



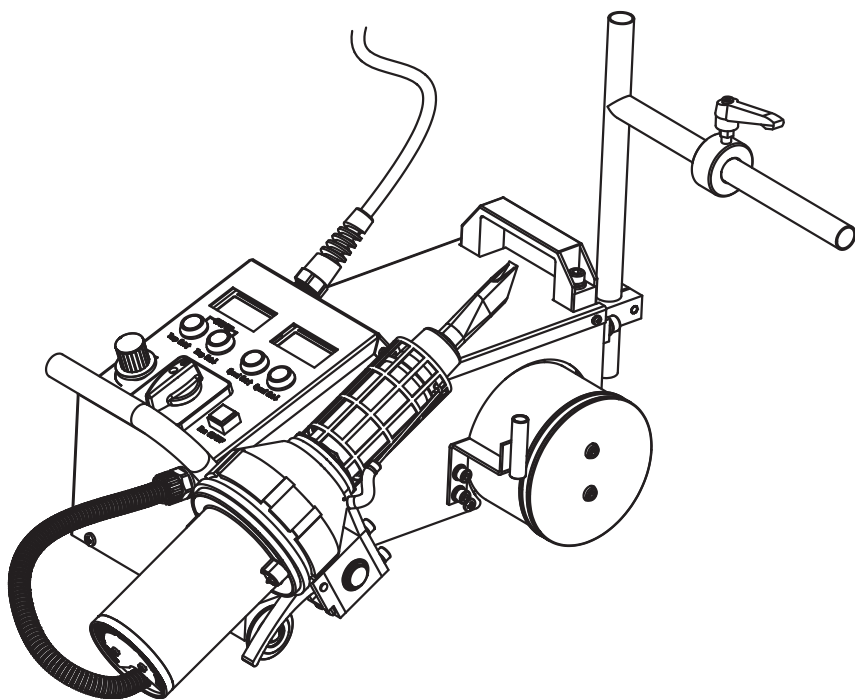
Lesite Technology

LST-FLR

Flr Automatic Welder

Manual

V1.0





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

Application

LST-FLR is intended for professional use for laying elastic floor coverings.



Precautions



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



Incorrect use of it can cause fire and explosion hazard because of high temperature, especially near combustible materials and explosive gases.



Don't touch heater tube and nozzle when they are hot. They may cause burns. Don't point hot air flow in the direction of people or animals.



The voltage rating stated on the welder must correspond to line/mains voltage (220V). The drop cable / wire with protective earthed conductors can only be used.



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



It must be running at the correct use of manipulation of the operator, or they may cause a fire or explosion caused by high temperature.



Don't use welder in the water, or on a muddy construction site, to avoid flooding, rain or moisture.

Parameter

Model	LST-FLR
Rated Voltage	230 V
Frequency	50 Hz
Rated Power	1800 W
Welding Temperature	50 - 620 °C
Welding Speed	1.0 - 10.0 m/min
Electrode Diameter	< 8 mm
Net Weight	12.5 Kg
Size	460 × 236 × 250 mm
Motor	Brushless
Warranty	One Year

Nameplate

The model identification and serial number are marked on the nameplate of your machine.
Please provide these data when consulting Lesite Sales and Service Center.



