

**LEISTER**

PLASTIC WELDING

# General Catalog Plastic Welding 2014/15

## The only choice for professionals

Version 4.0



**We know how.**



Leister Technologies AG, Corporate Center, Kaegiswil, Switzerland



Leister Technologies AG, factory, Sarnen, Switzerland



Leister Technologies AG, factory, Kaegiswil, Switzerland



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Shanghai, China



Leister Technologies GmbH,  
Aachen, Germany



Leister Technologies Benelux BV  
Houten, Holland



Leister Technologies S.r.l.  
Milan, Italy



Leister Technologies LLC  
Itasca, USA



Leister Technologies KK,  
Yokohama, Japan



Leister Technologies India Pvt  
Chennai, India

### Leister delivers performance.

For over 60 years, Leister has been the worldwide leader in the field of plastic welding and industrial hot-air applications. In addition we also offer innovative and effective lasersystems and microsystems. Leister is proud to develop and produce all products in Switzerland – so you can always rely on the proverbial Swiss made quality.

Over 98 percent of our products are exported. With an established network of 130 sales and service centers all over the globe, you will find a Leister partner guaranteed. We are local worldwide.



## LEISTER

PLASTIC WELDING

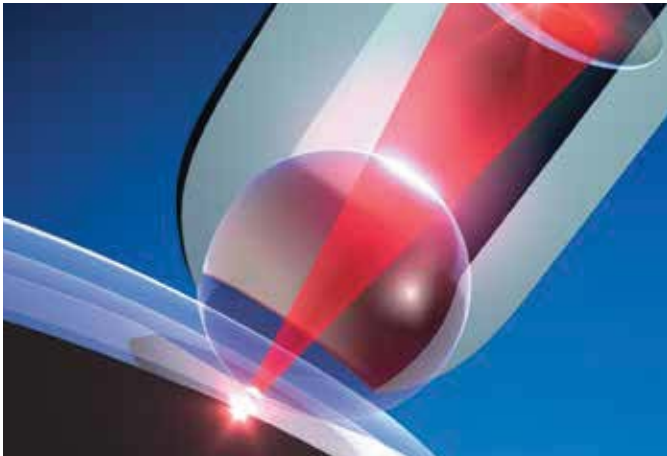
For decades now, Leister has been the worldwide market leader. The performance and reliability of our products makes Leister the first choice. Our tools are used in roofing, billboards, tarpaulins, civil engineering, tunneling, landfills, plastic fabrication, flooring, and shrinking to name a few.



## LEISTER

PROCESS HEAT

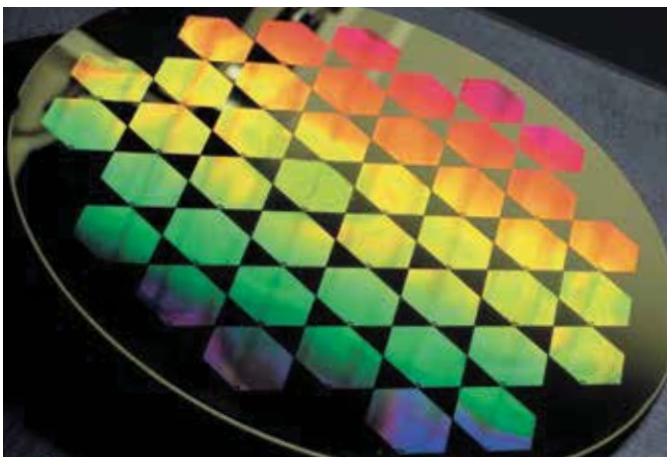
Hot-air is increasingly deployed in industrial processes. Typical applications include activating, heating, curing, melting, shrinking, welding, sterilizing, drying and warming to name a few. Leister customers profit from our extensive engineering knowledge and benefit from our recommendations during the conceptual design of hot-air applications.



## LEISTER

LASER PLASTIC WELDING

Leister's innovative and patented laser bonding solutions provide alternative production processes in automotive, medical, sensor, electronics and textile manufacturing as well as microsystems technology. Our clean, precise and non-invasive laser technology can also be applied to process heat applications.



## axetris

Company of the Leister Group

Along with our experienced engineering team, advanced MEMS foundry capabilities and total quality management approach, Axetris works to ensure our customers remain ahead of their field, now and in the future. We continue to actively develop and produce next-generation sensors and optical components in our cleanroom today.

### Plastic welding with Leister

Leister Technologies AG provides the appropriate high quality welding device for all sectors of the plastics processing industry. Our tools are used in sealing systems on roofs, plastic sheeting, floor coverings, in earthworks, hydraulic and tunnel engineering, equipment manufacturing and vehicle repair. However demanding the task, we provide an applicable solution.

### Research and development

With years of experience in plastic processing and industrial processes we are the ideal partner to work your plastic application. We have dedicated ourselves to constantly develop new and to persistently improve existing products. We strive to provide our customers with outstanding quality, reliability, performance and cost-efficient products.

### Quality management

As an innovative company, Leister commits to transparent and consistent quality management. Leister Technologies AG is certified to comply with the ISO 9001 quality standards. All processes are regularly audited and improved to comply with all quality-relevant criteria; therefore, our products enjoy a reputation of providing reliable service even after years of use under adverse conditions.

### Testing and certification

Our products are designed and developed to comply with nationally and internationally recognized standards. This includes both product-specific standards – such as ISO, IEC, EN or UL standards – as well as application-specific standards. For our client's protection, tests are carried out by accredited and independent test institutes. The products are then certified and qualified to carry the conformity marking.

### Application and laboratory testing

Our team of experts will assist you in choosing the right equipment for your application process. Running test series on your applications will help optimize processes. The equipment of the application laboratory allows for comprehensive testing of process analysis and documentation of the results.

### More than 130 Sales and Service Centers in over 100 countries







We believe that the basis for customer satisfaction lies within the quality of our products and the smooth running global service network. A close network of more than 130 sales and service centers in more than 100 countries ensures competent and responsive service. Distributors and their staff are trained and certified by Leister on a regular basis; therefore, Leister know-how is locally available to you at all times.







WELDPLAST S1

Roofing Billboards / Tarpaulins Civil Engineering / Tunneling / Landfills Plastic Fabrication Flooring / Interior Decoration	Hot-air hand tools Blowers General accessories Welding rods	9 – 31		Hot-Air Hand Tools
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Technical Textiles & industrial Fabrics	Automatic welders	44 – 55		Technical Textiles & industrial Fabrics
Civil Engineering / Tunneling / Landfills	Automatic welders Extrusion welders Testing instruments	56 – 73		Civil Engineering / Tunneling / Landfills
Plastic Fabrication	Extrusion welders Welding rods	74 – 89		Plastic Fabrication
Flooring / Interior Decoration	Hot-air welder Grooving machine	90 – 93		Flooring / Interior Decoration













## Hot-Air Hand Tools

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## Product overview Hot-air hand tools

								
Type	TRIAC ST	TRIAC AT	ELECTRON ST	HOT JET S	GHIBLI	SONORA S1	HOTWIND PREMIUM	FORTE S3
Voltage V~	230	230	230	230	230	230	230	3 × 230 / 3 × 400
Max. power W	1600	1600	3400	460	2000	2000	3700	10 000
Temperature °C	40 – 700	40 – 620	40 – 650	20 – 600	20 – 600	80 – 650	20 – 650	20 – 650
Size mm (L × Ø)	338 × 90	335 × 90	338 × 90	235 × 70	195 × 85 × 160	230 × 200	232 × 106	390 × 132
Handle (Ø)	56	56	56	40	57		179	215
Weight kg (without cord)~	1.0	1.0	1.1	0.4	0.9	0.6	2.2	4.4
Conformity mark	CE	CE	CE	CE	CE	CE	CE	CE
Approval mark		§		§	§	§	§	§
Certification scheme		CCA		CCA	CCA	CCA	CCA	CCA
Protection class	□	□	□	□	□	□	□	□
<b>Applications</b>								
Outdoor use	✓	✓	✓	✓				✓
Indoor use	✓	✓	✓	✓	✓	✓	✓	✓
Roofing	✓	✓	✓	✓				
Billboards / Tarpaulins	✓	✓	✓	✓	✓	✓		
Civil engineering / Tunneling / Landfills	✓	✓	✓	✓				
Plastic fabrication	✓	✓	✓	✓	✓			
Flooring / Interior design	✓	✓	✓	✓	✓	✓		
Shrinking	✓	✓	✓	✓	✓	✓	✓	✓
Integrated blower	✓	✓	✓	✓	✓	✓	✓	✓
Digital display		✓				✓		
Catalog page	12 – 15	13 – 15	16 / 17	18 / 19	20	21	22	23

## Product overview Hot-air hand tools and Blower

					
Type	WELDING PEN R / S	ROBUST	DIODE PID / S	MINOR	LABOR S
Voltage V~	230	3 × 230 / 3 × 400	230	230	230
Max. power W	1000	250	1600	100	800 / 900
Temperature °C	20 – 600		20 – 600		20 – 600
Size mm (L × Ø)	270 × 43	255 × 221	265 × 57	250 × 95	180 × 54
Handle (Ø)	32		40	64	40
Weight kg (without cord)~	1.0	8.0	1.15	1.15	0.15
Conformity Mark	CE	CE	CE	CE	CE
Approval mark	§		§	§	§
Certification Scheme	CCA		CCA	CCA	CCA
Protection Class	□	⊕	□	□	□
<b>Applications</b>					
Outdoor use					
Indoor use	✓	✓	✓	✓	✓
Roofing					
Billboards / Tarpaulins					
Civil engineering / Tunneling / Landfills					
Plastic fabrication	✓	✓	✓	✓	✓
Flooring / Interior design					
Shrinking					
Integrated blower		✓		✓	
Digital display	✓ (R)		✓ (PID)		
Catalog page	24	25	26	27	28

# TRIAC ST – Design meets experience

The new TRIAC ST from Leister is primarily used for welding and plastic fabrication. During its development, a deliberate choice was made to do without extra technical features. Instead it is distinguished by comfort, being reliable versatile and user friendly, like its predecessor the TRIAC S. A prominent feature here is the two-component handle, which is not only attractive, but also gives the user perfect grip. The low weight of less than 1 kg/2.18 lbs ensures a perfect weight balance.

## Product advantage

1



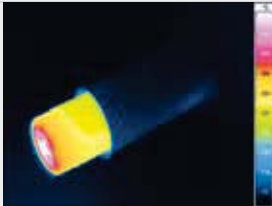
### Ergonomic handling:

The 2-component handle and perfect tool balance ensure ideal grip and optimum working even under the toughest conditions.

### Perfect weight:

Weighing less than 1 kg, the TRIAC ST is even lighter than its predecessor.

2



### Always keeps a cool head:

There is an actively cooled protective tube for greater work safety.

### Design meets experience:

The TRIAC ST is already the seventh generation of Leister's revolutionary TRIAC hot-air hand tool line. Decades of experience packed into a modern design.

1

2

3

4



3



### Swiss thoroughness:

The air filters, located on either side, can easily be removed and cleaned. This ensures optimum air flow and maximum power output.

4



### Plug'n Leister

Like the TRIAC S, the TRIAC ST impresses with easy operation and Swiss quality.

### Reliable partner:

The TRIAC ST has kept what is probably its predecessor's most important feature: It is and remains reliable!



## TRIAC AT: Robust and intelligent.

The TRIAC AT is an intelligent hot-air hand tool for welding and shrinking plastics that is suitable for on-site use. It is designed for the needs of even the most demanding professional. Every tool undergoes stringent quality checks prior to leaving the factory in Switzerland. This high-quality hot-air hand tool is equipped for all situations. Its universal areas of application are virtually unlimited. The TRIAC AT will continue to prove its merit in any weather condition and is just as effective outside as it is indoors – all during continuous operation.

### Hot-air hand tool TRIAC ST



### Hot-air hand tool TRIAC AT



- Suitable for the work site
- The sturdy, professional hot-air hand tool that weighs less than 1 kg/2.18 lbs
- Functional design: two-component handle grip and optimum center of gravity ensure good ergonomics
- Quick clean air filters
- Automatic carbon stop and heating element protection provide automatic protective measures

- Suitable for the work site
- Closed loop controlled temperature
- Open loop controlled air volume
- Intelligent «e-Drive» operating unit
- Ergonomic handling
- Modern design

#### Technical data

Voltage	V~	120 / 230
Power	W	1600 / 1600
Temperature	°C	40 – 700
Size (L × Ø)	mm	338 × 90, handle Ø 56
Weight	kg	<1 (without power cord)
Conformity mark	CE	
Protection class II	□	

#### Article No.:

141.308	TRIAC ST 120V / 1600W for push-fit nozzles with UK-plug
141.309	TRIAC ST 230V / 1600W for push-fit nozzles with UK-plug
141.311	TRIAC ST 230 V / 1600 W for push-fit nozzles with CH plug
141.227	TRIAC ST 230 V / 1600 W for push-fit nozzles with Euro plug
144.013	TRIAC ST 230 V / 1600 W for screw-on nozzles with Euro plug

#### Technical data

Voltage	V~	120 / 230
Power	W	1600 / 1600
Temperature	°C	40 – 620
Size (L × Ø)	mm	335 × 90, handle Ø 56
Weight	kg	1 (without 3 m cord)
Approval mark	S	
Conformity mark	CE	
Protection class II	□	

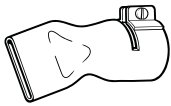
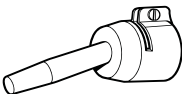
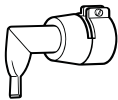
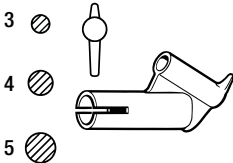
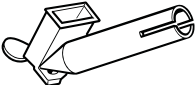
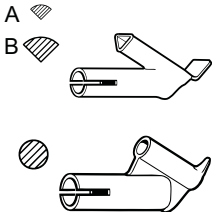
#### Article No.:

141.319	TRIAC AT 120V / 1600W, with UK-plug
141.320	TRIAC AT 230V / 1600W, with UK-plug
141.314	TRIAC AT 230 V / 1600 W, with EU plug
141.322	TRIAC AT 230 V / 1600 W, with CH plug

➔ Accessories on page 14/15

➔ Accessories on page 14/15

## Accessories TRIAC ST / TRIAC AT

	<p>Wide slot nozzle, push-fit</p> <p><b>107.123</b> 20 mm, angled</p> <p><b>105.487</b> 20 mm, bent and angled</p> <p><b>105.503</b> 20 mm, 60° angle</p> <p><b>105.492</b> 20 mm, straight jaw, 120° bent at right angle</p> <p><b>128.535</b> 30 mm, 45° angle</p> <p><b>107.132</b> 40 mm</p> <p><b>107.130</b> 40 mm, 60° angle</p> <p><b>107.133</b> 40 mm, perforated</p> <p><b>107.135</b> 40 mm, PTFE-coated</p> <p><b>107.129</b> 60 mm for bitumen</p> <p><b>107.131</b> 80 mm</p>
	<p><b>100.303</b> Ø 5 mm, tubular nozzle, push-fit</p> <p><b>105.622</b> Ø 5 mm, tubular nozzle, screw-on</p>
	<p><b>107.124</b> 20 mm angled nozzle, 90°, push-fit</p> <p><b>107.125</b> 20 mm angled nozzle, 60°, push-fit</p>
	<p><b>105.431</b> 3 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle</p> <p><b>105.432</b> 4 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle</p> <p><b>105.433</b> 5 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle</p>
	<p><b>107.139</b> 4.5 × 12 mm speed weld nozzle for fillet weld, push-fit on Ø 5 mm tubular nozzle</p> <p><b>107.137</b> 8 mm speed weld nozzle for tape welding, push-fit on Ø 5 mm tubular nozzle</p>
	<p>Speed weld nozzle, push-fit on Ø 5 mm tubular nozzle</p> <p><b>106.992</b> 5.7 mm, profile A</p> <p><b>106.993</b> 7 mm, profile B</p> <p><b>106.989</b> 3 mm</p> <p><b>106.990</b> 4 mm</p> <p><b>106.991</b> 5 mm</p>



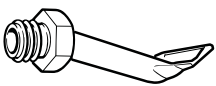










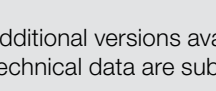

Overlap welding



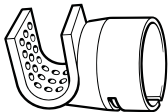
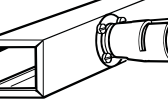


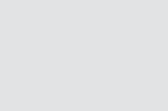


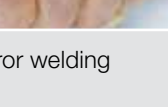
Draw welding



Shrinking

	<b>106.988</b> Tacking nozzle, screw-on
	<b>126.552</b> Ø 4 mm drawing nozzle, screw-on for fluor plastics
	<b>113.666</b> Ø 3 mm drawing nozzle with tacking tip, screw-on
	<b>113.399</b> Ø 4 mm drawing nozzle with tacking tip, screw-on
	<b>113.876</b> Ø 3 mm drawing nozzle without tacking tip, screw-on
	<b>113.874</b> Ø 4 mm drawing nozzle without tacking tip, screw-on
	<b>113.670</b> Drawing nozzle triangular-shaped, with tacking tip, screw-on 5.7 mm
	<b>113.877</b> Without tacking tip, screw-on 5.7 mm, profilee A
	<b>106.986</b> Without tacking tip, screw-on 7 mm, profile B
	<b>106.987</b> 7 x 5.5 mm
	<b>106.996</b> Tacking nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>106.982</b> Ø 5 mm extension nozzle, 150 mm
	<b>107.344</b> 135 mm welding mirror, push-fit
	<b>143.833</b> Nozzle adapter for screw-on nozzles
	<b>143.332</b> Protection tube for screw-on nozzles

Additional versions available upon request.  
Technical data are subject to change without prior notice.

	<b>107.324</b> 12 x 10 mm sieve reflector, push-fit on Ø 5 mm tubular nozzle
	<b>107.337</b> 50 x 35 mm sieve reflector, push-fit
	<b>107.338</b> 35 x 20 mm sieve reflector, push-fit
	<b>107.326</b> 25 x 150 mm shell reflector, push-fit
	<b>107.307</b> 27 x 35 mm spoon reflector, push-fit
	<b>107.339</b> 17 x 34 mm soldering reflector, push-fit
	<b>142.717</b> Heating element for TRIAC ST / TRIAC AT, 230 V / 1550 W
	<b>142.718</b> Heating element for TRIAC ST / TRIAC AT, 120 V / 1550 W



Mirror welding

# ELECTRON ST – Strong, compact and handy

The new ELECTRON ST is a real powerhouse among Leister's hand tools. The appearance of this tool has been modeled after the new TRIAC range. For the user, this means improved ergonomics and, as a result, the ability to work in more comfort. Existing ELECTRON nozzles fit the new model.

## Product advantages



### Powerful:

Suitable for any application thanks to its outstanding power rating of up to 3400 W.



### Perfectly ergonomic:

100 grams lighter and with a 2 component handle that's up to 8 mm slimmer than its predecessor.



### Infinitely adjustable:

Easy air temperature adjustment up to 650°C.



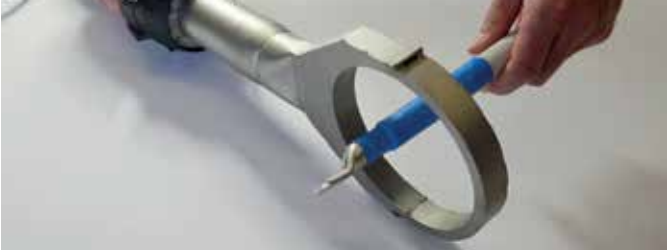
### Clean:

Air filters, located on either side, can be removed and cleaned in no time at all.



### Compatible:

All predecessor nozzles fit the ELECTRON ST.



Shrinking cable connections is just one of many applications for which the ELECTRON ST can be used.

