



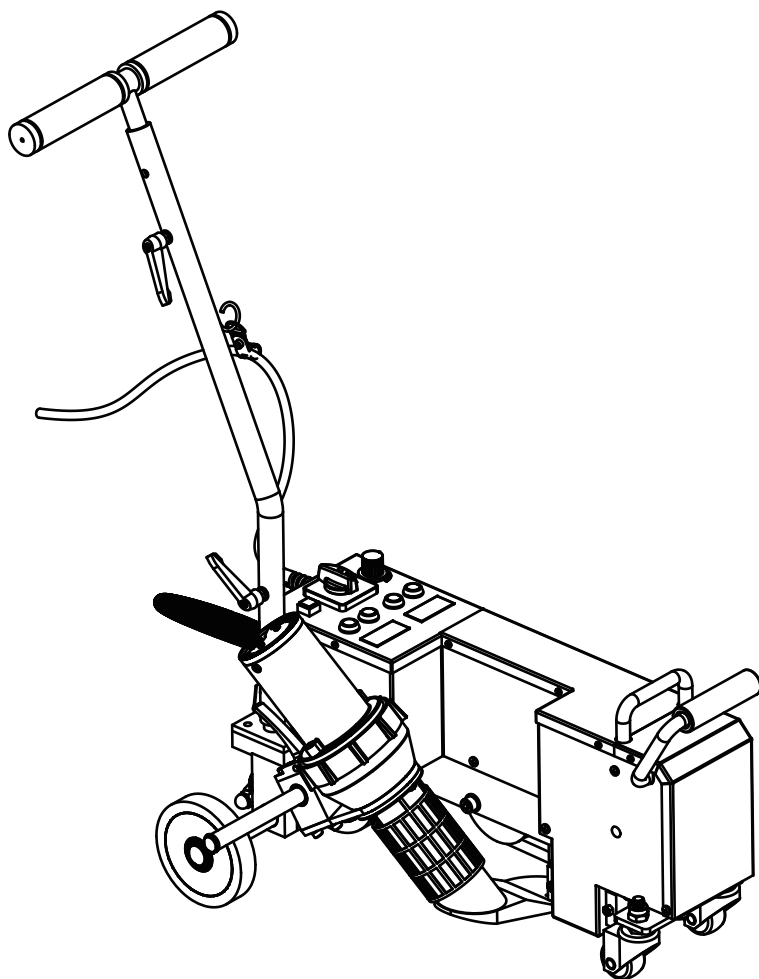
Lesite Technology

LST-WP4

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

The new generation roofing hot air welder LST-WP4 offers more application diversity with the welding of high quality thermoplastic waterproof membrane (PVC,TPO,EPDM, ECB,EVA, etc.) can be realized quickly in the gutter of the roof, near the edge of the gutter, near the parapet or in other narrow spaces.



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 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.



