



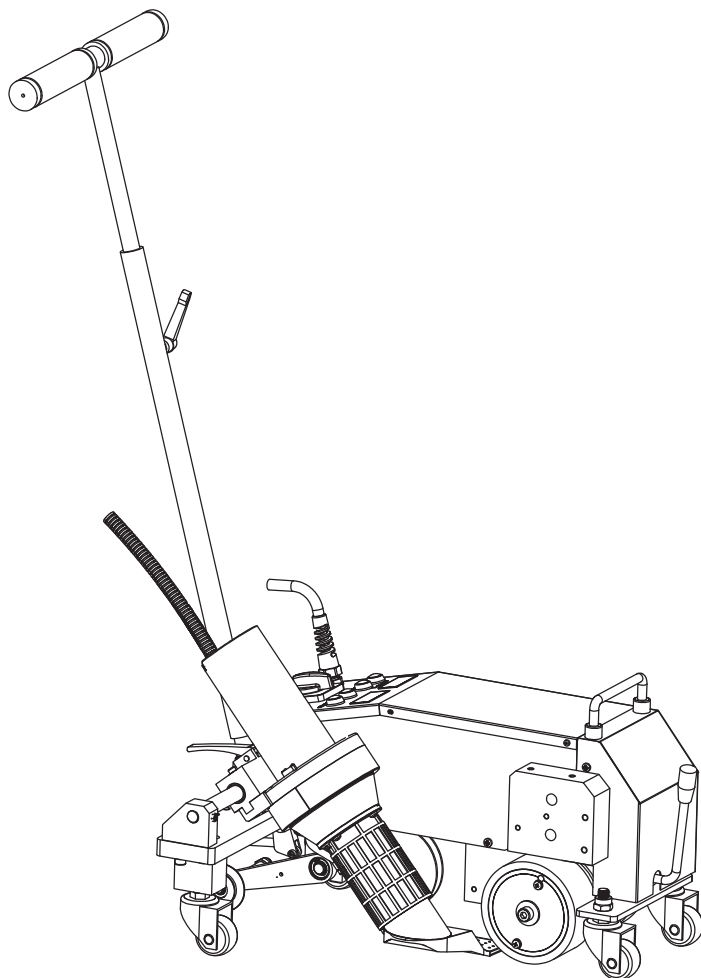
Lesite Technology

LST-MAT

Banner & Tarpaulin Welder

Manual

V1.0





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

Provide practical and high-quality equipment and application solutions for the splicing and production of advertising printing, fast soft doors, awnings, tents, inflatable castles, plastic products, etc.

Application

- Splicing and production of advertising printing
- car tents
- automobile transportation
- tents
- membrane structures
- inflatable castles
- open-air storage
- plastic



Precautions



Unplug the welder before disassembling it to avoid of injury from exposed wires or component inside the machine with power.



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



Don't touch heater tube and nozzle when they are hot. They may cause burns. Don't point the nozzle at people to avoid burns.



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 equipped with a voltage stabilizer and a residual current device.



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.