Hot-air hand tool  
**ELECTRON ST**



- Suitable for construction sites
- Leister's most powerful hand tool
- Easy-clean air filter
- Carbon stop and heating element protection provide automatic protective measures
- Sturdy tool case supplied
- Swiss made

Technical data					
Voltage	V~	230	230	200	120
Power	W	2300	3400	3000	2400
Temperature	°C	40 – 650			
Size (L × Ø)	mm	338 × 90, handle Ø 56			
Weight	kg	1.1 without connection cable			
Conformity mark		CE			
Protection class II		□			

Article No.	
145.567	ELECTRON ST 230 V / 3400 W for push-fit nozzles with Euro plug
149.673	ELECTRON ST 230 V / 2300 W for push-fit nozzles with Euro plug *
145.564	ELECTRON ST 200 V / 3000 W for push-fit nozzles with JP plug
145.563	ELECTRON ST 120 V / 2400 W for push-fit nozzles with UK plug
145.568	ELECTRON ST 230 V / 3400 W for push-fit nozzles with UK plug

\* Please ask about availability

**Accessories ELECTRON ST**

	<b>107.258</b>	Wide slot nozzle, push-fit 70 × 10 mm, for bitumen
	<b>107.653</b>	Wide slot nozzle 75 × 2 mm, push-fit
	<b>151.068</b>	Tool stand for 107.653
	<b>107.270</b>	Wide slot nozzle 150 × 12 mm, push-fit
	<b>107.229</b>	Round nozzle 20 mm
	<b>107.331</b>	72 × 70 mm folding reflector, push-fit
	<b>107.328</b>	60 × 75 mm folding reflector, push-fit
	<b>107.330</b>	125 × 22 mm folding reflector, push-fit
	<b>107.327</b>	85 × 85 mm sieve reflector, push-fit
	<b>107.333</b>	150 × 110 mm sieve reflector, push-fit
	<b>106.127</b>	Ø 65 mm sieve reflector push-fit
	<b>107.340</b>	45 × 250 mm Shell reflector, push-fit
	<b>107.346</b>	270 mm welding mirror, push-fit
	Heating elements	
	<b>145.604</b>	120 V / 2300 W
	<b>145.606</b>	230 V / 3300 W
	<b>145.605</b>	200 V / 3300 W
	<b>149.675</b>	230 V / 2200 W

# HOT JET S: Small and powerful.

As the most compact hot-air hand tool from Leister, the HOT JET S' low weight of 600 grams (including cord and slim handle) ensures high-powered, fatigue-free welding.



Especially suited to facilitate tasks in difficult to access areas.

## Hot-air hand tool HOT JET S



- The smallest Leister hot-air hand tool
- Stepless, electronically controlled temperature
- Stepless, electronically controlled air flow
- Low noise
- Flexible, integrated tool stand

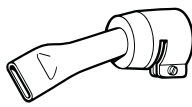
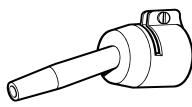
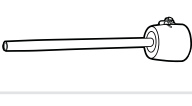

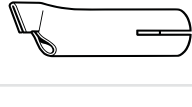
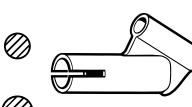

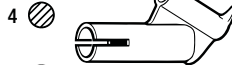


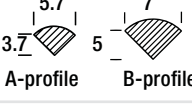
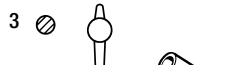
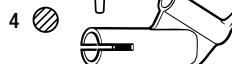
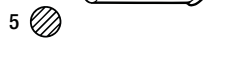
### Technical data

Voltage	V~	120 / 230
Power	W	460 / 460
Temperature	°C	20 – 600
Size (L x Ø)	mm	235 x 70, handle Ø 40
Weight	kg	0.4 (without 3 m cord)
Conformity mark	CE	
Approval mark	UL / ENEC	
Certification Scheme	CCA	
Protection class II	□	

### Article No.:

100.648	HOT JET S 230 V / 460 W, with Euro plug
100.862	HOT JET S 120 V / 460 W, without plug
100.854	HOT JET S 230 V / 460 W, with AUS plug

## Accessories HOT JET S

	<b>107.141</b> 15 mm wide slot nozzle, push-fit
	<b>107.142</b> 20 mm wide slot nozzle, push-fit
	<b>107.144</b> Ø 5 mm tubular nozzle, push-fit
	<b>105.567</b> Ø 5 x 150 mm extension nozzle, straight
	<b>105.556</b> 20 mm angled nozzle, 90° angled, push-fit
	<b>106.996</b> Tacking nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>106.989</b> 3 mm speed welding nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>106.990</b> 4 mm speed welding nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>106.991</b> 5 mm speed welding nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>106.992</b> 5.7 mm, A profilee speed welding nozzle, push-fit
	<b>106.993</b> 7 mm, B profilee speed welding nozzle, push-fit
	<b>105.431</b> 3 mm speed welding nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle
	<b>105.432</b> 4 mm speed welding nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle
	<b>105.433</b> 5 mm speed welding nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle

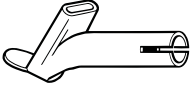
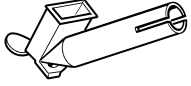
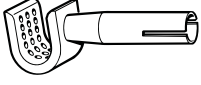
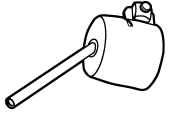
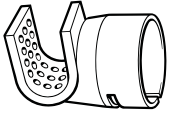

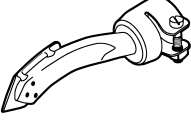

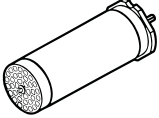


HOT JET S with angled nozzle welding a T-joint on the roof.



Fitting a solder shrink connection with the HOT JET S outfitted with a push-fit sieve reflector.

## Accessories HOT JET S

	<b>107.137</b> 8 mm speed welding nozzle for tape welding, push-fit on Ø 5 mm tubular nozzle
	<b>107.139</b> 4.5 x 12 mm speed welding nozzle for fillet weld, push-fit on Ø 5 mm tubular nozzle
	<b>107.324</b> 12 x 10 mm sieve reflector, push-fit on Ø 5 mm tubular nozzle
	<b>107.146</b> Ø 2 mm soldering nozzle
	<b>107.151</b> Ø 4 mm soldering nozzle
	<b>107.148</b> Ø 3 x 1.5 mm soldering nozzle, oval
	<b>107.310</b> 35 x 20 mm sieve reflector, push-fit
	<b>107.311</b> 50 x 35 mm sieve reflector, push-fit
	<b>107.312</b> 25 x 30 mm spoon reflector, push-fit
	<b>107.305</b> 15 x 25 mm ironing nozzle
	<b>143.831</b> Nozzle adapter for screw-on nozzles
	<b>100.818</b> 230 V / 435 W heating element
	<b>103.607</b> 120 V / 435 W heating element

Small and handy: The HOT JET S is perfect when welding complicated details in billboard and tarpaulin applications.



# GHIBLI: The “hot-air gun“.

GHIBLI, derived from a hot desert wind, certainly lives up to its name. Thanks to its two-step airflow switching and steplessly adjustable temperature, the GHIBLI can be used for the most diverse applications.



Shrinking cable connections which the GHIBLI.

## Hot-air hand tool GHIBLI



- Universal tool for welding and shrinking
- Welding results independent of voltage fluctuations and ambient temperature
- Two-step selectable airflow

### Technical data

Voltage	V	120 / 230
Power	W	1500 / 2000
Temperature	°C	20 – 600
Size (L x W x H)	mm	195 x 85 x 160, Handle Ø 57
Weight	kg	0.9 (without 3 m cord)
Conformity mark	CE	
Approval mark	UL / ENEC	
Certification Scheme	CCA	
Protection class II	□	

### Article No.:

- 101.881 GHIBLI 230 V / 2000 W with Euro plug  
101.887 GHIBLI 120 V / 1500 W with US plug

Additional versions available upon request.

	<b>106.998</b> 20 mm wide slot nozzle, push-fit
	<b>106.999</b> 40 mm wide slot nozzle
	<b>107.154</b> Ø 5 mm tubular nozzle, push-fit
	<b>107.006</b> Ø 5 x 130 mm extension nozzle, straight
	<b>107.308</b> 50 x 35 mm sieve reflector
	<b>107.309</b> 35 x 20 mm sieve reflector
	<b>107.313</b> 25 x 30 mm spoon reflector, push-fit
	<b>107.325</b> 17 x 34 mm soldering reflector, push-fit
	<b>107.319</b> Ø 65 mm sieve reflector
	<b>107.315</b> 70 x 12 mm folding reflector, push-fit
	<b>107.345</b> 135 mm welding mirror, push-fit
	<b>115.513</b> 230 V / 1800 W heating element

# SONORA S1: Handy and quiet.

The handy, quiet and compact tool for universal use. The SONORA S1 is the perfect hot-air hand tool for shrinking, car wrapping, forming and heating. Excellent price / performance ratio.



Ergonomic design for strain-free car wrapping.

## Hot-air hand tool SONORA S1



- Lightweight and compact
- High stability for long term use
- Balanced ergonomics with soft grip
- Very quiet tool, ideal for indoor use
- Constant temperature and closed-loop controlled electronics

### Technical data





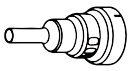

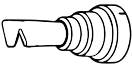
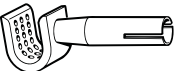

Voltage	V	230
Power	W	2000
Temperature	°C	80 – 650
Size	mm	230 × 200
Weight	kg	0.6 (without 2 m cord)
Conformity mark		CE
Approval mark		§
Certification Scheme		CCA
Protection class II		□

### Article No.:

140.996 SONORA S1, 230 V / 2000 W, with Euro plug

Additional versions available upon request

## Accessories SONORA S1

	<b>119.269</b> Glass protection nozzle
	<b>119.270</b> 50 mm wide slot nozzle
	<b>119.314</b> Reducer nozzle (included with S1 purchase)
	<b>119.271</b> Reflector nozzle (included with S1 purchase)
	<b>119.316</b> 5 mm tubular nozzle
	<b>119.315</b> 20 mm wide slot nozzle
	<b>119.312</b> Solder sleeve reflector nozzle (included with S1 purchase)
	<b>107.324</b> 12 × 10 mm sieve reflector, push-fit on Ø 5 mm tubular nozzle
	<b>107.308</b> 50 × 35 mm sieve reflector

Included  
with purchase



# HOTWIND: The new dimension.

Weighing just 2.2 kg, the HOTWIND can be used either as an integrated or bench-top device. The high maximum temperature of 650 °C means that the HOTWIND can be used in a variety of ways.



The HOTWIND is perfectly suited for drying and baking of print on plastic components.

## Hot-air hand tool

### HOTWIND PREMIUM / SYSTEM



HOTWIND PREMIUM

- Ideal for warming, heating, forming and drying
- Stepless adjustment of the heating and blower
- Integrated device and heating element protection
- Extremely smooth running

#### Technical data

Voltage	V~	230
Power	W	3700
Max. Luftaustritts-Temperature	°C	650
Size (L × W × H)	mm	332 × 106 × 179
Weight	kg	2.2 (without 3 m cord)
Conformity mark	CE	
Approval mark	S	
Certification Scheme	CCA	
Protection class II	□	

#### Article No.:

- 142.609 HOTWIND PREMIUM, 230 V / 3700 W, with Euro plug  
 142.645 HOTWIND SYSTEM, 230 V / 3700 W, with Euro plug

Additional versions available upon request

### Accessories HOTWIND PREMIUM / SYSTEM

	Wide slot nozzle, push-fit (a × b)
	107.260 85 × 15 mm
	107.259 150 × 12 mm
	105.977 200 × 9 mm
	107.263 250 × 12 mm
	107.262 300 × 4 mm
	105.992 400 × 4 mm
	105.991 500 × 4 mm
	125.317 Flange connector, push-fit a = 90 mm
	107.335 Ø 150 mm sieve reflector, push-fit
	107.248 Stainless steel filter, push-fit on air intake
	141.723 Hand tool kit (handle and protective tube)
	143.530 230 V / 3600 W heating element

## FORTE S3: Flameless shrinking.

The most powerful hot-air hand tool from Leister. The FORTE S3 is extremely well-suited for flameless shrinking of pallets and bulk goods.



Flameless shrink-wrapping of pallets and bulky goods with the FORTE S3.

### Hot-air hand tool FORTE S3



- Powerful pallet shrink-wrapping
- Uniform shrinkage
- May be used in confined spaces
- Integrated tool stand

#### Technical data

Voltage	V~	3 × 230	3 × 400
Power	kW	10	10
Temperature	°C	650	
Size (L × W × H)	mm	390 × 132 × 215	
Weight	kg	4.4 (without 10 m cord)	
Conformity mark		CE	
Approval mark		Ⓢ	
Certification Scheme		CCA	
Protection class II		Ⓜ	

#### Article No.:

102.027 FORTE S3, 3 × 400 V / 10 kW with 16A CEE plug

Additional versions available upon request

## WELDING PEN: Slim and flexible.

The WELDING PEN is a hot-air hand tool optimized for draw welding. Due to its slim design and swivelling external air supply it makes hard work easy.



Draw welding using the compact and lightweight WELDING PEN R.

External air hand tool

### WELDING PEN R / WELDING PEN S



- Digital temperature display (WELDING PEN R)
- Connection makes working easier.
- Cooled heating element tube
- Used in combination with ROBUST blower or compressed air

#### Technical data

Voltage	V~	230
Power	W	1000
Temperature	°C	20 – 600
Size (L × Ø)	mm	270 × 43, handle Ø 32
Weight	kg	1.0 (with 3 m cord / air hose and Y-connection)
Conformity mark	CE	
Approval mark	S	
Certification Scheme	CCA	
Protection class II	□	

#### Article No.:

114.275	WELDING PEN S, 120 V / 600 W, with UK-plug
119.966	WELDING PEN R, 120 V / 600 W, with UK-plug
114.380	WELDING PEN R, 230 V / 1000 W, for screw-on nozzle, with Euro plug
113.081	WELDING PEN S, 230 V / 1000 W, for screw-on nozzle, with Euro plug

Additional versions available upon request

### Accessories WELDING PEN R / S

	<b>105.622</b> Ø 5 mm tubular nozzle, 15° screw-on
	<b>106.988</b> Tacking nozzle, screw-on
	<b>113.666</b> Ø 3 mm round drawing nozzle with tacking tip, screw-on
	<b>113.399</b> Ø 4 mm round drawing nozzle, with tacking tip, screw-on
	<b>113.876</b> Ø 3 mm round drawing nozzle without tacking tip, screw-on
	<b>113.874</b> Ø 4 mm round drawing nozzle, without tacking tip, screw-on
	<b>113.670</b> Triangular drawing nozzle with tacking tip, screw-on, 5.7 mm, profile A
	<b>113.877</b> Without tacking tip, screw-on 5.7 mm, profile A
	<b>106.986</b> Without tacking tip, screw-on 7 mm, profile B
	<b>106.987</b> 7 × 5.5 mm
	<b>126.552</b> Ø 4 mm drawing nozzle, screw-on for fluoroplastics
	Angular adapter for screw-on nozzles, screw-on
	<b>127.726</b> 30° <b>127.727</b> 45°
	<b>113.412</b> 230 V / 1000 W heating element for WELDING PEN R and WELDING PEN S



Swiveling air hose for easy working.

## ROBUST: The powerhouse.

Versatile and operable at high ambient temperatures of up to 60 °C. Despite its small size, the ROBUST is a real powerhouse. This blower can simultaneously supply air for up to three hot-air hand tools.



ROBUST blower, serving as the external air supply for the WELDING PEN.

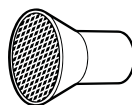
### Blower

## ROBUST

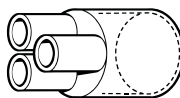


- High-performance, compact design
- Sound-suppression
- Can be integrated at any position
- Can be used as an external air supply to 1 WELDING PEN R or up to max. 3 DIODE S / PID or max. 3 LABOR S (with 107.281 hose adapter)

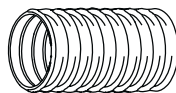
### Accessories ROBUST



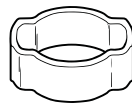
**107.354** Stainless steel filter, push-fit on air intake



**107.281** Ø 38 mm hose connection adapter, 3 output each 14 mm



**113.859** Ø 14 mm air hose



**101.031** Ø 14 mm hose clip for air hose

#### Technical data

Frequency	Hz	50	60
Power	W	250	250
Air volume (20 °C)	l/min	1200	1300
Static pressure	kPa	8.0	10.5
Max. ambient temperature	°C	60	60
Max. air inlet temperature	°C	60	60
Noise emission level	dB(A)	62	62
Environmental protection (IEC 60529)	IP 54	IP 54	IP 54
Outside diameter air inlet	Ø mm	38	38
Outside diameter air outlet	Ø mm	38	38
Weight	kg	8.0	8.0
Conformity mark	CE	CE	CE
Protection class I	⊕	⊕	⊕

#### Article No.:

Voltage V~	50 Hz	1 × 120	1 × 230	3 × 230 / 400
	60 Hz			3 × 440 – 480
Without cord	Article No.:	<b>103.434</b>		<b>103.429</b>
3 m cord / Euro plug	Article No.:		<b>103.432</b>	

## DIODE PID / S: The powerful pair.

There are two options for high-quality work: The closedloop DIODE PID provides the perfect welding temperature at all times. The DIODE S easily puts you in control with a manual temperature knob.



Convenient wire welding using the powerful and lightweight DIODE PID.

### External air hand tool

#### DIODE PID / DIODE S



- Operated with MINOR or ROBUST blower or with compressed air
- Digitally controlled and displayed temperatures (DIODE PID)
- Cooled heating element tube
- Suitable for field applications when used in combination with a MINOR blower

#### Technical data

Voltage	V~	120 / 230
Power	W	1600 / 1600
Temperature	°C	20 – 600
Size (L x Ø)	mm	265 x 57, handle Ø 40
Weight	kg	1.15 kg (with 3 m cord / 3 m air hose)
Conformity mark	CE	
Approval mark	S	
Certification Scheme	CCA	
Protection class II	□	

#### Article No.:

101.303	DIODE PID, 230 V / 1600 W, push-fit, with Euro plug
101.281	DIODE S, 230 V / 1600 W, push-fit, with Euro plug
101.304	DIODE PID, 230 V / 1600 W, screw-on, with Euro plug
101.282	DIODE S, 230 V / 1600 W, screw-on, with Euro plug
101.293	DIODE S, 120 V/1600 W for push-fit nozzles, with UK-plug

Additional versions available upon request

### Hand tool and blower

#### DIODE PID / DIODE S with MINOR



MINOR blower and DIODE PID with screw-on drawing nozzle.

- Ideal for assembly work

#### Technical data

Voltage	V~	230
Power	W	1700
Temperature	°C	20 – 600
Size (L x Ø)	mm	265 x 57, handle Ø 40
Weight	kg	2.5 kg (with 3 m cord / 1.5 air hose)
Conformity mark	CE	
Approval mark	S	
Certification Scheme	CCA	
Protection class II	□	

#### Article No.:

108.880	DIODE PID with MINOR, 230 V / 1700 W, screw-on, 1.5 air hose, Euro-plug
101.441	DIODE S with MINOR, 230 V / 1700 W, push-fit, 1.5 air hose, Euro-plug

Additional versions available upon request

## MINOR: The mobile air supplier.

Don't be deceived by the MINOR's small size and low weight. This blower delivers sufficient air to enable quality work with the DIODE PID / DIODE S or LABOR S.



The MINOR blower as an air supply for the DIODE PID.

