



Lesite Technology

LST-RM1

Roofing Hot Air Welder

Manual





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

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 tools before opening it to avoid of being hurt by exposed wires or component inside the machine with power.



Incorrect use of it can 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 hot air flow in the direction of people or animals.



The voltage rating stated on the welder must correspond to line/mains voltage (120V). 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.



Parameter

Model	LST-RM1 
Voltage	230 V
Frequency	50 Hz
Power	3600 W
Temperature	50 - 620 °C
Welding Speed	1~10 m/min
Welding Width	40 mm
Size(L*W*H)	530 × 330 × 280 mm
Motor	Brushless
Weight	20 Kg
Certification	CE
Warranty	One year

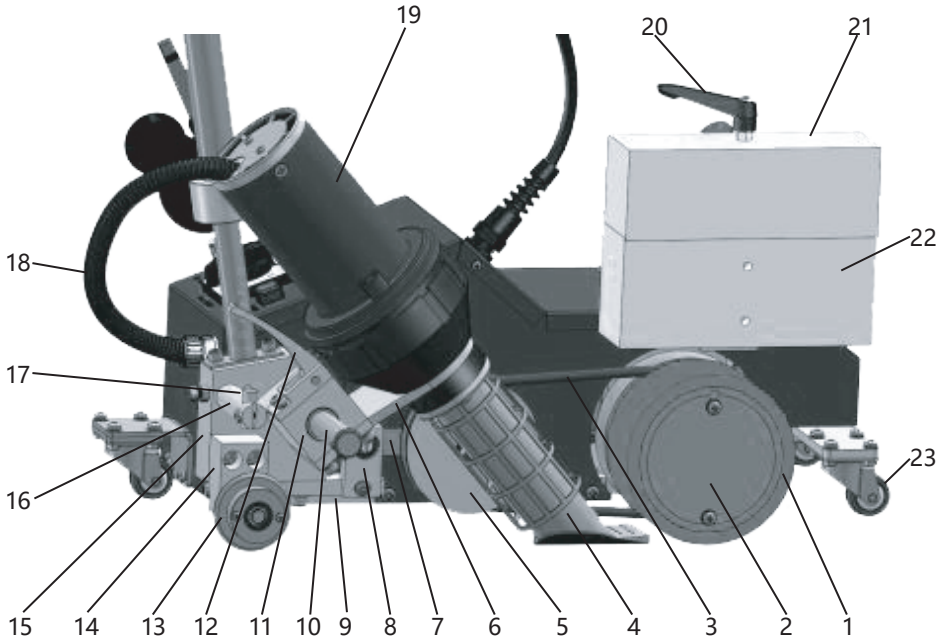
Nameplate

The model identification and serial number identification are marked on the nameplate of the machine you choose.

Please provide these data when consulting Lesite Sales and Service Center.

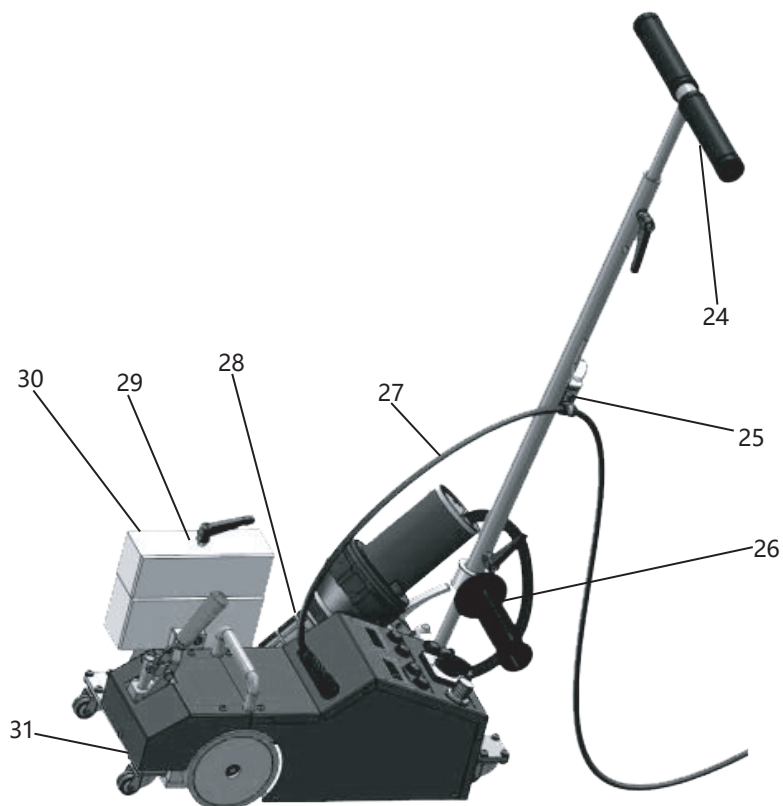
	ROOFING WELDING MACHINE	
Model : LST-RM1	Voltage : 230V	
Power : 3600W	Temperature : 50-620°C	
Speed : 1.0-10m/min	Welding Seam : 40mm	
Net Weight : 20 KG	SN : See Machine Frame	
Fuzhou Lesite Plastics Welding Technology Co., LTD		
www.lesiteweld.com		
info@lesite.com.cn		
		

