

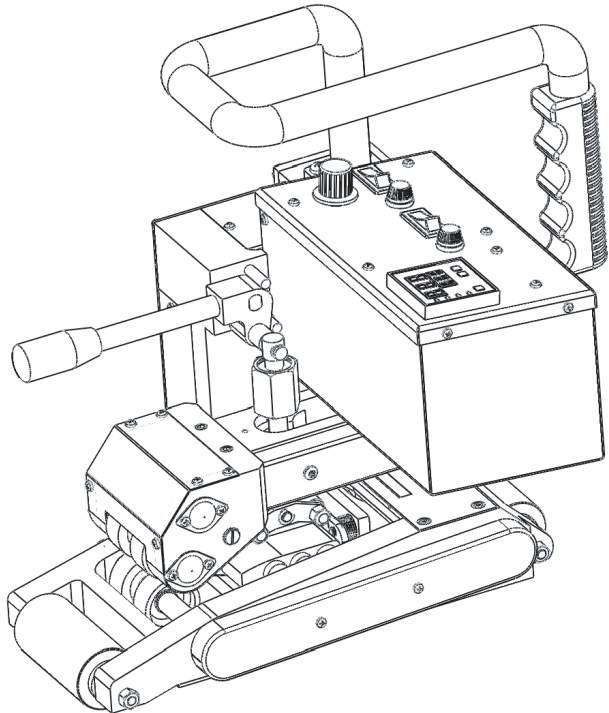


Lesite Technology

LST900/900D

Hot Wedge Welder

Manual





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

This machine adopts an advanced hot wedge structure, which has better heating efficiency and faster welding speed. It is specially for welding 1.0mm-3.0mm HDPE, LDPE, PP, TPO, PVC

Application

- Solid Waste Landfills
- Sewage Treatment
- Anti-seepage Project
- Chemical Mining
- Water Conservancy
- Aquaculture



Precautions



Please confirm that the machine is turned off and unplugged before disassembling the welding machine, so as not to be injured by live wires or components inside the machine.



The welding machine generates high temperature and high heat, which may cause fire or explosion when used incorrectly,



especially when it is close to combustible materials or explosive gas. Please do not touch the hot wedge (during welding work or when the welding machine has not completely cooled down) so as not to burn.



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.



In order to ensure the safety of the operators and the reliable operation of the equipment, the power supply at the construction site must be equipped with a regulated power supply and a leakage protector.



The welding machine must be operated under the correct control of the operator, otherwise it may cause combustion or explosion due to high temperature.



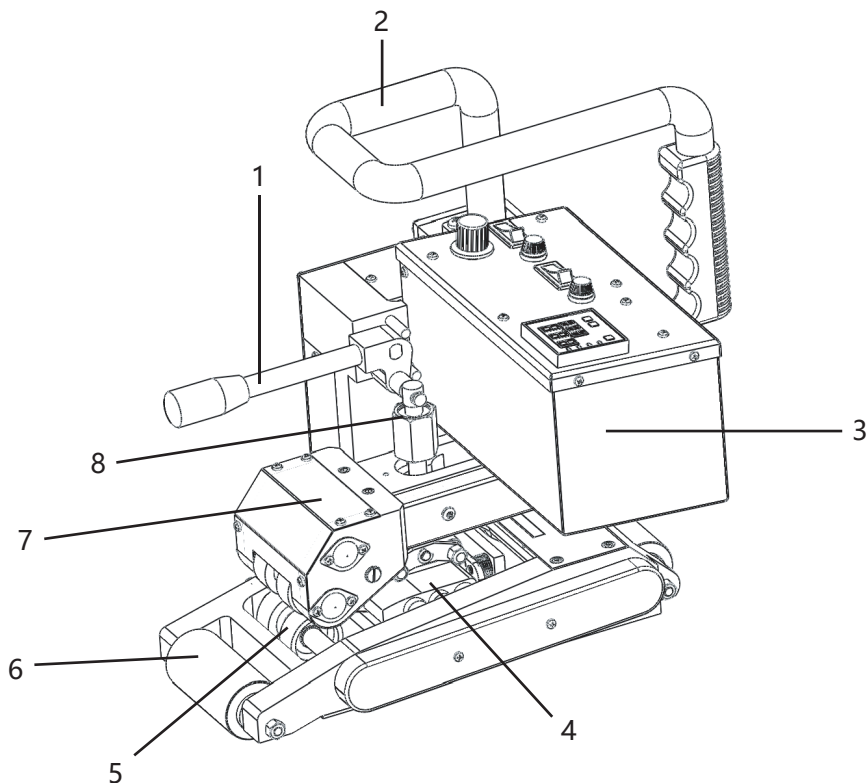
It is strictly forbidden to use the welding machine in water or muddy ground, avoid soaking, rain or damp.

