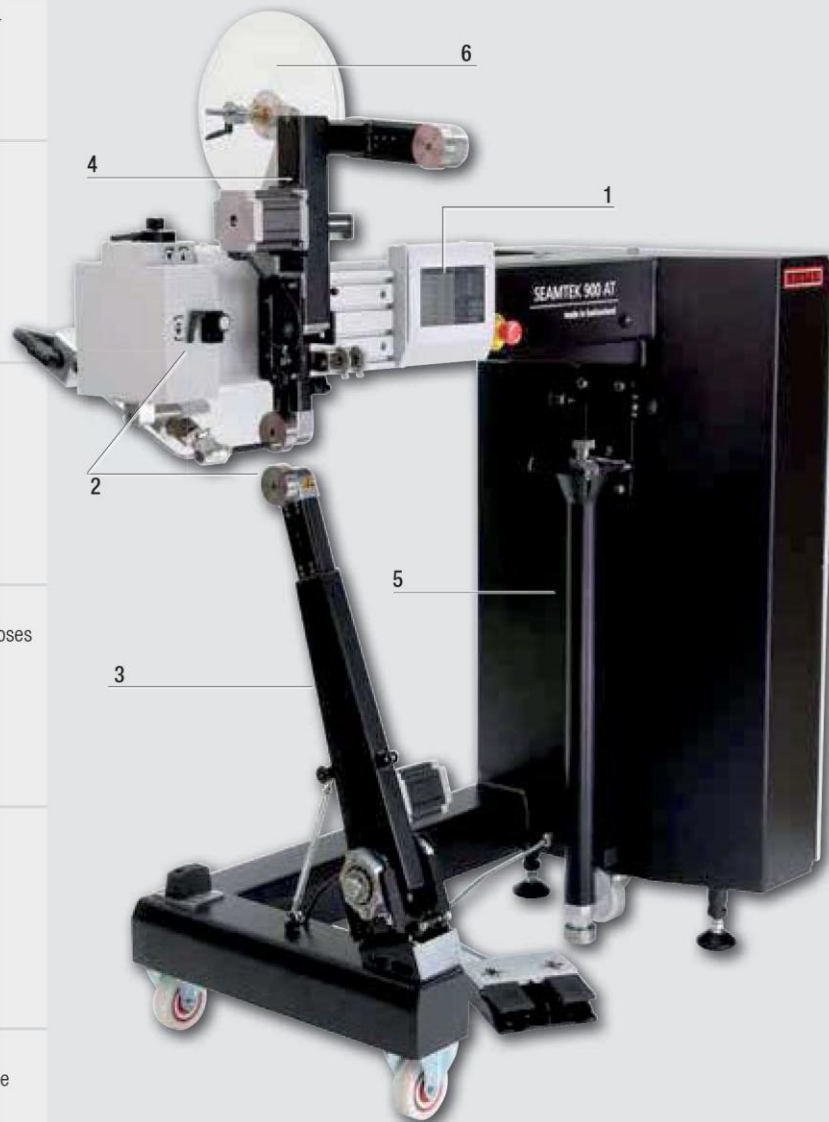
Accessories HEMTEK ST

	157.048 157.047 108.117	Pressure roller, top 20 mm 30 mm 40 mm
	157.070 157.071 153.641	Pressure roller, bottom 20 mm 30 mm 40 mm
	157.707 157.706 157.705	Nozzle 20 mm 30 mm 40 mm
	157.098	Nozzle adjustment gauge
	156.472	Adjustable hemming/piping guide
	157.879	Adjustable hemming/piping guide for heavy materials
	155.800	Overlap guide
	159.780	Tape welding guide
	160.269	Contact pressure weight large
	153.947 149.675 155.473	Heating elements 120 V/1800 W (20/30/40 mm) 230 V/2200 W (20 mm) 230 V/3300 W (30/40 mm)
	157.540	Rubber stoppers
	116.798	Brass brush

SEAMTEK 900 AT: New Generation

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

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

Accessories SEAMTEK 900 AT

	Wheel, Steel, Ø 63.5 mm
	155.392 8 mm
	155.393 13 mm
	155.863 19 mm
	154.593 25 mm
	155.864 38 mm
	155.394 50 mm
	Wheel, Silicone, 50A, Ø 63.5 mm
	155.401 13 mm
	155.402 19 mm
	155.403 25 mm
	155.404 38 mm
	155.405 50 mm
	155.406 57 mm
	155.407 64 mm

Technical data

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


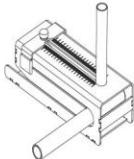
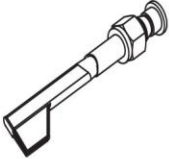




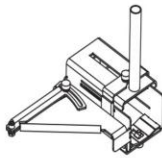

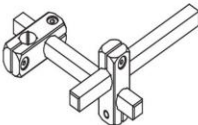
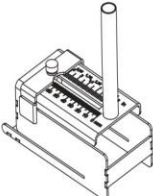
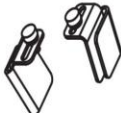

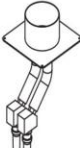
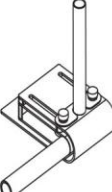
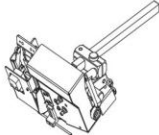
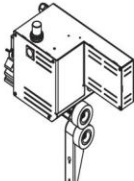
Article No.:

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



Example: Seam sealing for Outdoor Equipment.

Accessories SEAMTEK 900 AT

	<p>SEAMTEK Nozzle</p> <p>157.808 8 mm (Low Flow)</p> <p>157.799 13 mm (Low Flow)</p> <p>151.598 13 mm</p> <p>151.601 19 mm</p> <p>151.597 25 mm</p> <p>151.608 38 mm</p> <p>151.599 50 mm</p> <p>151.850 55 mm</p> <p>151.600 64 mm</p>		<p>155.380 Open Hem/Pocket Guide up to 110 mm</p>
	<p>152.941 Closing nozzle with angle</p>		<p>155.540 Modular 3D guide</p>
	<p>152.956 Hem nozzle</p>		<p>156.760 Overlap guide from the left</p>
	<p>153.730 Taping Nozzle 25 mm</p>		<p>156.770 Adjustable acrylic tape guide</p>
	<p>152.931 Adjustable taping nozzle 50 mm</p>		<p>155.400 Holder system for guides</p>
	<p>155.660 Adjustable overlap guide, 0 - 64 mm</p>		<p>156.780 Overlap guide for quick arm</p>
	<p>155.530 Adjustable hem-/ piping guide 0 - 50 mm</p>		<p>155.410 Connection adapter for fume extraction</p>
	<p>155.760 Adjustable hem-/ piping guide 0-60 mm, for heavy materials</p>		<p>158.789 Tape cutting unit 18 - 25 mm</p>
			<p>158.928 Puller unit</p>

VARIANT T1: Quality, productivity, ergonomic.

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



VARIANT T1 TAPE 50 mm

VARIANT T1

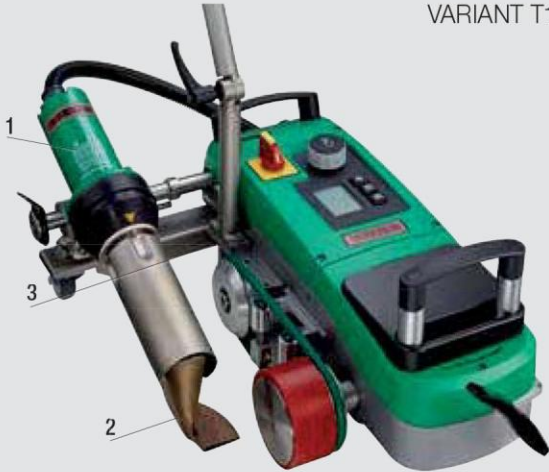
1		Economical: Up to 18 m/min welding speed and powerful, maintenance-free hot air blower.
2		Reliable: Constant, wrinkle-free welds thanks to process-optimised nozzle.
3		Hem- / piping welding kit: Welding hems, hem pockets and piping in short time with easy-to-use accessories.

