

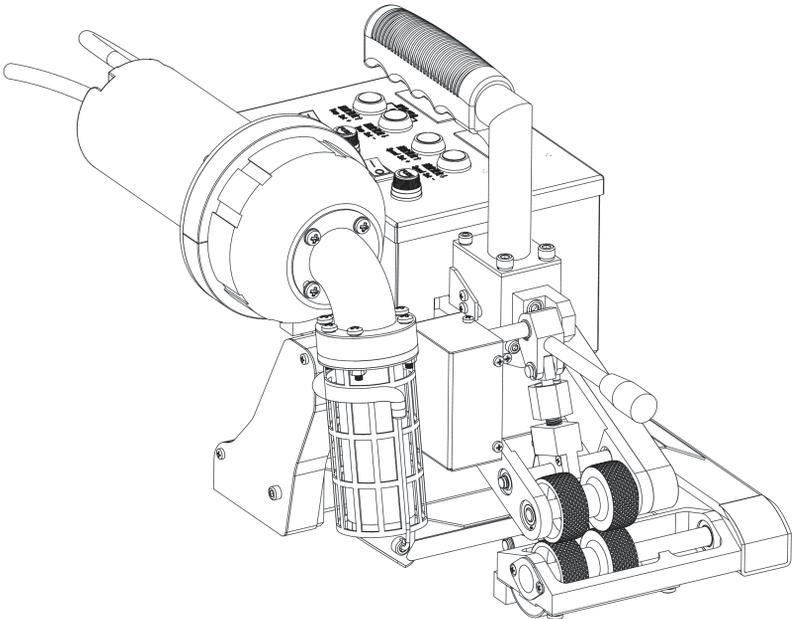


Lesite Technology

LST700

Geo Hot Air Welder

Manual





Please read this manual carefully before using this machine, and keep it for future reference.

Application

- Solid Waste Landfills
- Sewage Treatment
- Anti-seepage Project
- Chemical Mining
- Water Conservancy
- Aquaculture



Precautions



Unplug the welder before disassembling it to avoid of being hurt by exposed wires or component inside the machine with power.



Incorrect operation may cause fire and explosion hazard because of high temperature, especially near combustibile materials and explosive gases.



Don' t touch heater tube and nozzle when they are hot. They may cause burns. Don' t let hot air nozzle go towards people or animals.



The power supply voltage must match the rated voltage marked on the welding machine and be reliably grounded. Connect the welding machine to a socket with a protective ground conductor.



To ensure operator safety and reliable operation of equipment, the power supply must be installed power supply and leakage protection at the construction site.

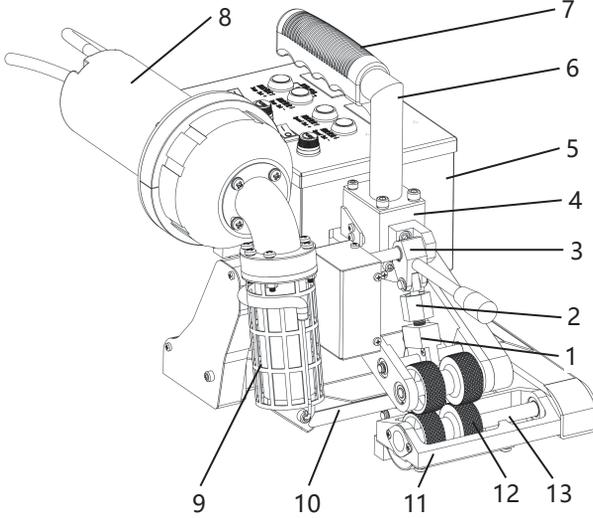


The welding machine must be operated under the correct control of the operator, otherwise it may cause combustion or explosion due to hightemperature.

