



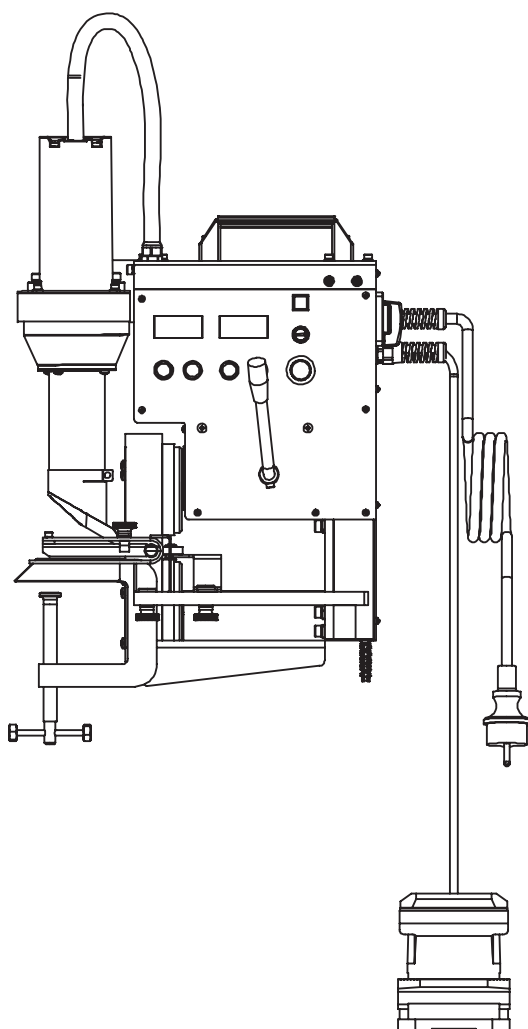
Lesite Technology

LST-PAU

Table 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.

This machine provides heat welding function for thermoplastic soft materials such as advertising cloth and industrial tarpaulin with many functions such as overlap welding, closed hemming welding, open hemming welding and stringing welding.

Parameter

Model	LST-PAU
Rated Voltage	230 / 120 V
Frequency	50 / 60 Hz
Rated Power	3600 / 2200 W
Welding Temperature	60 - 650 °C
Welding Speed	1.0 - 12.0 m/min
Seam Width	30 mm
Net Weight	19 Kg (Including mounting bracket)
Size	350 × 350 × 560 mm
Motor	Brushless
Air Volume	Stepless Adjustable
Certificate	CE
Warranty	One Year

Machine Installation

1. The machine is packed by stainless steel carry case. We apply horizontal placement to transport it. Please set up the case after receiving the case. As shown in Fig 1.

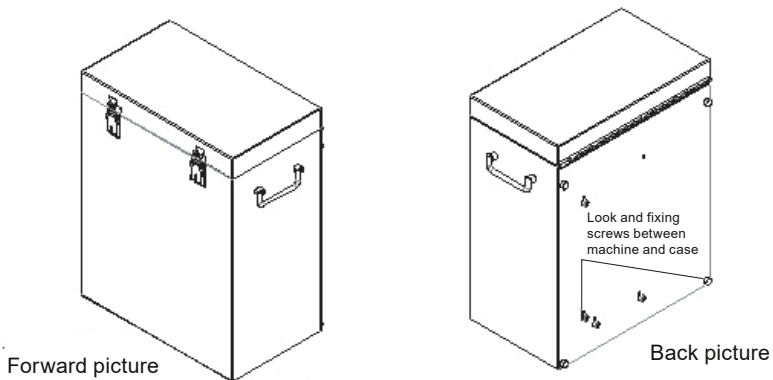
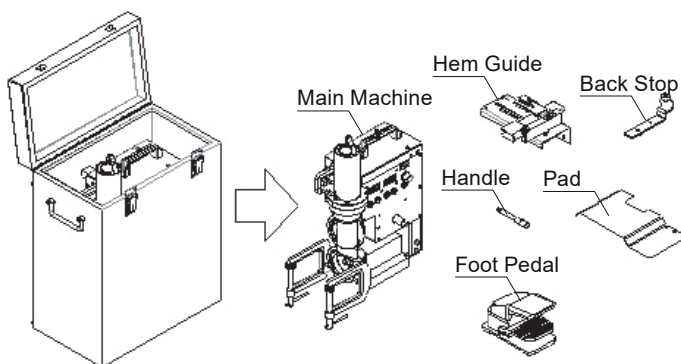