Technical Textiles and Industrial Fabrics

VARIANT T1 TAPE

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

VARIANT T1



VARIANT T1: Compact, fast and reliable.

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



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

Hot-air welder

VARIANT T1 Overlap



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

Technical data

Voltage	V~	230 / 400 (3LNPE)
Power	W	3680 / 5700
Temperature	°C	100 – 620
Speed	m/min	1.5 – 18
Air flow range	%	40 – 100
Welding seam width	mm	20 or 40
Size (L x W x H)	mm	500 x 400 x 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

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

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

UNIPLAN: Just perfect.

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



The handy partner for precise welding: UNIPLAN E.

Hot-air welder

UNIPLAN E / UNIPLAN S



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

Technical data

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

Article No.:

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

Additional versions available upon request.

Accessories UNIPLAN E / UNIPLAN S

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

TAPEMAT: The power pack.

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



Welding tape at maximum speed.

Tape hot-air welder TAPEMAT



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

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






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

Spriegel hot-air welder TAPEMAT SPIEGEL



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

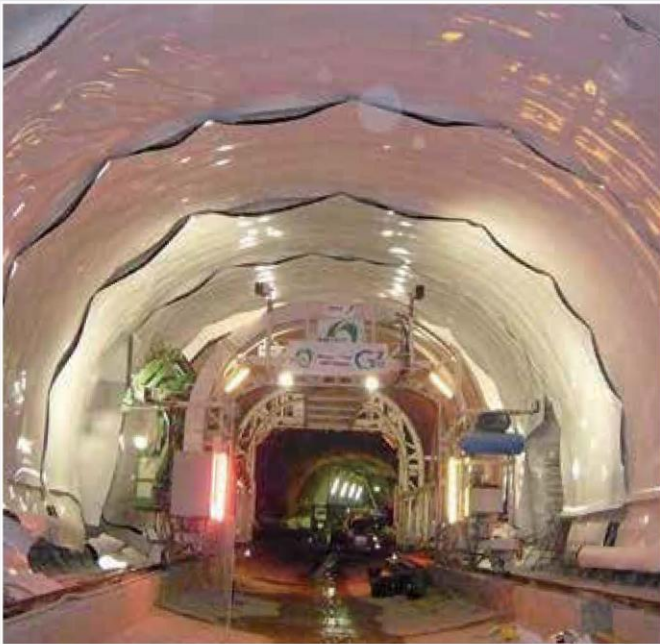
Accessories TAPEMAT / TAPEMAT SPIEGEL

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





Shrimp Farm HDPE 0.5 mm



Tunnel PVC 2.5 mm



Water Reservoir HDPE 2.0 mm



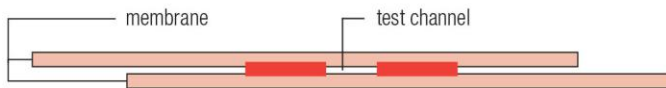
Civil Engineering / Tunneling / Landfills

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Double tap seam with test channel



Double tap seam without test channel



Product overview wedge welders for Civil Engineering / Tunnelling / Landfills

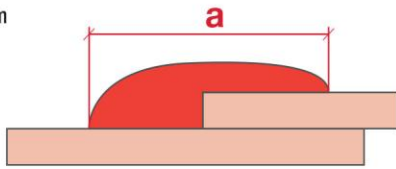
						
Device type	GEOSTAR G5	GEOSTAR G7	COMET / COMET USB	TWINNY T / TWINNY T USB	TWINNY S	TRIAC DRIVE AT
Voltage V~	120 / 230	230	120 / 230	230	120 / 230	230
Max. Power W	1800 / 2800	2800	1800 / 1500 / 1200	2300	1900 / 2900	1700
Temperature °C	80 – 460	80 – 460	80 – 420	80 – 560	80 – 600	80 – 650
Speed m/min	0.8 – 12	0.8 – 12	0.8 – 3.2	0.8 – 3.2	0.2 – 2.5 (4.0/6.0')	0.5 – 3.0
Max. Welding pressure N	1500	1500	1000	1000	1000 (500)	n.a.
Weld seam width mm	2 x 15	2 x 15	2 x 15	2 x 15	2 x 15	30
Material thickness mm	0.8 - 3.0	1.0 - 3.0	0.5 – 3.0	0.5 – 3.0	0.5 – 3.0	0.5 – 3.0
Max. overlap mm	150	150	125	125	125	
Data recording	- / ✓	- / ✓	- / ✓	- / ✓		
Digital display	✓	✓	✓	✓		✓
Size (L x W x H) mm	482 x 278 x 269	482 x 278 x 269	295 x 250 x 245	340 x 360 x 245	350 x 390 x 270	300 x 230 x 380
Weight kg	16.4	17.7	7.5	6.9 – 7.9	6.5 – 6.9	4.1
Conformity mark	CE	CE	CE	CE	CE	CE
Protection class	⚡	⚡	⚡	⚡	⚡	⚡
Welding technologies						
Hot-wedge welding	✓	✓	✓			
Combi-wedge welding				✓	✓	(✓)
Applications						
HDPE, LDPE, TPO, FPO, PP	0.8 - 3.0 mm	1.0 - 3.0 mm	0.5 - 2.5 mm	0.5 - 2.5 mm	0.5 - 2.5 mm	0.5 - 2.0 mm
PVC, CSPE, EIA	0.8 - 3.0 mm *(steel wedge only)	-	0.5 - 3.0 mm *(steel wedge only)	0.5 - 3.0 mm	0.5 - 3.0 mm	0.5 - 3.0 mm
Catalog page	 66 / 69	66 / 69	70 / 71	72 / 73	73	75

¹ For details, see page 73

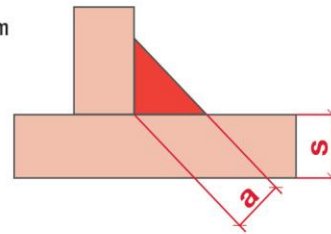
Attention these are Leister recommendations only, depending upon material specifications the possible min. thicknesses may vary.
For more information please contact your Leister Distributor.