Parameter

Model	LST900
Rated Voltage	230 V / 120 V
Frequency	50 / 60 Hz
Power	1800 W / 1650 W
Welding Speed	1 - 5 m/min
Heating Temperature	50 - 450 °C
Welding Pressure	100-1000N
Thickness Welded	1.0 mm - 3.0 mm (Single Layer)
Overlap Width	12 cm
Seam Width	15 mm *2 , Interior Cavity 15mm
Seam Strength	≥ 85 % Material
Net Weight	13.0 Kg
Digital Display	Temperature
Certificate	CE
Warranty	One Year

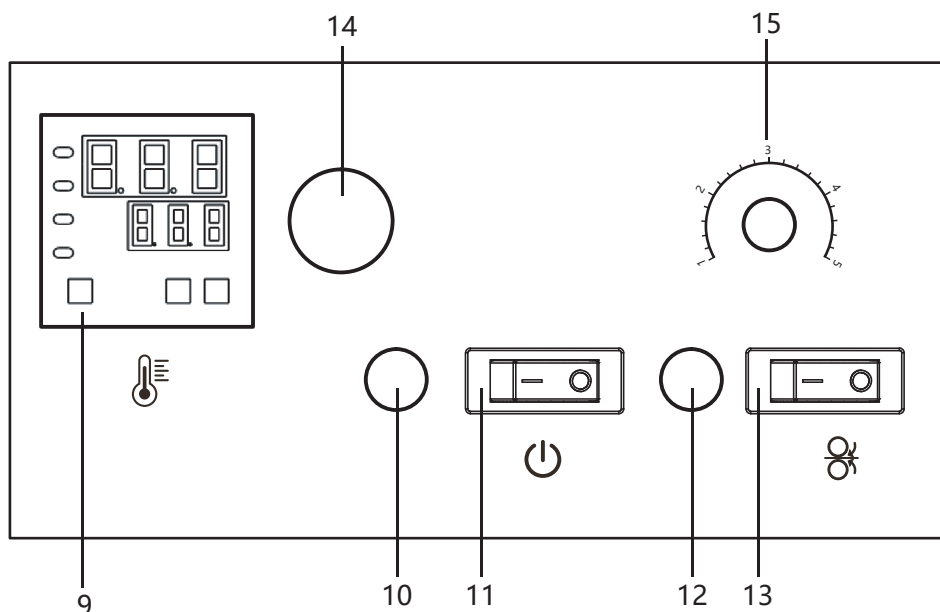
Model	LST900D
Rated Voltage	230 V / 120 V
Frequency	50 / 60 Hz
Power	1800 W / 1650 W
Welding Speed	1 - 5 m/min
Heating Temperature	50 - 450 °C
Welding Pressure	100-1000N
Thickness Welded	1.0 mm - 3.0 mm (Single Layer)
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Seam Strength	≥ 85 % Material
Net Weight	13.0 Kg
Digital Display	Temperature and Speed
Certificate	CE
Warranty	One Year

LST900 Main Parts



- | | | |
|--------------------|------------------------|-------------------|
| 1、 Pressure Handle | 2、 Operation Handle | 3、 Control Box |
| 4、 Hot Wedge | 5、 Pressure Roller | 6、 Creeping Wheel |
| 7、 Swing Head | 8、 Pressure Adjustment | |