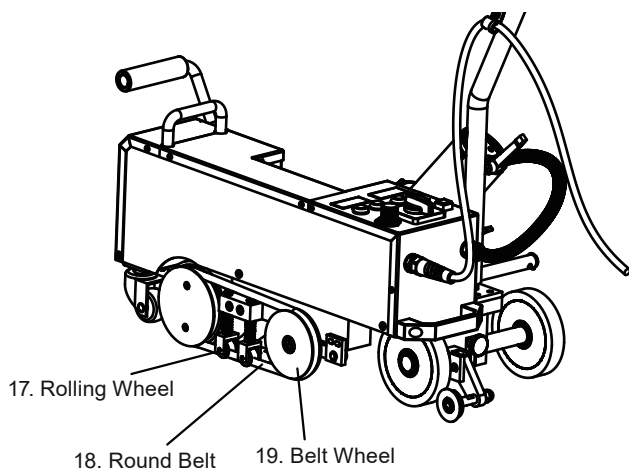
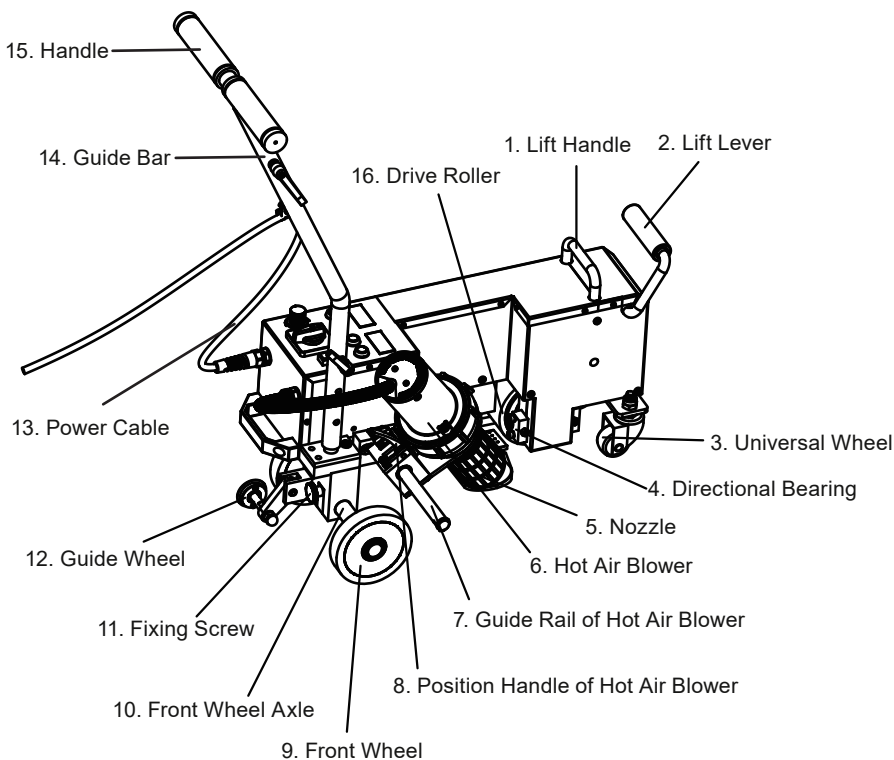
It is strictly forbidden to use the welding machine in water or muddy ground, avoid soaking, rain or damp.

Parameter

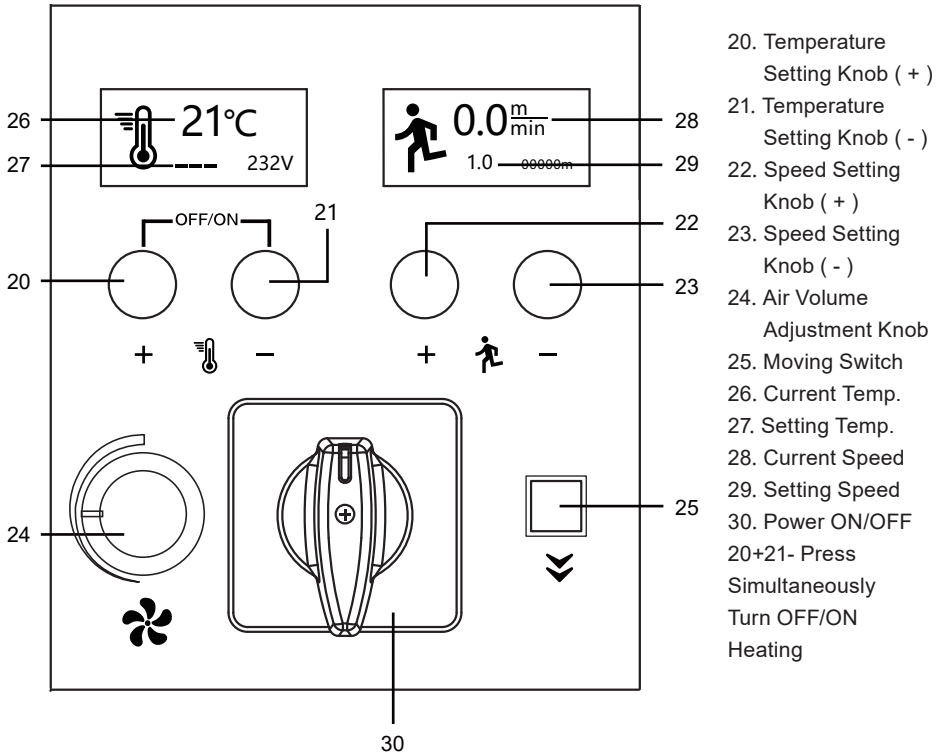
Model	LST-WP4
Rated Voltage	230 / 380 V
Frequency	50 Hz
Rated Power	4200 / 5200 W
Heating Temperature	60 - 650 °C
Welding Speed	1.0 - 10.0 m/min
Seam Width	40 mm
Net Weight	29 Kg
Size	557 × 316 × 295 mm
Motor	Brush
Air Volume	No Adjustable
Certificate	CE
Warranty	One Year