Main Parts



- 1、 Drive Silica Roller
- 2、 Drive Roller
- 3、 Round Belt
- 4、 Nozzle
- 5、 Pulley
- 6、 Hot Gun Fixed Plate
- 7、 Pulley Connecting Rod
- 8、 Belt Wheel Fixing Block
- 9、 Floor Plate
- 10、 Guide
- 11、 Hot Gun Fixed Slider
- 12、 Hot Gun Positioning Handle
- 13、 Guide Wheel
- 14、 Guide Wheel Support Block
- 15、 Hot Gun Fixed Seat
- 16、 Locator Fixed Column
- 17、 Laser Line Locator
- 18、 Hot Gun Power Cord
- 19、 Gun
- 20、 Handle Screw
- 21、 Counterweight Block 1
- 22、 Counterweight Block
- 23、 Universal Wheel

Main Parts



24、 Handrail

26、 Movable Handle

28、 Cable Connector

30、 Lifting Handle

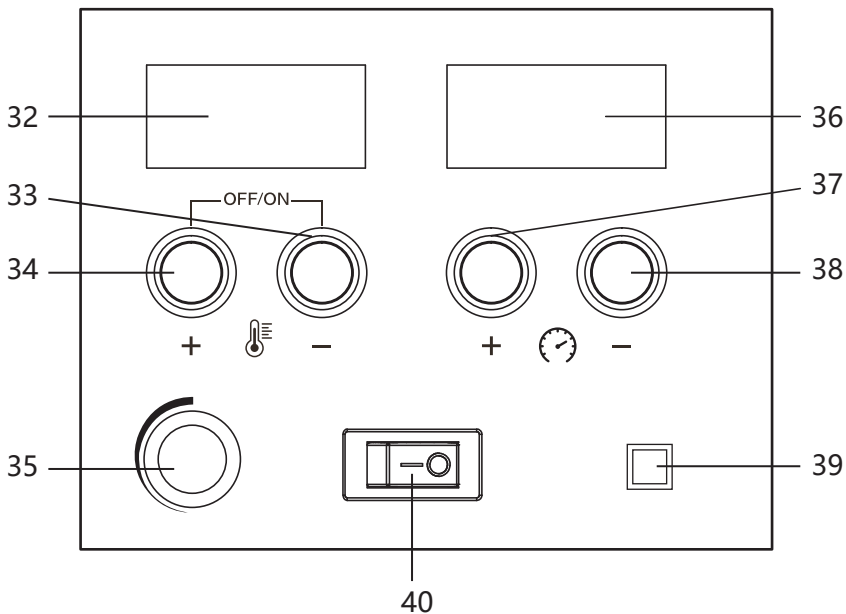
25、 Clamp

27、 General Power Line

29、 Handle

31、 Side Wheel

Controller Panel



- 1、 ON/OFF switch (40) is used for 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 to 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 bottoms +  - 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 bottoms +  - 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.

- The machine has a memory function parameters, namely when you use the welder next time, the welder will automatically use the last set of parameters without having to re-set parameters.

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.