Parameter

Model

LST-MAT1

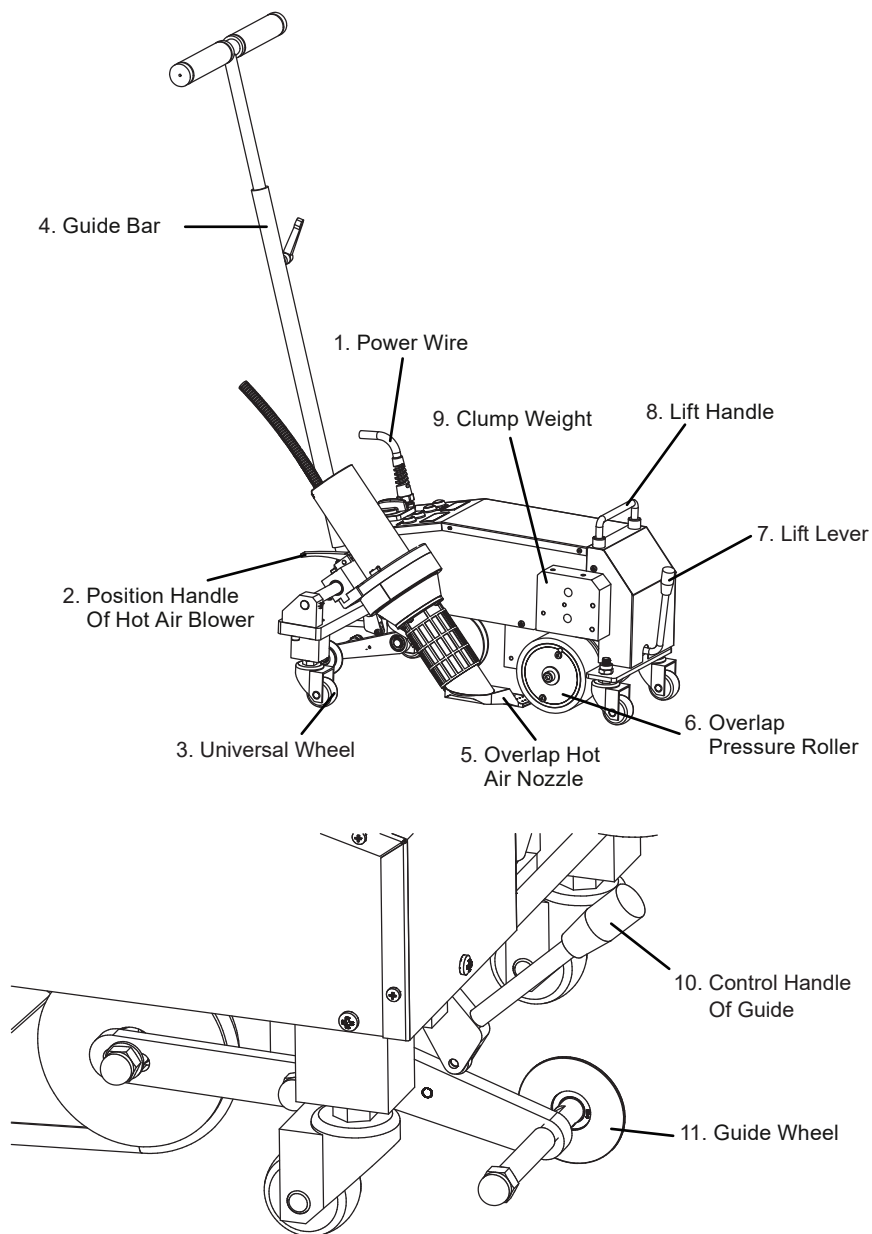
Rated Voltage	230 V
Frequency	50 Hz
Rated Power	4200 W
Welding Temperature	60 - 650 °C
Welding Speed	1.0 - 10.0 m/min
Seam Width	40 mm
Net Weight	22 Kg
Size	535 × 336 × 268 mm
Motor	Brush / Brushless
Air Volume	No Adjustable / Stepless Adjustable
Certificate	CE
Warranty	One Year