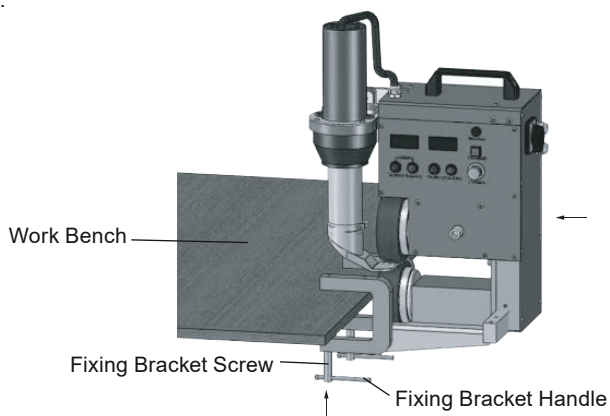
Fig 1 Outlook Picture of Packing Case

Machine Installation

- Open the case cover, take out the supplied tools, remove the loose parts inside, and loosen and remove the four screws on the back of the stainless steel case with the supplied tools (shown in the back view of Figure 1). These four screws are used to secure the device to the package to avoid turbulence during transportation and damage to the device. After removing the screws, take out the machine. Note: The net weight of the machine is 20 kg. Please hold the handle of the machine to avoid slipping. As shown in picture 2. Inventory and check machine and accessory components. There is one set of main machine, one set of hem guide, one set of back stop, one handle, one pad, one foot pedal, one set of installation tools and screws.

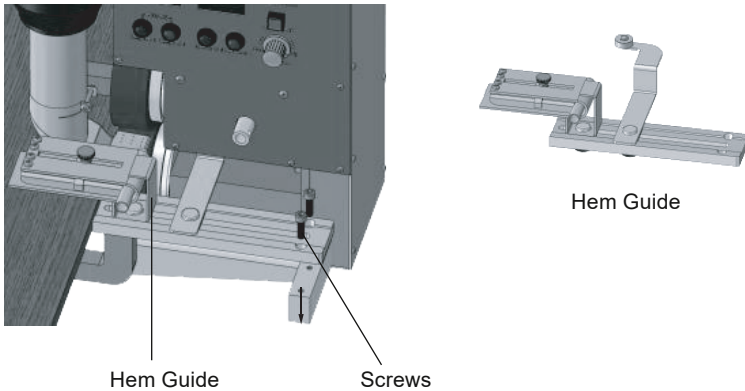


- Install the main machine: Rotate the fixed bracket handle to loosen the fixing bracket screw, place the machine on the workbench, determine the position, rotate the fixing bracket handle to tighten the fixing bracket screw, and finally fix the machine on the workbench.

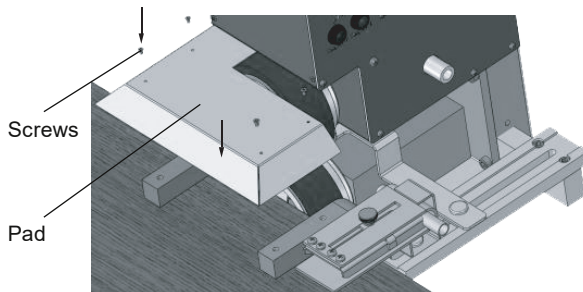


Machine Installation

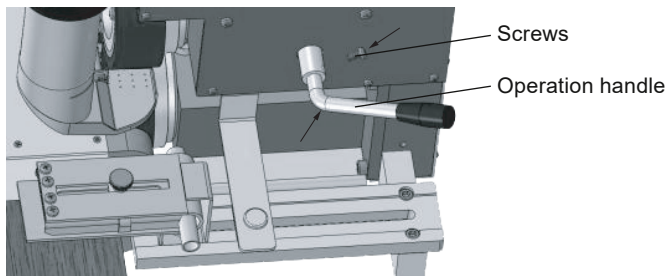
4. Mounting guide: Secure the guide to the main machinet with 2 screws as shown below.