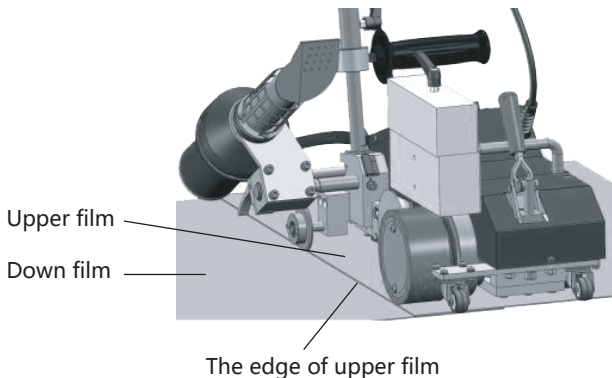
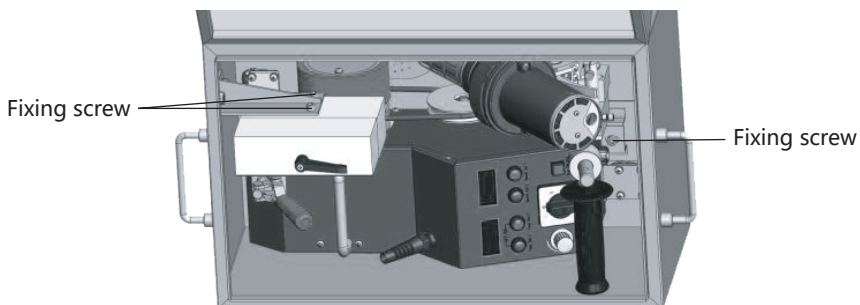
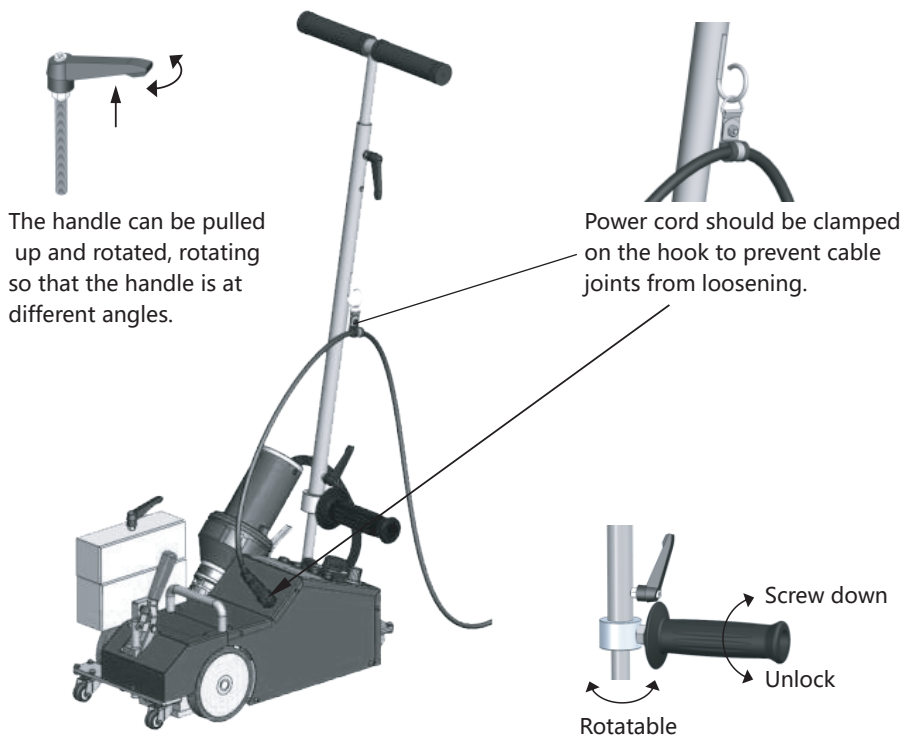


Figure 4

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, as shown in the figure above.



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.

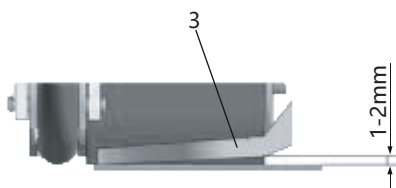


Figure 5

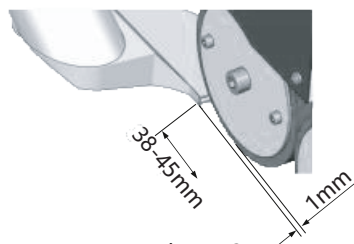


Figure 6

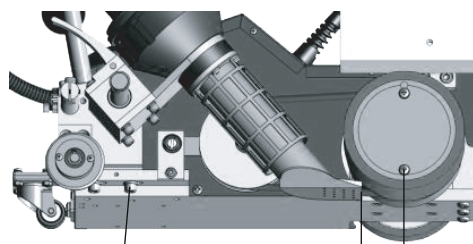


Figure 7

Nozzle adjustment screw

(Nozzle and driving rubber wheel of interval)

Quality Assurance

- This product guarantees a 12-month shelf life 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.

Error Code

Error Code	Description	Measures
Error T002	No thermocouple detected	1.Check thermocouple connection 2.Replace thermocouple
Error S002	No heating element detected	1.Check heating element connection 2.Replace heating element
CT:999 Err-T001	Thermocouple failure in operation	1.Check thermocouple connection 2.Replace thermocouple
Error FANerr	Overheating	1.Check hot air blower 2.Clean nozzle and filter
PROPmode ST:100	Operation mode without thermocouple	under this mode, the temperature can be set for emergency use
ThermocoupleERR	No thermocouple detected	1.Check thermocouple connection 2.Replace thermocouple

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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