Model

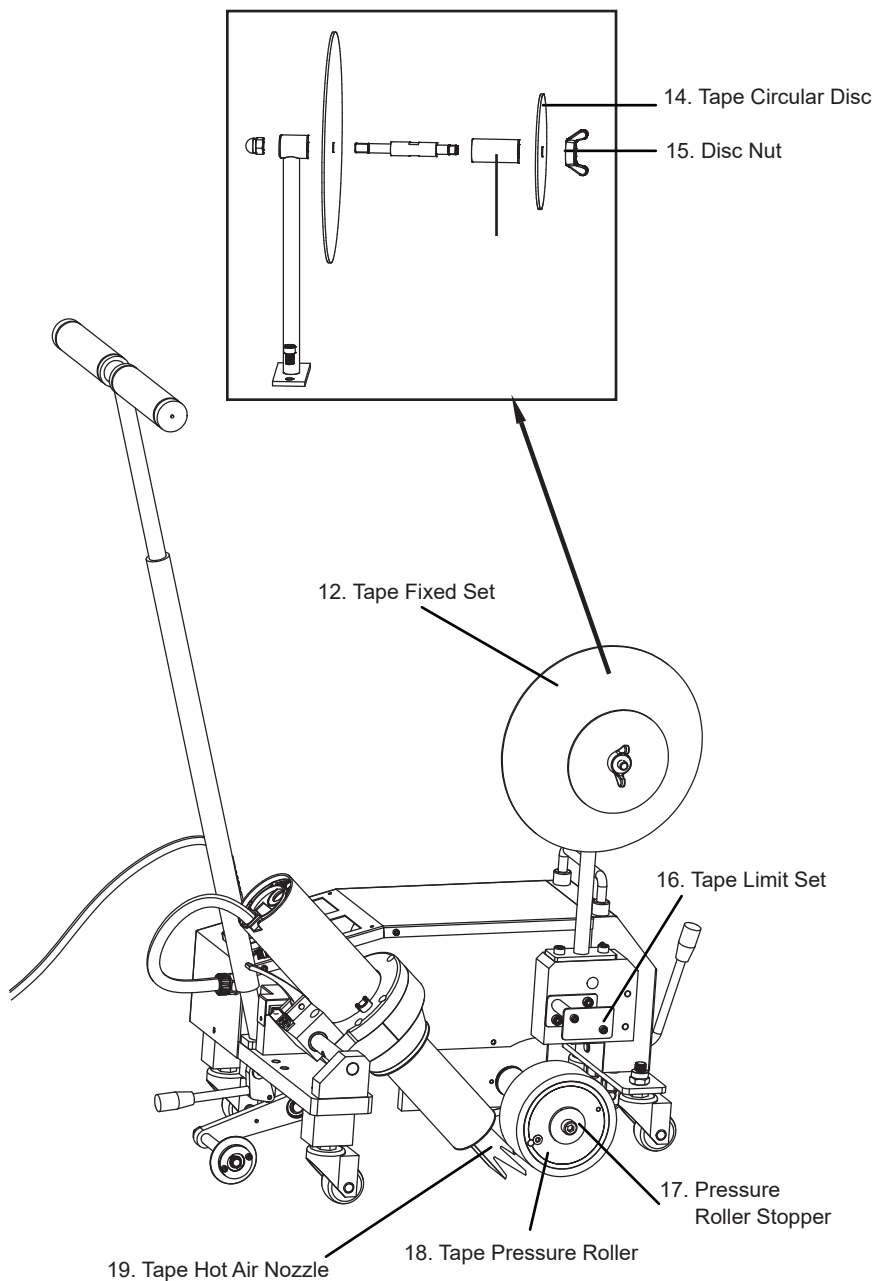
LST-MAT2

Rated Voltage	230 V
Frequency	50 Hz
Rated Power	4200 W
Welding Temperature	60 - 650 °C
Welding Speed	1.0 - 10.0 m/min
Seam Width	40 mm
Net Weight	25 Kg
Size	535 × 336 × 268 mm
Motor	Brush / Brushless
Air Volume	No Adjustable / Stepless Adjustable
Certificate	CE
Warranty	One Year