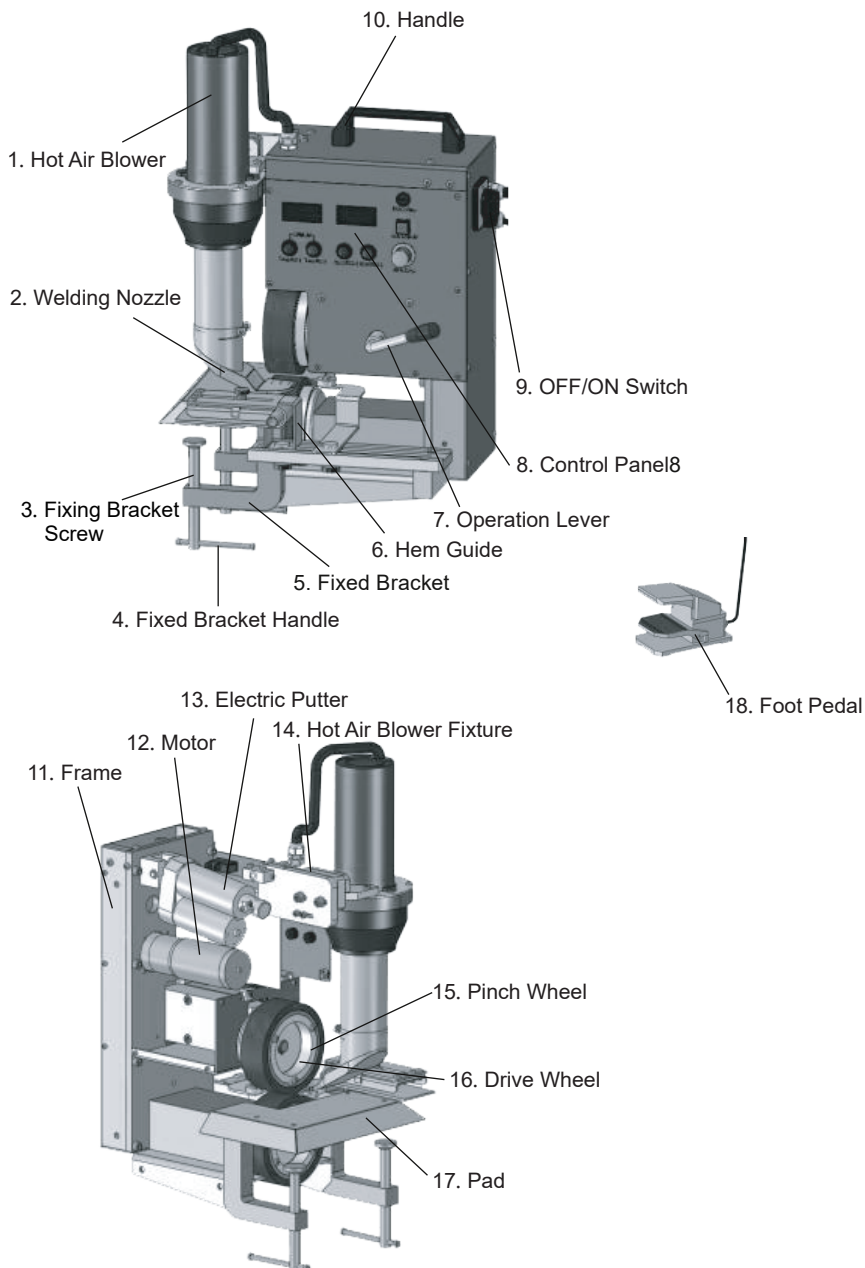
5. Mounting the pad: Secure the pad to the main machine with 4 screws as shown below.