Model	LST-WP4 
Rated Voltage	230 / 380 V
Frequency	50 Hz
Rated Power	4200 / 5200 W
Heating Temperature	60 - 650 °C
Welding Speed	1.0 - 10.0 m/min
Seam Width	40 mm
Net Weight	29 Kg
Size	557 × 316 × 295 mm
Motor	Brushless
Air Volume	Stepless Adjustable
Certificate	CE
Warranty	One Year

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:

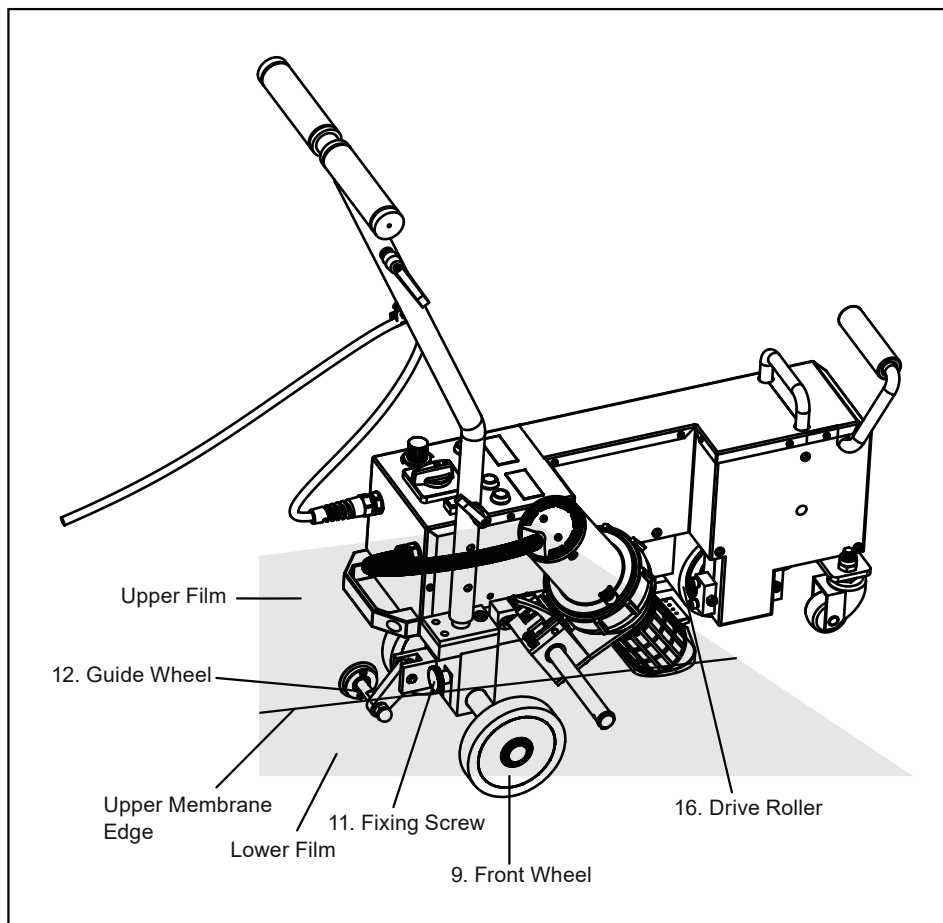
Using buttons **+**  **-** to set the required speed according to the welding temperature. LCD display will show the setting speed and the current speed.

