



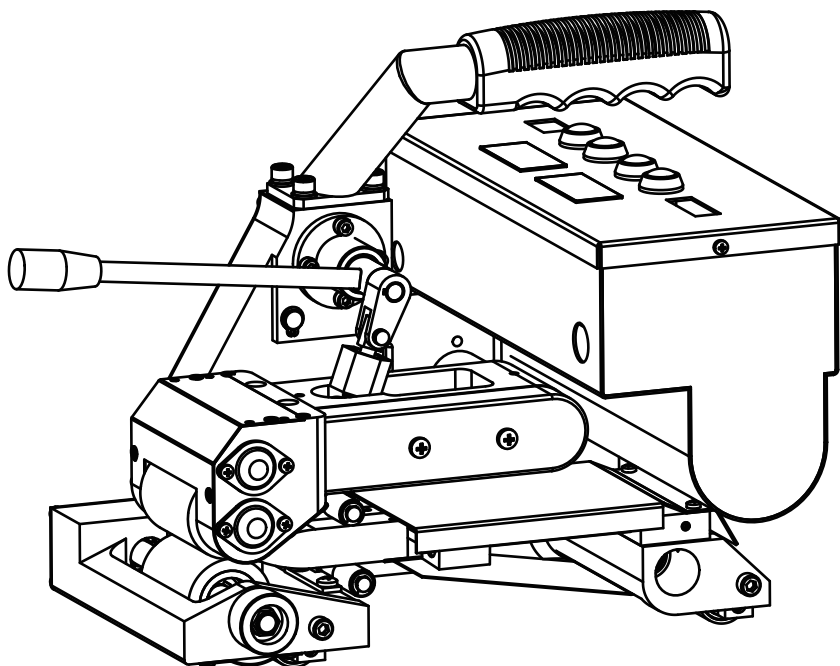
Lesite Technology

LST-GM2

Geo Hot Wedge Welder

Manual

V1.0





**Please read this instruction manual carefully before use.
Only correct operation can ensure the long-term reliable and
trouble-free operation of the product.**

Application

It can be applicable for welding PE, PVC, HDPE, EVA, PP and other hot melted materials.



Precautions



Please use a grounded three-pin socket with a capacity of more than 15A. Do not tamper with the plug, and do not pull the cord to pull the plug.



Pressure roller will not engage on free running.



Don't touch hot wedge when they are hot. They may cause burns.



The voltage rating stated on the welder must correspond to line/mains voltage (230V). 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.



The circuit board and other components in the controller box may be charged, please don't disassemble it without professional skills.



Please preheat the welder about 30 minutes if it hasn't be used for a long time or it is affected with damp.



The power of this welder is large. Please don't heat it for long time to avoid excessive heating if it is in absence of welding or interval time is longer.

Parameter

Model	LST-GM2
Rated Voltage	230 V
Frequency	50 Hz
Rated Power	600 W
Heating Temperature	60 - 450 °C
Welding Speed	0.5 - 5.0 m/min
Welding Pressure	100 - 1000 N
Material Thickness Welded	0.3 - 2.0 mm (Single Layer)
Seam Width	15mm×2, Interior Cavity 20 mm
Overlap Width	12 cm
Seam Strength	≥85% Material
Net Weight	7.9 Kg
Size	256 × 232 × 260 mm
Membrane Laying Ways	Membrane laying way by one edge against the other edge
Digital Display	Temperature & Speed Display
Certificate	CE
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.



