



Lesite Technology

LST-C4200

Electromagnetic Wave Waterproof
Board Welding Machine

Manual

V1.0





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

Application

Used for various thermoplastic plastics such as HDPE, PP, PVDF, PVC, EVA, etc



Precautions



Improper use of this equipment may cause fire, electric shock, and other injuries.



There is high voltage inside this equipment, and non professional personnel are strictly prohibited from disassembling it.



Please use the National Grid 230/50Hz power supply.



Please use a three core socket with grounding and do not modify the plug without authorization.



Please strictly prevent water, moisture, and dust accumulation in this equipment.



Please be attentive during operation. To ensure welding quality, please send professional personnel to operate and use.



Be sure to use specialized hot melt gaskets with metal wire mesh, as this machine is not suitable for ordinary hot melt gaskets.



It is strictly prohibited to use welding heads to directly press various metals such as iron nails, blades, and steel bars for heating, as it is extremely easy to burn the motherboard.



It is strictly prohibited to use welding heads to hit hard objects, as there are fragile parts inside.



Long term no-load heating and no-load testing are strictly prohibited.

Parameter

Model	LST-C4200
Voltage	230 V
Frequency	50 Hz
Power	4200 W / Adjustable
Operating Frequency	Automatic
Effective Welding Surface	≥Φ75 mm
Welding Gun Wire Length	10 M
Welding Gun Size	210 × 200 × 85 mm
Host Size	250 × 270 × 125 mm
Weight	6.7 Kg

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.

**ELECTROMAGNETIC WAVE
WELDING MACHINE**

Model: LST-C4200**Voltage: 230V**

Frequency: 50/60Hz**Power: 4200W**

SN: see machine frame

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Instructions for Use



Fig 4 Work interface

- 1、Place the machine stably on the workbench, connect the power cable, welding gun connection cable, and turn the power switch to "ON (I)". At this time, the front panel LCD screen will display the work interface shown in Figure (4).
- 2、At this point, the welding time and output amplitude displayed on the interface are factory debugging values. The production personnel can also dynamically adjust the welding time and output amplitude for trial welding based on the characteristics and thickness of the welding material, and inspect the welding effect.
- 3、The time "+-" button can adjust the increase and decrease of welding time, with a time unit of "seconds".
- 4、The power "+-" button can adjust the output amplitude and percentage of output power.
- 5、The set/reset button is a button that restores the factory settings. Press it for 10 seconds to reset the host to the factory settings.
- 6、The test button is used to detect the welding gun and determine whether it is emitting waves normally. Press and hold the welding gun to emit waves, release and stop.
- 7、The workpiece parameters in the interface are the working frequency of the machine, and this option automatically matches the machine computer with the workpiece.

The processing quantity in the interface increases by "1" for each work. You can frequently press the set/reset button to reset.

Attention: When using, do not move the host, directly plug and unplug the power supply or aviation plug. If you hear any abnormal sound or indication, please immediately turn off the power supply and then find the cause of the fault, otherwise it is easy to damage the equipment or cause accidents.

Fault & Solutions

Fault	Causes	Solutions
The power switch indicatorlight is not on	The power socket is not powered on	Check if the socket is properly connected or loose from the machine
	Internal power cord disconnection	Check and determine the internal breakpoint, reconnect the power cord, or replace it with a new one
	Poor plug contact	Reinsert and unplug the power cord
No display on the LCD screen	LCD screen malfunction	Return to the factory to replace the LCD screen
	Host motherboard failure	Returning to the factory for maintenance of the host
No response when pressing the welding gun switch	Host parameters are scrambled	Reset parameters
	Welding gun switch damaged	Replace the welding gun switch
	Welding gun cable internal breakage	Identify breakpoints and reconnect
	Loose or damaged aviation socket	Retighten or replace the plug
	Welding gun circuit fault	Returning to the factory for repair or purchasing a new welding gun
	Host motherboard failure	Returning to the factory for maintenance of the host

Quality Assurance

From the date of shipment, the warranty period for the main unit is 12 months, and the warranty period for the welded joint is 6 months. Human damage (such as rolling of construction site vehicles, welding head damage caused by human impact, three-phase power connection, and other abnormal usage situations) cannot be guaranteed.

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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