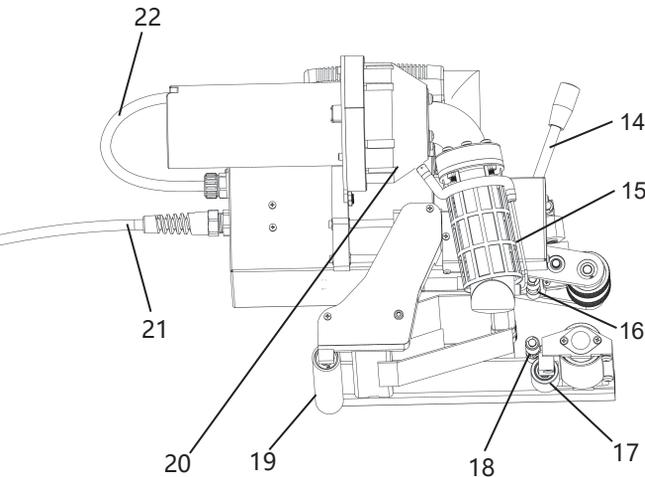


It is strictly forbidden to use the welding machine in water or muddy ground, avoid soaking, rain or damp.

Main Parts

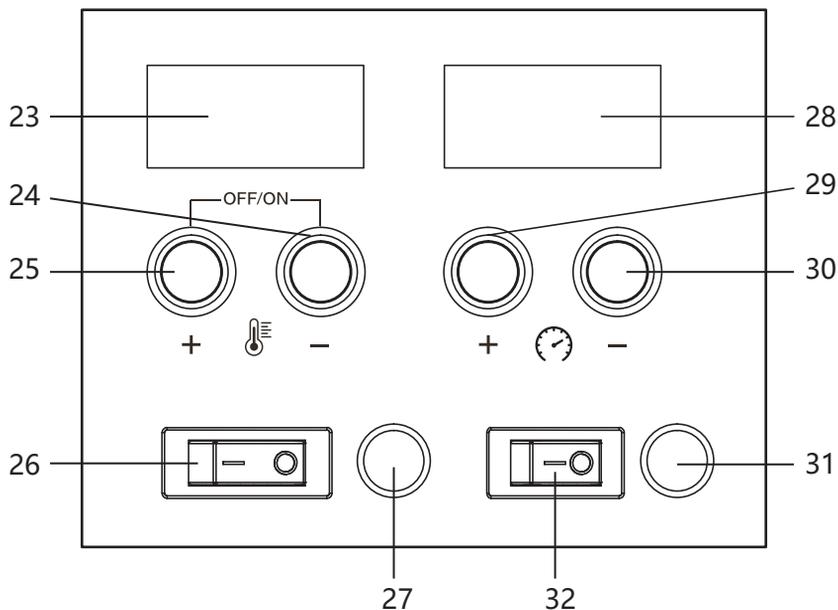


- 1、Rocker Arm
- 2、Pressure Adjusting Nut
- 3、Cam
- 4、Speed Reduction Box
- 5、Control Box
- 6、Handle
- 7、Handle Case
- 8、Hot air Blower
- 9、Nozzle Protector
- 10、Nozzle
- 11、Bottom Transmission Frame
- 12、Pressure Roller
- 13、Bottom Roller Bearing



- 14、Pressure Handle
- 15、Thermocouple
- 16、Upper Pressing Wheel
- 17、Back Creeping Roller
- 18、Bottom Pressing Roller
- 19、Ahead Creeping Roller
- 20、Thermocouple Joint
- 21、Main Power Wire
- 22、Hot Air Blower Power Wire

LST700 Control Panel



23、Temperature LCD Display

25、Temperature Rise Knob

27、Power Fuse

29、Speed Increase Knob

31、Motor Fuse

24、Temperature Drop Knob

26、ON/OFF Switch

28、Speed LCD Display

30、Speed Down Knob

32、Moving Switch

LST700 Operations

- 1、 Please lift the pressure handle (14) to separate the upper and down pressure roller (12), switch the power on.
- 2、 Setting the welding parameters according to the data of welding test.
- 3、 Please wait the actual temperature value reaching the setting value.
- 4、 Put the welder at the welding position and put the two films (one up and the other one down) into the machine.
- 5、 Press down the pressure handle (14) to make the upper and down pressure roller (12) fit completely. Then turn on the moving switch (31), the machine starts walking and welding automatically.
- 6、 To observe the relative position of the welding seam and the edge of the welded membrane at any time. It must be promptly corrected if there is deviation.
- 7、 When the welder finish welding job, its pressures handle needs to be lifted to separate the upper and down pressure roller in time.
- 8、 After completion of the welding work, press the buttons (24) and (25) on the panel to make the hot air blower in a cold blowing condition in order to cool the nozzle.
- 9、 Power off.