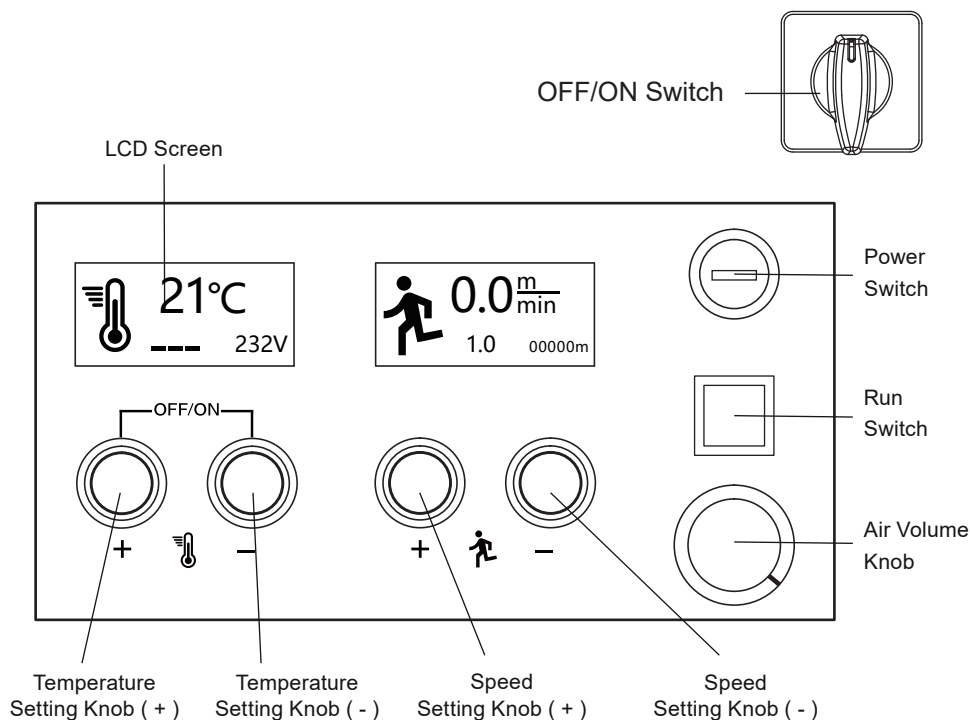
6. Install the lever: take out the lever, as shown in the figure below, insert the lever into the shaft and tighten with screws.



Main Parts



Control Panel



1. Power Switch: turn on or turn off the power of machine.
2. Turn on the power switch, the LCD display is as shown in Figure 1, at this time, the air blower is not heating and is blowing natural wind.



Fig 1

Control Panel

- Press the temperature up button and the temperature down button simultaneously. The display shows as Fig 2. At this time, the air blower starts to heat up to the setting temperature.



Fig 2

- Press the temperature up button and the temperature down button simultaneously again. At this time, the air blower stop heating and is blowing natural wind.
- Press the run switch when the welding nozzle is in the welding position, the drive wheel and the pressure roller start to rotate, and when the run switch is pressed again, the rotation stops.
- When the machine begins to walk, the display shows as Fig 3.



Fig 3

- Air Volume Knob: control the amount of airflow, increase the air volume clockwise, and reduce the air volume counterclockwise.

Setting Welding Parameters

- Welding Temperature:

Use buttons $+$  $-$ to set the welding temperature according to the welded materials and ambient temperature. The LCD screen shows the setting temperature and current temperature.

- Welding Speed:

Use buttons $+$  $-$ to set the welding speed. The specific speed should match the welding temperature. The LCD screen shows the setting speed and current speed.