* 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	 76	77	78	79 / 80	79 / 80

✓✓ very suitable ✓ suitable

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

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

Overview of Extrusion Welders Output (kg/hr)


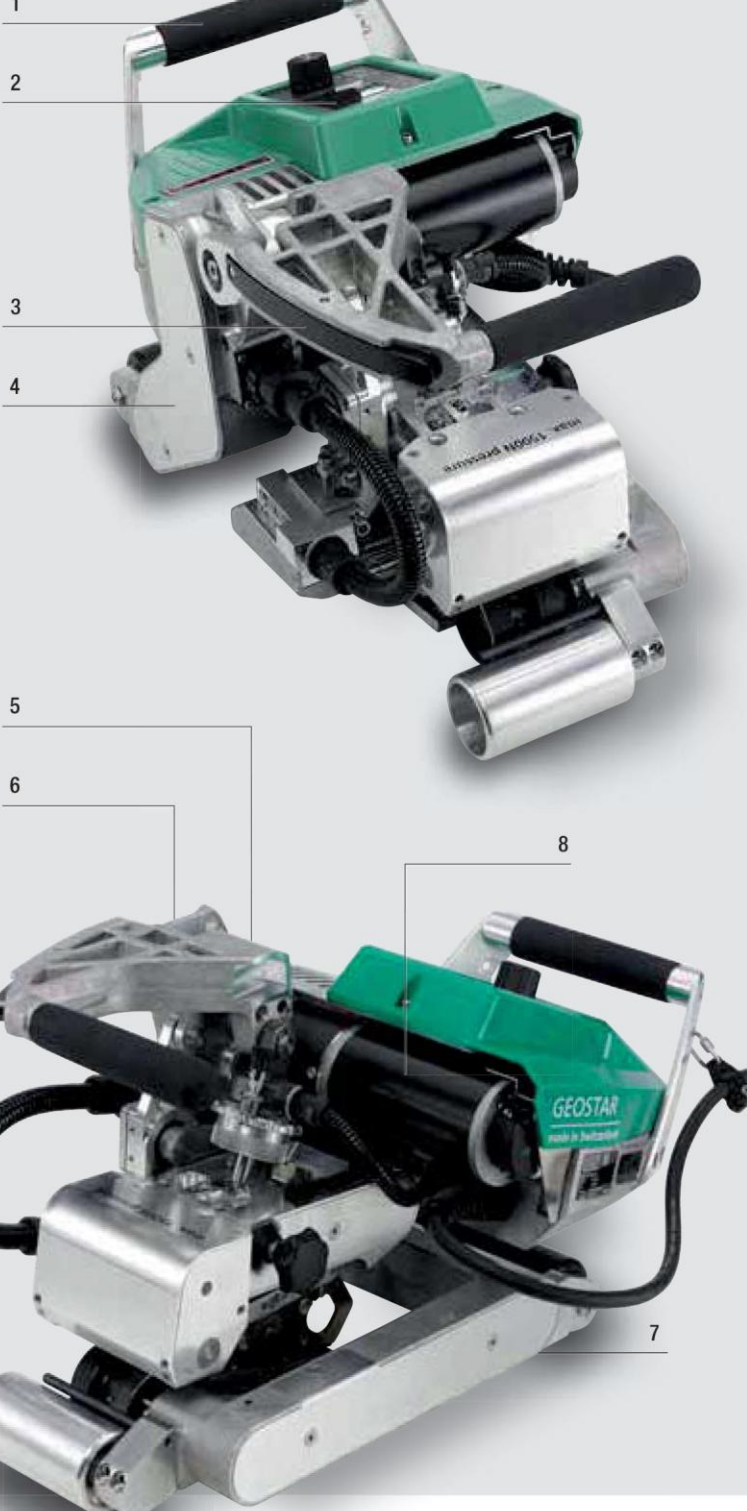









GEOSTAR G5 and GEOSTAR G7 – Faster, lighter, smarter

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

Wedge welders

GEOSTAR G5/G7

1		Maintenance friendly: The well-thought-out construction enables easy access to mechanical parts for cleaning or service.	
2		eDrive: Integrated display of weld pressure, travel speed, wedge temperature and supply voltage enables constant monitoring of key weld parameters during the work process.	
3		Ergonomic: The newly developed clamping mechanism enables simple, one-hand operation to engage rollers and begin welding.	
4		Shifting gears: The GEOSTAR is equipped with a two-gear transmission that can be modified in accordance with work conditions in just a few steps.	
5		Weld pressure measurement: Constant measurement and display of weld pressure.	
6		Spacious: Plenty of room for easy loading of material into the machine to accelerate the start of the welding process.	
7		The new wedge geometry: The new geometry supports the natural flow of geomembranes over the wedge. An intelligent interface makes it possible to replace the wedge in less than one minute!	
8		Powerful Drive motor: G7 supplies up to 100% more power than the G5	



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

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

Wedge welders

GEOSTAR G5/G7

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

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

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

*2: Requires steel wedge

Article No.

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

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

Accessories GEOSTAR G5/G7

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

For further accessories see www.leister.com/geostar



GEOSTAR G5 / G7 LQS – Leister Quality System

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

Article No.:

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



GPS



GEOSTAR G5 / G7



Pinpoint precision

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



GEOSTAR G7 / G5 LQS

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



Wireless data transfer

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



GEOSTAR G5 in field operation.



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



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

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



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

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

COMET / COMET USB: The highflyers.

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

Wedge welder

COMET



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

Technical Data

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

Article No.

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

* with test channel, EURO plug

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

Wedge welder

COMET USB



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

Technical Data

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

Article No.

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

* with test channel, EURO plug

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






Comet operating in the tunnel ...



... or on a landfill site.

Accessories COMET / COMET USB

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



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

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

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

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

Combi-wedge welder

TWINNY T



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

Technical Data

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

Article No.

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

Combi-wedge welder

TWINNY T USB



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

Technical Data

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

Article No.

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

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

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

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

TWINNY S: Perfect weight.

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



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

Combi-wedge welder

TWINNY S



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



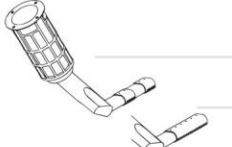
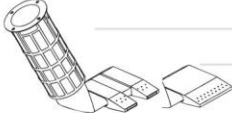



Technical Data

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

Article No.

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

Accessories TWINNY T / T USB / TWINNY S

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

See COMET for roles.

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



TRIAC DRIVE AT: The little all-rounder

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



The perfect choice for welding joint sealing tape.

Semiautomatic hot-air welder

TRIAC DRIVE AT



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







Technical Data

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

Article No.

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

Accessories TRIAC DRIVE AT

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

WELDPLAST S6: The workhorse.

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



WELDPLAST S6, Gold Mine Mexico.

Digitally regulated extrusion welder

WELDPLAST S6



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

Technical Data

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

Article No.

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

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

Accessories WELDPLAST S6

	146.239	Welding shoe complete
	146.240	54 × 40 × 52 mm blank welding shoe
	146.241	74 × 50 × 58 mm blank welding shoe
	146.241	25 mm overlap
	146.242	35 mm overlap
	145.899	40 mm overlap
	146.245	20 mm V-seam
	146.246	25 mm V-seam
	146.247	30 mm V-seam
	146.232	20 mm fillet weld seam (a = 14 mm*)
	146.233	25 mm fillet weld seam (a = 17.5 mm*)
	146.234	30 mm fillet weld seam (a = 21 mm*)
	146.230	Corner seam Ø 14 mm
	146.218	Corner seam Ø 20 mm
	144.905	45° angled adapter
	145.705	90° angled adapter
Caution: You must use welding shoes with an integrated air guide for this.		
	117.055	35 mm preheat nozzle, large
	136.859	50 mm preheat nozzle, XL large
	117.790	Side hot-air guide (Position 9h/3h)
	116.367	Ultra strong storage case WELDPLAST S6 (included with purchase)
	149.744	Insulation sleeve

* a = welding seam thickness

WELDPLAST S4

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



The powerful WELDPLAST S4 at work.

Digitally regulated extrusion welder

WELDPLAST S4



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

Technical Data

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

Article No.

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

Accessories WELDPLAST S4

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

* a = welding seam thickness

WELDPLAST S2: The masterpiece.

