



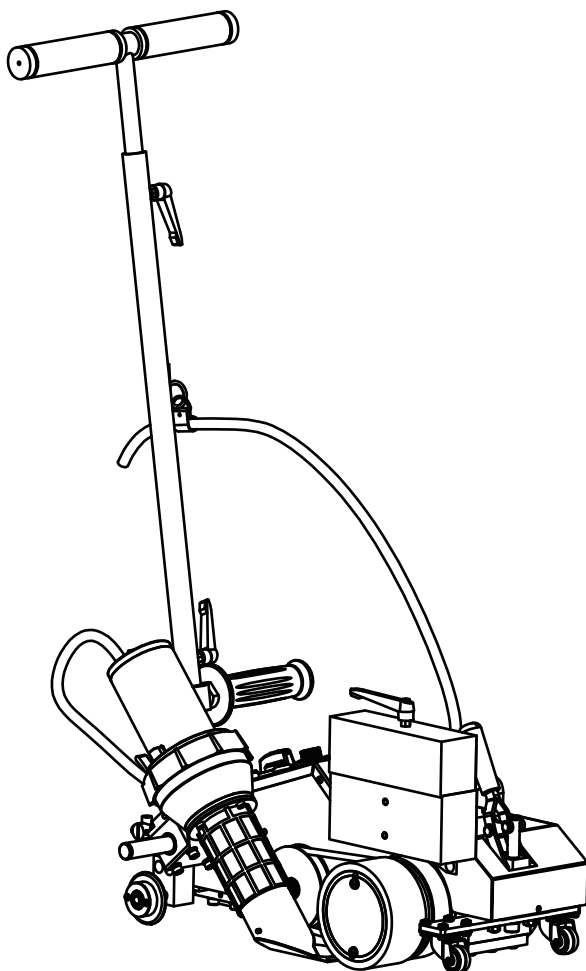
Lesite Technology

LST-RM1

Roofing Hot Air 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 PVC-P, PE, TPO, ECB, CSPE, EPDM, PVDF and other Coated fabric covering, foil and homogeneous or coating sealing film and PE coating fabric.



Precautions



Unplug the welder before disassembling it to avoid 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 and 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 high temperature.



It is strictly forbidden to use the welding machine in water or muddy ground, avoid soaking, rain or damp.

Parameter

Model	LST-RM1 
Rated Voltage	230 V
Frequency	50 Hz
Rated Power	3600 W
Welding Temperature	60 - 650 °C
Welding Speed	1.0 - 10.0 m/min
Seam Width	40 mm
Net Weight	23 Kg
Size	530 × 330 × 280 mm
Motor	Brushless
Air Volume	Stepless Adjustable
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 Centre



ROOFING WELDING MACHINE

Model: LST-RM1

Voltage: 230V/50Hz

Power: 3600W

Temperature: 60-650°C

Welding Speed: 1.0-10.0m/min

Welding Seam: 40mm

Weight: 23Kg

SN: See Machine Frame

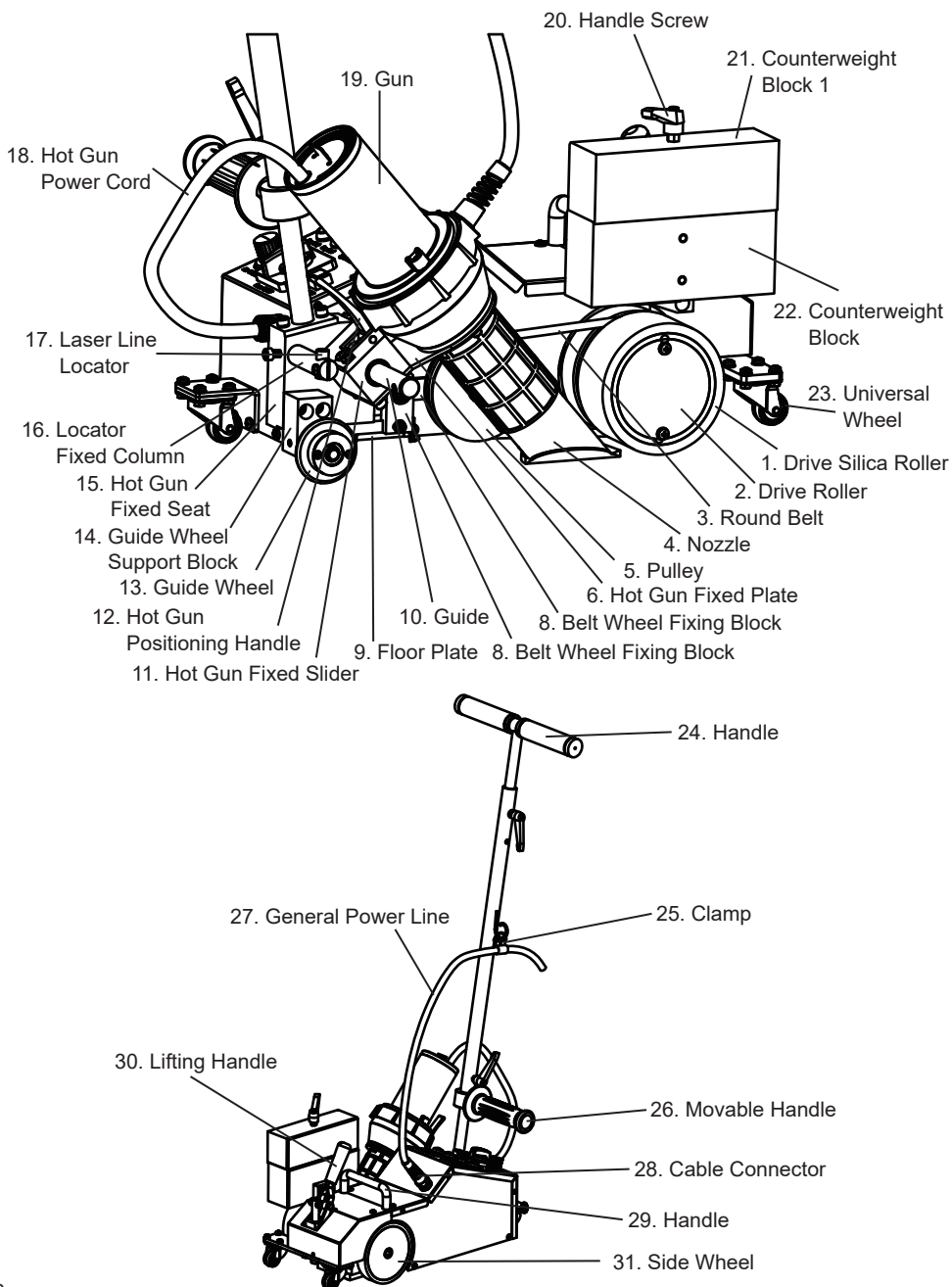
Fuzhou Lesite Plastics Welding Technology Co., LTD