LST900 Control Panel



9、Temperature Controller

10、Power Fuse

11、Power Switch

12、Motor Fuse

13、Motor Switch

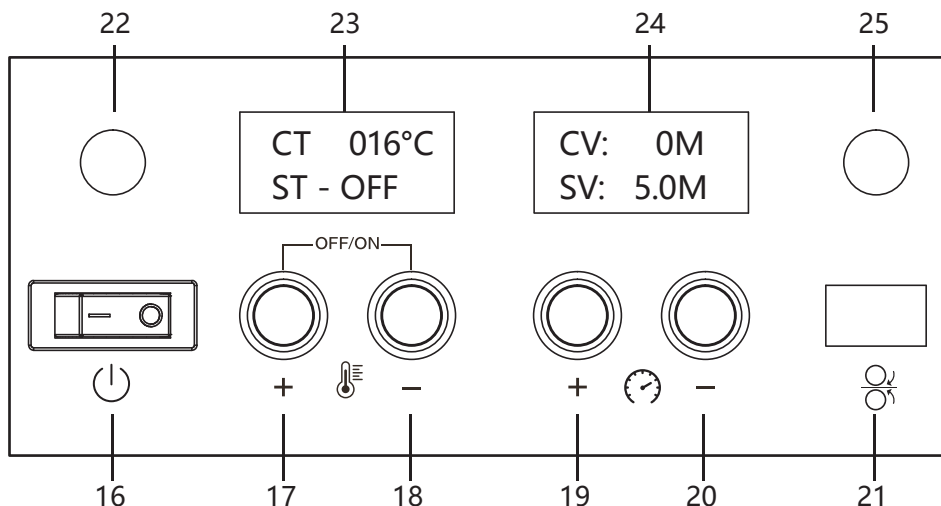
14、Voltmeter

15、Speed Control Knob

Steps for Machine On/Off

- 1、Connect the power supply, lift up the pressure handle (1) and the pressure roller (5) to separate automatically, and press the power on/off switch(11)
- 2、Check whether the voltage value displayed on the voltmeter (14) is normal
- 3、Turn on the temperature controller (9), set to the temperature required for welding, and wait for the temperature to reach the preset value
- 4、Turn on the motor switch (13) and set the speed control knob (15) to the required figure
- 5、Place the welding machine and insert the membrane layers
- 6、Put down the pressure handle (1) , the machine starts to move and weld
- 7、Keep observing the welding trail and the position of the upperlayer and lower layer sat any time to adjustincase of deviation
- 8、After finishing welding, lift up the pressure handle (1), and move the machine away from the welding position
- 9、Turn off the motor switch (13), turn off the temperature controller (9), the hot wedge stops heating
- 10、Turn off the power switch (11)

LST900D Control Panel



16、Power Switch

18、Temperature Drop Knob

20、Speed Down Knob

22、Power Fuse

24、Welding Speed Display

17、Temperature Rise Knob


19、Speed Increase Knob

21、Motor Switch


23、Welding Temperature Display

25、Motor Fuse


1. Welding temperature:

Press the buttons +  - on the panel to set the required welding temperature , which depends on the welding material and ambient temperature. The LCD screen will display the preset temperature and the current actual temperature.

2. Welding speed:

Press the buttons +  - on the panel to set the required welding speed, which matches the welding temperature. The LCD screen will display the preset speed and the current actual speed.

3. Motor is on:

Press  the motor moves

- This machine has a parameter storage memory function that the welding machine will automatically use the last parameters without resetting the parameters when the machine is turned on next time.

LST900D Switching Steps



Drawing 1

- 1、 Connect the power supply, lift up the pressure handle (1) and the pressure roller (5) to separate automatically
- 2、 Turn on the power switch (16), the LCD screen displays as shown in drawing 1 While the hot wedge has not started to heat up



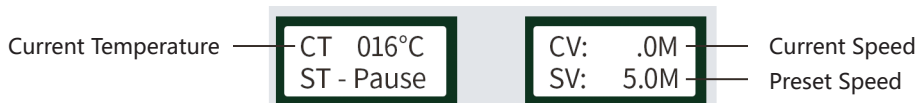
Drawing 2

- 3、 Turn the temperature rise knob (17) so the LCD screen displays as shown in drawing 2 While the hot wedge starts to heat until the actual temperature is equal to the preset temperature



Drawing 3

- 4、 Turn on the motor switch (21), and turn the speed knobs (19) (20) to set the required welding speed (the LCD screen displays as shown in Drawing 3.), then insert the membrane layers after placing the machine
- 5、 Put down the pressure handle (1) , the machine starts to move and weld
- 6、 Keep observing the welding trail and the position of the upper layer and lower layer at any time to adjust in case of deviation
- 7、 After finishing welding, lift up the pressure handle (1),move the machine away from the welding position



Drawing 4

- 8、 Turn off the motor switch (21) , press the temperature rise knob (17) and the temperature drop knob at the same time (18) (As shown in drawing 4), or turn the temperature drop knob to "OFF" , the hot wedge will stop heating
- 9、 Turn off the power switch