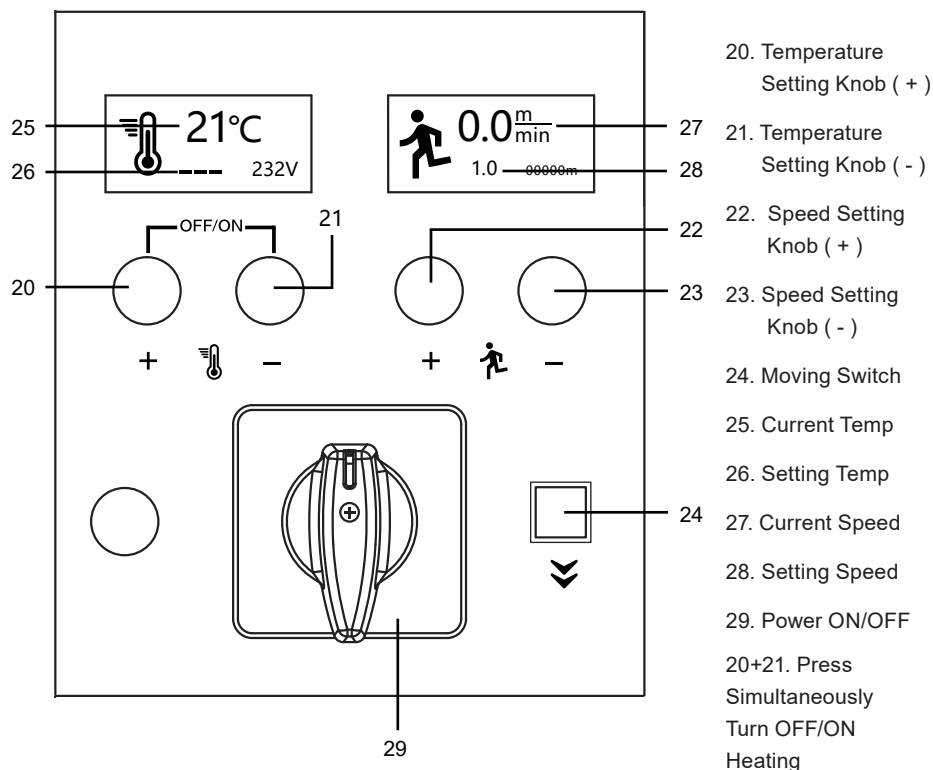
LST-MAT1 Main Parts



LST-MAT2 Main Parts



Control Panel



1. Welding temperature:

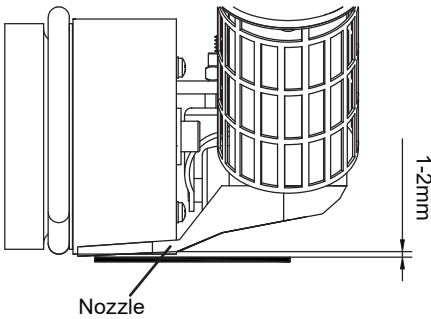
Using buttons **+**  **-** to set the required temperature. You can set the temperature according to the welding materials and the ambient temperature. LCD display screen will show the setting temperature and the current temperature.

2. Welding speed:

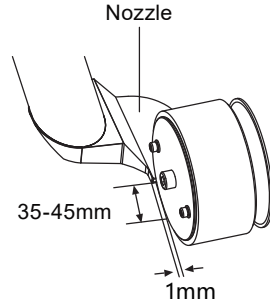
Using buttons **+**  **-** to set the required speed according to the welding temperature. LCD display will show the setting speed and the current speed.

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

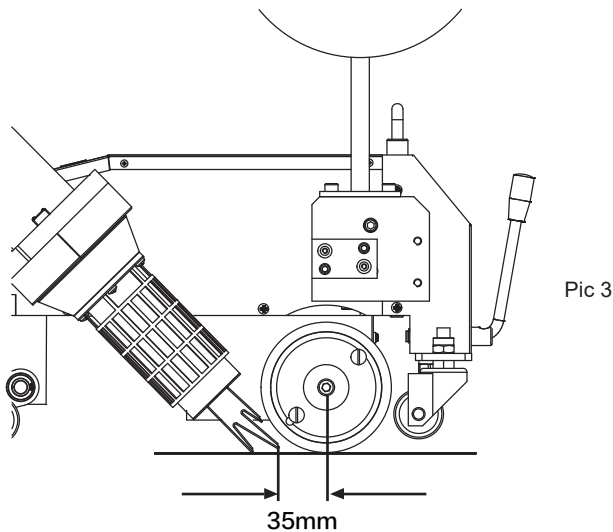
Welding Nozzle Setting



Pic 1



Pic 2



Pic 3

1. The distance between the air nozzle and the ground should be shown in Pic 1 (the distance has been adjusted before delivery).
2. The distance between the air nozzle and the pressure wheel should be as shown in Pic 2 and Pic 3 (the distance has been adjusted before delivery). If the distance is not correct, loosen the fixing screws below the air gun fixing base (left) (14) and the air gun fixing base (right) (15) for adjustment.
3. The tape welding should be installed as shown in Pic 3.

