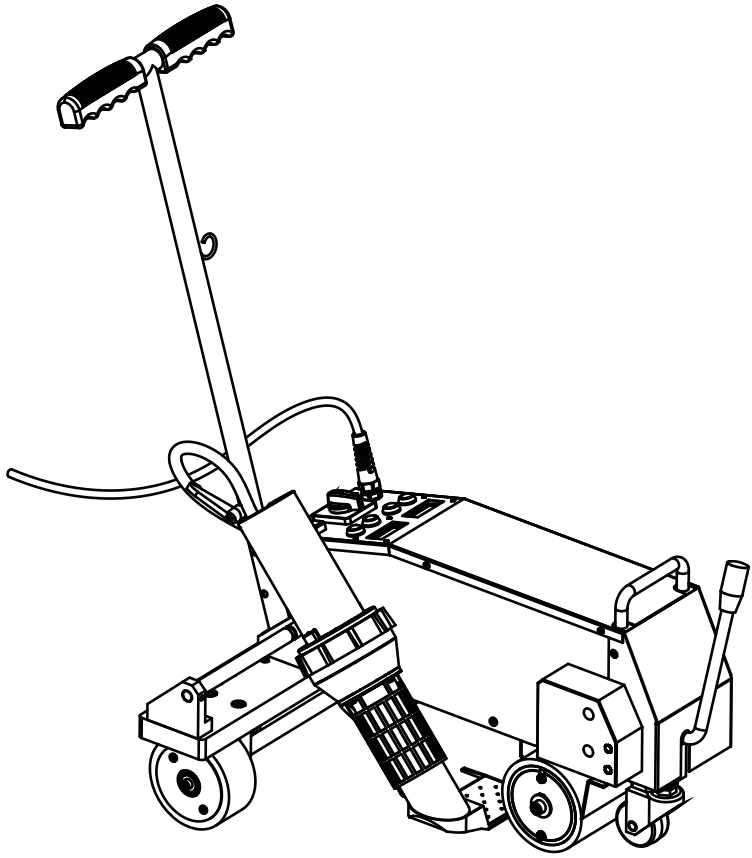
Lesite Technology

LST-WP2

Bitumen 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 overlap welding modified SBS bitumen waterproofing film materials.

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.

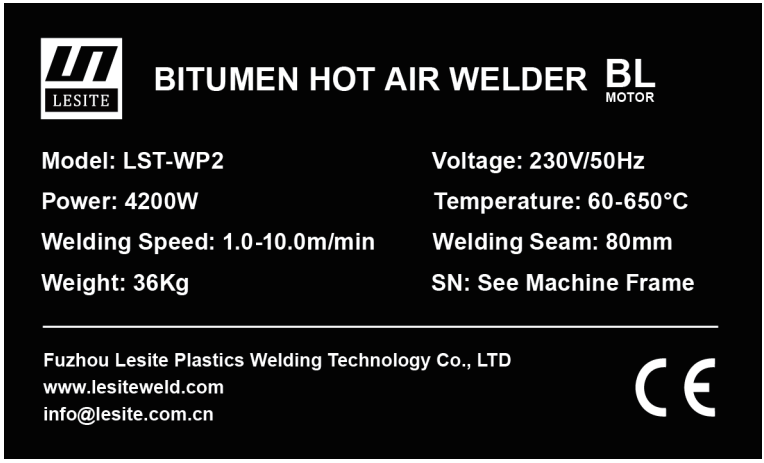
It is strictly forbidden to use the welding machine in water or muddy ground, avoid soaking, rain or damp.

Parameter

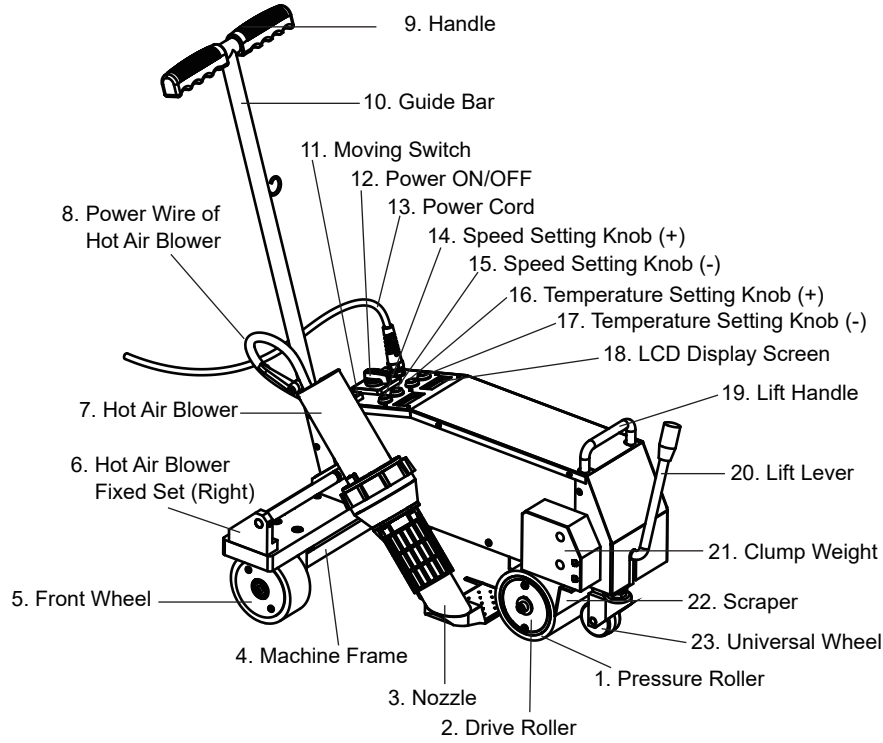
Model	LST-WP2
Rated Voltage	230 / 380 V
Frequency	50 Hz
Rated Power	4200 / 5200 W
Heating Temperature	60 - 650 °C
Welding Speed	1.0 - 10.0 m/min
Seam Width	80 mm
Net Weight	36 Kg
Size	543 × 370 × 320 mm
Motor	Brushless
Air Volume	Stepless Adjustable
Certificate	CE
Warranty	One Year