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



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

Digitally regulated extrusion welder

WELDPLAST S2 / S2 TPO



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





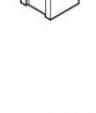















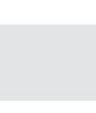




Technical Data

Voltage	V~	230
Power	W	3000
Material standard version		PE /PP
Welding rod	mm	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

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

* a = welding seam thickness

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, blank welding shoe, 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

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

General accessories

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

FUSION 3C with heat blanket.



EXAMO: The inspector.

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



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

Tensiometer

EXAMO 300F USB, 600F USB



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

Technical Data

Type		300F USB	600F USB
Voltage	V~	230	230
Power	W	200	200
Tensile load	N	4000	4000
Jaw spacing	mm	5 – 300	5 – 600
Range	mm	300	600
Test speed	mm/min	10 – 550	10 – 550
Sample thickness	mm	max. 7	max. 7
Sample width	mm	max. 40 (60 optional)	max. 40 (60 optional)
Size (L × W × H)	mm	750 × 270 × 190 (case)	1050 × 270 × 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
	145.813 143.824	COUPON CUTTER 20 × 150 mm Spare blade 150 × 20 mm
	146.449 146.468	COUPON CUTTER (25 × 150 mm) Spare blade 150 × 25 mm
	143.828	Cutting plate
	137.855	Leister cutter with four spare blades
	138.902	Hooked blade for LEISTER-cutter (10 dispenser with 10 pcs=100 pcs)
	138.539	Straight-edge blade for LEISTER-cutter (10 dispenser with 10 pcs = 100 pcs)

VACUUM PUMP / VACUUM BOX: Fast and reliable.

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

Testing instruments

VACUUM BELL



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

Testing instruments

VACUUM BOX



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

Testing instruments

VACUUM PUMP



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

Article No.:

153.026 VACUUM BELL Ø 320 mm

152.981 VACUUM BOX 830 x 320 x 150 mm

153.024 VACUUM PUMP 230V

153.025 VACUUM PUMP 120V

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

Compressed air testing device.

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



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

Testing instrument Compressed air testing device with thin testing needle



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



Manometer standard
(bar/psi)

Article No.:
142.475 Flexible injection needle with manometer

Accessories



142.569 Flexible spare needle
(fits also to 150.720)

Testing instrument Compressed air testing device with thick testing needle



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



Manometer ASTM
(psi/kPa)

Article No.:
150.720 Tapered injection needle with manometer (standard)
158.374 Tapered injection needle with manometer PSI (ASTM)

Accessories



150.142 Tapered Spare needle
(fits also to 142.475)





Air purification system, Spain. Material: HD-PE



The Wave House, San Diego. Material: PVC



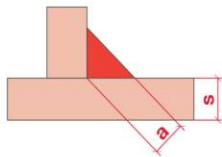
Electroplating tank, Turkey. Material: PP

Plastic Fabrication

Overview of hand extruders	86
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Hot-Air Hand Tools

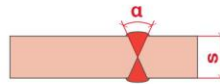
TRIAC ST	12 – 15
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Fillet welding seam

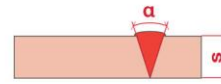


Corner outside seam



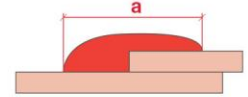
X-seam

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

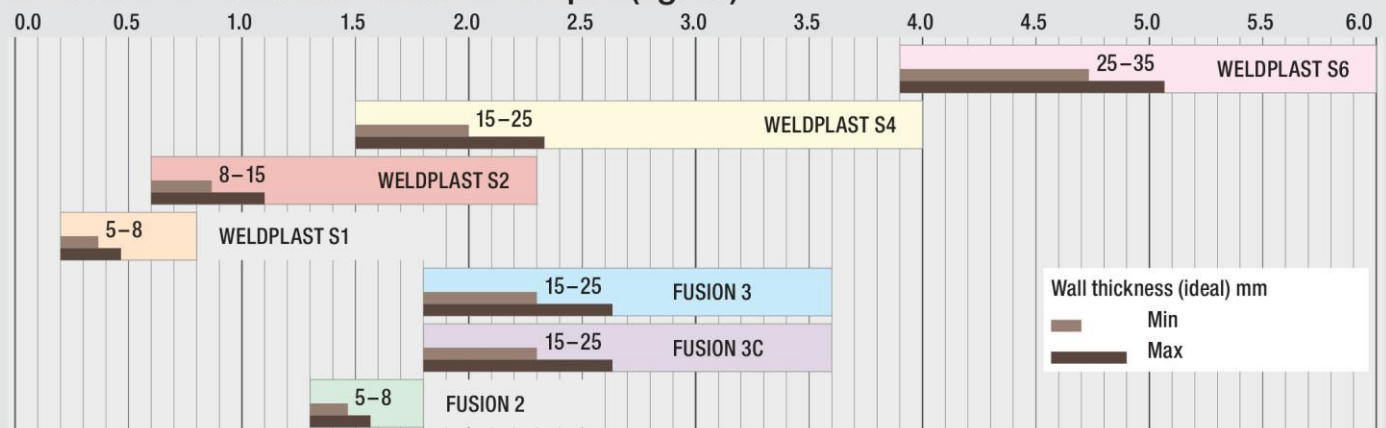
	Digitally regulated extrusion welders				Air heated extrusion welders		
							
Device type	WELDPLAST S6	WELDPLAST S4	WELDPLAST S2	WELDPLAST S1	FUSION 3	FUSION 3C	FUSION 2
Output (HDPE) kg/hr	3.9 – 6	1.5 – 4	0.6 – 2.3	0.2 – 0.8	1.8 – 3.6	1.8 – 3.6	1.3 – 1.8
Material	HD-PE, PP	HD-PE, PP	HD-PE, PP, PVC	PE, PP, PVC, etc.	HD-PE, PP	HD-PE, PP	HD-PE, PP
Wall thickness mm	15 – 40	8 – 35	4 – 20	4 – 10	8 – 25	8 – 25	6 – 15
Welding rod Ø mm	4 – 5	3 – 4 / 4 – 5	3 – 4	3 – 4	3 – 4 / 4 – 5	3 – 4 / 4 – 5	4
Weight kg	14	8.7	5.8	4.7	7.2	6.9	5.9
Length mm	821	560	450	435	690	588	450
Voltage V~	230	230	230	230 / 120	230	230	230
Screw extruder	yes	yes	yes	yes	yes	yes	yes
Container construction	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓
Pipeline construction	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓
Landfills / civil engineering	✓✓	✓✓	✓	○	✓✓	✓	○
Brushless blower	yes	yes	yes	yes	no	no	no
Remarks	1	1	1	1	2	2	2
Catalog page	 89	90	91 / 92	87 / 88	93 / 94	93 / 94	95

✓✓ very suitable ✓ suitable ○ unsuitable

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

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

Overview of Extrusion Welders Output (kg/hr)




WELDPLAST S1: Outstandingly compact.

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

Digitally regulated extrusion welder


WELDPLAST S1

1




Full control:
The multifunctional operating unit gives you perfect control over the welding parameters, ensures reproducible results, and guarantees more efficiency during work.

2




Smart features:
Thanks to the integrated hanging point, the WELDPLAST S1 can be hung on a balancer so that it is always ready at hand – preventing fatigue work.

3




Versatile:
The WELDPLAST S1 can work with all typical kinds of plastic, such as HD-PE, LD-PE, PP, PVC-U, PVC-C, ECTFE, PVDF or PA.

4




Bright spot:
The integrated LED operating lights provides you with a perfect view of the welding process.