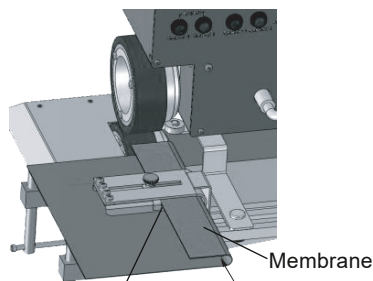
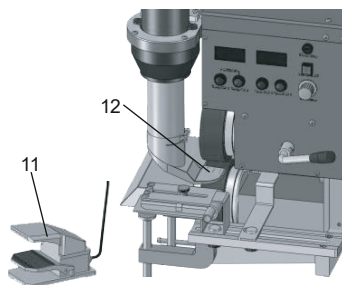
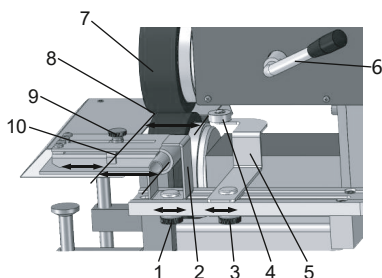
- Air Volume:

Use the knob  to set air volume. Increase the air volume clockwise and reduce the air volume counterclockwise. The maximum air volume can be used under normal conditions. When the ambient temperature is too low and the current temperature does not reach the set temperature, the air volume can be appropriately reduced.

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

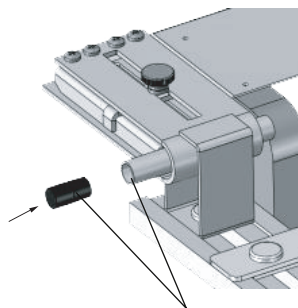
Welding and Adjustment Process Operations

1. Loosen 1 move 2, lock 1 when the distance A between the edge of 2 and the edge of 8 match the welding requires.
2. Loosen 9 adjust the position of 10 to align the right edge of 10 with the left edge of 8.
3. Loosen 3 move 5 to drive 4, lock 3 when the distance B between the edge of 4 and the edge of 8 match the welding requires. This can make 4 better position and guidance in the rope welding.
4. Press the operation lever 6 down to lower the upper pressure roller 7.
5. Step on the foot pedal 11, the welding nozzle 12 is in position with the air blower, and then the foot pedal 11 is depressed, and the welding nozzle 12 leaves the working position.

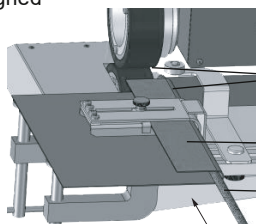


The membrane and the limit pad should be aligned

Hem welding



It needs the insulated plug to block the rope guide tube to prevent the hot air flowing back from the rope guide tube (not in the rope welding situation)



The pressure roller should be close to the membrane to limit and guide

Membrane

Rope

Rope welding

Welding Steps

1. Adjust guide position per Section 8. Use insulation plug if not rope welding.
2. Turn on machine, set temperature, speed, and air volume per Section 7.
3. Feed material through hem guide, press lever until pinch wheel contacts material.
4. When temperature is reached, step on foot pedal to lower nozzle and start welding.
5. After welding, step pedal again to raise nozzle and stop wheels.

Welding Precautions

1. Please be noticed: Before starting the welding, it must be ensured that the welding preheating temperature has been reached, and the general heating time takes 3-5 minutes.
2. For the change of different specifications and materials, the welding test shall be carried out according to the welding procedure of the material manufacturer and the national standard or regulations before welding, and the test results shall be tested. After achieving satisfactory results, mass production begins. If necessary, adjust the process according to the test results.
3. Since the fabric is soft and easy to move, it is necessary to manually assist the edge of the flange to abut the limit of the hem guide device during the welding process. Maintain proper tension on the fabric throughout the welding process.
4. When the machine is turned on and the work button or the foot pedal is pressed, the hot air blower will automatically sway into the nozzle and will protrude between the base material and the flange, and the drive motor will automatically open. Therefore, it is necessary to install the welding cloth clamping roller before this.
5. After the welding is completed, the foot pedal is stepped on again, and the air blower will automatically lift up and leave the welding position. The drive motor stops automatically. The heating should be turned off at this time. Wait for the hot air blower to cool down before turning it off.
6. To fold the outer cover of the machine, please disconnect the power supply first. Avoid injury.
7. Pay attention to the local power supply voltage in accordance with the nominal voltage of the machine. Over-voltage and under-voltage can cause damage to the machine.

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.



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 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

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 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