### Accessories DIODE PID / DIODE S

#### With push-fit nozzle

	<b>100.303</b> Ø 5 mm tubular nozzle, for versions with nozzles, push-fit
	<b>106.992</b> Speed welding nozzle, push-fit on Ø 5 mm tubular nozzle 5.7 mm, profile A <b>106.993</b> 7 mm, profile B
	<b>106.989</b> 3 mm <b>106.990</b> 4 mm <b>106.991</b> 5 mm
	<b>106.996</b> Tacking nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>143.833</b> Nozzle adapter for screw-on nozzles
	<b>100.296</b> Heating element DIODE PID, 230 V / 1550 W <b>100.650</b> Heating element DIODE PID, 120 V / 1600 W <b>100.689</b> Heating element DIODE S, 230 V / 1550 W <b>100.702</b> Heating element DIODE S, 120 V / 1600 W

#### With screw-on nozzle

	<b>105.622</b> Ø 5 mm tubular nozzle, screw-on
	<b>106.988</b> Tacking nozzle, screw-on
	<b>113.666</b> Ø 3 mm round drawing nozzle with tacking tip, screw-on <b>113.399</b> Ø 4 mm round drawing nozzle, with tacking tip, screw-on
	<b>113.876</b> Ø 3 mm round drawing nozzle without tacking tip, screw-on <b>113.874</b> Ø 4 mm round drawing nozzle, without tacking tip, screw-on
	<b>113.670</b> Triangular drawing nozzle, with tacking tip, screw-on, 5.7 mm
	<b>113.877</b> Without tacking tip, screw-on 5.7 mm, profile A <b>106.986</b> Without tacking tip, screw-on 7 mm, profile B <b>106.987</b> 7 x 5.5 mm
	<b>126.552</b> 4 mm drawing nozzle, screw-on, for fluoroplastics

### Blower MINOR



- Lightweight and compact
- Powerful
- Serves as a mobile air supply for the DIODE PID / DIODE S and LABOR S
- Suitable for work on construction sites

#### Technical data

Voltage	V~	230
Power	W	100
Air volume (20°C)	l/min	400
Pressure static	Pa	4000 (40 mbar)
Air outlet (external)	mm	14.5
Size (L x Ø)	mm	250 x 95, handle Ø 64
Weight	kg	1.15 (with 3 m cord)
Conformity mark		CE
Approval mark		£
Certification Scheme		CCA
Protection class II		□

#### Article No.:

- 108.747 MINOR, 230 V / 100 W, with Euro plug  
109.988 MINOR, 120V / 100W, with UK plug

Additional versions available upon request

## LABOR S: Small and handy.

The fatigue-free LABOR S is a „jack of all trades“. Its small size makes it ideal for perfect welding in small spaces.



LABOR S, used in combination with MINOR as an external air supply.

### External Air Hand tool

## LABOR S



- Temperature adjustment via rotary knob
- Very small and handy device
- Ideal for draw welding and tacking
- Air supply with ROBUST blower, MINOR (p. 27) or with compressed air
- Ideal for mobile use when coupled with MINOR blower

### Technical data

Voltage	V~	230
Power	W	800 / 900
Temperature	°C	20 – 600
Size (L x Ø)	mm	180, handle Ø 40
Weight	kg	0.15 (without air hose and without cord)
Conformity mark	CE	
Approval mark	S	
Certification Scheme	CCA	
Protection class II	□	

### Article No.:

101.716	LABOR S with connection box, 230 V / 800 W with Euro plug, air hose 3 m
101.754	LABOR with MINOR blower, 230 V / 900 W with Euro plug, air hose 1.5 m

Additional versions available upon request

## Accessories LABOR S

	<b>107.144</b> Ø 5 mm tubular nozzle, push-fit
	Speed weld nozzle, push-fit on Ø 5 mm tubular nozzle
<b>106.992</b>	5.7 mm, profilee A
<b>106.993</b>	7 mm, profilee B
<b>106.989</b>	3 mm
<b>106.990</b>	4 mm
<b>106.991</b>	5 mm
	<b>106.996</b> Tacking nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>101.581</b> 230 V / 800 W heating element

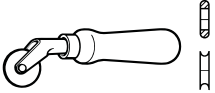
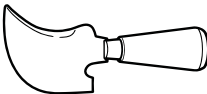
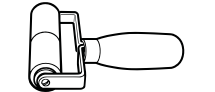
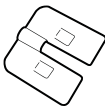


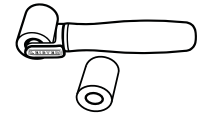
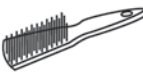

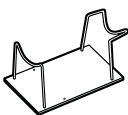
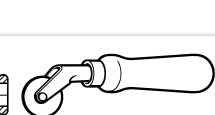
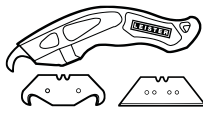

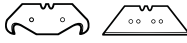
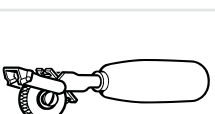
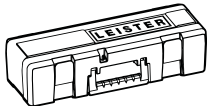


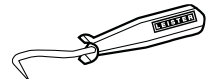


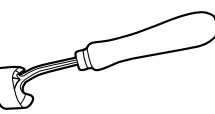

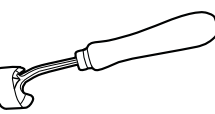
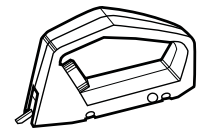




The new «Groovy» gouging tool is also perfectly suited for floor joints.

## Hot-air hand tools

### General accessories

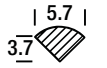
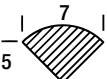
	<b>106.972</b> Brass pressure roller with ball bearings		<b>106.969</b> Spatula
	<b>106.970</b> Brass pressure roller, for welding rods $\varnothing$ 4 – 5 mm		<b>122.541</b> Trimming guide, to use with spatula (106.969)
	<b>106.974</b> 80 mm silicone pressure roller		<b>106.997</b> $\varnothing$ 6 mm rotary burr for drilling machine, for car repairs
	<b>140.160</b> 40 mm silicone pressure roller with ball bearings (silicone)		<b>116.798</b> Brass brush
	<b>140.599</b> Spare roll for 140.160		<b>107.348</b> Tool rest for TRIAC AT, TRIAC ST, ELECTRON ST
	<b>140.161</b> Pressure roller 28 mm, with ball bearings (silicone)		<b>137.855</b> Leister cutter with four spare blades
	<b>140.598</b> Spare roll for 140.161		<b>138.902</b> 10 spare blades hook-shaped <b>138.539</b> 10 spare blades trapezoid-shaped
	<b>106.976</b> 28 mm pressure roller (PTFE)		<b>116.586</b> Storage case for TRIAC AT, TRIAC ST, ELECTRON ST
	<b>106.972</b> Brass pressure roller with ball bearings		
	<b>106.981</b> Pressure roller for custom seal		
	<b>138.314</b> Seam probe tester for overlap seams		
	<b>111.346</b> Chamfer plane with seven spare blades, for sealing sheets		
	<b>111.348</b> Spare blades kit containing ten blades		
	<b>106.966</b> Hand grooving tool		
	<b>106.968</b> Spare blades for hand grooving tool		
	<b>151.188</b> Chamfer plane for T-joints on		
	<b>150.809</b> Hand splice tool «Groovy» for flooring applications		



## Welding rods

Article		packaging units (kg)	Article		packaging units (kg)	
Welding rods PE			Welding rods div.			
104.283	Welding rod HDPE, profile A, black	3	104.297	Welding rod PA, profile A, black	3	
104.294	Welding rod HDPE, profile A, white	3	104.298	Welding rod PC, profile A, transparent	3	
104.284	Welding rod HDPE, profile B, black	5	104.313	Welding rod PC / ABS / ALPHA (Honda), profile A, black	3	
104.299	Welding rod HDPE, profile B, white	5	104.311	Welding rod PC / PBTP (Xenoy), profile A, grey	3	
106.650	Welding band HDPE, 8x 2 mm, white	1	104.309	Welding rod PS, profile A, white	3	
104.300	Welding rod LDPE, profile A, black	3	104.308	Welding rod PUR, profile A, black	3	
Welding rods PP			106.654	Welding band Xenoy, 8x 2 mm, grey	2	
104.287	Welding rod PP, profile A, grey / beige	3	106.642	Welding rod PPs, profile A, grey, flame resistant	3	
104.301	Welding rod PP, profile A, black	3	104.304	Welding rod PVDF, profile A, natural	3	
104.288	Welding rod PP, profile B, grey / beige	5	104.303	Welding rod POM, profile A, natural	3	
126.356	Welding band PP, 8x 2 mm, natural	2	Test bundles			
Welding rods PVC			107.036	Test bundle (bodywork) welding rods, each consisting of profile A pieces of 37 mm single marked 6× HDPE, 6× PP, 6× PA, 6× PC, 6× ABS, 6× PCABS / APLHA Honda, 6× PC / PBTP / Xenoy		
104.296	Welding rod PVC-U (hard), profile A, transparent	3		107.037	Test bundles (standard) each consisting of profile A pieces of 37 mm single marked 5x PVC-U, 5× PVC-P, 5× PP, 5× ABS, 5× HDPE, 3× PC, 3× PA, 3× POM, 3× LDPE, 3× PC / ABS / ALPHA Honda, 3× PC / PBTP / Xenoy	
104.278	Welding rod PVC-U (hard), profile A, grey	3			107.040	Test bundle (welding band) each consisting of profile A pieces of 37 mm single marked 9× HDPE, 8× 2 mm white, 9× PP, 8× 2 mm natural, 9× ABS, 8× 2 mm white, 9× PC / PBTP / Xenoy grey
106.641	Welding rod PVC-U, profile A, brown	3				
104.280	Welding rod PVC-U (hard), profile B, brown	5				
104.279	Welding rod PVC-U (hard), profile B, grey	5				
104.302	Welding rod PVC-P (soft), profile A, transparent	3				
Welding rods ABS						
104.295	Welding rod ABS, profile A, white	3				
113.587	Welding rod ABS, profile A, black	3				
107.027	ABS welding band, 8x 2 mm, white	1				

## Profile sizes

	<b>Profile A</b> Diameters in mm
	<b>Profile B</b>





## Roofing

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## Hot Air Tools for Roofing

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TRIAC AT	13 – 15
ELECTRON ST	16 / 17
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General accessories	30










The VARIMAT V2 guide bar fits in tight spaces.



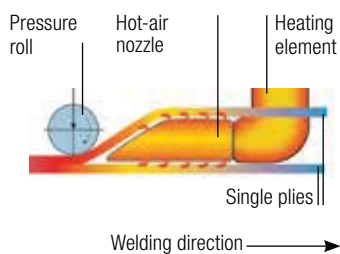
Flameless modified bitumen welding with the BITUMAT B2.

## Overview Roofing Welders

					
Materials	Single-ply plastic membranes				Modified bitumen
Type of welding machine	VARIMAT V2	UNIROOT E 40 mm	TRIAC DRIVE AT with guide	COMET SUB-ROOF	BITUMAT B2
Main application	Welding close to edges Large areas over 500 m²	Parapets, edges Small areas, parapets under 500 m²	Cramped conditions, vertical parapets	For pre-fabricators	First bitumen layer
Roof construction					
Flat roof	✓✓✓	✓✓✓	✓✓✓		✓✓✓
Sloping roof	✓	✓✓	✓✓	✓✓	✓
Basic weld seams	✓✓✓	✓	✓	✓✓✓	✓✓✓
Detail work	✓	✓✓✓	✓✓✓	✓	✓
Special features	High welding power	Welding at edges	Vertical welding	Welding thin membranes	Flameless welding
Fastening					
Mechanically fastened, hard substrate	X	X	X		X
Loosely laid, soft substrate	X	X	X	X	X
Parapet spacing in mm	110	190 **	40	220	200
Electronics					
Controlled (closed-loop system)	X	X	× (blower)	X	
Controlled (open loop)			× (drive)		X
Speed m/min.					
Drive	0.7 – 12	1 – 5	0.5 – 3	0.8 – 6	0.8 – 12
Welding (depending on material)	4 – 8	2 – 3	1.5 – 3	3 – 6	3 – 6
Weight kg	35	15.4	4	7.7	40
Welding technology	Hot-air*	Hot-air	Hot-air	Hot-wedge	Hot-air
✓✓✓ = Highly suitable, ✓✓ = Suitable, ✓ = Limited suitability					
		* Brushless blower	**No gap necessary for laminated sheets		

## Welding technologies Roofing welders

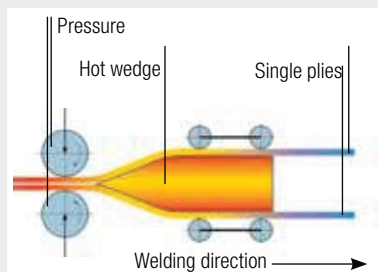
### Hot gas welding



### Heating by hot-air

- VARIMAT V2
- UNIROOF E 40 mm
- TRIAC DRIVE AT
- BITUMAT B2

### Hot-wedge welding



### Heating by electrically heated wedge

- COMET SUB-ROOF





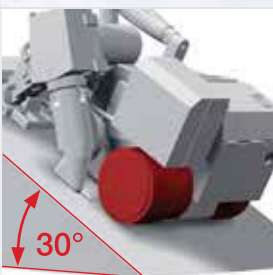


The VARIMAT V2 is perfectly protected and can easily be moved into and out of its sturdy storage case.

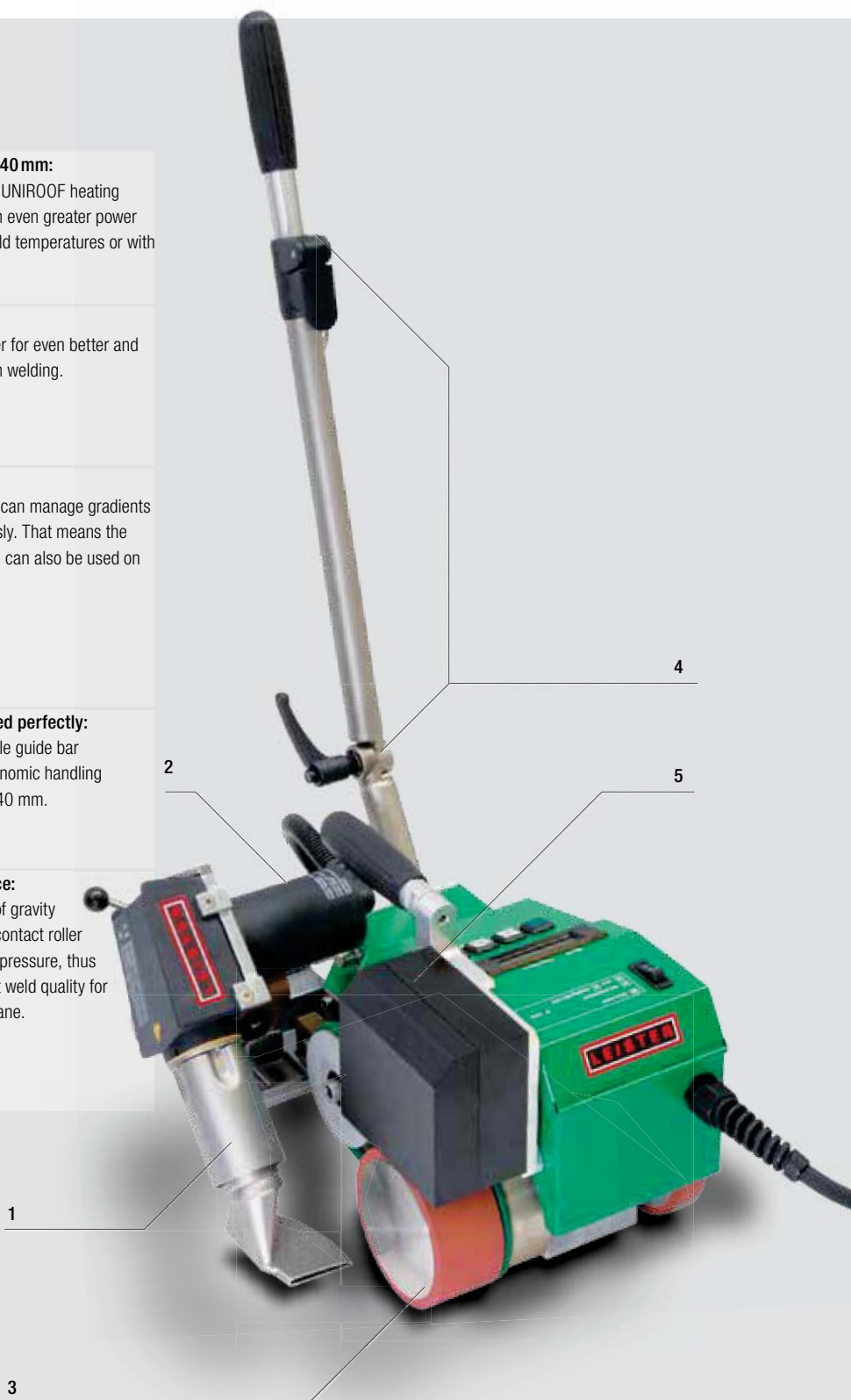
# UNIROOF E 40 mm

Leister's UNIROOF E 40 mm, the automatic roof welding machine of the new, powerful compact class, makes it convenient and easy to work with single-ply membranes. The new 40 mm nozzle means greater safety with overlap welding. Thanks to 2900 Watt power at only 13A, the tool can be used practically anywhere while providing ample power reserves.

Hot-air welder

## UNIROOF E 40 mm

1		<b>More power with 40 mm:</b> The most powerful UNIROOF heating element ensures an even greater power reserve, even at cold temperatures or with thick materials.
2		<b>Tool guidance:</b> Adapted guide roller for even better and easier control when welding.
3		<b>A powerhouse:</b> The powerful drive can manage gradients up to 30° effortlessly. That means the UNIROOF E 40 mm can also be used on sloping roofs.
4		<b>Everything handled perfectly:</b> The freely adjustable guide bar ensures ideal, ergonomic handling of the UNIROOF E 40 mm.
5		<b>More contact force:</b> Having the centre of gravity directly above the contact roller creates even more pressure, thus allowing a constant weld quality for all types of membrane.





## Hot-air welder

### UNIROOF E 40 mm



- Controlled technology with display guarantees a constant and reliable weld for a leakproof roof
- 100% swiss made quality
- Powder-coated, rust-free stainless steel housing and rustproof components
- Lightweight and compact


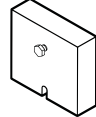
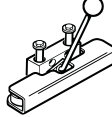

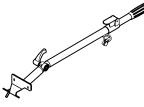
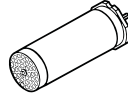
#### Technical Data

Amperage	A	13
Voltage	V~	230
Power	W	2900
Frequency	Hz	50 / 60
Temperature	°C	80 – 600
Speed	m / min	1 – 5
Welding seam width	mm	40
Size (L x W x H)	mm	420 x 280 x 210
Weight		
(incl. cable and additional weights)	kg	15.4
Weldable materials PVC, TPO, ECB, EPDM, CSPE		
Protection class I		⊕
Approval marks		CE, CCA

#### Article No.:

147.828 UNIROOF E 40 mm, 230 V with Euro-plug  
Included in scope of supply: Handle, with guide bar, 2 additional weights, storage case, operating instructions and DVD

### Accessories UNIROOF E 40 mm

	<b>148.731</b> 40 mm grip-nozzle for TPO / FPO single plies
	<b>107.067</b> Additional weight for even more pressure
	<b>115.057</b> Lifting device for simple moving to the next weld seam
	<b>126.448</b> Storage case (included with purchase)
	<b>147.836</b> Guide-bar, complete, adjustable
	<b>103.605</b> Heating element 230 V / 2750 W

The storage case included in the scope of supply keeps the UNIROOF E 40 mm safe at all times and makes it convenient to carry.



## VARIMAT V2:

### Fast and dependable.

Using the new VARIMAT V2, polymer roofing membranes can be welded more rapidly resulting in lower cost. Users appreciate its streamlined ergonomics and its ease of use. The clearly laid out operating unit's „e-drive“ allows for the control of all relevant welding parameters.



Due to its slim line design, welding is possible even up close to edges.