5




More options:
Double-sided, twist-free wire intake for wires of 3 to 4 mm.

6

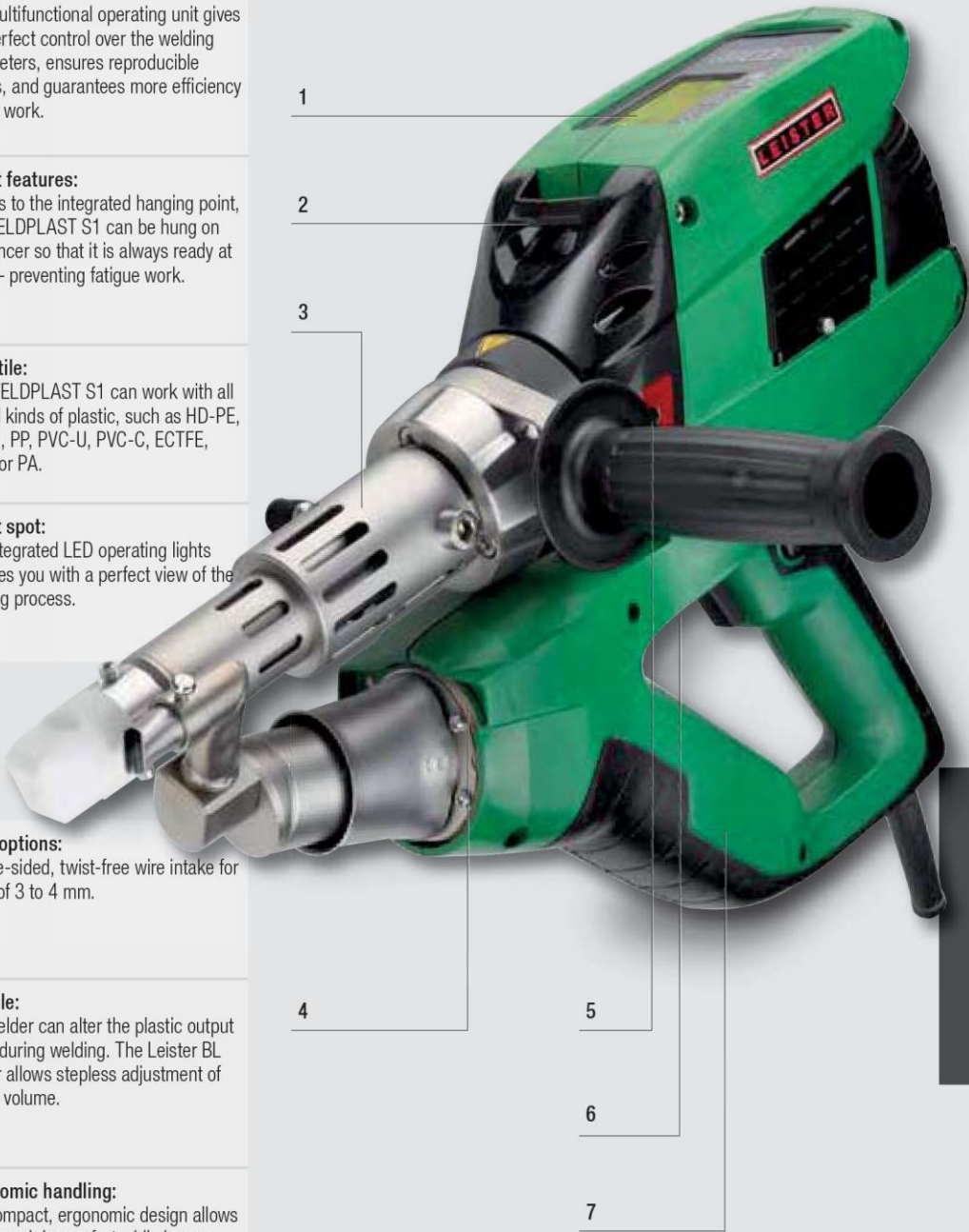


Flexible:
The welder can alter the plastic output easily during welding. The Leister BL blower allows stepless adjustment of the air volume.

7



Ergonomic handling:
The compact, ergonomic design allows you to work in comfort while in any welding position.



Plastic Fabrication



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

Digitally regulated extrusion welder

WELDPLAST S1



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

Technical Data


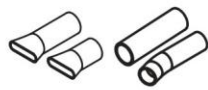
Voltage	V~	230 / 120 / 100
Power	W	1600 / 1800 / 1500
Material		HD-PE, LD-PE, PP, PVC-U PVC-C, PVDF, ECTFE, PA
Welding rod	mm	Ø 3 – 4
Output	kg/h	0.2 – 0.8 (PVC up to 1.15 kg/h)
Size (L × W × H)	mm	435 × 91 × 264
Integrated welding profiles		HD-PE, PP, PVC-U, PVC-C, PVDF 10 free profile storage spaces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

Article No.:

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

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

Accessories WELDPLAST S1

	149.430	Welding shoe complete Blank
	149.402	Fillet weld 5 / 6
	148.627	Fillet weld 8 / 10
	149.401	Fillet weld 12
	149.388	V-seam 3 / 4
	149.383	V-seam 5 / 6
	149.385	V-seam 8 / 10
	149.364	Corner For additional welding shoes, see Weldplast S2 PVC page 84
	152.720	Nozzle extension
	153.143	Angled adapter 45°
	153.236	Angled adapter 90°
	149.600	Top hot-air guide
	149.456	Hot-air tube, position 6h Ø 14 mm
	149.461	Hot-air tube, position 6h Ø 16 mm
	149.467	Hot-air tube, position 9h/3h Ø 14 mm (standard)
	149.469	Hot-air tube, position 9h/3h Ø 16 mm
	154.107	Air nozzle set Ø 14 mm (standard)
	154.106	Air nozzle set Ø 16 mm
	154.002	Insulation sleeve WELDPLAST S1/S2

General accessories



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





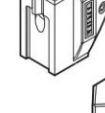









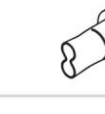






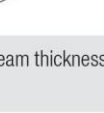
Voltage	V~	230
Power	W	4600
Material		PE / PP
Welding rod	mm	Ø 4 or Ø 5
Output	kg/h	3.9 – 6.0
Size (L x W x H)	mm	821 x 116 x 240
Weight	kg	14
Conformity mark		CE
Protection class I		⏚

Article No.:

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

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

Accessories WELDPLAST S6

Welding shoe complete	
	146.239 54 x 40 x 52 mm blank welding shoe
	146.240 74 x 50 x 58 mm blank welding shoe
	146.241 25 mm overlap
	146.242 35 mm overlap
	145.899 40 mm overlap
	146.245 20 mm V-seam
	146.246 25 mm V-seam
	146.247 30 mm V-seam
	146.232 20 mm fillet weld seam (a = 14 mm*)
	146.233 25 mm fillet weld seam (a = 17.5 mm*)
	146.234 30 mm fillet weld seam (a = 21 mm*)
	146.644 Corner outside seam 10 mm
	146.646 Corner outside seam 12 mm
	146.652 Corner outside seam 15 mm
	146.230 Corner seam Ø 14 mm
	146.218 Corner seam Ø 20 mm
	144.905 45° angled adapter
	145.705 90° angled adapter Caution: You must use welding shoes with an integrated air guide for this
	117.055 35 mm preheating nozzle, large
	136.859 50 mm preheat nozzle, XL Large
	117.790 Side hot-air guide
	149.744 Insulation sleeve WELDPLAST S6

*a = Welding seam thickness

General accessories



Procedures for welding floor coverings



Step 1:
Milling the groove
with the GROOVER.