GEO HOT WEDGE WELDER

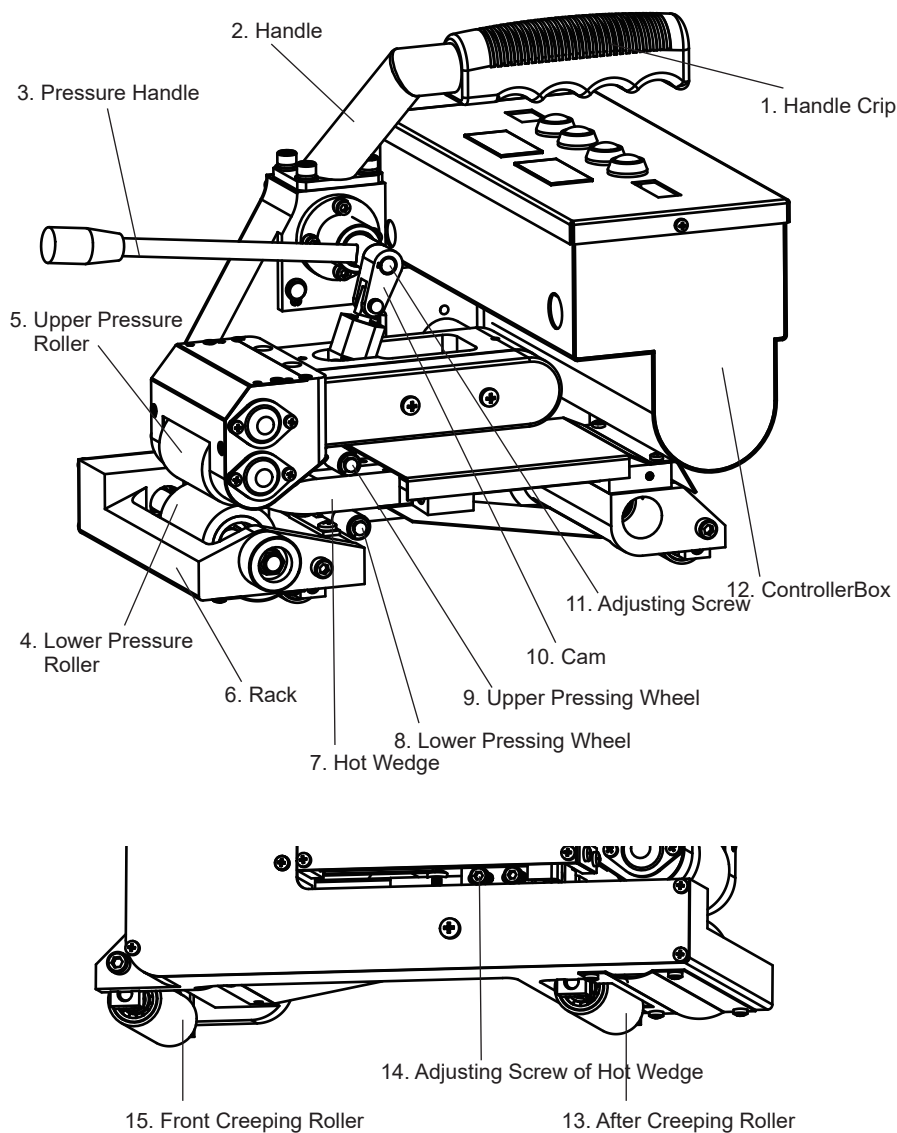
Model: LST-GM2
Welding Thicknes: 0.3-2.0mm
Welding Speed: 0.5-5.0m/min
Overlap Width: 12cm
Welding Seam: 15mm*2

Voltage: 230V/50Hz
Power: 600W
Temp.: 60-450°C
Weight: 7.9Kg
SN: See Machine Frame

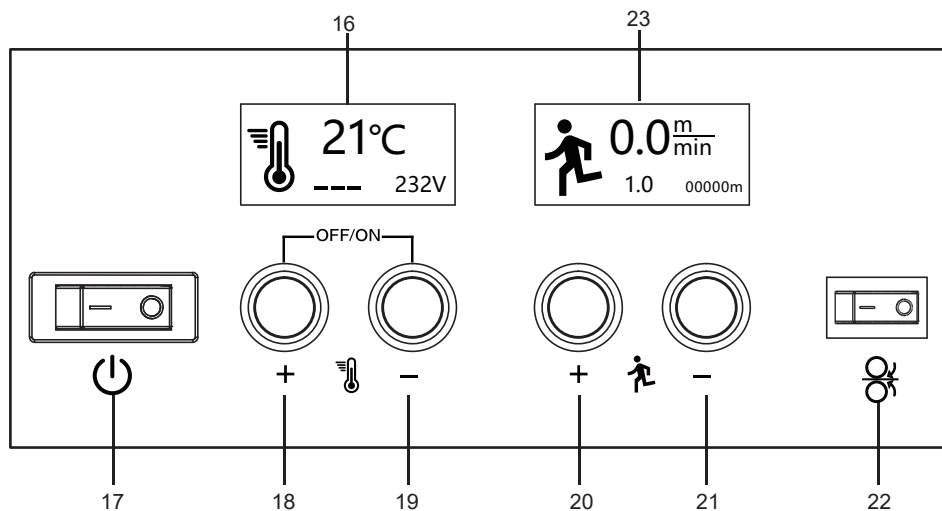
Fuzhou Lesite Plastics Welding Technology Co., LTD
www.lesiteweld.com
info@lesite.com.cn
 Standards: Q/350100LST 001