Hot-air welder

### VARIMAT V2



- 12 m/min maximum welding speed (depending on material)
- Guide bar for ergonomic handling
- Maintenance free blower means lower service costs
- User-friendly display with “e-Drive” (press and turn control) to recall preset and saved welding settings
- Constant drive with regulated electronics

#### Technical Data

Voltage	V~	230	400
Power	W	4600	5700
Temperature	°C	100 – 620	
Speed	m/min	0.7 – 12	
Air flow range	%	50 – 100	
Width of welding nozzle	mm	40	
Size (L x W x H)	mm	640 x 430 x 330	
Weight	kg	35	
Conformity mark		CE	
Approval mark		3	
Certification scheme		CCA	
Protection class I		⊕	

#### Article No.:

138.108	VARIMAT V2, 230 V / 4600 W, Euro plug, storage case
137.821	VARIMAT V2, 400 V / 5700 W, 16 A CEE-plug, storage case

Additional versions available upon request.

### Accessories VARIMAT V2

	<b>113.995</b>	Grip-nozzle 30 mm for TPO / FPO single plies
	<b>113.600</b>	Grip-nozzle 40 mm for TPO / FPO single plies
	<b>107.067</b>	Additional weight for even more pressure
	<b>139.048</b>	Sturdy storage case 720 x 470 x 450 mm plywood, green *
	<b>107.649</b>	Replacement rolls
	<b>132.429</b>	2 welding plates for optimum welding start *
	<b>138.817</b>	Steel brush to clean nozzle *
	<b>146.514</b>	Solar profile kit
	<b>143.162</b>	Gentle pressure roller for difficult ground conditions
	<b>151.530</b>	Mirror welding kit, nozzle right, for special welding applications
	<b>107.612</b>	Heating elements 230 V / 4400 W
	<b>107.613</b>	400 V / 5500 W

\* Included with purchase

# TRIAC DRIVE AT: The all-purpose hot-air tool.

The unique, semiautomatic welding tool. The flexible concept makes the TRIAC DRIVE AT an all-around tool that is universal in use.



Greater stability and reliability in device guidance thanks to the welding guide.

Semiautomatic hot-air tool

## TRIAC DRIVE AT



- More consistent and up to three times faster than manual welding
- Unique semiautomatic welding tool
- Automatic welding in areas inaccessible to other tools
- With welding guide, inside nozzle or outside nozzle, the unit is suitable for all roofing applications and other areas of use

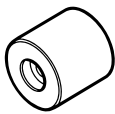



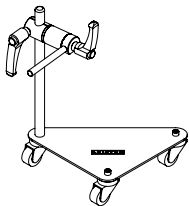
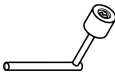



### Technical Data

Voltage	V~	230
Power	W	1700
Temperature	°C	40 – 650
Speed	m/min	0.5 – 3
Size (L x W x H)	mm	300 x 230 x 380
Weight (with 3 m cable)	kg	4.1
Conformity mark		CE
Protection class II		□

### Article No.:

117.331	TRIAC DRIVE AT 230 V / 1700 W, without guiding help, nozzle inside, 30 mm, without grip, Euro plug
117.332	TRIAC DRIVE AT 230 V / 1700 W, with guiding help, nozzle inside, 30 mm, without grip, Euro plug
117.333	TRIAC DRIVE AT 230 V / 1700 W, with guiding help, nozzle inside, 30 mm, without grip, Euro plug, with extension for parapet welding
148.605	TRIAC DRIVE AT, 230V / 1700 W, without guiding help, inside nozzle 38 mm, without grip, pressure roller steel, Euro plug
148.606	TRIAC DRIVE AT, 230 V / 1700 W, without guiding help, inside nozzle 12 mm, with grip, pressure roller steel, Euro plug

## Accessories TRIAC DRIVE AT

	<b>115.274</b> 12 mm pressure roller, steel <b>115.176</b> 30 mm pressure roller, steel <b>115.712</b> 40 mm pressure roller, steel <b>115.857</b> 30 mm pressure roller, silicone <b>115.921</b> 40 mm pressure roller, silicone
	<b>115.276</b> Single supporting carrier, brass <b>138.570</b> Single supporting carrier, silicone
	Overlap welding nozzle, inside, push-fit <b>115.283</b> 12 mm, with grip <b>115.279</b> 30 mm, with grip <b>115.281</b> 38 mm, with grip <b>115.699</b> 12 mm, without grip <b>115.701</b> 30 mm, without grip <b>115.703</b> 38 mm, without grip
	Overlap welding nozzle, outside, push-fit <b>115.285</b> 12 mm, with grip <b>115.278</b> 30 mm, with grip <b>115.280</b> 38 mm, with grip <b>115.700</b> 30 mm, without grip <b>115.702</b> 38 mm, without grip
	<b>138.549</b> Guiding help for TRIAC DRIVE AT, for easy horizontal welding, e.g. for parapets  <b>115.700</b> Overlap welding nozzle 30mm, outside, push-fit, without grip (included with purchase)
	<b>142.422</b> Guiding help with extension for parapet
	<b>142.413</b> Extension bar for extension on parapet
	<b>108.985</b> Storage case (included with purchase)
	<b>142.717</b> Heating element, 230 V / 1550 W, for TRIAC AT

Roofing

# BITUMAT B2: The flameless.

Welding of modified bitumen sheeting (SBS, APP) with the flameless BITUMAT B2 is much safer than welding with an open flame. The weld strength is significantly better and the single step process makes welding more economical.



Easy unit guidance and clean working with the BITUMAT B2.

## Hot-air welder

### BITUMAT B2



- Flameless welding of modified bitumen
- No shrinking of the insulation due to integrated air dam
- Uniform welding results
- High working speed
- Requires only one user to efficiently weld seams (torch welding requires two)

#### Technical Data


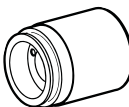


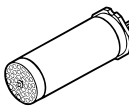
Voltage	V~	230	400
Power	W	6700	6700
Temperature	°C	20 – 650	
Speed	m/min	0.8 – 12	
Air flow range	%	85 – 100	
Welding nozzle width	mm	75 / 100	
Size (L x W x H)	mm	690 x 490 x 330	
Weight	kg	40 (with cable)	
Conformity mark		CE	
Approval mark		Ⓢ	
Certification scheme		CCA	
Protection class I		Ⓜ	

#### Article No.:

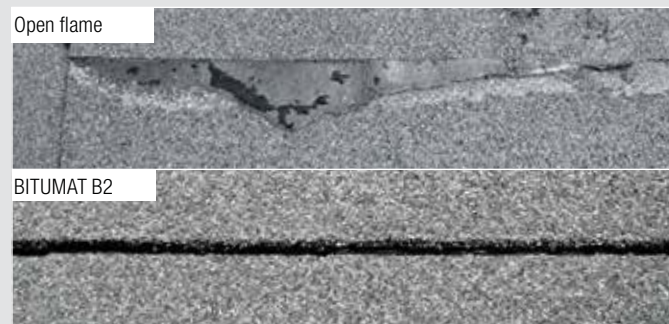
- 140.438 BITUMAT B2 400 V / 6700 W, 75 mm, 16 A-CEE-plug
- 140.437 BITUMAT B2 400 V / 6700 W, 100 mm, 16 A-CEE-plug
- 140.436 BITUMAT B2 230 V / 6700 W, 75 mm, 32 A-CEE-plug
- 138.386 BITUMAT B2 230 V / 6700 W, 100 mm, 32 A-CEE-plug

Additional versions available upon request.

## Accessories BITUMAT B2

	<b>138.048</b>	75 mm bitumen nozzle
	<b>138.047</b>	100 mm bitumen nozzle
	<b>137.895</b>	100 mm pressure roller with gap
	<b>137.896</b>	75 mm pressure roller with gap
	<b>140.229</b>	100 mm pressure roller without gap
	<b>140.228</b>	75 mm pressure roller without gap
	<b>140.476</b>	Lifting device
	<b>140.489</b>	Sturdy storage case, 750 x 555 x 450 mm (included with purchase)
	<b>126.594</b>	Heating elements 400 V / 6500 W
	<b>126.386</b>	230 V / 6500 W

Considerably better welding results when compared with open flame tools. No damage to insulating material due to integrated air dam.



# COMET: Perfectly pre-fabricated.

The COMET works smoke-free and quietly. Thanks to the built-in guide system, the width of the weld zone is uniform – resulting in perfectly welded seams.



Hands-free welding due to integrated guiding plates.

Hot-wedge welder

## COMET SUB-ROOF



- Smoke-free, low-noise welding using hot-wedge technology
- Digital temperature and speed display
- Integrated guiding plates
- No non-welded edge zones
- Ideal for indoor applications

### Technical Data

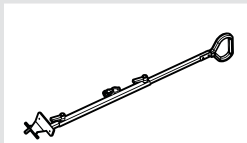
Voltage	V~	230
Power	W	700
Temperature	°C	20 – 420
Speed	m/min	0.8 – 6
Pressure static	N	100 – 500
Material thickness	mm	Up to 0.8 mm
USB-memory-stick		optional
Size (L × W × H)	mm	355 × 250 × 245
Weight	kg	7.7 (with 3 m cable)
Conformity mark		CE
Approval mark		§
Certification scheme		CCA
Protection class I		⊕

### Article No.:

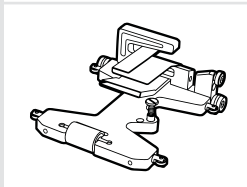
138.276 COMET SUB-ROOF, 230 V / 700 W, with EU-plug,  
for sub-roof membranes, without fitting welding carriage,

Additional versions available upon request.

## Accessories COMET SUB-ROOF



129.224 Guide-bar, complete, adjustable



110.694 Fitting welding carriage

The welding carriage transfers the drive to the sub-roof membrane located below. This enables friction-free, high-quality welding. The welding carriage is especially suitable for thin, homogenous material. Welding with a guide rail is also possible for the pre-fabricator.



The COMET SUB-ROOF is ideal for pre-fabricators.

## EXAMO USB: The inspector.

Is the welding seam sealed and can it withstand the specified peeling, tensile and shearing forces? EXAMO performs tests at the construction site – quick, reliable and uncomplicated.



Testing a weld seam with the EXAMO USB.

### Testing instrument

## EXAMO USB



- Handy, robust and reliable
- Testing of elongation, peak force, tear force, test speed and position
- Construction-site approved

### Technical Data

Type		300F	600F
Voltage	V~	230	230
Power	W	200	200
Tensile load	N	4000	4000
Jaw spacing	mm	5 – 300	5 – 600
Range	mm	300	600
Test speed	mm/min	10 – 300	10 – 300
Sample thickness	mm	max. 7	max. 7
Sample width	mm	max. 40 (60 optional)	max. 40 (60 optional)
Size (L × W × H)	mm	750 × 270 × 190 (storage case)	1050 × 270 × 190 (storage case)
Weight	kg	14	17.5
Conformity mark		CE	CE
Approval mark		§	§
Protection class I		⊕	⊕

### Article No.:

139.059 EXAMO 300F USB, 230 V / 200 W, incl. USB memory stick, Euro plug  
139.060 EXAMO 600F USB, 230 V / 200 W, incl. USB memory stick, Euro plug

## Accessory EXAMO USB



**134.832** Testing and calibration kit

To test and calibrate your EXAMO USB



**115.905** USB memory stick



The memory stick ensures a verifiable evaluation of the welding results with the EXAMO USB.







## Technical Textiles & industrial Fabrics

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## Hot-Air Hand Tools

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# SEAMTEK 36: Versatile and reliable

With its easily configurable, modular construction and wide range of pressure rollers and nozzle widths, the SEAMTEK 36 guarantees the greatest flexibility. The ingenious tape guiding system makes it easy to position the material and keep it taut right up to the final point. The pedestal, included in the SEAMTEK 36 Base version, is the workhorse of the system. Together with one of three additional modules almost every plastic weld technique is possible.

**New**

1		<b>User-friendly:</b> Welding parameters always under control. Multilingual touch-screen with 99 memory settings
2		<b>Well-arranged:</b> Easy access to the welding process
3		<b>Easy:</b> Modular, quickly changeable drive rolls
4		<b>Quick arm:</b> For welding tubes (accessory)
5		<b>Side arm:</b> For welding and taping tapes and for circumference taping caps (accessory)
6		<b>Tape Delivery System (TDS):</b> For welding of tapes (accessory)



Leister SEAMTEK 36 Base version



Easy, economical and safe welding.

## Welding machine

### SEAMTEK 36



- Suitable for seam or tape welding
- For different weld types like overlap, butt joints, any hem pipe, tape and prayer welds
- Test program to optimize weld parameters
- Easy access to welding process
- Quickly changeable accessories for many applications

#### Technical data

Voltage	V~	230 / 240
Power	W	3500 with small pump 3900 with big pump
Temperature °C	35 – 700	
Speed m/min	2.25 – 22	
Dimensions (L x W x H)	cm	170 x 80 x 170
Weight kg	330	
Regulated weld pressure	bar	1 – 6.2
Maintained air pressure	bar	6.2
Nozzle / pressure roller widths	mm	8 – 64

#### Article No.:

151.162	SEAMTEK Base version with pedestal, 2 steel or silicon pressure rollers, standard nozzle 25 mm
150.887	Quick arm
150.774	Side arm
151.161	Tape Delivery System (TDS)

## Technical textile applications



Inflatables










Bags



Clothing and apparel

## Product overview hot-air welders for Technical Textiles & industrial Fabrics

							
Device type	VARIANT T1 Overlap	VARIANT T1 TAPE 50 mm	VARIANT T1 TAPE 25 mm	UNIPLAN E / S	UNIPLAN WEDGE	TAPEMAT 50 mm	TAPEMAT SPRIEGEL 100 / 125 mm
Max. voltage V~	230 / 400	230 / 400	230 / 400	230	230	3 × 400	3 × 400
Max. power W	3680 / 5700	3680 / 5700	3680 / 5700	2300	900	10 000	10 000
Temperature °C	100 – 620	100 – 620	100 – 620	80 – 620	80 – 420	650	650
Speed m/min	1.5 – 18	1.5 – 18	1.5 – 18	1.0 – 7.5	1.0 – 7.5	4.0 – 20	4.0 – 20
Welding width mm	20 / 40	50	25	20 / 30	20 / 30	50	2 × 20
Size (L × W × H) mm	500 × 400 × 195	700 × 415 × 85	700 × 415 × 85	420 × 270 × 210	420 × 270 × 210	555 × 435 × 370	555 × 435 × 370
Weight kg	22.5	28.0	28.0	11.5	11.5	35.0	40.0
Conformity mark	CE	CE	CE	CE	CE	CE	CE
Approval mark	§	§	§	§	§	§	§
Certification scheme	CCA	CCA	CCA	CCA	CCA	CCA	CCA
Protection class	⊕	⊕	⊕	⊕	⊕	⊕	⊕
<b>Welding options</b>							
Overlap welding	✓			✓	✓		
Hem welding	✓			✓	✓		
Piping welding	✓			✓	✓		
Tape welding		✓	✓			✓	✓
<b>Welding technologies</b>							
Hot-air welding	✓	✓	✓	✓		✓	✓
Hot-wedge welding					✓		
<b>Features</b>							
Temperature regulation	✓	✓	✓	✓	✓		
Drive regulation	✓	✓	✓	✓	✓		
Temperature and drive infinitely adjustable	✓	✓	✓	✓	✓	✓	✓
Digital display	✓	✓	✓	✓	✓	✓	
Catalog page	49	50	51	52	53	54	54

## VARIANT T1: Compact, fast and reliable.

This tool's top welding speed of up to 18 m/min and its slim, compact design make it a winning choice.



Very easy hem and piping welds with the hem / piping welding kit.

Hot-air welder

### VARIANT T1 Overlap



- Top welding speed up to 18m/min
- Perfect view into the weld seam
- Sturdy and durable for professional use
- Smooth lifting device for precise positioning
- Simple operation due to «e-Drive» operating concept

#### Technical Data

Voltage	V~	230 / 400 (2LNPE)
Power	W	3680 / 5700
Temperature	°C	100 – 620
Speed	m/min	1.5 – 18
Air flow range	%	40 – 100
Welding seam width	mm	20 or 40
Size (L x W x H)	mm	500 x 400 x 195
Weight	kg	22 (without 1.5 m cord)
Conformity mark		CE
Protection class I		⊕

#### Article No.:

141.891	VARIANT T1, 230 V / 3680 W, 40 mm nozzle, with Euro plug
141.892	VARIANT T1, 230 V / 3680 W, 20 mm nozzle, with Euro plug
141.893	VARIANT T1, 400 V / 5700 W, 40 mm nozzle, with CEE plug (3LNPE)
141.894	VARIANT T1, 400 V / 5700 W, 20 mm nozzle, with CEE plug (3LNPE)

Additional versions available upon request.








### Accessories VARIANT T1 Overlap

	<b>142.650</b>	Hem / piping welding kit complete, comprising:
	<b>142.221</b>	Hold-down device
	<b>141.326</b>	Piping roll
	<b>140.530</b>	Hem / piping add-on part
	<b>148.961</b>	Conversion kit, VARIANT T1 Overlap to VARIANT T1 TAPE 25 mm
	<b>148.962</b>	Conversion kit, VARIANT T1 Overlap to VARIANT T1 TAPE 50 mm
	<b>139.438</b>	Additional weight 3 kg
	<b>116.798</b>	Brass brush
	<b>140.771</b>	Overlap welding nozzle 20 mm
	<b>141.558</b>	Overlap welding nozzle 40 mm
	<b>140.429</b>	25 mm pressure roller complete
	<b>138.938</b>	45 mm pressure roller complete
	<b>142.705</b>	Sturdy storage case
	<b>107.612</b>	Heating elements 230 V
	<b>107.613</b>	400 V

Technical Textiles & Industrial Fabrics

# VARIANT T1 TAPE: Quality, productivity, ergonomic.

Used for welding reinforcement and anti-vandalism tapes in vehicle tarpaulin production. Thanks to the "e-Drive" operating concept, setting the relevant welding parameters couldn't be easier. The tape holder and the newly developed guide rollers guide the tape under the pressure roller, keeping it taut right up to the final centimeter.

1		<b>User-friendly:</b> Clear display plus "e-Drive" and storable welding parameters
2		<b>Highly flexible:</b> Conversion kits make it possible to work with different types of tape: 50 mm reinforcement and 25 mm anti-vandalism tapes (see image).
3		<b>High-tech nozzles:</b> The new nozzle design ensures safe, reliable welding.
4		<b>Feeding to perfection:</b> The new guide rollers make it easy to position the material and keep it taut right up to the final centimeter.
5		<b>A tight grip:</b> The swivelling tape clamping lever keeps the material extra-taut.
6		<b>Dual-action:</b> The pressure roller can easily be converted from a 50 mm width to a 25 mm one (anti-vandalism tape) or vice versa.
7		<b>Optional:</b> The laser guide keeps the VARIANT T1 TAPE firmly on course.



VARIANT T1 TAPE 50 mm



An economical, ergonomic tool for welding reinforcement tapes.

## Tape hot-air welder

### VARIANT T1 TAPE



VARIANT T1 TAPE 25 mm,  
anti-vandalism

- Fastest, most precise automatic tape welding tool (up to 18 m/min)
- "e-Drive" operating unit
- Easy to use
- Taut tape guidance
- Kits for converting VARIANT T1 Overlap to 25 or 50 mm TAPE

#### Technical Data

Voltage	V~	230	400
Power	W	3680	5700
Temperature	°C	100 – 620	
Air flow range	%	50 – 100	
Speed	m/min	1.5 – 18	
Welding seam width	mm	50 or 25	
Size (L x W x H)	mm	700 x 415 x 85	
Weight	kg	28 (with 1.5 m cord)	
Conformity mark		CE	
Approval mark		Ⓢ	
Certification scheme		CCA	
Protection class I		Ⓢ	

#### Article No.:

148.963	VARIANT T1 TAPE 25	mm, 230 V / 3680 W, with Euro plug
148.964	VARIANT T1 TAPE 50	mm, 230 V / 3680 W, with Euro plug
148.965	VARIANT T1 TAPE 25	mm, 400 V / 5700 W, with Euro plug
148.966	VARIANT T1 TAPE 50	mm, 400 V / 5700 W, with Euro plug

Additional versions available upon request.