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



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



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

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 × W × H)	mm	560 × 110 × 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

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

* a = Welding seam thickness

General accessories



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 WELDPLAST 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

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

Article No.:

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

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

Technical Data

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

Article No.:

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

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



The handy WELDPLAST S2 in action.



Even inside radiuses are easy to weld.

Accessories WELDPLAST S2

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

* a = Welding seam thickness



With the WELDPLAST S2 perfect welds are possible

Accessories WELDPLAST S2 PVC

	Welding shoe complete
	146.239 54 × 40 × 52 mm blank welding shoe 146.240 74 × 50 × 58 mm blank welding shoe
	146.241 25 mm overlap 146.242 35 mm overlap
	146.248 5 / 6 mm V-seam 146.249 8 / 10 mm V-seam 146.243 12 mm V-seam 146.244 15 mm V-seam
	146.235 5/6 mm fillet weld seam (a = 4.2 mm*) 146.236 8/10 mm fillet weld seam (a = 7 mm*) 146.231 15 mm fillet weld seam (a = 10 mm*)
	146.642 Corner outside seam 8 mm 146.644 Corner outside seam 10 mm 146.646 Corner outside seam 12 mm 146.652 Corner outside seam 15 mm
	146.230 Corner seam Ø 14 mm 146.218 Corner seam Ø 20 mm
	133.850 Top hot-air guide
	154.002 Insulation sleeve WELDPLAST S2

* a = Welding seam thickness



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

General accessories



FUSION 3: Long and slim.

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

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, blank welding shoe, storage case

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 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

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

* a = Welding seam thickness

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



FUSION 2: The small powerhouse.

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



In operation during container construction in China.

Air heated extrusion welder

FUSION 2



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

Technical Data

Voltage	V~	230 / 120
Power	W	2800
Material		PE / PP
Air temperature	°C	up to 340
Plastification temperature	°C	up to 300
Welding rod	mm	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

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

* a = Welding seam thickness

General accessories





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



The WELDPLAST S4 during outdoor use in Spain.

General accessories hand extruder

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






















	154.259	Contour scraper
	154.026	Scraper blade
	Heating element	
	134.567	230 V / 2600 W, WELDPLAST S6
	109.984	230 V / 2200 W, WELDPLAST S4 / S2 / S2 PVC
	113.268	230 V / 1100 + 1100 W, FUSION 3
	123.561	230 V / 1750 W, FUSION 2 / 3C
	149.265	230 V / 1000 W, WELDPLAST S1
	149.529	120 V / 1100 W, WELDPLAST S1
	149.530	100 V / 1050 W, WELDPLAST S1
	151.026	120 V / 1750 W, FUSION 2

PLASTFIX lends the weld seam the necessary holding pressure.



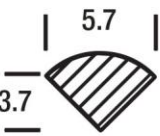
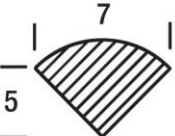
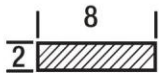














Welding rods

Article	Profile	Colour	kg
Welding accessories PE			
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
128.726 HDPE welding rod	D 	Black	2
Welding accessories PP			
104.287 PP welding rod	A 	Light Green	3
104.301 PP welding rod	A 	Black	3
104.288 PP welding rod	B 	Light Green	5
126.356 PP welding band	C 	White	2
128.725 PP welding rod	D 	Light Green	2
Welding accessories PVC			
104.296 PVC-U welding rod (hard)	A 	White	3
104.278 PVC-U welding rod (hard)	A 	Grey	3
106.641 PVC-U welding rod	A 	Dark Brown	3
104.280 PVC-U welding rod (hard)	B 	Dark Brown	5
104.279 PVC-U welding rod (hard)	B 	Grey	5
104.302 PVC-P welding rod (soft)	A 	White	3
Welding accessories ABS			
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

Dimensions in mm

Profile A	Profile B	Profile C	Profile D
			

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





Promotes the life of the floor.



For aseptic applications.








Suitable for frequent cleaning.

Flooring / Interior Decoration

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Hot-Air Hand Tools

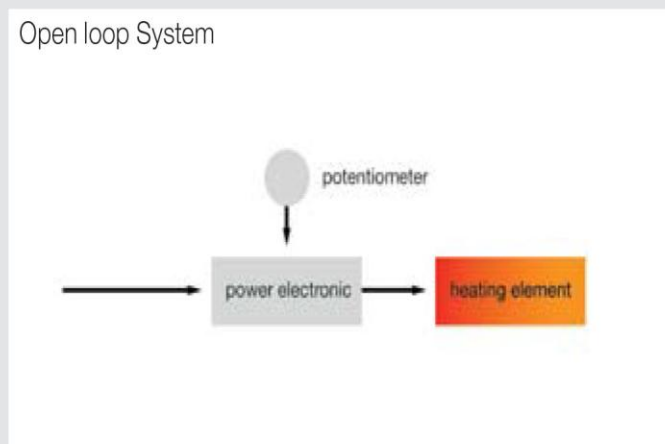
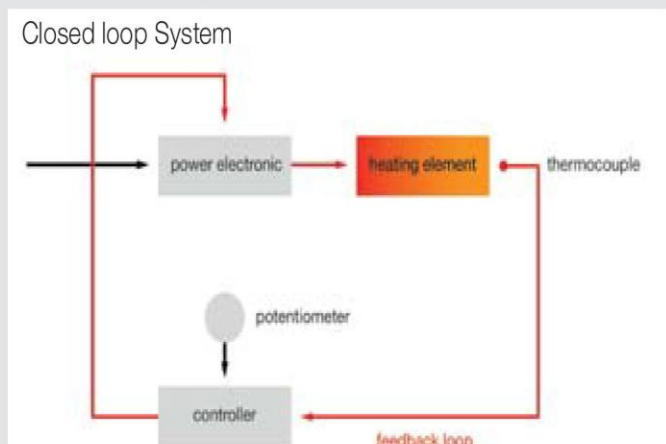
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Overview Flooring					
Typ		GROOVY	GROOVER	MINIFLOOR	UNIFLOOR
Area of application		Gouging tool for elastic floor coverings	Grooving machine for elastic floor coverings	Drive unit for welding elastic floor coverings	Welder for welding elastic floor 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 x 42 x 92	240 x 205 x 255	310 x 225 x 245 495 x 225 x 295	420 x 270 x 215
Cable length	m	-	3	3	3
Startup parameters*					
Materials			Linoleum (Phase 1) PVC, TPU, PU (Phase 2)	Linoleum PVC, TPU, PU	Linoleum PVC, TPU, PU
Speed	m/min	-	5 10	1.5 1.5	3 3
Temperature	°C	-	- -	400 - 450 500 - 550	400 - 450 500 - 550
Air flow range	%	-	- -	100% 100%	100% 100%
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*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.



Procedures for welding floor coverings



Step 1:
Milling the groove
with the GROOVER.



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



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



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

MINIFLOOR – efficient and affordable for everyone!

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

Hot-air welder

MINIFLOOR

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

UNIFLOOR E / S: A jack of all trades.

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



UNIFLOOR E, the reliable partner for welding floor coverings.