Fir Automatoc Welder **BL**
MOTOR

Model: LST-FLR

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Power: 1800W

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Electrode Diameter: <8mm

Weight: 12.5Kg

SN: See Machine Frame

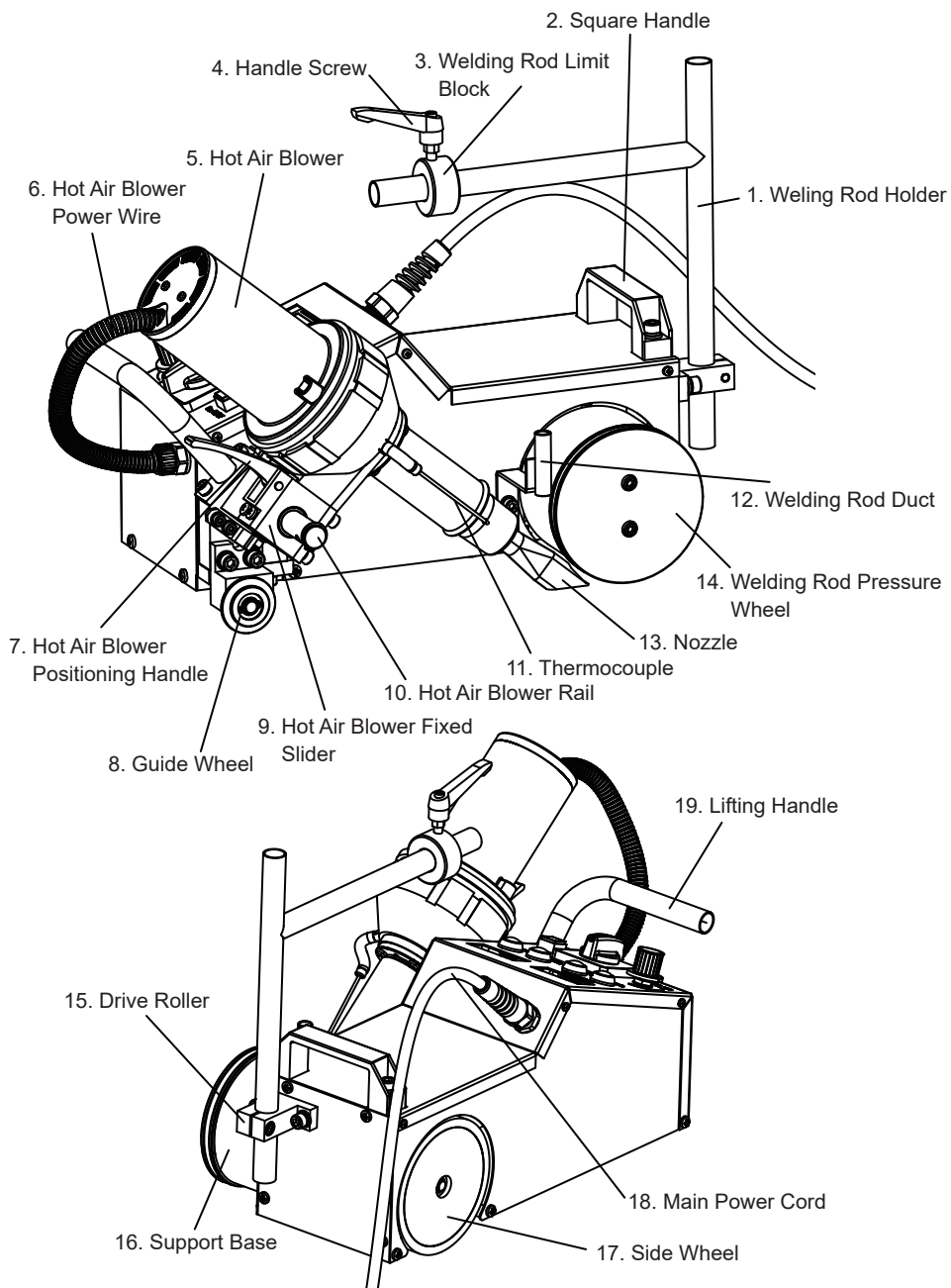
Fuzhou Lesite Plastics Welding Technology Co., LTD