LST700 Parameters Setting

1、 Welding temperature:

Press the buttons    on the panel to set the required welding temperature , which depends on the welding material and ambient temperature. The LCD screen will display the preset temperature and the current actual temperature.

2. Welding speed:

Press the buttons    on the panel to set the required welding speed, which matches the welding temperature. The LCD screen will display the preset speed and the current actual speed.

3、 Welding pressure:

It can change the welding pressure by rotating the pressure adjusting nut. To reduce the pressure in a clockwise direction, and increase the pressure in a counterclockwise direction.

- The machine has a memory function parameters, namely when you use the welder next time, the welder will automatically show the last set of parameters without resetting parameters.

LST700 Parameter

Model	LST700
Voltage	230 / 120 V
Frequency	50 / 60 Hz
power	2800 / 2200 W
Temperature	50~620 °C
Welding Speed	0.5~3.5 m/min
Thickness Of Materials	0.5~2.0 mm (single layer thickness)
Welding Width	15mm×2 cavity 15mm
Overlap Width	160 mm
Seam Strength	≥85% parent material
Weight	7.5Kg
Size(L*W*H)	352×267×267 mm

LST700 Nameplate

The model identification and serial number identification are marked on the nameplate of the machine you choose.

Please provide these data when consulting Lesite Sales and Service Center.



LESITE **GEO HOT WEDGE WELDER**

Model: LST700	Voltage: 230V 50/60Hz
Welding Thickness: 0.5-2.0mm	Power: 2800W
Welding Speed: 0.5-3.5m/min	Temp.: 50-620°C
Overlap width: 16cm	Weight: 7.5Kg
Welding Seam: 15mm*2	SN: see machine frame

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 Standards: Q/350100LST 001



LST700 Boot Steps

- 1、ON/OFF switch (27) is used for turning on the main power of the welder.
- 2、Turn on ON/OFF switch (27), LCD display shows as Fig 1,the hot air blower blows cold air without heating.



Fig 1

- 3、Press the button (25) and(24), the screen shows as Figure 2 and the hot air blower starts to heat until reach the setting temperature.



Fig 2

LST700 Boot Steps

- If press the bottoms (25) and (24) at the same time, LCD display shows as Fig 1, the hot air blower blows cold air without heating.
- When the welding nozzle is at the right position, press the moving switch (31) and the welder starts to move and weld. It will stop move if you press the moving switch again.
- When the welder starts to move, the LCD display shows as Fig 3.



Fig 3

Parts Replacement

1. Replacement of heating element:

Unplug the thermocouple connector ,Loosen the four fixing screws of nozzle. Then you can remove the heating element after removing the nozzle As shown on the right:

2. Replacement of thermocouple:

Unplug the thermocouple connector ,loosen the fixing wire in the nozzle protector, then thermocouple can be removed.



Fault Diagnosis And Solved Ways

Fault	Caused	Solutions
Motor cannot work	No power	Check the power and connect it
	Fuse burns	Replace new fuse
	Speed control board burns	Replace new control board
	Motor burns	Replace new motor

Routine Maintenance

Use steel brush to clean the hot air nozzle

Clean the air inlet at the back of the hot air blower

Quality Assurance

- This product guarantees a 12-month shelf life from the day it is sold to consumers. We will be responsible for failures caused by material or manufacturing defects. We will repair or replace defective parts at our sole discretion to meet the warranty requirements.
- The quality assurance does not include damage to wearing parts (heating elements, carbon brushes, bearings, etc.), damage or defects caused by improper handling or maintenance, and damage caused by falling products. Irregular use and unauthorized modification should not be covered by the warranty.

Standards

The company declares that the products manufactured and marketed by the company meet the requirements of the following enterprise implementation standards.

Standards: Q/350100LST 001.

Repairs and Spare Parts

- It is strongly recommended to send the product to Lesite company or authorized repair center for professional inspection and repair.
- Only original Lesite spare parts are allowed.





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