Hot-air welder

UNIFLOOR E / UNIFLOOR S


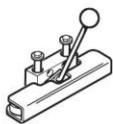






- Reproducible results thanks to permanent regulation of the NOMINAL and ACTUAL values
- Heater and drive electronically regulated
- Steplessly controlled air flow (only UNIFLOOR E)
- All floor coverings welded without reconfiguration
- Automatic start
- Integrated wall switch

Technical Data

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

Accessories UNIFLOOR E / UNIFLOOR S

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

Article No.:

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

GROOVER: Dust-free milling.

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



Strong drive suitable for PVC, PUR and linoleum materials.

Grooving machine

GROOVER



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

Accessories GROOVER

	102.401 Ø 110 × 3.5 mm, tungsten carbide-tipped blade, trapezium profile
	102.402 Ø 110 × 4 mm, tungsten carbide-tipped blade, round profile
	102.404 Ø 110 × 2.5 mm, tungsten carbide-tipped blade, round profile
	102.403 Ø 110 × 2.8 mm, tungsten carbide-tipped blade, round profile
	102.405 Ø 110 × 3.5 mm, tungsten carbide-tipped blade, round profile
	102.406 Ø 110 × 3.5 mm, diamond cutting blade, semi-round profile
	126.448 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		ISI
Protection class II		□

Article No.:

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

GROOVY: Lightweight and handy.

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

Gouging tool

GROOVY



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




Technical Data

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

Article number:

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

Accessories GROOVY

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

Ideal for surfaces that are small and difficult of access









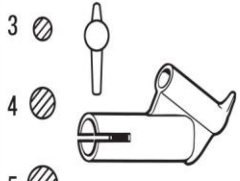
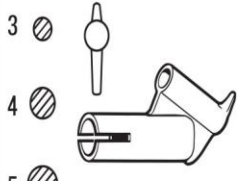
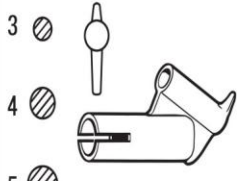
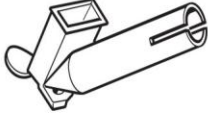
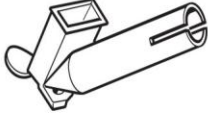
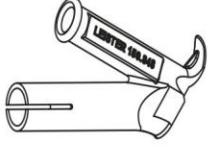


Executing clean grooves up to connecting walls



Precise and simple guidance thanks to integrated guide rollers



General accessories

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

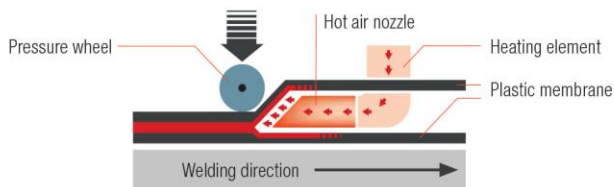
	148.933 Protective tube (ELECTRON)
	106.970 Pressure roller for welding rods Ø 4 – 5 mm
	106.971 Pressure roller for welding rods Ø 2 – 4 mm
	106.966 Hand grooving tool
	106.968 Spare blades for hand grooving tool
	150.809 Hand splice tool «Groovy» for flooring applications
	157.544 Leister Universal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

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

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

Know-how

Welding Methods

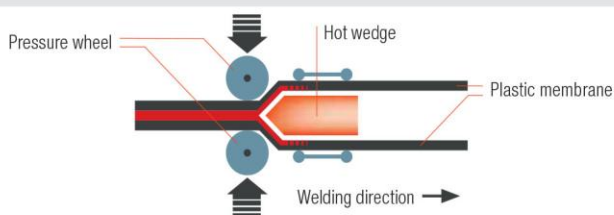


Hot-air welding

Hand tools, automatic welders, stationary welding machines



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

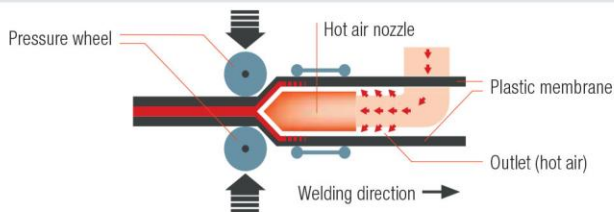


Hot-wedge welding

Wedge welders



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

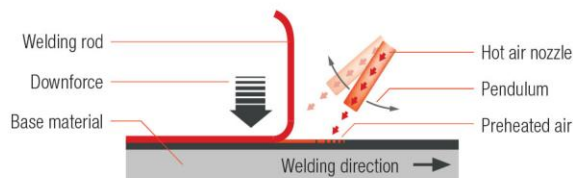


Combi-wedge welding

Combi-wedge welding machines



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

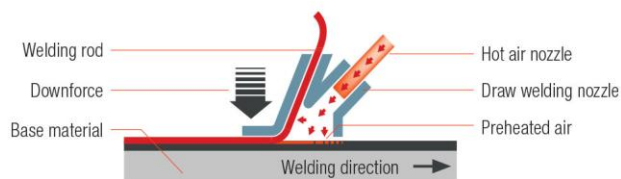


Pendulum Welding

Hand tools



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

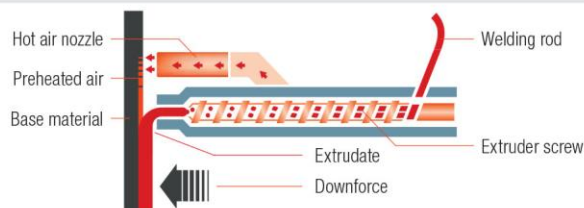


Draw Welding (Speed Welding)

Hand tools



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



Extrusion Welding

Extrusion Welders (FUSION & WELDPLAST)