### Accessories VARIANT T1 TAPE

	<b>149.652</b> Conversion kit VARIANT T1 TAPE 25 mm to VARIANT T1 TAPE 50 mm: 1 nozzle, 4 guide rollers, 1 gauge
	<b>149.653</b> Conversion kit VARIANT T1 TAPE 50 mm to VARIANT T1 TAPE 25 mm: 1 nozzle, 4 guide rollers, 1 gauge
	<b>149.654</b> Conversion kit VARIANT T1 TAPE to VARIANT T1 Overlap 20 mm
	<b>149.655</b> Conversion kit VARIANT T1 TAPE to VARIANT T1 Overlap 40 mm
	<b>149.100</b> Magnetic tool holder
	<b>149.344</b> Laser guide (available Jan. 2014)
	<b>139.438</b> Additional weight 3 kg
	<b>116.798</b> Brass brush
	<b>107.612</b> Heating elements 230V <b>107.613</b> 400V

# UNIPLAN: Just perfect.

The small, lightweight and handy hot-air welder produces perfect welding results. UNIPLAN E is electronically controlled for reproducible results.



The handy partner for precise welding: UNIPLAN E.

## Hot-air welder

### UNIPLAN E / UNIPLAN S



UNIPLAN E

- Small, lightweight and handy
- High welding speed
- Reproducible welding results (UNIPLAN E)
- Handy, robust case included in delivery
- Digital display (UNIPLAN E)

#### Technical Data

Voltage	V~	230
Power	W	2300
Temperature	°C	20 – 620
Speed	m/min	1.0 – 7.5
Air flow range	%	50 – 100 (for UNIPLAN E steplessly)
Welding seam width	mm	20 or 30
Size (L × W × H)	mm	420 × 270 × 210
Weight	kg	11.5 (with 3 m cord)
Conformity mark		CE
Approval mark		5
Certification scheme		CCA
Protection class I		⊕

#### Article No.:

114.221	UNIPLAN E 20 mm, 230V / 2300 W, with Euro plug
114.318	UNIPLAN E 30 mm, 230V / 2300 W, with Euro plug
115.049	UNIPLAN S 20 mm, 230V / 2300 W, with Euro plug
115.050	UNIPLAN S 30 mm, 230V / 2300 W, with Euro plug

Additional versions available upon request.

## Accessories UNIPLAN E / UNIPLAN S

	<b>115.065</b> 20 mm overlap welding unit
	<b>115.066</b> 30 mm overlap welding unit
	<b>115.067</b> Weight with holder
	<b>115.839</b> Handle with holder and screws
	<b>119.933</b> 20 mm hem welding kit
	<b>119.934</b> 30 mm hem welding kit
	<b>122.013</b> Hem cord welding kit with lifting (for units built prior to 2004)
	<b>122.016</b> Hem cord welding kit without lifting (for units built from 2004 on)
	<b>147.836</b> Guide bar complete
	<b>116.798</b> Brass brush to clean nozzle
	<b>126.448</b> Sturdy storage case (included with purchase)
	<b>103.604</b> 230 V / 2100 W heating element, for UNIPLAN E
	<b>101.910</b> 230 V / 2100 W heating element, for UNIPLAN S

# UNIPLAN Wedge: The quiet.

The quiet UNIPLAN WEDGE is the perfect machine for all critical materials. The innovative laser guide ensures flawless welding.



For accurately welded seams on technical Textiles.

Wedge welder

## UNIPLAN WEDGE



- Low noise
- High welding speed
- Portable and lightweight
- Easy, comfortable operation
- Digital display of welding speed and temperature

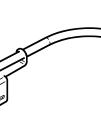

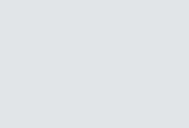
Technical Data		
Voltage	V~	230
Power	W	900
Temperature	°C	80 – 420
Speed	m/min	1.0 – 7.5
Welding seam width	mm	20 or 30
Size (L x W x H)	mm	420 x 270 x 210
Weight	kg	11.5 (with 3 m cord)
Conformity mark	CE	
Approval mark	S	
Certification scheme	CCA	
Protection class I	⊕	

### Article No.:

- 116.972 UNIPLAN Wedge, 20 mm laserguide, 230 V / 900 W, with Euro plug
- 116.975 UNIPLAN Wedge, 30 mm laserguide, 230 V / 900 W, with Euro plug

Additional versions available upon request.

## Accessories UNIPLAN WEDGE

	<b>127.992</b> 20 mm hot wedge
	<b>127.989</b> 30 mm hot wedge
	<b>116.506</b> Laser guide (included with purchase)
	<b>116.231</b> De-reeler for acrylic tape
	<b>116.798</b> Brass brush to clean nozzle

Technical Textiles & industrial Fabrics

# TAPEMAT: The power pack.

For rapid economical strip welding of truck covers and industrial curtains. Very fast strip welder at up to 20 meters per minute.



Welding tape at maximum speed.

Tape hot-air welder

## TAPEMAT



- High welding speed
- Process-optimized nozzle
- Maintenance-free, brushless blower
- Intuitive operation and simple handling

### Technical Data

Voltage	V~	3 × 400
Power	kW	10
Temperature	°C	~ 650
Speed	m/min	4 – 20
Welding seam width	mm	50
Size (L × W × H)	mm	555 × 435 × 370
Weight	kg	35
Conformity mark		CE
Approval mark		§
Certification scheme		CCA
Protection class I		⊕

### Article No.:

129.757 TAPEMAT 50 mm, 400 V / 10 kW, with 16A CEE plug

Spriegel hot-air welder

## TAPEMAT SPIEGEL



- Top welding speed
- Process-optimized high-precision nozzle
- Maintenance-free, brushless blower
- Easy to exchange counter-pressure roller
- Constant tarpaulin bow tension

### Technical Data

Voltage	V~	3 × 400
Power	kW	10
Temperature	°C	~ 650
Speed	m/min	4 – 20
Welding seam width max.	mm	2 × 20
Band with	mm	100 / 125
Size (L × W × H)	mm	555 × 435 × 370
Weight	kg	40
Conformity mark		CE
Approval mark		§
Certification scheme		CCA
Protection class I		⊕

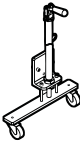

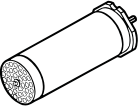
### Article No.:

138.229 TAPEMAT Spiegel 100 mm, 400 V / 10 kW, with 16A CEE plug  
133.597 TAPEMAT Spiegel 125 mm, 400 V / 10 kW, with 16A CEE plug

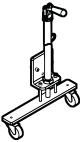


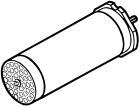


Tarpaulin bows for fixed and sliding rooftops of trucks.  
(picture: Krone)

### Accessories TAPEMAT

	<b>138.242</b> Lifting device
	<b>131.690</b> 50 mm welding nozzle
	<b>101.991</b> 3 x 400 V / 3 x 3300 W heating element

### Accessories TAPEMAT SPRIEGEL

	<b>138.242</b> Lifting device
	<b>137.412</b> 100 mm welding nozzle, complete
	<b>135.392</b> 125 mm welding nozzle, complete weldseam 20 mm left and right
	<b>101.991</b> 3 x 400 V / 3 x 3300 W heating element

Technical Textiles &  
Industrial Fabrics





## Civil Engineering / Tunneling / Landfills

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## Hot Air Tools for Roofing

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## Product overview wedge welder for Civil Engineering / Tunneling / Landfills

								
Device type	ASTRO	ASTRO USB	COMET	COMET USB	TWINNY T	TWINNY T USB	TWINNY S	TRIAC DRIVE AT
Max. Voltage V~	230	230	230	230	230	230	230	230
Max. Power W	1800	1800	1800 / 1500 / 1200	1800 / 1500 / 1200	2300	2300	2900	1700
Temperature °C	80 – 420	80 – 420	80 – 420	80 – 420	80 – 560	80 – 560	80 – 600	80 – 650
Speed m/min	0.8 – 5.0	0.8 – 5.0	0.8 – 3.2	0.8 – 3.2	0.8 – 3.2	0.8 – 3.2	0.2 – 2.5 (4.0 <sup>1</sup> )	0.5 – 3.0
Welding pressure N	100 – 1500	100 – 1500	100 – 1000	100 – 1000	100 – 1000	100 – 1000	1000 (500)	n.a.
Weld seam width mm	2 × 15	2 × 15	2 × 15	2 × 15	2 × 15	2 × 15	2 × 15	30
Material thickness mm	1.5 – 3.0	1.5 – 3.0	0.5 – 3.0	0.5 – 3.0	0.5 – 3.0	0.5 – 3.0	0.5 – 3.0	0.5 – 3.0
Size (L × W × H) mm	430 × 270 × 310	430 × 270 × 310	295 × 250 × 245	295 × 250 × 245	340 × 360 × 245	340 × 360 × 245	350 × 390 × 270	300 × 230 × 380
Weight kg (with 3 m cable)	23.0	23.0	7.5	7.5	6.9 – 7.9	6.9 – 7.9	6.5 – 6.9	4.1
Conformity mark	CE	CE	CE	CE	CE	CE	CE	CE
Approval mark	§	§	§	§	§	§	§	§
Certification scheme	CCA	CCA	CCA	CCA	CCA	CCA	CCA	CCA
Protection class	⚡	⚡	⚡	⚡	⚡	⚡	⚡	⚡
<b>Welding technologies</b>								
Hot-wedge welding	✓	✓	✓	✓				
Combi-wedge welding					✓	✓	✓	
Hot-air welding								✓
<b>Features</b>								
Temperature regulation	✓	✓	✓	✓	✓	✓		✓
Drive regulation	✓	✓	✓	✓	✓	✓		✓
Temperature and drive infinitely adjustable	✓	✓	✓	✓	✓	✓	✓	✓
USB data recording		✓		✓		✓		
Digital display	✓	✓	✓	✓	✓	✓		✓
Catalog page	61	60/61	62	62	694	64	65	66

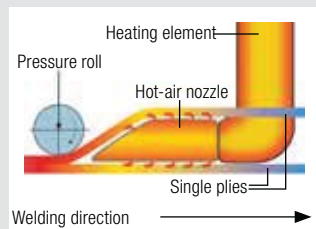
<sup>1</sup> with drive 144:1

## Product overview – manual extrusion welders

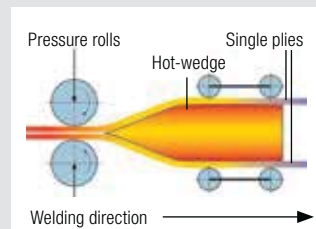
					
Device type	WELDPLAST S6	WELDPLAST S4	WELDPLAST S2	FUSION 3	FUSION 3C
Max. Voltage V~	230	230	230	230	230
Max. Power W	4600	3680	3000	3500	2800
Material	PE / PP	PE / PP	PE / PP / TPO <sup>2</sup>	PE / PP	PE / PP
Welding rod mm	Ø 4 – Ø 5	Ø 3 – 4 / Ø 4 – 5	Ø 3 – Ø 4	Ø 3 – 4 / Ø 4 – 5	Ø 3 – 4 / Ø 4 – 5
Output kg/h	3.9 – 6.0	1.5 – 4.0	0.5 – 2.3	1.8 – 3.6	1.8 – 3.6
Size (L × W × H) mm	821 × 116 × 240	560 × 110 × 300	450 × 98 × 260	670 × 90 × 180	588 × 98 × 225
Weight kg	14.0	8.7	5.8	7.2	6.9
Conformity mark	CE	CE	CE	CE	CE
Approval mark	§	§	§	§	§
Certification scheme	CCA	CCA	CCA	CCA	CCA
Protection class II	⊕	⊕	⊕	⊕	⊕
<b>Features</b>					
Maintenance-free blower	✓	✓	✓		
Multifunction display	✓	✓	✓		
Adjustable grip	✓	✓	✓	✓	✓
Catalog page	68	69	70	71	71

<sup>2</sup> WELDPLAST S2 TPO variant

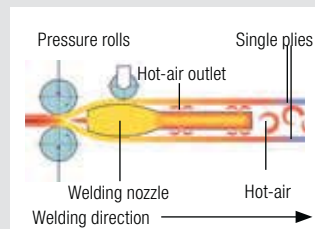
### Hot-air welding



### Hot-wedge welding



### Combi-wedge welding

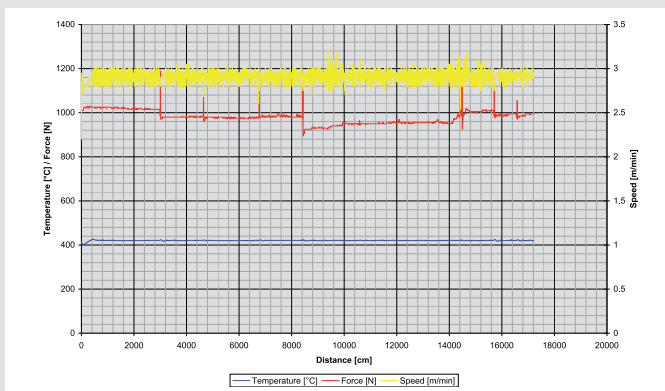
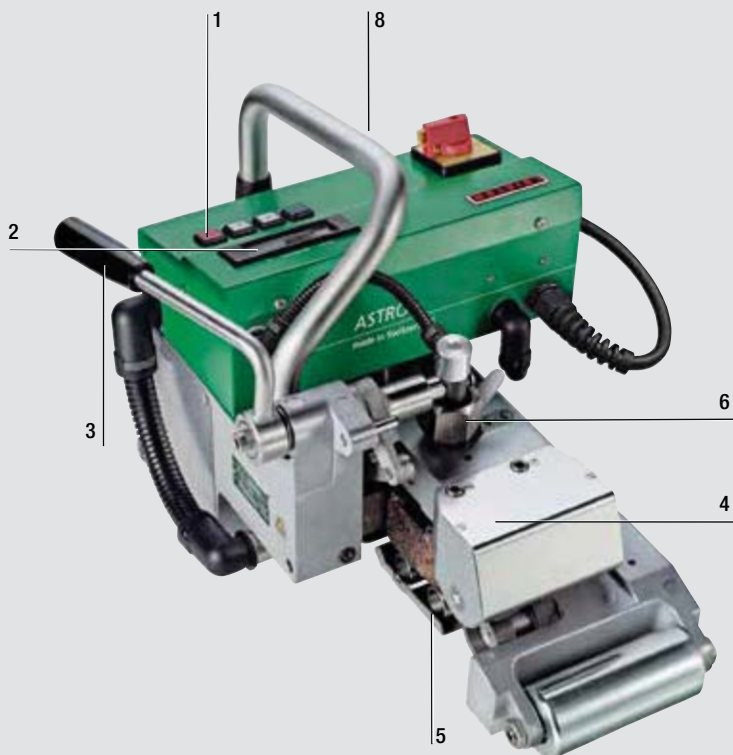


# ASTRO / ASTRO USB: The thoroughbred.

The ASTRO and ASTRO USB are used anywhere all over the world. They weld up to five meters per minute. Its robust design and easy handling make it the perfect workhorse. The ASTRO USB allows for the consistent recording of all relevant welding parameters.

Wedge welder

## ASTRO USB



Graphical evaluation of a weld seam (length 170 m).

1		<b>Simple operation</b> All functions can be accessed and controlled by just a few buttons.
2		<b>Display</b> Allows the user to control and monitor all the parameters at any given time!
3		<b>One-handle operation</b> Simultaneous operation of clamping lever and hot-wedge.
4		<b>Pendulum head</b> Perfect pressure distribution of both welding tracks.
5		<b>Hot wedge</b> Sufficient capacity reserve and optimal welding speed due to high capacity cartridge type heaters.
6		<b>Pressure sensor</b> Precise pressure sensor for optimal process control.
7		<b>Acoustic alarm</b> Safer working with limit value monitoring.
8		<b>USB memory system</b> Recording all relevant welding parameters becomes childs play with the USB memory system.
9		<b>Handy storage case</b> Convenient transport – perfect protection. (Included with purchase)



Fast and perfect!



ASTRO CPL special version for concrete protective liners.

## Wedge welder ASTRO



- High welding capacity
- Digital display of temperature, velocity and mains voltage
- Stepless adjustment of welding pressure
- Closed-loop control of temperature and drive

### Technical Data

Voltage	V~	230
Power	W	1800
Temperature	°C	80 – 420
Speed	m/min	0.8 – 5.0
Welding pressure	N	100 – 1500
Weld seam width	mm	2 × 15
Material thickness	mm	1.5 – 3.0
Size (L × W × H)	mm	430 × 270 × 310
Weight	kg	23.0 (with 3 m cable)
Conformity mark	CE	
Approval mark	S	
Certification scheme	CCA	
Protection class I	⊕	

### Article No.:

117.100 ASTRO, 230 V / 1800 W, roller 50 mm, with test channel, with Euro plug, sturdy storage case

Included with purchase: Welder, manual, storage case

## Wedge welder ASTRO USB



- Digital display of pressure
- Acoustic alarm if limit value is exceeded
- USB memory system

### Technical Data

Voltage	V~	230
Power	W	1800
Temperature	°C	80 – 420
Speed	m/min	0.8 – 5.0
Welding pressure	N	100 – 1500
Weld seam width	mm	2 × 15
Material thickness	mm	1.5 – 3.0
Size (L × W × H)	mm	430 × 270 × 310
Weight	kg	23.0 (with 3 m cable)
Conformity mark	CE	
Approval mark	S	
Certification scheme	CCA	
Protection class I	⊕	

### Article No.

141.126 ASTRO USB, 230 V / 1800 W, roller 50 mm, with test channel, with Euro plug, sturdy storage case

Included with purchase: Welder, manual, memorystick, storage case

# COMET / COMET USB: The highflyers.

This compact heavy-duty welding machine is in use worldwide. The small powerhouse is specially designed for the demands of landfills sites, mines and tunnels. Documentation made simple: COMET USB's memory system is designed for use on construction sites. Because this compact hot-wedge welding machine records all relevant welding parameters, data transfer is mere child's play.

## Wedge welder

### COMET



- Lightweight and compact
- Digital display of temperature and velocity
- Closed loop control of temperature and drive
- Easy and user friendly

#### Technical Data

Voltage	V~	230 / 120
Power	W	1850 / 1500 / 1200
Temperature	°C	80 – 420
Speed	m/min	0.8 – 3.2
Welding pressure	N	100 – 1000
Weld seam width	mm	2 × 15, with test channel
Material thickness	mm	0.5 – 3
Size (L × W × H)	mm	295 × 250 × 245
Weight	kg	7.5 (with 3 m cable)
Conformity mark		CE
Approval mark		§
Protection class I		⊕

#### Article No.:

107.547	COMET, with wedge 50 mm for PE, 230 V / 1200 W *
107.538	COMET, with wedge 70 mm for PE, 230 V / 1500 W *
145.893	COMET, with wedge 95 mm for PE, 230 V / 1850 W *
107.558	COMET, with wedge 50 mm for PVC, 230 V / 1200 W *
107.553	COMET, with 50mm wedge for PE, 120 V / 1200 W*
107.539	COMET, with 70mm wedge for PE, 120 V / 1500 W*

Included with purchase: Welder, manual, guide-bar short, storage case

\* = with test channel, EURO plug

## Wedge welder

### COMET USB



- Digital display of welding pressure
- Complete recording of all relevant welding parameters.
- USB memory system designed for use on construction sites
- Convenient data transfer

#### Technical Data

Voltage	V~	230
Power	W	1850 / 1500 / 1200
Temperature	°C	80 – 420
Speed	m/min	0.8 – 3.2
Welding pressure	N	100 – 1000
Weld seam width	mm	2 × 15, with test channel
Material thickness	mm	0.5 – 3
Size (L × W × H)	mm	295 × 250 × 245
Weight	kg	7.5 (with 3 m cable)
Conformity mark		CE
Approval mark		§
Protection class I		⊕

#### Article No.:

137.626	COMET USB, with wedge 50 mm for PE, 230 V / 1200 W *
138.088	COMET USB, with wedge 70 mm for PE, 230 V / 1500 W *
146.052	COMET USB, with wedge 95 mm for PE, 230 V / 1850 W *

Included with purchase: Welder, manual, guide-bar short, memorystick, storage case

\* = with test channel, EURO plug

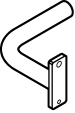
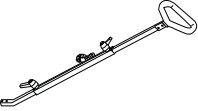
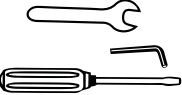



Comet operating in the tunnel ...