Main Parts



Control Panel



16. Temperature Display

17. Power Switch

18. Temperature Setting Knob (+)

19. Temperature Setting Knob (-)

20. Speed Setting Knob (+)

21. Speed Setting Knob (-)

22. Walk Switch

23. Speed Display

1. Welding temperature:

Using buttons +  - on the panel to set the required temperature. You can set the temperature according to the welding materials and the ambient temperature. LCD display will show the set temperature and the current actual temperature.

2. Welding speed:

Using buttons +  - on the panel to set the required speed according to the welding temperature. LCD display will show the set speed and the current actual speed.

3. Welding pressure:

It can change the welding pressure by rotating the pressure adjusting nut (11). Clockwise to reduce the pressure, counterclockwise to increase the pressure.

4. Adjusting hot wedge:

Loosen Adjusting screw of hot wedge (14), then you can move the hot wedge back and forth, lock the adjustment screw of hot wedge (14) after choosing the appropriate position.

- This machine features parameter memory function. The previous settings will be restored automatically upon next power-on without the need for resetting.

Operation Steps

1. Power ON/OFF(17) is for controlling the main power of the welder.
2. Switch power ON/OFF(17), LCD display shows as Fig 1, the hot wedge is not heating in natural state.



Fig 1

3. Press the buttons +  - at the same time, LCD display shows as Figure 2, the hot wedge start to heat until reach your setting temperature.



Fig 2

4. Press the buttons +  - at the same time again, LCD display shows as Figure 1, the hot wedge is not heating in natural state.
5. Run ON/OFF (22) is used to control walking and stop of the welder.
6. When the welder start to run, LCD display shows as Figure 3.



Fig 3

Welding Process

1. Please lift the pressure handle (3) to separate the upper and lower pressure roller(5、4), then plug the power and open the on power switch.
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 prepared materials (one up and the other one down) into the machine.
5. Press the pressure handle (3) to make the upper and lower pressure roller (5) (4) in place. Then open the walk switch (22) , the machine would start 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 walks into the end of material, the pressures handle (3) needs to be lifted to separate the upper and lower pressure roller (5) (4) in time.
8. After completion of the welding work, press the buttons (18) and (19) on the panel to make the hot wedge to stop heating.
9. Turn off the power (17) ON/OFF .

Fault Codes

Fault	Cause of the Fault	Solution
Motor doesn't move	Power is not on	Check power condition and switch on
	Blown fuse	Change insurance
	Speed control circuit board burned out	Replace the speed control circuit board
	Motor burned out	Replace the motor
Hot wedge doesn't heat	Thermocouple failt	Replace the thermocouple
Hot wedge burned	Thermocouple failt	Replace the thermocouple
	Thermocouple failt	1. Check wiring; 2. Replace thermocouple; 3. Replace wedge assy.
	Heating element failt	1. Check wiring; 2. Replace heating tubes; 3. Replace wedge assy.
 179V	Voltage below 180V Alarm (230V)	Raise voltage
 251V	Voltage above 250V Alarm (230V)	Reduce voltage
 --- 281V	Voltage reaching 280V Alarm (230V)	Cut off the power, reduce voltage

Quality Assurance

- 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 cover damage to wearing parts (heating elements, bearings, chains, pressure, rollers, 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.





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