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.

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

Positioning Before Welding



Press the Lifting Handle to raise the welding machine and move it to the welding position (the edge of the upper film is aligned with the side edge of the Drive Roller (16), and the edge of the upper film is also aligned with the edge of the Guide Wheel (12)), loosen the Fixing Screw (11) to adjust the position of the Front Wheel (9) from left to right, and tighten the Fixing Screw (11) after adjusting, as shown in this Figure.

Welding Nozzle Setting

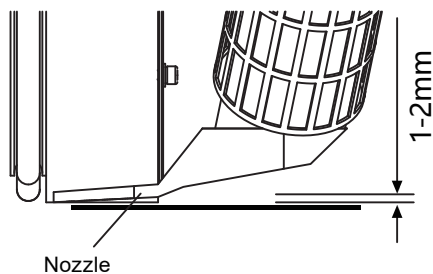


Fig 1

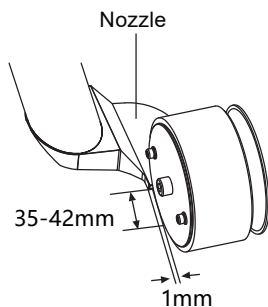


Fig 2

◆ The factory setting of the nozzle is shown in Fig 1 and Fig 2.

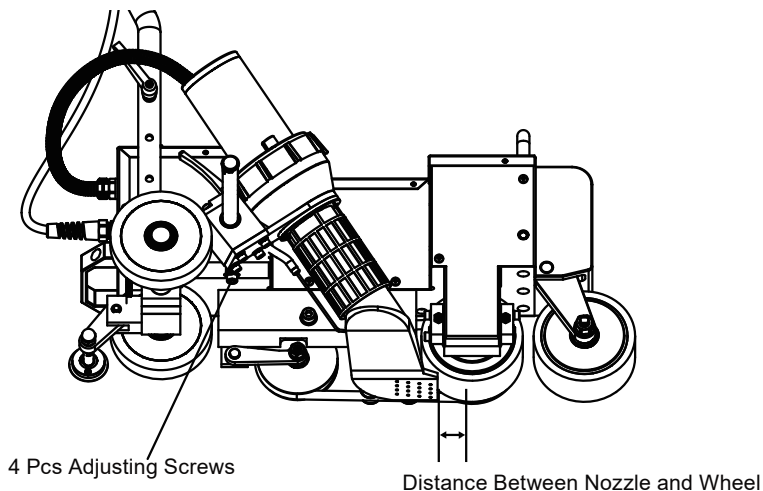


Fig 3

◆ Adjust the nozzle position as needed by adjusting the screws, as shown in Figure 3.

Boot Steps

Current Temp.



Current Speed

Current Speed

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.

Current Temp.



Current Speed

Current Speed

Setting Temp.

2. Press the buttons Temperature Rise (20) and Temperature Drop (21) 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 Speed Rise (22) to set speed. The LCD screens are shown as above.

Current Temp.



Current Speed

Current Speed

Setting Temp.

3. Pull up the Blower Location Handle (8), raise the Hot Air Blower (6), lower the Welding Nozzle (5) 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 (12) at all times. If the position deviates, you can touch the Operating Handle (15) to adjust.
5. After completing the welding work, remove the hot air 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 hot air nozzle to cool down after waiting for the temperature to drop to 60°C, and then turn off the power ON/OFF.