Boot Steps



1. Turn on the machine, and the LCD display screens are shown as above. At this time, the air blower does not heat and is in the state of blowing natural wind.



2. Press the buttons of +  - at the same time. At this time, the air blower starts to heat up to the setting temperature. When the current temperature reach the setting temperature, press button +  - to set speed. The LCD screens are shown as above.



3. Pull up the blower location handle, raise the hot air blower , lower the welding nozzle to make it close to the lower membrane, move the air blower to the left to insert the welding nozzle into the membranes and make the welding nozzle in place. At this time, the welding machine automatically walks for welding. The LCD screens are shown above.
4. Pay attention to the position of the guide wheel (22) at all times. If the position deviates, you can touch the operating handle (26) to adjust.



5. After completing the welding work, remove the welding nozzle and return to the initial position, and press the buttons +  - on the control panel at the same time to turn off the heating. At this time, the hot air blower stops heating and is in cold air standby mode while allowing the welding nozzle to cool down after waiting for the temperature to drop to 60°C, and then turn off the power switch.

Fault Codes

Fault	Cause of the Fault	Solutions
	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 blower motor or its carbon brushes; 2. Clean the air nozzle and air blower 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.
	Voltage Below 180V Alarm	Raise Voltage
	Voltage Above 250V Alarm	Reduce Voltage
	Voltage Reaching 280V Alarm	Cut off the power, reduce voltage

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.



BANNER & TARPAULIN WELDER

Model: LST-MAT1

Power: 4200W

Welding Speed: 1.0-10.0m/min

Weight: 22Kg

Voltage: 230V/50Hz

Temperature: 60-650°C

Welding Seam: 40mm

SN: See Machine Frame

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BANNER & TARPAULIN WELDER BL MOTOR

Model: LST-MAT2

Power: 4200W

Welding Speed: 1.0-10.0m/min

Weight: 25Kg

Voltage: 230V/50Hz

Temperature: 60-650°C

Welding Seam: 40mm

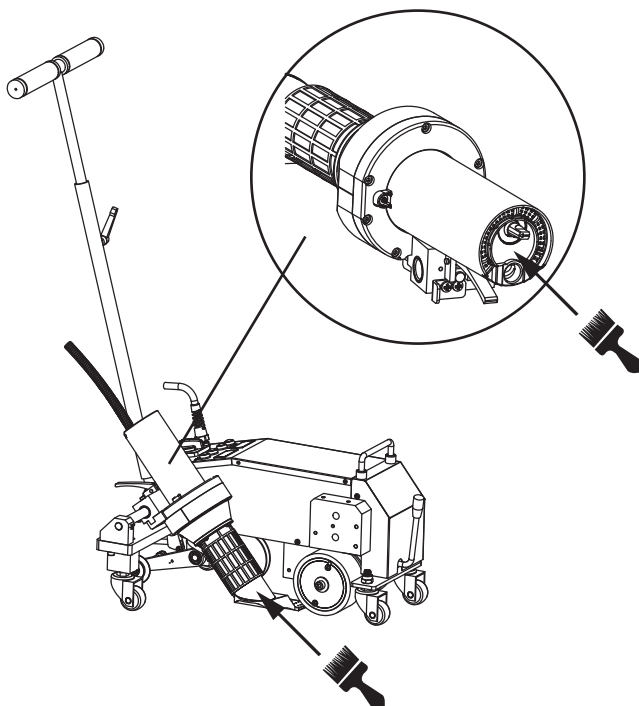
SN: See Machine Frame

Fuzhou Lesite Plastics Welding Technology Co., LTD
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Daily Maintenance

Use steel brush to clean the welding nozzle.
Clean the air inlet at the back of the hot air blower.



Quality Assurance

- This product guarantees a one year warranty from the day it is sold to customers. 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 (bearings, chains, 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.

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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