www.lesiteweld.com

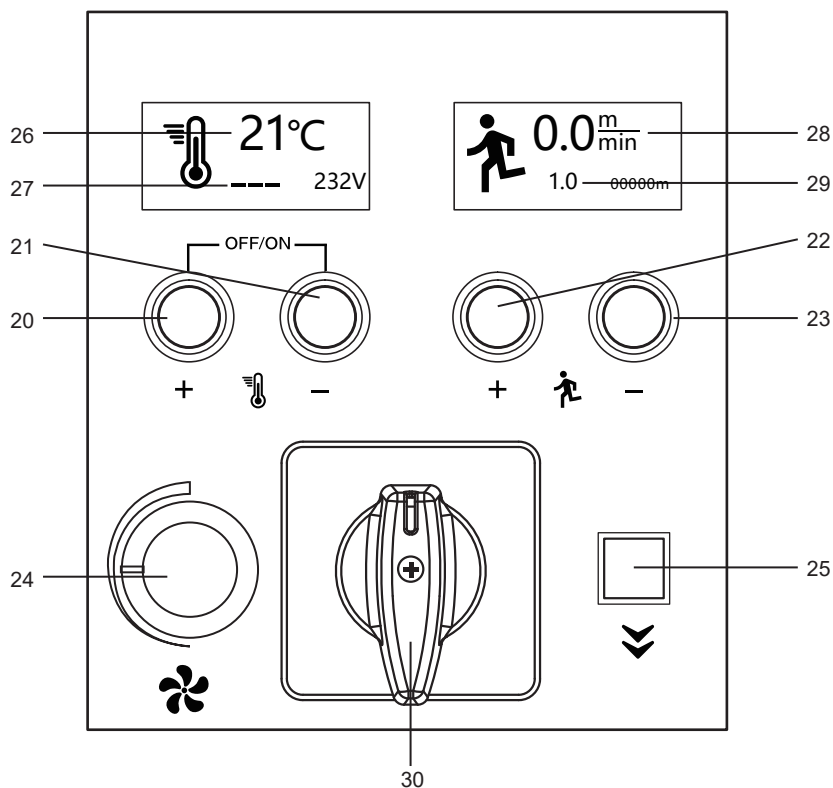
info@lesite.com.cn



Main Parts



Control Panel



- | | |
|------------------------------------|------------------------------------|
| 20. Temperature Setting Knob (+) | 21. Temperature Setting Knob (-) |
| 22. Speed Setting Knob (+) | 23. Speed Setting Knob (-) |
| 24. Air Volume Knob | 25. Moving Switch |
| 26. Current Temp. | 27. Setting Temp. |
| 28. Current Speed | 29. Setting Speed |
| 30. ON / OFF Switch | |

20+21——Press simultaneously to turn off/on heating

Control Panel

- 1、ON/OFF switch (30) is used for open the main power of the welder.
- 2、Open ON/OFF switch (30), LCD display is shown as figure 1,the hot air blower is under natural wind without heating.



Fig 1

- 3、Press the button (20) and (21), the screen shows as Figure 2 and the hot air blower starts to heat until to the setting temperature.
- 4、If press the bottoms (20) and (21) at the same time, LCD display shows as figure 1, the hot air blower is under natural wind without heating.



Fig 2

- 5、When the welding nozzle is at the right position, press the moving switch (25) and the welder starts to move and weld. It will stop move if you press the moving switch again.
- 6、When the welder starts to move, the LCD display shows as figure 3.



Fig 3

- 7、Air Volume Knob (24): control the amount of airflow, increase the air volume clockwise, and reduce the air volume counterclockwise.

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 setting 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 setting speed and the current actual speed.

3、Air volume:

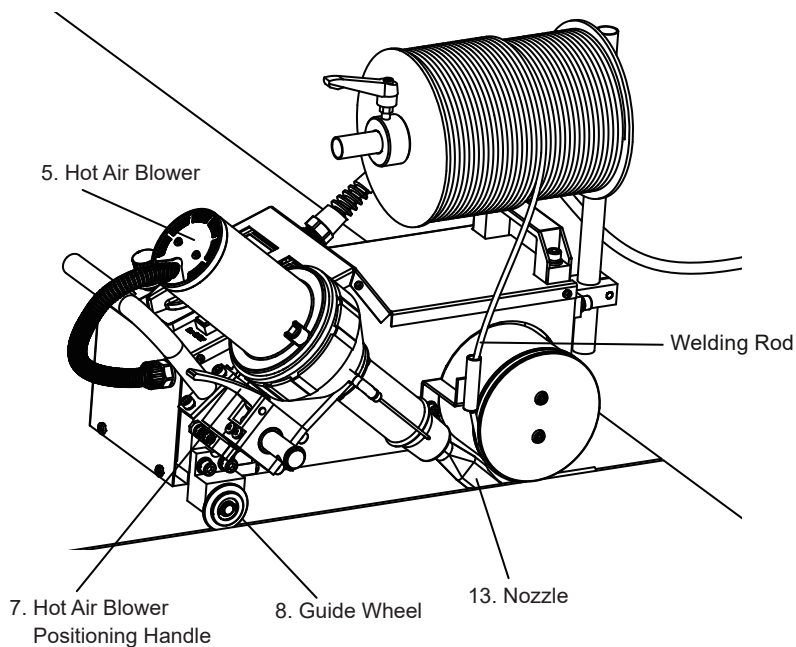
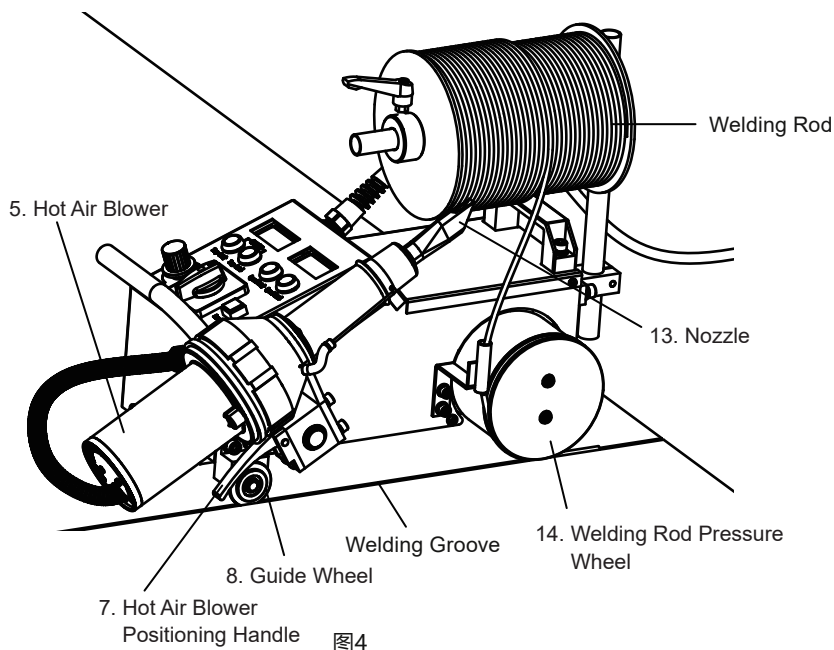
Use the knob  to set the air volume, increase the air volume clockwise, and decrease the air volume counterclockwise. When the ambient temperature is too low and the current temperature does not reach the setting temperature, the air volume can be appropriately reduced.

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

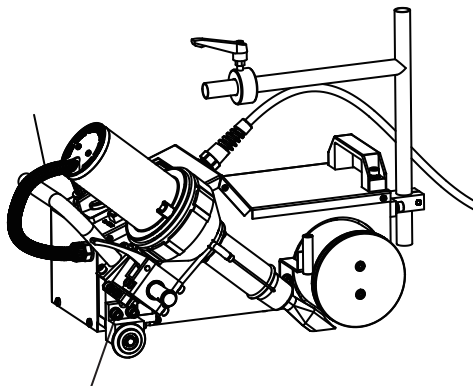
Welding Parameters Setting

- 1、Rolling in welding rod as figure 4.
- 2、Setting welding parameters.
- 3、Please wait the current temperature value reaching the setting value.
- 4、Positioning the welder to move Guide wheel (11) and welding rod pressure wheel (15) in the middle of welding groove.
- 5、Feeding in welding rod as figure 5.
- 6、Pull up the Hot Air Blower Positioning Handle (7), while raising the Hot Air Blower Handle (5) and lowering the Nozzle (13) to make it close to the floor. Move the hot air blower to the left to make the nozzle enter between the welding rod and the welding groove, and the welding machine will automatically move for welding.
- 7、To observe the relative positions of Guide wheel (8) and welding rod pressure wheel (14).
- 8、After welding is completed, pull up the Hot Air Blower Positioning Handle (7) and move it to the right. Press down the Hot Air Blower Handle (5) to lift the nozzle upwards.
- 9、After finish the welding job, press the **+**  **-** simultaneously to make the hot air blower in a cold blowing condition in order to cool the nozzle.
- 10、Last step is to off power.