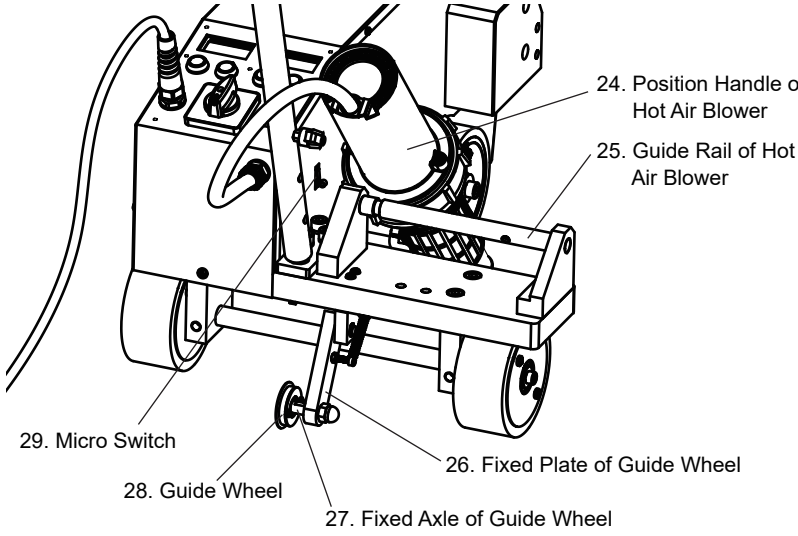
Nameplate

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



Main Parts


9. Handle
10. Guide Bar
11. Moving Switch
12. Power ON/OFF
13. Power Cord
14. Speed Setting Knob (+)
15. Speed Setting Knob (-)
16. Temperature Setting Knob (+)
17. Temperature Setting Knob (-)
18. LCD Display Screen
19. Lift Handle
20. Lift Lever
21. Clump Weight
22. Scraper
23. Universal Wheel
1. Pressure Roller
2. Drive Roller
3. Nozzle
4. Machine Frame
5. Front Wheel
6. Hot Air Blower Fixed Set (Right)
7. Hot Air Blower
8. Power Wire of Hot Air Blower


24. Position Handle of Hot Air Blower
25. Guide Rail of Hot Air Blower
26. Fixed Plate of Guide Wheel
27. Fixed Axle of Guide Wheel
28. Guide Wheel
29. Micro Switch

Controller Panel

1. Power ON/OFF (12) is used for open the main power of the welder.
2. Open Power ON/OFF (12), LCD display is shown as Fig 1,the hot air blower is under natural wind without heating.

Fig1

3. Press the buttons +  − , the screen shows as Fig 2 and the hot air blower starts to heat until to the setting temperature.

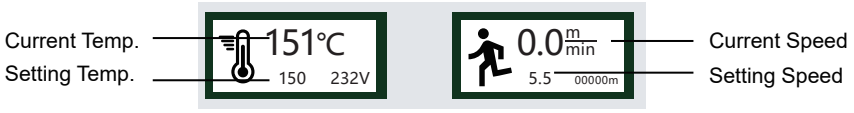


Fig2

4. If press the bottoms +  − at the same time, LCD display shows as Fig 1, the hot air blower is under natural wind without heating.
5. When the hot air nozzle is at the right position, press the moving switch (11) 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 Fig 3.

Fig3

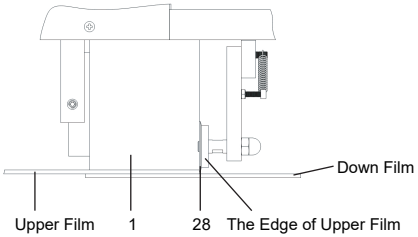
1. Welding temperature:
Using bottons +  − on the panel to set the required temperature. You can set the temperature according to the welding materials and the ambient temperature. LCD display will show the set temperature and the current actual temperature.

2. Welding speed:
Using bottons +  − on the panel to set the required speed according to the welding temperature. LCD display will show the setting speed and the current speed.

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

Positioning The Welder

1. Turn the lift lever (20) counterclockwise to make pressure roller (1) off the ground, move welder to welding position (the edge of upper film should keep in the same alignment with pressure roller (1)), as shown in the figure below.



2. Pressure fixed plate of guide wheel (26) to make guide wheel (27) on the ground, to keep the guide wheel (27) in the same alignment with the edge of upper film.

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

Quality Assurance

1. Setting the welding parameters according to the data of welding test.
2. Please wait the current temperature value reaching the setting value.
3. Positioning the welder.
4. Lift the position handle of hot air blower (24) to lower down the hot air nozzle (3) to close the down ground, to place hot air nozzle to left in the right position. The machine would start walking and welding automatically.
5. To observe the relative position of guide wheel (27). If it deviations from position, you can adjust it by flipping the handle (9)
6. When the welder walks into the end of material, pull up the position handle of hot air blower (24), move out of the hot air nozzle to right until stop, spin it up until lock.
7. After finish the welding job, press the buttons +  − to make the hot air blower in a cold blowing condition in order to cool the nozzle.
8. Last step is to off the power.

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.

1 One year warranty

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