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

Plastic welding with Leister

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

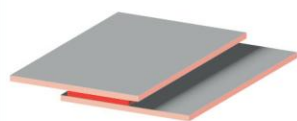
Know-how

Weld Types / Weld Geometries

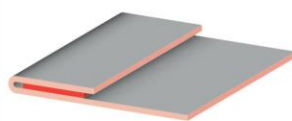
Welding without filler material

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

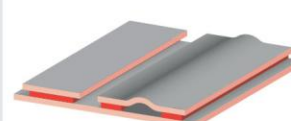
Overlap



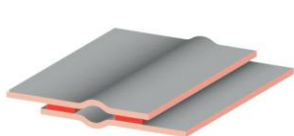
Hem



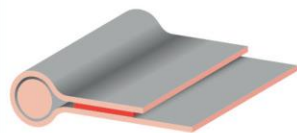
Tape



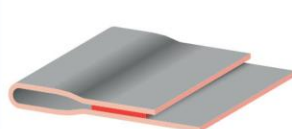
Double seam w/test channel



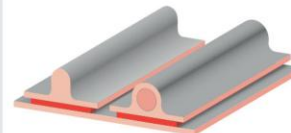
Keder / Piping



Pole pockets

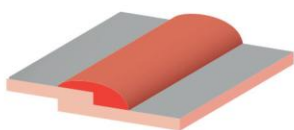


Antivandalism

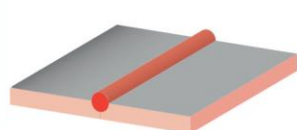


Welding with additional material

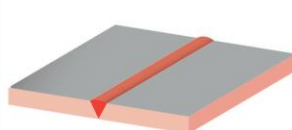
Overlap seam



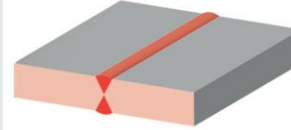
Floor seam



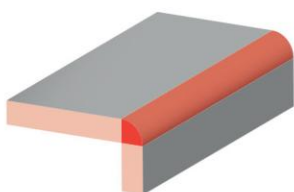
V-seam



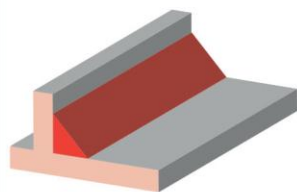
X-seam



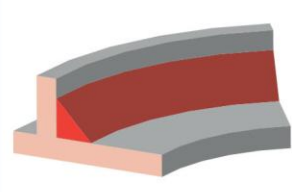
Outside corner seam



Fillet weld seam



Corner seam



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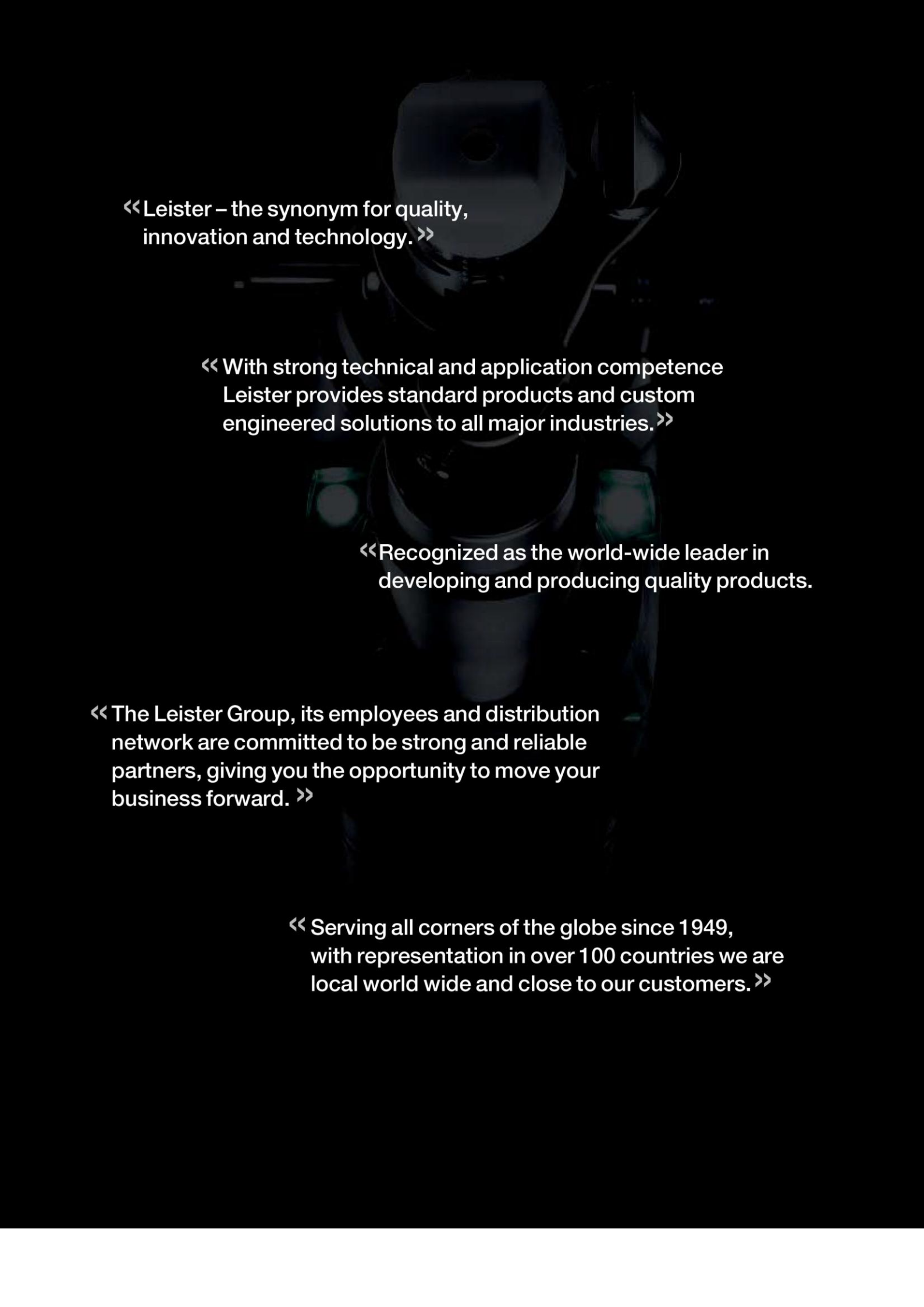
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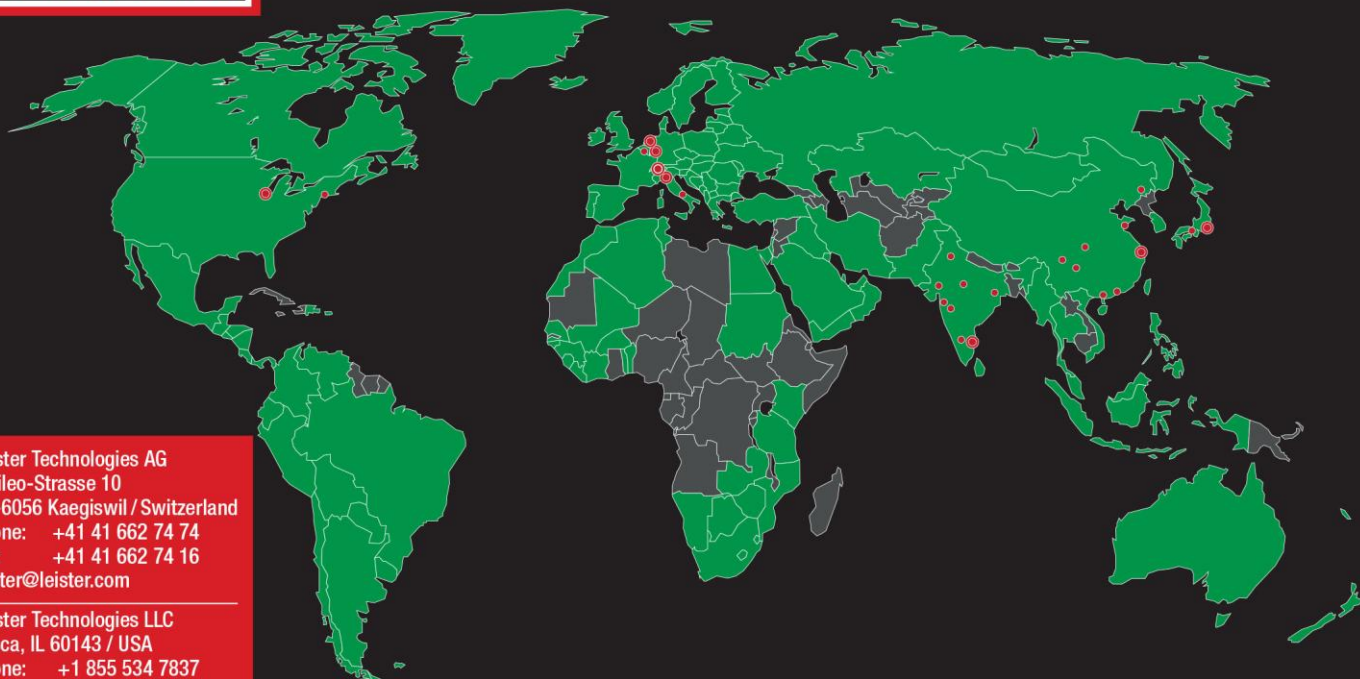
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