... or on a landfills site.

## Accessories COMET / COMET USB

	<b>112.974</b> Extremely light cross handle, material: aluminum
	<b>129.224</b> Guide-bar, complete
	<b>110.715</b> Tool set consists of hexagon spanner 8 / 10 / 13 / 17 mm and Allen keys 3 / 4 / 6 mm
	<b>115.905</b> USB memory stick



Perfectly protected in the storage case.

**126.448**  
(included with purchase)

## Fields of application COMET / COMET USB

Power	1850 W		1500 W		1200 W	
Type of material	Wedge	Material thickness	Wedge	Material thickness	Wedge	Material thickness
PE-HD, PE-C, PP	95 mm copper	1.5 – 2.0 mm	70 mm copper	1.5 – 2.0 mm	50 mm copper	0.5 – 1.5 mm
PE-LD	95 mm copper	2.0 – 3.0 mm	70 mm copper	2.0 – 3.0 mm	50 mm copper	1.0 – 2.0 mm
PVC-P			70 mm steel	2.0 – 3.0 mm	50 mm steel	1.0 – 2.0 mm

# TWINNY T / TWINNY T USB: The little all-rounders.

The TWINNY T is excellent for welding PVC and other thin or soft membranes. It is available either with or without air-test channel. The TWINNY T USB, which makes data storage and display easy with a USB flash memory system, is perfect for critical applications where constant real-time monitoring of primary weld conditions can be stored and displayed.

## Combi-wedge welder

### TWINNY T



- Simple operation
- High welding speed
- Digital display of temperature and velocity
- Closed-loop control of temperature and drive
- Perfect welding result even in harsh environmental conditions thanks to hot-air system.

#### Technical Data

Voltage	V~	230 / 120
Power	W	2300 / 1900
Temperature	°C	20 – 560
Speed	m/min	0.8 – 3.2
Welding pressure	N	100 – 1000
Size (L x W x H)	mm	340 x 360 x 245
Weight	kg	6.9 – 7.9 (with 3 m cable)
Conformity mark	CE	
Approval mark	S	
Protection class I	⊕	

#### Article No.:

107.562	TWINNY T for civil engineering, 230 V / 2300 W, with test channel, with combi-wedge long, with Euro plug
107.564	TWINNY T for civil engineering, 230 V / 2300 W, with test channel, with combi-wedge short, with Euro plug
111.190	TWINNY T for tunnel construction, 230 V / 2300 W, with test channel, with combi-wedge short, with Euro plug
113.362	TWINNY T for tunnel construction, 120 V / 1900 W, with test channel, with combiwedge short, with UK plug

#### Included with purchase:

Cvile engineering version: Welder, manual, guide-bar long (129.224), storage case  
Tunneling version: Welder, manual, guide-bar short, storage case

## Combi-wedge welder

### TWINNY T USB



- Digital display of welding pressure
- Complete recording of all relevant welding parameters
- USB memory system
- Data transfer made simple

#### Technical Data

Voltage	V~	230
Power	W	2300
Temperature	°C	80 – 560
Speed	m/min	0.8 – 3.2
Welding pressure	N	100 – 1000
Size (L x W x H)	mm	340 x 360 x 245
Weight	kg	6.9 – 7.9 (with 3 m cable)
Conformity mark	CE	
Approval mark	S	
Protection class I	⊕	

#### Article No.:

138.089	TWINNY T USB for civil engineering, 230 V / 2300 W, with test channel, with combi-wedge long, with Euro plug
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Additional versions (incl. 120 V) available upon request.

#### Included with purchase:

Civil engineering version: Welder, manual, guide-bar long (129.224), USB-memory-stick, storage case  
Tunneling version: Welder, manual, guide-bar short, storage case

# TWINNY S: Perfect weight.

This lightweight tool is optimized for overhead welding and is ideal for thin materials used in civil engineering and tunnel construction. Leister offers a choice between replaceable combi-wedges with or without test channel.



TWINNY T, with convenient cross-handle, at work overhead welding in a tunnel.

## Combi-wedge welder

### TWINNY S



- Simple operation
- Lightweight
- High welding speed
- Stepless adjustment of temperature and drive
- Perfect welding result even in harsh environmental conditions thanks to hot-air system.

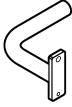

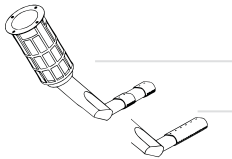
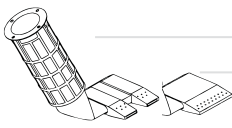
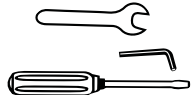



#### Technical Data

Voltage	V~	120 / 230
Power	W	2900 / 1900
Temperature	°C	80 – 600
Speed	m/min (drive 256:1)	0.2 – 2.5
	(drive 144:1)	1.4 – 4 (6)
Welding pressure	N (256:1 / 144:1)	1000 / 500
Size (L x W x H)	mm	350 x 390 x 270
Weight	kg	6.5 – 6.9 (with 3 m cable)
Conformity mark		CE
Approval mark		§
Certification scheme		CCA
Protection class II		□

#### Article No.:

119.031	TWINNY S for tunnel construction, drive 256:1, 230 V / 2900 W, with test channel, combi-wedge long, Euro plug
119.027	TWINNY S for civil engineering, drive 256:1, 230 V / 2900 W, with test channel, combi-wedge long, Euro plug
119.008	TWINNY S for civil engineering, drive 144:1, 230 V / 2900 W, with test channel, combi-wedge short, Euro plug
128.808	TWINNY S for civil engineering, drive 144:1, 6 m/min, 230 V / 2900 W, with test channel, combi-wedge short, Euro plug
119.039	TWINNY S for tunnel construction, drive 256:1, 120 V / 1900 W, with test channel, combi-wedge long, w/o plug

## Accessories TWINNY T / T USB / TWINNY S

	<b>112.974</b> Cross handle extremely light, material: aluminum
	<b>129.224</b> Guide bar, complete
	Combi-wedge short <b>100.517</b> 50 mm, with test channel <b>100.519</b> 30 mm, with test channel <b>100.518</b> 50 mm, without test channel <b>100.520</b> 30 mm, without test channel
	Combi-wedge long, complete <b>100.525</b> 50 mm, with test channel <b>100.526</b> 50 mm, without test channel, slotted, perforated
	<b>110.715</b> Tool set consists of hexagon spanner 8 / 10 / 13 / 17 mm and hexagon bolt 3 / 4 / 6 mm
	<b>115.905</b> USB memory stick TWINNY T USB
	<b>126.448</b> Storage case (included with purchase)
	<b>103.604</b> 230 V / 2100 W heating element, TWINNY T / T USB <b>103.602</b> 120 V / 1800 W heating element, TWINNY T / T USB <b>101.905</b> 230 V / 2750 W heating element, TWINNY S <b>101.910</b> 230 V / 2100 W heating element, TWINNY S <b>101.913</b> 120 V / 1800 W heating element, TWINNY S

Included with purchase:

Cvile engineering version: Welder, manual, guide-bar long (129.224), storage case  
Tunneling version: Welder, manual, guide-bar short, storage case

# TRIAC DRIVE AT: The little all-rounder

This semiautomatic hot-air welder that's truly one of a kind. Its flexible concept enables the TRIAC DRIVE AT to be used in all kinds of applications.



The perfect choice for welding joint sealing tape.

## Semiautomatic hot-air welder

### TRIAC DRIVE AT



- Consistent and up to 3x faster than hand welding
- Unique semiautomatic welding machine
- Can perform automatic welding in places other devices can't reach
- With guide, inside or outside nozzle for all precision work in tunnels (available as optional accessory)

#### Technical Data


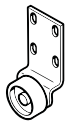



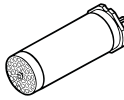
Voltage	V~	230
Power	W	1700
Temperature	°C	80 – 650
Speed	m/min	0.5 – 3
Air flow	l / min	(20 °C) 120 – 240
Size (L x W x H)	mm	300 x 230 x 380
Weight (with 3 m cable)	kg	4.1
Conformity mark		CE
Protection class II		□

#### Article No.:

- 117.331 TRIAC DRIVE AT 230 V / 1700 W, inside, without guide, width of welding nozzle 30 mm, without grip, pressure roller silicone, EURO-plug
- 148.606 TRIAC DRIVE AT 230 V / 1700 W, inside, without guide, width of welding nozzle 12 mm, with grip, pressure roller steel, EURO-plug
- 148.605 TRIAC DRIVE AT 230 V / 1700 W, inside, without guide, width of welding nozzle 38 mm, without grip, pressure roller steel, EURO-plug

Additional versions available upon request.

## Accessories TRIAC DRIVE AT

	<b>115.274</b>	12 mm pressure roller, steel
	<b>115.176</b>	30 mm pressure roller, steel
	<b>115.712</b>	40 mm pressure roller, steel
	<b>115.857</b>	30 mm pressure roller, silicone
	<b>115.276</b>	Single supporting carrier, brass
	<b>138.570</b>	Single supporting carrier, silicone
		Overlap welding nozzle, inside, push-fit
	<b>115.281</b>	38 mm, with grip
	<b>115.279</b>	30 mm, with grip
	<b>115.699</b>	12 mm, without grip
	<b>115.703</b>	38 mm, without grip
		Overlap welding nozzle, outside, push-fit
	<b>115.280</b>	38 mm, with grip
	<b>115.278</b>	30 mm, with grip
	<b>115.702</b>	38 mm, without grip
	<b>115.700</b>	30 mm, without grip
	<b>108.985</b>	Storage case (included with purchase)
	<b>142.637</b>	230 V / 1550 W heating element for TRIAC AT

# EXAMO USB: The inspector.

Is the welding seam sealed and can it withstand the specified peeling, tensile and shearing forces? EXAMO performs tests at the construction site – quick, reliable and uncomplicated.



Seam tests can be conducted in the labor on-site with the EXAMO USB.

Tensiometer

## EXAMO USB



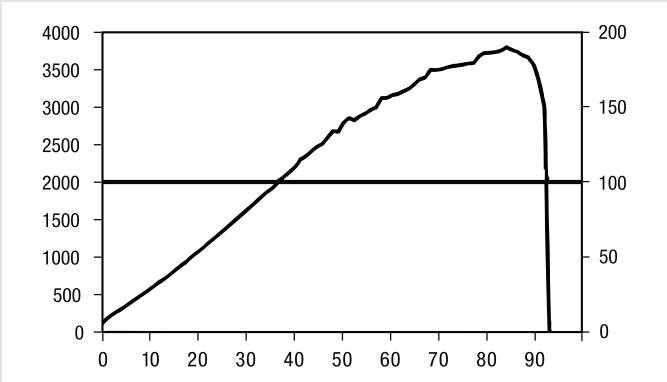
- Construction-site approved
- Handy, robust and reliable
- Testing of elongation, peak force, tear force, test speed and position
- With jaws also suitable for geo textiles (see accessories)

Technical Data			
Type		300F	600F
Voltage	V~	230	230
Power	W	200	200
Tensile load	N	4000	4000
Jaw spacing	mm	5 – 300	5 – 600
Range	mm	300	600
Test speed	mm/min	10 – 300	10 – 300
Sample thickness	mm	max. 7	max. 7
Sample width	mm	max. 40 (60 optional)	max. 40 (60 optional)
Size (L × W × H)	mm	750×270×190 (case)	1050×270×190 (case)
Weight	kg	14	17.5
Conformity mark		CE	CE
Approval mark		Ⓢ	Ⓢ
Protection class I		⊕	⊕
Article No.:			
139.059	EXAMO 300F USB, 230 V / 200 W, incl. USB memory stick, Euro plug		
139.060	EXAMO 600F USB, 230 V / 200 W, incl. USB memory stick, Euro plug		

## Accessories EXAMO USB

	<b>134.832</b> Testing and calibration kit to test and calibrate your EXAMO USB
	<b>108.185</b> Jaw kit 60 mm for geotextiles including two pairs of jaws
	<b>115.905</b> USB memory-stick

Civil Engineering / Tunneling / Landfills



Visualization of an EXAMO USB report.

# WELDPLAST S6: The workhorse.

WELDPLAST S6 is the world's highest rated handheld extrusion welder. With an output of 6 kg/h, it is surprisingly maneuverable. It features a brushless, preheat motor, multifunction display and comfortable ergo-grip, making the S6 Leister's flagship extrusion welder.



WELDPLAST S6 undertaking assembly applications on a landfill site.

Digitally regulated extrusion welder

## WELDPLAST S6



- 6 kg output per hour
- Highest possible preheating capacity
- Adjustable control wheel
- Maintenance-free hot-air blower
- Multifunctional display

### Technical Data

Voltage	V~	230
Power	W	4600
Material		PE / PP
Welding rod	mm	Ø 4 – Ø 5
Output	kg/h	3.9 – 6.0
Size (L × W × H)	mm	821 × 116 × 240
Weight	kg	14
Conformity mark		CE
Approval mark		Ⓢ
Protection class I		Ⓢ

### Article No.:

134.318 Extrusion Welder WELDPLAST S6, 230 V / 4600 W, with CEE 32A plug

Included with purchase: WELDPLAST S6, overlap welding shoe, storage case

## Accessories WELDPLAST S6

	<b>146.239</b>	Welding shoe complete
	<b>146.240</b>	54 × 40 × 52 mm blank welding shoe
	<b>146.241</b>	25 mm overlap
	<b>146.242</b>	35 mm overlap
	<b>145.899</b>	40 mm overlap
	<b>146.245</b>	20 mm V-seam
	<b>146.246</b>	25 mm V-seam
	<b>146.247</b>	30 mm V-seam
	<b>146.232</b>	20 mm fillet weld seam (a = 14 mm*)
	<b>146.233</b>	25 mm fillet weld seam (a = 17.5 mm*)
	<b>146.234</b>	30 mm fillet weld seam (a = 21 mm*)
	<b>146.644</b>	Corner outside seam 10 mm
	<b>146.646</b>	Corner outside seam 12 mm
	<b>146.652</b>	Corner outside seam 15 mm
	<b>146.230</b>	Corner seam Ø 14 mm
	<b>146.218</b>	Corner seam Ø 20 mm
	<b>144.905</b>	45° angled adapter
	<b>145.705</b>	90° angled adapter
Caution: You must use welding shoes with an integrated air guide for this.		
	<b>117.055</b>	35 mm preheating nozzle, large
	<b>136.859</b>	50 mm preheating nozzle, XL large
	<b>117.790</b>	Side hot-air guide
	<b>116.367</b>	Ultra strong storage case WELDPLAST S6 (included with purchase)

\* a = welding seam thickness

# WELDPLAST S4

The WELDPLAST S4 is the first extrusion welder of its kind with brushless, maintenance-free motor for generating preheated air. Output of up to four kilograms per hour is made possible thanks to the S4's powerful drive system.



The powerful WELDPLAST S4 at work.

Digitally regulated extrusion welder

## WELDPLAST S4



- Compact housing design reduces noise and guarantees optimal cooling for the electronics and drive.
- Microprocessor to regulate the welding process and to monitor the tool
- Menu with function programs
- Dual-sided twist-free wire intake
- Maintenance-free blower

### Technical Data

Voltage	V~	230
Power	W	3680
Material		PE / PP
Welding rod	mm	Ø 3 – 4      Ø 4 – 5
Output	kg/h	1.5 – 4.0
Size (L × W × H)	mm	560 × 110 × 300
Weight	kg	8.7
Conformity mark		CE
Approval mark		5
Certification scheme		CCA
Protection class I		⊕

### Article No.:

146.812	WELDPLAST S4, 230 V / 3680 W, 4–5 mm, top hot-air guide, overlap welding shoe 40 mm, preheating nozzle large, with Euro plug, storage case
116.948	WELDPLAST S4, 230 V / 3680 W, 3–4 mm, side hot-air guide, blank welding shoe, preheating nozzle large, medium and small, with Euro plug, storage case

## Accessories WELDPLAST S4

	<b>146.239</b>	Welding shoe complete
	<b>146.240</b>	54 × 40 × 52 mm blank welding shoe
		74 × 50 × 58 mm blank welding shoe
	<b>146.241</b>	25 mm overlap
	<b>146.242</b>	35 mm overlap
	<b>145.899</b>	40 mm overlap
	<b>146.243</b>	12 mm V-seam
	<b>146.244</b>	15 mm V-seam
	<b>146.245</b>	20 mm V-seam
	<b>146.246</b>	25 mm V-seam
	<b>146.247</b>	30 mm V-seam
	<b>146.231</b>	15 mm fillet weld seam (a = 10 mm*)
	<b>146.232</b>	20 mm fillet weld seam (a = 14 mm*)
	<b>146.233</b>	25 mm fillet weld seam (a = 17.5 mm*)
	<b>146.234</b>	30 mm fillet weld seam (a = 21 mm*)
	<b>146.642</b>	Corner outside seam 8 mm
	<b>146.644</b>	Corner outside seam 10 mm
	<b>146.646</b>	Corner outside seam 12 mm
	<b>146.652</b>	Corner outside seam 15 mm
	<b>146.230</b>	Corner seam Ø 14 mm
	<b>146.218</b>	Corner seam Ø 20 mm
	<b>144.904</b>	45° angled adapter
	<b>145.704</b>	90° angled adapter
		Caution: You must use welding shoes with an integrated air guide for this
	<b>117.064</b>	Side hot-air guide
	<b>117.065</b>	Top hot-air guide
	<b>117.053</b>	preheating nozzle small, 20 mm
	<b>117.518</b>	medium, 25 mm
	<b>141.177</b>	large, 35 mm
	<b>118.804</b>	Tool rest
	<b>136.231</b>	Pre-heat reflector

\* a = welding seam thickness

# WELDPLAST S2: The masterpiece.

The WELDPLAST S2 is a compact, ergonomically designed workhorse. The handy size extruder puts out two kilograms per hour and can even weld TPO materials without difficulty.



The robust WELDPLAST S2 welding a patch in a tunneling application.