Fault & Solutions

Fault	Causes	Solutions
Screen shows nothing	Power failure or low voltage	Check the voltage and power wire
	Power fuse has blown	Replace fuse 15A
	Power switch doesn't work	Replace the power switch
Motor doesn't move	Motor fuse has blown	Replace fuse 1A
	Power switch doesn't work	Replace the power switch
	Motor doesn't work	Replace the motor
	Drive board fuse has blown	Replace the drive board fuse
	Drive board doesn't work	Replace the drive board
Speed knob can't be adjusted or the motor moves at a abnormal speed	Speed knob doesn't work	Replace the speed knob
	Sensor can't detect the data	Replace the photo sensor board and sensor wire
	Drive board doesn't work	Replace the drive board
Hot wedge doesn't heat	Heating tubes do not work	Replace the heating tubes
	Hot wedge doesn't work	Replace the hot wedge
	Drive board doesn't work	Replace the drive board

Fault & Solutions

Fault	Causes	Solutions
Hot wedge burned	Thermocouple failure	Replace the thermocouple
	Drive board doesn't work	Replace the drive board
	Wires "+" and "-" of thermocouple were connected wrongly	Connect correctly
Shows on display "thermoc-ouple ERR"	No thermocouple	Check whether the thermocouple wire in the display board is off
	Thermocouple burned	Replace the thermocouple
Shows on display "CT:016°C ST: Pause"	Stop heating	Press two buttons at the same time so that it heats
Shows on display: Mosaicgarbled	Display screen or board doesn't work	Change the display screen or board

LST900/900D Nameplate



GEO HOT WEDGE WELDER

Model: LST900
Welding Thickness: 1.0-3.0mm
Speed: 1.0-5.0m/min
Overlap width: 12cm
Welding Seam: 15mm*2

Voltage: 230V 50/60Hz
Power: 1800W
Temp.: 50-450°C
Weight: 13Kg
SN: see machine frame

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GEO HOT WEDGE WELDER

Model: LST900D
Welding Thickness: 1.0-3.0mm
Speed: 1.0-5.0m/min
Overlap width: 12cm
Welding Seam: 15mm*2

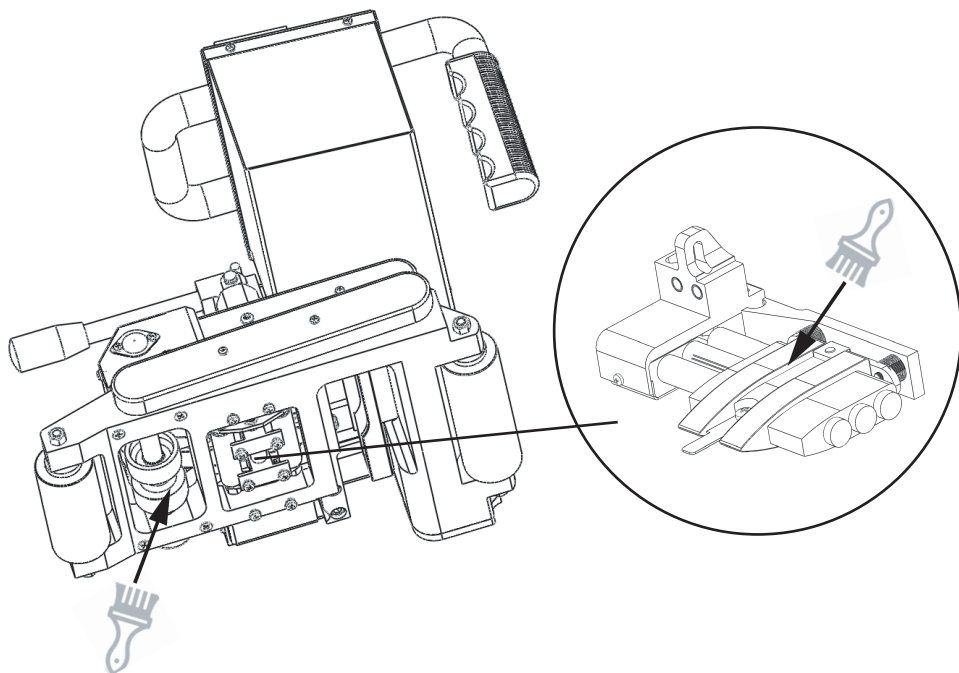
Voltage: 230V 50/60Hz
Power: 1800W
Temp.: 50-450°C
Weight: 13Kg
SN: see machine frame

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Maintenance

Do clean the hot wedge and pressure rollers after welding



Warranty

- 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.

Maintenance

- 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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