Nameplate

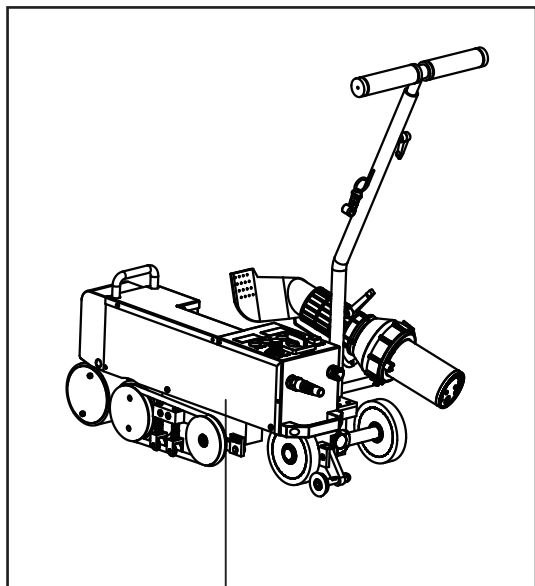
The model identification and serial number are marked on the nameplate of your machine. Please provide these data when consulting Lesite Sales and Service Center

 ROOFING HOT AIR WELDER Model: LST-WP4 Voltage: 230V/50Hz Power: 4200W Temperature: 60-650°C Welding Speed: 1.0-10.0m/min Welding Seam: 40mm Weight: 29Kg SN: See Machine Frame Fuzhou Lesite Plastics Welding Technology Co., LTD www.lesiteweld.com info@lesite.com.cn 	 ROOFING HOT AIR WELDER BL MOTOR Model: LST-WP4 Voltage: 380V/50Hz Power: 5200W Temperature: 60-650°C Welding Speed: 1.0-10.0m/min Welding Seam: 40mm Weight: 29Kg SN: See Machine Frame Fuzhou Lesite Plastics Welding Technology Co., LTD www.lesiteweld.com info@lesite.com.cn 
---	--

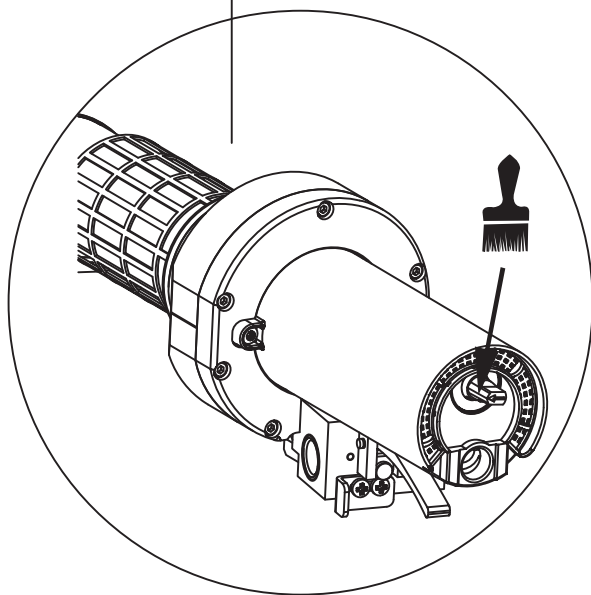
Fault Codes

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  319V	Voltage Below 180V Alarm Voltage Below 320V Alarm	Raise Voltage Raise Voltage
 251V  431V	Voltage Above 250V Alarm Voltage Above 430V Alarm	Reduce Voltage Reduce Voltage
 281V  461V	Voltage Reaching 280V Alarm Voltage Reaching 460V Alarm	Cut off the power, reduce voltage Cut off the power, reduce voltage

Daily Maintenance



Use steel brush to clean the hot air nozzle.



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

Default Accessories

- Spare Heating Element
- Steel Brush
- Phillips Screwdriver
- Fuse 4A
- Anti-hot Plate
- Slotted Screwdriver
- Allen Wrench (M3, M4, M5, M6)

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.

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