Digitally regulated extrusion welder

## WELDPLAST S2 / S2 TPO



- Maintenance-free blower
- Perfect weld seam quality
- Multifunctional display
- Ergonomic and handy
- Successfully operated worldwide

### Technical Data

Voltage	V~	230
Power	W	3000
Material standard version		PE / PP
Welding rod	mm	Ø 3 – Ø 4
Output Ø 3 mm	kg/h	PE: 0.6 – 1.3 PP: 0.5 – 1.2
Output Ø 4 mm	kg/h	PE: 1.0 – 2.3 PP: 0.9 – 2.0
Size (L x W x H)	mm	450 x 98 x 260
Weight	kg	5.8
Conformity mark		CE
Approval mark		®
Certification scheme		CCA
Protection class I		⚡

### Article No.:

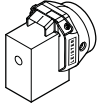
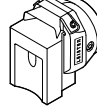

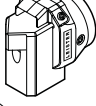


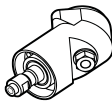

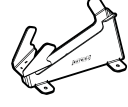

127.215 WELDPLAST S2, 230 V / 3000 W, with Euro plug

Included with purchase: WELDPLAST S2, blank welding shoe, storage case

136.602 WELDPLAST S2, 230 V / 3000 W, TPO, with Euro plug

Included with purchase: WELDPLAST S2, UBL-blank welding shoe, storage case

## Accessories WELDPLAST S2 / S2 TPO

	<b>145.945</b>	Welding shoe complete
	<b>145.946</b>	45 x 30 x 54 mm blank welding shoe
	<b>145.896</b>	25 mm overlap
	<b>145.947</b>	30 mm overlap
	<b>145.897</b>	35 mm overlap
	<b>145.915</b>	8 / 10 mm V-seam
	<b>145.907</b>	12 mm V-seam
	<b>145.903</b>	15 mm V-seam
	<b>145.909</b>	20 mm V-seam
	<b>145.944</b>	8 / 10 mm fillet weld (a = 7 mm*)
	<b>145.812</b>	15 mm fillet weld (a = 10*)
	<b>145.940</b>	20 mm fillet weld (a = 14 mm*)
	<b>146.645</b>	Corner outside seam 10 mm
	<b>146.649</b>	Corner outside seam 12 mm
	<b>146.651</b>	Corner outside seam 15 mm
	<b>145.811</b>	Corner seam Ø 14 mm
	<b>145.488</b>	Corner seam Ø 20 mm
	<b>139.460</b>	45° angled adapter
	<b>139.461</b>	90° angled adapter
	<b>134.361</b>	Air filter set (included with purchase)
	<b>143.776</b>	Textile dust filter (not included with purchase)
	<b>131.451</b>	Tool rest WELDPLAST S2
	<b>136.231</b>	Pre-heat reflector

\* a = welding seam thickness

# FUSION 3 / 3C: THE slim twins.

With its long and narrow shape, the FUSION 3 enables comfortable work, even on the floor. The somewhat shorter 3C provides an astounding output volume of up to 3.6 kilograms per hour.



Due to its length, the FUSION 3 is especially suited for civil engineering applications.

Air heated extrusion welder

## FUSION 3



- High welding performance
- Compact and handy
- Motor start-up protection prevents cold start
- Dual-sided twist-free wire intake
- 360° rotatable welding shoe

Technical Data		Version Ø 3 – 4		Version Ø 4 – 5	
Welding rod Ø	mm	3	4	4	5
Output PE	kg/h	2.0 – 2.5	2.7 – 3.6	2.1 – 2.6	2.7 – 3.6
Output PP	kg/h	1.8 – 2.3	2.5 – 3.4	1.8 – 2.4	2.5 – 3.4
Voltage	V~	230			
Power	W	3500			
Material		PE / PP			
Size (L x W x H)	mm	670 x 90 x 180			
Weight	kg	7.2			
Conformity mark		CE			
Approval mark		S			
Certification scheme		CCA			
Protection class II		□			

**Article No.:**  
118.300 FUSION 3, 230 V / 3500 W, Welding rod Ø 3 – 4 mm, Euro plug  
144.615 FUSION 3, 230 V / 3500 W, Welding rod Ø 4 – 5 mm, Euro plug  
Included with purchase: FUSION 3, raw welding shoe, storage case

Air heated extrusion welder

## FUSION 3C



- High welding performance
- Compact and handy
- Motor start-up protection prevents cold start
- Dual-sided twist-free wire intake
- 360° rotatable welding shoe

Technical Data		Version Ø 3 – 4		Version Ø 4 – 5	
Welding rod Ø	mm	3	4	4	5
Output PE	kg/h	2.0 – 2.5	2.7 – 3.6	2.1 – 2.6	2.7 – 3.6
Output PP	kg/h	1.8 – 2.3	2.5 – 3.4	1.8 – 2.4	2.5 – 3.4
Voltage	V~	230			
Power	W	2800			
Material		PE / PP			
Size (L x W x H)	mm	588 x 98 x 225			
Weight	kg	6.9			
Conformity mark		CE			
Approval mark		S			
Certification scheme		CCA			
Protection class II		□			

**Article No.:**  
123.866 FUSION 3C, 230 V / 2800 W, Welding rod Ø 3 – 4 mm, Euro plug  
144.826 FUSION 3C, 230 V / 2800 W, Welding rod Ø 4 – 5 mm, Euro plug  
Included with purchase: FUSION 3C, raw welding shoe, storage case

Civil Engineering /  
Tunneling / Landfills

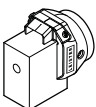

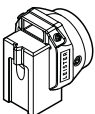
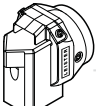


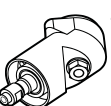



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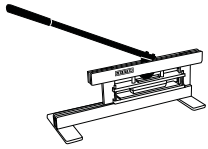
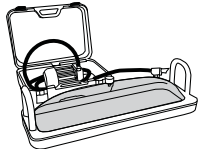

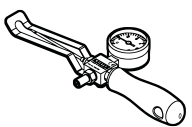
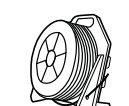

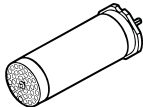
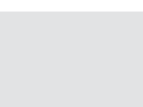


The FUSION 3 for comfortable working in upright positions.

## Accessories FUSION 3 / FUSION 3C

	<b>145.945</b> Welding shoe complete
	<b>145.946</b> 35 × 30 × 54 mm blank welding shoe
	<b>145.946</b> 74 × 50 × 58 mm blank welding shoe
	<b>145.896</b> 25 mm overlap
	<b>145.947</b> 30 mm overlap
	<b>145.897</b> 35 mm overlap
	<b>145.915</b> 8 / 10 mm V-seam
	<b>145.907</b> 12 mm V-seam
	<b>145.903</b> 15 mm V-seam
	<b>145.909</b> 20 mm V-seam
	<b>145.916</b> 25 mm V-seam
	<b>145.905</b> 30 mm V-seam
	<b>145.944</b> 8 / 10 mm fillet weld (a = 7 mm*)
	<b>145.812</b> 15 mm fillet weld (a = 10 mm*)
	<b>145.940</b> 20 mm fillet weld (a = 14 mm*)
	<b>145.816</b> 25 mm fillet weld (a = 17.5 mm*)
	<b>145.817</b> 30 mm fillet weld (a = 21 mm*)
	<b>146.643</b> Corner outside seam 8 mm
	<b>146.645</b> Corner outside seam 10 mm
	<b>146.649</b> Corner outside seam 12 mm
	<b>146.651</b> Corner outside seam 15 mm
	<b>145.811</b> Corner seam Ø 14 mm
	<b>145.488</b> Corner seam Ø 20 mm
	<b>148.817</b> 45° angled adapter
	<b>148.816</b> 90° angled adapter
	<b>135.082</b> Air filter in stainless steel FUSION 3C
	<b>118.804</b> Tool rest
	<b>136.231</b> Pre-heat reflector

## General accessories

	<b>145.813</b> COUPON CUTTER 20 × 150 mm
	<b>143.824</b> Spare blade 150 × 20 mm
	<b>143.826</b> Blade protection
	<b>143.828</b> Cutting plate
	<b>146.449</b> COUPON CUTTER 1" × 6" (25 × 150 mm)
	<b>146.468</b> Spare blade 150 × 25 mm
	<b>146.536</b> Blade protection
	<b>146.883</b> VACUUM BOX, 810 × 310 mm
	<b>146.880</b> VACUUM PUMP, 230 V
	<b>146.882</b> VACUUM PUMP, 120 V
	<b>146.461</b> VACUUM BOX / -PUMP KIT 230 V
	<b>146.881</b> VACUUM BOX / -PUMP KIT 120 V
	<b>109.795</b> Vacuum bell Ø 320 mm
	<b>142.475</b> Testing device with injector needle
	<b>142.569</b> Spare needle
	<b>144.095</b> Welding rod de-reeler
	<b>123.173</b> Storage case
	<b>119.540</b> WELDPLAST S4 / FUSION 3
	WELDPLAST S2 / S2 TPO / FUSION 3C (included with purchase)
	<b>134.567</b> Heating element, 230 V / 2600 W, for WELDPLAST S6
	<b>109.984</b> 230 V / 2200 W, for WELDPLAST S4 / S2
	<b>113.268</b> 230 V / 1100 + 1100 W, for FUSION 3
	<b>123.561</b> 230 V / 1750 W, for FUSION 3C







## Plastic Fabrication

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# WELDPLAST S1: Outstandingly compact.

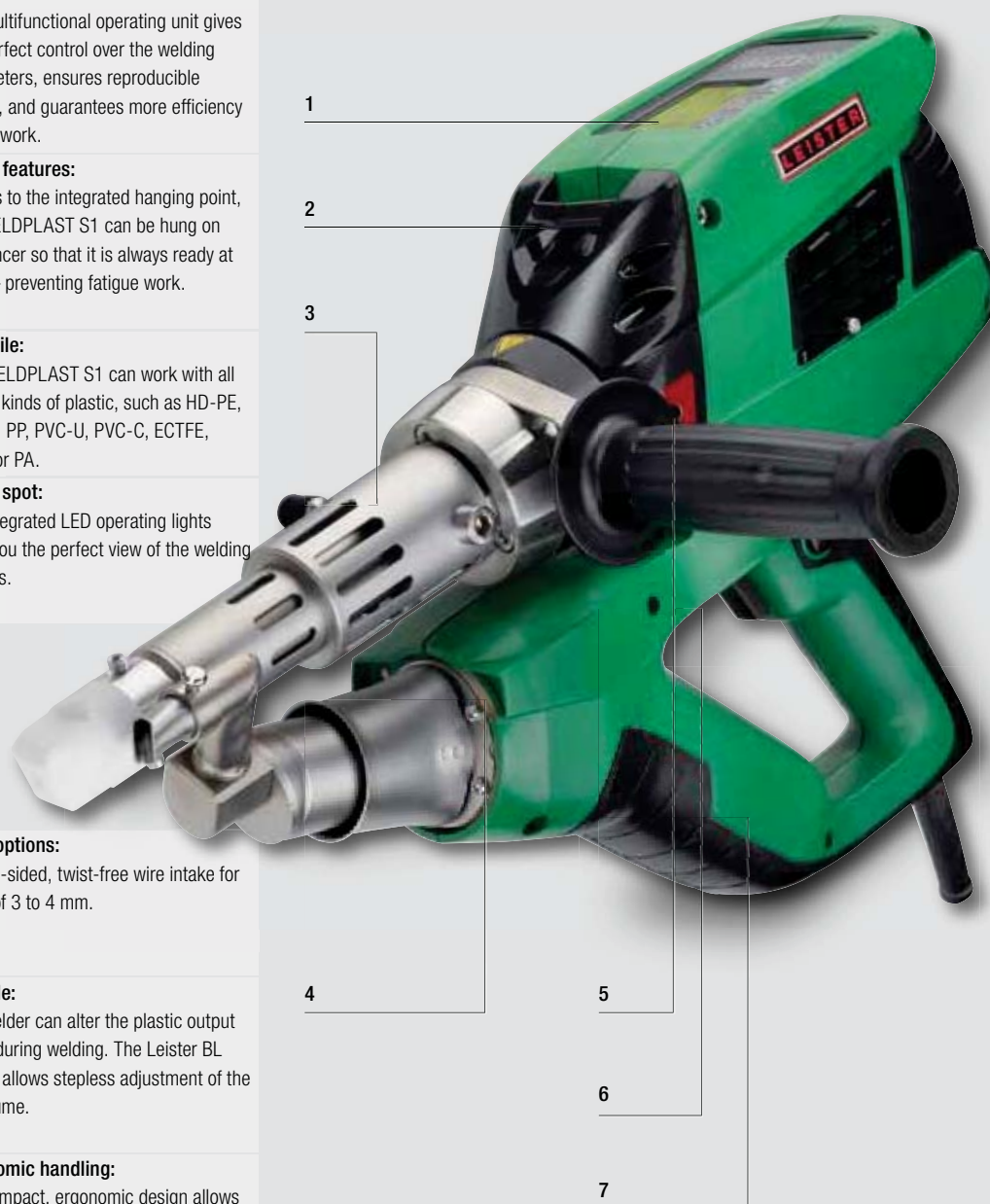
With the new WELDPLAST S1 compact extruder, you can achieve perfect seam quality with plate thicknesses of 4 to 12mm and a maximum output power of 0.8 kg/h (PVC: up to 1.15 kg/h). The double-sided, twist-free wire intake can work with 3 to 4 mm wires. Integrated LED lighting plus the innovative operating panel are the perfect way to monitor the process of welding all typical kinds of materials (such as PE, PP, PVC, PA, PVDF or

Digitally regulated extrusion welder

## WELDPLAST S1

1		<b>Full control:</b> The multifunctional operating unit gives you perfect control over the welding parameters, ensures reproducible results, and guarantees more efficiency during work.
2		<b>Smart features:</b> Thanks to the integrated hanging point, the WELDPLAST S1 can be hung on a balancer so that it is always ready at hand – preventing fatigue work.
3		<b>Versatile:</b> The WELDPLAST S1 can work with all typical kinds of plastic, such as HD-PE, LD-PE, PP, PVC-U, PVC-C, ECTFE, PVDF or PA.
4		<b>Bright spot:</b> The integrated LED operating lights gives you the perfect view of the welding process.

5		<b>More options:</b> Double-sided, twist-free wire intake for wires of 3 to 4 mm.
6		<b>Flexible:</b> The welder can alter the plastic output easily during welding. The Leister BL blower allows stepless adjustment of the air volume.
7		<b>Ergonomic handling:</b> The compact, ergonomic design allows you to work in comfort in any welding position.



ECTFE) – at all times. The ergonomic design, which offers several grip positions and holding options, allows you to work in comfort in areas that are difficult to access.



Full control, even in cramped conditions with very little light.

## Digitally regulated extrusion welder

### WELDPLAST S1



- Functional, ergonomic design with comfort grip areas
- Extremely high output power of 0.8 kg/h (HD-PE)
- Integrated LED lighting and hanging point
- Can work with all typical kinds of plastic
- Multifunction panel with predefined welding parameters
- BL blower, adjustable air volume

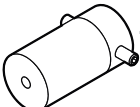
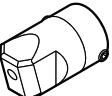
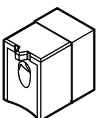

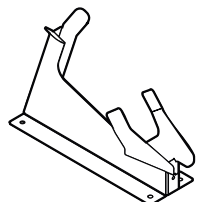
#### Technical Data

Voltage	V~	230 / 120 / 100
Power	W	1600 / 1800 / 1500
Material		HD-PE, LD-PE, PP, PVC-U PVC-C, PVDF, ECTFE, PA
Welding rod	mm	Ø 3 – 4
Output	kg/h	0.2 – 0.8 (PVC up to 1.15 kg/h)
Size (L × W × H)	mm	435 × 91 × 264
Integrated welding profiles		HD-PE, PP, PVC-U, PVC-C, PVDF 10 free profile storage spaces
Weight	kg	4.7
Conformity mark		CE
Certification scheme		CCA
Protection class I		⚡

#### Article No.:

148.396 WELDPLAST S1, 230 V / 1600 W, Ø 3 – 4 mm, Euro plug  
 148.395 WELDPLAST S1, 120 V / 1800 W, Ø 3 – 4 mm, Euro plug  
 148.394 WELDPLAST S1, 100 V / 1500 W, Ø 3 – 4 mm, Euro plug  
 Included with purchase: WELDPLAST S1, user manual, 2 pre-heating nozzles, welding shoe K10, storage case

### Accessories WELDPLAST S1

	<b>149.430</b>	Welding shoe complete Blank
	<b>149.402</b>	Fillet weld 5/6
	<b>148.627</b>	Fillet weld 8/10
	<b>149.401</b>	Fillet weld 12
	<b>149.388</b>	V-seam 3 / 4
	<b>149.383</b>	V-seam 5 / 6
	<b>149.385</b>	V-seam 8 / 10
	<b>149.364</b>	Corner
	<b>148.923</b>	Tool rest



→ Accessories page 86

# WELDPLAST S6: The workhorse.

WELDPLAST S6 is the world's highest rated handheld extrusion welder. With an output of 6 kg/h, it is surprisingly maneuverable. It features a brushless, preheat motor, multifunction display and comfortable ergo-grip – making the S6 Leister's flagship extrusion welder.



The WELDPLAST S6 is guided easily with the practical control wheel grip.

Digitally regulated extrusion welder

## WELDPLAST S6



- 6 kg output per hour
- Highest possible preheating capacity
- Adjustable control wheel
- Maintenance-free hot-air blower
- Multifunctional display

### Technical Data

Voltage	V~	230
Power	W	4600
Material		PE / PP
Welding rod	mm	Ø 4 or Ø 5
Output	kg/h	3.9 – 6.0
Size (L × W × H)	mm	821 × 116 × 240
Weight	kg	14
Conformity mark		CE
Approval mark		Ⓢ
Protection class I		Ⓢ

### Article No.:

134.318 WELDPLAST S6, 230 V / 5300 W, CEE 32A plug  
Included with purchase: WELDPLAST S6, overlap welding shoe, storage case

## Accessories WELDPLAST S6

	<b>146.239</b>	<b>Welding shoe complete</b>
	<b>146.240</b>	54 × 40 × 52 mm blank welding shoe
	<b>146.241</b>	25 mm overlap
	<b>146.242</b>	35 mm overlap
	<b>145.899</b>	40 mm overlap
	<b>146.245</b>	20 mm V-seam
	<b>146.246</b>	25 mm V-seam
	<b>146.247</b>	30 mm V-seam
	<b>146.232</b>	20 mm fillet weld seam (a = 14 mm*)
	<b>146.233</b>	25 mm fillet weld seam (a = 17.5 mm*)
	<b>146.234</b>	30 mm fillet weld seam (a = 21 mm*)
	<b>146.644</b>	Corner outside seam 10 mm
	<b>146.646</b>	Corner outside seam 12 mm
	<b>146.652</b>	Corner outside seam 15 mm
	<b>146.230</b>	Corner seam Ø 14 mm
	<b>146.218</b>	Corner seam Ø 20 mm
	<b>144.905</b>	45° angled adapter
	<b>145.705</b>	90° angled adapter
Caution: You must use welding shoes with an integrated air guide for this		
	<b>117.055</b>	35 mm preheating nozzle, large
	<b>136.859</b>	50 mm preheating nozzle, XL Large
	<b>117.790</b>	Side hot-air guide

\*a = Welding seam thickness

→ Accessories page 86

# WELDPLAST S4: The workmate.

The WELDPLAST S4 is the first extruder of its kind with brushless, maintenance-free motor for generating pre-heated air. Output of up to four kilograms per hour is made possible thanks to the S4's powerful drive system.



The powerful WELDPLAST S4 in use.

Digitally regulated extrusion welder

## WELDPLAST S4



- Compact housing design reduces noise and guarantees optimal cooling for the electronics and drive.
- Microprocessor regulates the welding process and monitors the tool
- Menu with function programs
- Dual-sided, twist-free wire intake
- Maintenance-free blower

### Technical Data

Voltage	V~	230
Power	W	3680
Material		PE / PP
Welding rod	mm	Ø 3 – 4      Ø 4 – 5
Output	kg/h	1.5 – 4.0
Size (L x W x H)	mm	560 x 110 x 300
Weight	kg	8.7
Conformity mark		CE
Approval mark		Ⓢ
Certification scheme		CCA
Protection class I		Ⓢ

### Article No.:

116.948 WELDPLAST S4, 230 V / 3680 W, 3 – 4 mm, with Euro plug, blank welding shoe

146.813 WELDPLAST S4, 230 V / 3680 W, 4 – 5 mm, with Euro plug, welding shoe K 15

Included with purchase: WELDPLAST S4, preheating nozzle large, medium and small, storage case

## Accessories WELDPLAST S4

	<b>146.239</b>	<b>Welding shoe complete</b>
	<b>146.240</b>	54 x 40 x 52 mm blank welding shoe
	<b>146.241</b>	25 mm overlap
	<b>146.242</b>	35 mm overlap
	<b>145.899</b>	40 mm overlap
	<b>146.243</b>	12 mm V-seam
	<b>146.244</b>	15 mm V-seam
	<b>146.245</b>	20 mm V-seam
	<b>146.246</b>	25 mm V-seam
	<b>146.247</b>	30 mm V-seam
	<b>146.231</b>	15 mm fillet weld seam (a = 10 mm*)
	<b>146.232</b>	20 mm fillet weld seam (a = 14 mm*)
	<b>146.233</b>	25 mm fillet weld seam (a = 17.5 mm*)
	<b>146.234</b>	30 mm fillet weld seam (a = 21 mm*)
	<b>146.642</b>	Corner outside seam 8 mm
	<b>146.644</b>	Corner outside seam 10 mm
	<b>146.646</b>	Corner outside seam 12 mm
	<b>146.652</b>	Corner outside seam 15 mm
	<b>146.230</b>	Corner seam Ø 14 mm
	<b>146.218</b>	Corner seam Ø 20 mm
	<b>144.904</b>	Angled adapter 45°
	<b>145.704</b>	Angled adapter 90°
		Caution: You must use welding shoes with an integrated air guide for this.
	<b>117.064</b>	Side hot-air guide
	<b>117.065</b>	Top hot-air guide
		Preheating nozzle
	<b>117.053</b>	20 mm, small
	<b>117.518</b>	25 mm, medium
	<b>141.177</b>	35 mm, large

\* a = Welding seam thickness

# WELDPLAST S2 / S2 PVC: The masterpieces.

WELDPLAST S2 and S2 PVC are masterpieces of modern technology. While externally they fulfill the highest requirements of functionality and design, their interior satisfies the highest expectations concerning the material to be processed. The WELDPLAST S2 PVC has integrated corrosion protection and has been especially designed to satisfy the high requirements of PVC extrusion welding. Their perfect seam quality makes both – WELDPLAST S2 and S2 PVC – reliable partners for today and tomorrow.