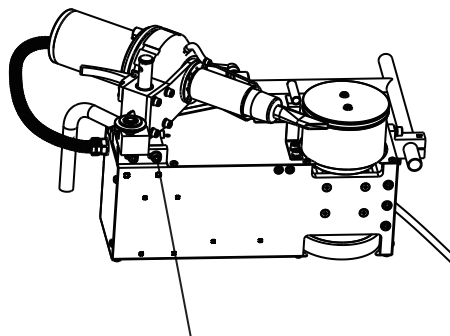
Welding Parameters Setting



Nozzle Position Adjustment



Loosen this screw to adjust the height of the nozzle above the ground



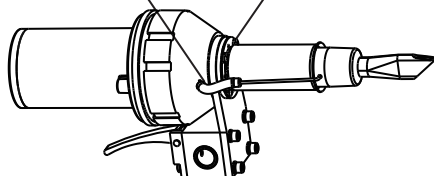
Loosen this screw to adjust the front and rear positions of the nozzle

Parts Replacement

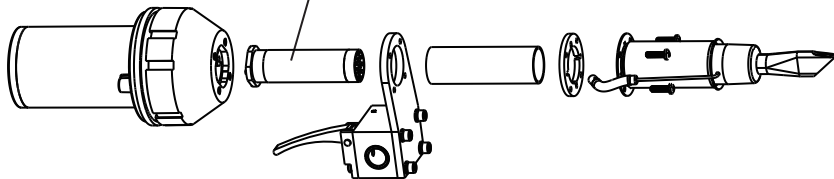
• Replacement of heating element

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

Thermocouple Connector Hot Air Welding Nozzle Screw

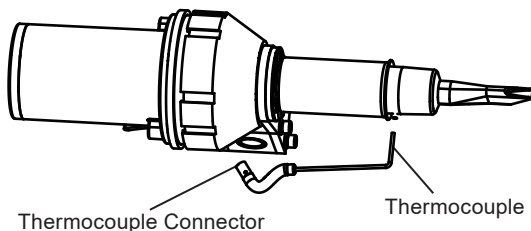


Heating Element



• Replacement of thermocouple

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



Thermocouple Connector

Thermocouple

Fault Codes

Fault	Cause of the Fault	Solution
	Thermocouple Fault	1. Replace the heating element; 2. The outer casing connection terminal is broken; replace the outer casing assembly; 3. The drive board is faulty; replace the drive board.
	Overheating Fault	1. If the fan is not turning, replace the air gun motor or its carbon brushes; 2. Clean the air nozzle and air gun intake filter; 3. If the photosensitive element is faulty, replace it; 4. Replace the heating element;
	Heating Element Fault	1. Replace the heating element; 2. The outer casing connection terminal is broken; replace the outer casing assembly; 3. The drive board is faulty; replace the drive board.
 179V	Voltage Below 180V Alarm	Raise Voltage
 251V	Voltage Above 250V Alarm	Reduce Voltage
 --- 281V	Voltage Reaching 280V Alarm	Cut off the power, reduce voltage

Routine Maintenance

Use steel brush to clean the hot air nozzle

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

Repairs and Spare Parts

- This product guarantees a one year warranty 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.

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.





FUZHOU LESITE PLASTICS WELDING TECHNOLOGY CO.,LTD



Tel: +86(591)83818890



E-mail: info@lesite.com.cn
Web: www.lesiteweld.com



Add: 5# Jingpu Road, Pushang Industry Park,
Cangshan, Fuzhou, 350007, Fujian, China