www.lesiteweld.com

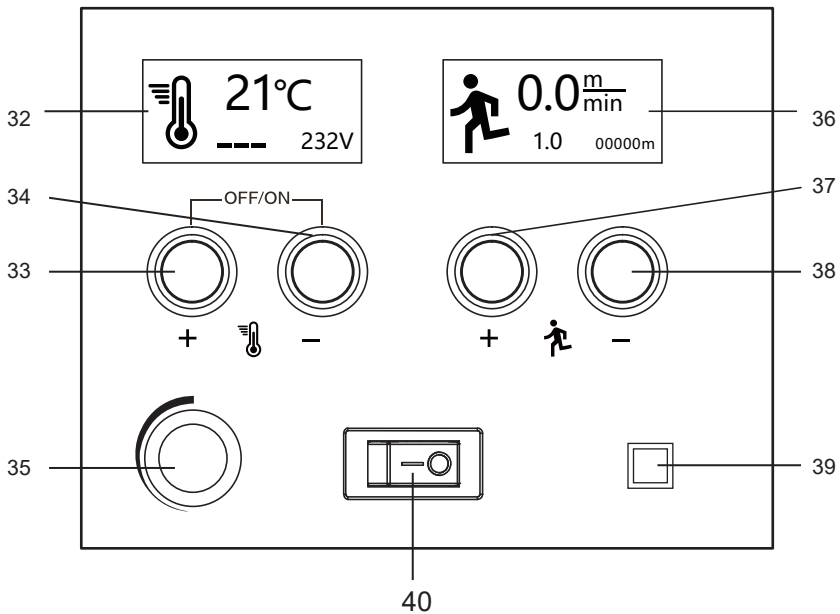
info@lesite.com.cn



Main Parts



Controller Panel



1. ON/OFF switch (40) is used to open the main power of the welder.
2. Open ON/OFF switch (40), LCD display is shown as figure 1, the hot air blower is under natural wind without heating.



Figure 1

3. Press the button (34) and (35), the screen shows as Figure 2 and the hot air blower starts to heat until it reaches the setting temperature.



Figure 2

Controller Panel

4. If press the bottoms (33) and (34) at the same time, LCD display shows as figure 1, the hot air blower is under natural wind without heating.
5. When the welding nozzle is at the right position, press the moving switch (39) 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.



Figure 3

7. The knob (35) is used to adjust the air flow of the air gun, increase the air flow by rotating clockwise, and reduce the air flow by rotating counter-clockwise.

Welding Parameters Setting

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. Air Volume:

Using the button  on the panel to set the air volume, increase the air volume clockwise and reduce the air volume counterclockwise. When the ambient temperature is too low and the current temperature can not reach the set temperature, the air volume can be reduced appropriately.

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

Welding Steps

1. Setting welding parameters (see above).
2. When the temperature reaches the set value.
3. Welding machine positioning.
4. Pull up the positioning handle (12) of the air gun, lift the air gun (19), lower the air nozzle (4) and make it close to the submerged membrane. Move the air gun to the left to insert the air nozzle into the overlap membrane and make the air nozzle in place. At this time, the welding machine will walk automatically for welding.
5. Always pay attention to the position of the guide wheel (13) and adjust it by touching the handle (24) lightly if it deviates from the position.
6. Pull up the positioning handle (12) of the air gun after welding, move the air nozzle to the right until it stops, and rotate upward until it is locked.
7. After welding, press the button on the control panel at the same time (33) and (34) and make the air gun in the state of blowing cold air to cool the air nozzle.
8. Turn off the power supply with the power switch.

Positioning the Welder

Pressure Lift lever (30) to lift machine, move it to welding position (the edge of upper membrane should keep in the same alignment with Drive silica roller (1) and the edge of Guide wheel (13), as shown in Figure 4.

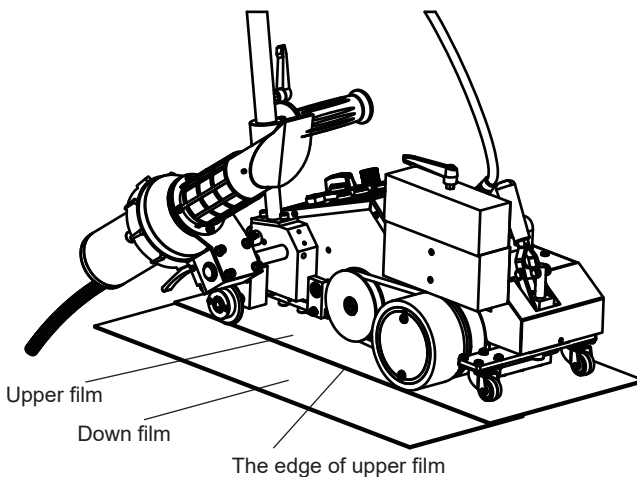
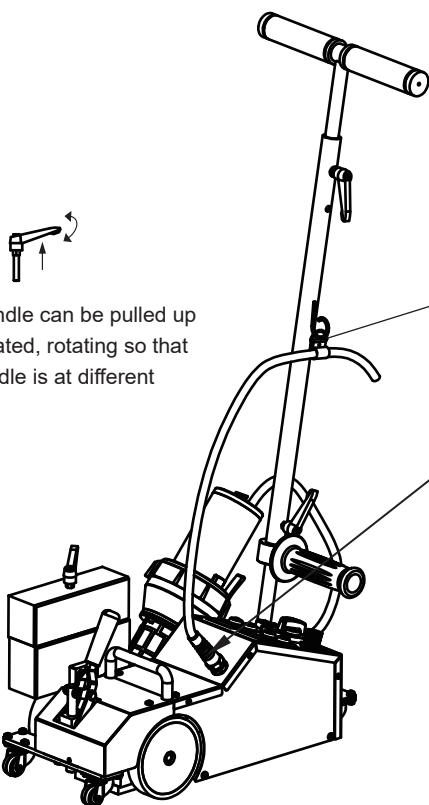


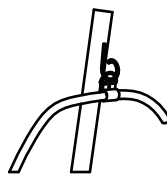
Figure 4

Instructions For Use

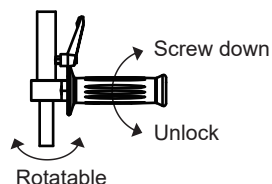
In order to prevent the machine from being damaged during transportation, the machine is fixed in the steel packing box with screws. When using the machine for the first time, it is necessary to loosen three machine fixing screws and take them out to remove the machine from the packing box.



The handle can be pulled up and rotated, rotating so that the handle is at different angles.



Power cord should be clamped on the hook to prevent cable joints from loosening.



Screw down

Unlock

Rotatable

Using Condition

1. The distance between hot air nozzle and ground should be shown as Figure 5 (We have adjusted the distance) .
2. The distance between hot air nozzle and Drive roller should be shown as Figure 6 (We have adjusted the distance) . You can adjust hot air nozzle adjusting screw Figure 7 if the distance is not right.

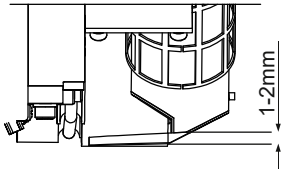


Figure 5

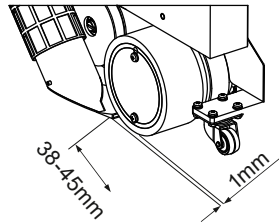
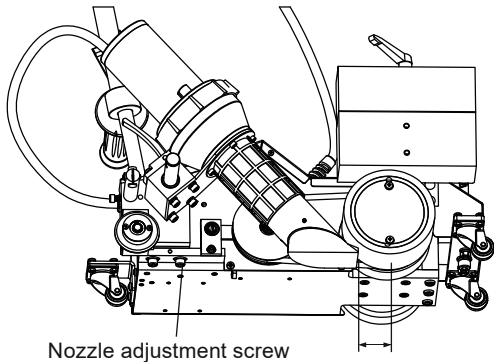


Figure 6



Nozzle adjustment screw

Nozzle and driving rubber wheel of interval

Figure 7

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 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.

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.
 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

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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