Digitally regulated extrusion welder

## WELDPLAST S2



- Maintenance-free blower
- Perfect weld seam quality
- Multifunctional display
- Ergonomic and handy
- Successfully operated worldwide

### Technical Data

Voltage	V~	230
Power	W	3000
Material		PE / PP Other materials on request
Welding rod	mm	Ø 3 or Ø 4
Output Ø 3 mm	kg/h	PE: 0.6 – 1.3   PP: 0.5 – 1.2
Output Ø 4 mm	kg/h	PE: 1.0 – 2.3   PP: 0.9 – 2.0
Size (L x W x H)	mm	450 x 98 x 260
Weight	kg	5.8
Conformity mark		CE
Approval mark		Ⓢ
Certification scheme		CCA
Protection class I		Ⓢ

### Article No.:

127.215 WELDPLAST S2, 230 V / 3000 W, Euro plug

Included with purchase: WELDPLAST S2, welding shoe raw part, storage case

Digitally regulated extrusion welder

## WELDPLAST S2 PVC



- Optimized for PVC-U
- Perfect weld seam quality
- PVC specific extrusion menu
- Corrosion protection
- Standby mode

### Technical Data

Voltage	V~	230
Power	W	3000
Material		PVC-U, PE, PP Other materials on request
Welding rod	mm	Ø 3 or Ø 4
Output Ø 3 mm	kg/h	PVC-U: 0.9 – 1.7   PE: 0.6 – 1.3
Output Ø 4 mm	kg/h	PVC-U: 1.5 – 2.7   PE: 1.0 – 2.3
Size (L x W x H)	mm	450 x 98 x 260
Weight	kg	5.8
Conformity mark		CE
Approval mark		Ⓢ
Certification scheme		CCA
Protection class I		Ⓢ

### Article No.:

135.724 WELDPLAST S2 PVC, 230 V / 3000 W, Euro plug

Included with purchase: WELDPLAST S2 PVC, 3 pre-heating nozzles, welding shoe K 8 / 10 mm (Art. no. 146.236), storage case



The handy WELDPLAST S2 in action.



Even inside radiuses are easy to weld.

## Accessories WELDPLAST S2

	<b>Welding shoe complete</b>
	<b>145.945</b> 45 × 30 × 54 mm blank welding shoe
	<b>145.946</b> 74 × 50 × 58 mm blank welding shoe
	<b>145.896</b> 25 mm overlap
	<b>145.947</b> 30 mm overlap
	<b>145.897</b> 35 mm overlap
	<b>145.912</b> 5 / 6 V-seam
	<b>145.915</b> 8 / 10 V-seam
	<b>145.907</b> 12 mm V-seam
	<b>145.903</b> 15 mm V-seam
	<b>145.909</b> 20 mm V-seam
	<b>145.916</b> 25 mm V-seam
	<b>145.943</b> 5 / 6 mm fillet weld (a = 4.2 mm*)
	<b>145.944</b> 8 / 10 mm fillet weld (a = 7 mm*)
	<b>145.812</b> 15 mm fillet weld (a = 10*)
	<b>145.940</b> 20 mm fillet weld (a = 14 mm*)
	<b>145.816</b> 25 mm fillet weld (a = 17.5 mm*)
	<b>146.643</b> Corner outside seam 8 mm
	<b>146.645</b> Corner outside seam 10 mm
	<b>146.649</b> Corner outside seam 12 mm
	<b>146.651</b> Corner outside seam 15 mm
	<b>145.811</b> Corner seam Ø 14 mm
	<b>145.488</b> Corner seam Ø 20 mm
	<b>139.460</b> 45° angled adapter
	<b>139.461</b> 90° angled adapter

\* a = Welding seam thickness

## Accessories WELDPLAST S2 PVC

	<b>Welding shoe complete</b>
	<b>146.239</b> 54 × 40 × 52 mm blank welding shoe
	<b>146.240</b> 74 × 50 × 58 mm blank welding shoe
	<b>146.241</b> 25 mm overlap
	<b>146.242</b> 35 mm overlap
	<b>146.248</b> 5 / 6 mm V-seam
	<b>146.249</b> 8 / 10 mm V-seam
	<b>146.243</b> 12 mm V-seam
	<b>146.244</b> 15 mm V-seam
	<b>146.235</b> 5/6 mm fillet weld seam (a = 4.2 mm*)
	<b>146.236</b> 8/10 mm fillet weld seam (a = 7 mm*)
	<b>146.231</b> 15 mm fillet weld seam (a = 10 mm*)
	<b>146.642</b> Corner outside seam 8 mm
	<b>146.644</b> Corner outside seam 10 mm
	<b>146.646</b> Corner outside seam 12 mm
	<b>146.652</b> Corner outside seam 15 mm
	<b>146.230</b> Corner seam Ø 14 mm
	<b>146.218</b> Corner seam Ø 20 mm
	<b>133.850</b> Top hot-air guide

\* a = Welding seam thickness



With the WELDPLAST S2 perfect welds are possible



The 45° angled adapter for the WELDPLAST S2 facilitates welding in difficult positions. (accessory)

→ Accessories page 86

## FUSION 3: Long and slim.

With its long and narrow shape, the FUSION 3 enables comfortable work, even on the floor.

Air heated extrusion welder

### FUSION 3



- High-quality welding performance
- Compact and handy
- Motor start-up protection prevents cold start
- Simple operation
- Dual-sided twist-free wire intake
- 360° rotating welding shoe

#### Technical Data

		Version Ø 3 – 4		Version Ø 4 – 5	
		3	4	4	5
Welding rod Ø	mm	3	4	4	5
Output PE	kg/h	2.0 – 2.5	2.7 – 3.6	2.1 – 2.6	2.7 – 3.6
Output PP	kg/h	1.8 – 2.3	2.5 – 3.4	1.8 – 2.4	2.5 – 3.4
Voltage	V~	230			
Power	W	3500			
Material		PE / PP			
Size (L x W x H)	mm	670 x 90 x 180			
Weight	kg	7.2			
Conformity mark		CE			
Approval mark		S			
Certification scheme		CCA			
Protection class II		□			

#### Article No.:

118.300 FUSION 3, 230 V / 3500 W, welding rod Ø 3 – 4 mm, Euro plug  
144.615 FUSION 3, 230 V / 3500 W, welding rod Ø 4 – 5 mm, Euro plug

Included with purchase: FUSION 3, blank welding shoe, storage case

## FUSION 3C: Short and handy.

The somewhat shorter FUSION 3C provides an astounding output volume of up to 3.6 kilograms per hour.

Air heated extrusion welder

### FUSION 3C



- High-quality welding performance
- Compact and handy
- Motor start-up protection prevents cold start
- Simple operation
- Dual-sided, twist-free wire intake
- 360° rotating welding shoe

#### Technical Data

		Version Ø 3 – 4		Version Ø 4 – 5	
		3	4	4	5
Welding rod Ø	mm	3	4	4	5
Output PE	kg/h	2.0 – 2.5	2.7 – 3.6	2.1 – 2.6	2.7 – 3.6
Output PP	kg/h	1.8 – 2.3	2.5 – 3.4	1.8 – 2.4	2.5 – 3.4
Voltage	V~	230			
Power	W	2800			
Material		PE / PP			
Size (L x W x H)	mm	588 x 98 x 225			
Weight	kg	6.9			
Conformity mark		CE			
Approval mark		S			
Certification scheme		CCA			
Protection class II		□			

#### Article No.:

123.866 FUSION 3C, 230 V / 2800 W, welding rod Ø 3 – 4 mm, Euro plug  
144.826 FUSION 3C, 230 V / 2800 W, welding rod Ø 4 – 5 mm, Euro plug

Included with purchase: FUSION 3C, blank welding shoe, storage case

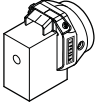

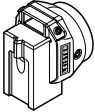




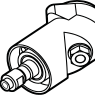
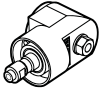


Perfectly stored in the case.



FUSION 3C during the welding of a V-seam.

## Accessories FUSION 3 / 3C

<b>Welding shoe complete</b>	
	<b>145.945</b> 50 x 30 x 38 mm blank welding shoe
	<b>145.946</b> 74 x 50 x 58 mm blank welding shoe
	<b>145.896</b> 25 mm overlap
	<b>145.947</b> 30 mm overlap
	<b>145.897</b> 35 mm overlap
	<b>145.912</b> 5 / 6 V-seam
	<b>145.915</b> 8 / 10 mm V-seam
	<b>145.907</b> 12 mm V-seam
	<b>145.903</b> 15 mm V-seam
	<b>145.909</b> 20 mm V-seam
	<b>145.916</b> 25 mm V-seam
	<b>145.943</b> 5 / 6 mm fillet weld (a = 4.2 mm*)
	<b>145.944</b> 8 / 10 mm fillet weld (a = 7 mm*)
	<b>145.812</b> 15 mm fillet weld (a = 10 mm*)
	<b>145.940</b> 20 mm fillet weld (a = 14 mm*)
	<b>145.816</b> 25 mm fillet weld (a = 17.5 mm*)
	<b>146.643</b> Corner outside seam 8 mm
	<b>146.645</b> Corner outside seam 10 mm
	<b>146.649</b> Corner outside seam 12 mm
	<b>146.651</b> Corner outside seam 15 mm
	<b>145.811</b> Corner seam Ø 14 mm
	<b>145.488</b> Corner seam Ø 20 mm
	<b>148.817</b> 45° angled adapter
	<b>148.816</b> 90° angled adapter

\* a = Welding seam thickness

## FUSION 2: The small powerhouse.

The FUSION 2 convinces with its ergonomic design. The simple operation and first-class welding quality have helped it to become the breakthrough product.



In operation during container construction in China.

Air heated extrusion welder

### FUSION 2



- At 450 mm, it is the shortest in its performance class!
- Motor start-up protection prevents cold start
- Simple operation
- Dual-sided, twist-free wire intake
- 360° rotating welding shoe
- Integrated electronics for stepless adjustment of the preheating temperature and output quantity

#### Technical Data

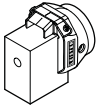
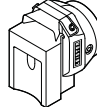


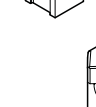
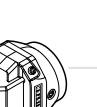

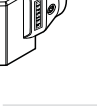



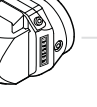


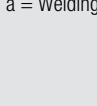
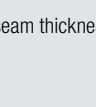
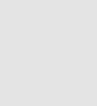
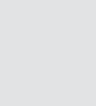
Voltage	V~	230 / 120
Power	W	2800
Material		PE / PP
Air temperature	°C	up to 340
Plastification temperature	°C	up to 300
Welding rod	Ø mm	4
Output PE	kg/h	1.3 – 1.8
Size (L x W x H)	mm	450 x 98 x 225
Weight	kg	5.9 (without cable)
Conformity mark		CE
Approval mark		③
Certification scheme		CCA
Protection class II		□

#### Article No.:

119.200	FUSION 2, 230 V / 2800 W, Euro plug
150.102	FUSION 2, 120 V / 2800 W, CEE plug

Included with purchase: FUSION 2, blank welding shoe, storage case

### Accessories FUSION 2

Welding shoe complete	
	<b>145.945</b> 45 x 30 x 54 mm blank welding shoe
	<b>145.946</b> 74 x 50 x 58 mm blank welding shoe
	<b>145.896</b> 25 mm overlap
	<b>145.947</b> 30 mm overlap
	<b>145.897</b> 35 mm overlap
	<b>145.912</b> 5 / 6 V-seam
	<b>145.915</b> 8 / 10 mm V-seam
	<b>145.907</b> 12 mm V-seam
	<b>145.903</b> 15 mm V-seam
	<b>145.943</b> 5 / 6 mm fillet weld (a = 4.2 mm*)
	<b>145.944</b> 8 / 10 mm fillet weld (a = 7 mm*)
	<b>145.812</b> 15 mm fillet weld (a = 10 mm*)
	<b>146.643</b> Corner outside seam 8 mm
	<b>146.645</b> Corner outside seam 10 mm
	<b>146.649</b> Corner outside seam 12 mm
	<b>146.651</b> Corner outside seam 15 mm
	<b>145.811</b> Corner seam Ø 14 mm
	<b>145.488</b> Corner seam Ø 20 mm

\* a = Welding seam thickness

→ Accessories page 86

# WELDMAX: Small but nice.

The smallest tool still packs a punch: With separately regulated heating systems for preheated air and filler, the lightweight and compact WELDMAX fulfills even the most stringent requirements.



The easy to handle and low-noise WELDMAX.

Compact extrusion welder

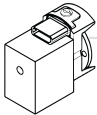
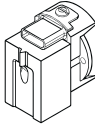
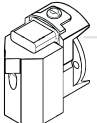
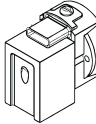
## WELDMAX



- Compact, handy and quiet thanks to its non-screw transportation and plastification
- The lightest Leister extrusion welder
- Ideal for confined spaces
- Separate, stepless temperature control for plastification unit and preheated air

Technical Data		
Voltage	V~	230
Power	W	2200
Material		PE / PP / PVDF / PA (other materials on demand)
Welding rod	mm	Ø 4 ± 0.3
Output (HDPE Ø 4)	kg/h	0.3 – 0.8
Size (L × W × H)	mm	443 × 94 × 255, handle Ø 57
Weight	kg	3.8
Conformity mark		CE
Approval mark		Ⓢ
Certification scheme		CCA
Protection class II		□
<b>Article No.:</b>		
110.272 WELDMAX, 230 V / 2200 W, with EU-plug, storage case		
Additional versions on request		

## Accessories WELDMAX

	112.830	<b>Welding shoe complete</b> Blank welding shoe
	112.629	5 mm V-seam
	112.621	6 mm V-seam
	112.623	8 mm V-seam
	112.624	10 mm V-seam
	112.630	5 mm fillet weld (a = 3.5 mm*)
	112.625	6 mm fillet weld (a = 4.2 mm*)
	112.627	8 mm fillet weld (a = 5.6 mm*)
	112.628	10 mm fillet weld (a = 7 mm*)
	112.626	20 mm overlap

\* a = Welding seam thickness

➔ Accessories page 86

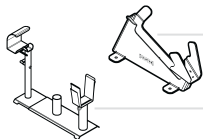

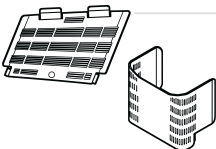
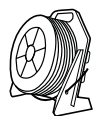




Draw welding on a PE-container with the DIODE PID.



The WELDPLAST S4 during outdoor use in Spain.

## General accessories hand extruder

	<p><b>Tool rest</b>  <b>131.451</b> WELDPLAST S2 / S2 PVC / FUSION 2   <b>118.804</b> WELDPLAST S4 / FUSION 3 / FUSION 3C</p>
	<p><b>Pre-heat reflector</b>  <b>136.231</b> WELDPLAST S2 / S2 PVC / S4 / S6 FUSION 2 / 3 / 3C</p>
	<p><b>134.361</b> Air filter WELDPLAST S2 / S2 PVC (included with purchase)  <b>143.776</b> Textile dust filter WELDPLAST S2 / S2 PVC (not included with purchase)   <b>135.082</b> Air filter FUSION 2 / 3C</p>
	<p><b>144.095</b> Welding rod de-reeler</p>
	<p><b>Storage case</b>  (included with purchase)  <b>116.367</b> WELDPLAST S6  <b>123.173</b> WELDPLAST S4 / FUSION 3  <b>119.540</b> WELDPLAST S2 / S2 PVC / FUSION 2 / 3C / WELDMAX</p>
	<p><b>Heating element</b>  <b>134.567</b> 230 V / 2600 W, WELDPLAST S6  <b>109.984</b> 230 V / 2200 W, WELDPLAST S4 / S2 / S2 PVC  <b>113.268</b> 230 V / 1100 + 1100 W, FUSION 3  <b>123.561</b> 230 V / 1750 W, FUSION 2 / 3C  <b>112.638</b> 230 V / 1400 W, WELDMAX</p>



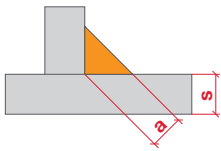
## Welding rods

Article		packaging units (kg)
<b>Welding accessories PE</b>		
104.283	HDPE welding rod, profile A, black	3
104.294	HDPE welding rod, profile A, white	3
104.284	HDPE welding rod, profile B, black	5
104.299	HDPE welding rod, profile B, white	5
106.650	HDPE welding rod, 8x 2 mm, white	1
104.300	LDPE welding rod, profile A, black	3
<b>Welding accessories PP</b>		
104.287	PP welding rod, profile A, grey / beige	3
104.301	PP welding rod, profile A, black	3
104.288	PP welding rod, profile B, grey / beige	5
126.356	PP welding rod, 8x 2 mm, natural	2
<b>Welding accessories PVC</b>		
104.296	PVC-U welding rod (hard), profile A, transparent	3
104.278	PVC-U welding rod (hard), profile A, grey	3
106.641	PVC-U welding rod, profile A, brown	3
104.280	PVC-U welding rod (hard), profile B, brown	5
104.279	PVC-U welding rod (hard), profile B, grey	5
104.302	PVC-P welding rod (soft), profile A, transparent	3
<b>Welding accessories ABS</b>		
104.295	ABS welding rod, profile A, white	3
113.587	ABS welding rod, profile A, black	3
107.027	ABS welding band, 8x 2 mm, white	1

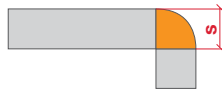
Article		packaging units (kg)
<b>Welding accessories div.</b>		
104.297	PA welding rod, profile A, black	3
104.298	PC welding rod, profile A, transparent	3
104.313	PC welding rod / ABS / ALPHA (Honda), profile A, black	3
104.311	PC welding rod / PBTP (Xenoy), profile A, grey	3
104.309	PS welding rod, profile A, white	3
104.308	PUR welding rod, profile A, black	3
106.654	Xenoy welding band, 8x 2 mm, grey	2
106.642	PPs welding rod, profile A, grey, flame resistant	3
104.304	PVDF welding rod, profile A, natural	3
104.303	POM welding rod, profile A, natural	3
<b>Test bundles</b>		
107.036	Test bundle bodywork welding rods, each consisting of profile A pieces of 37 cm single marked 6x HDPE, 6x PP, 6x PA, 6x PC, 6x ABS, 6x PCABS / ALPHA Honda, 6x PC / PBTP / Xenoy	
107.037	Test bundles standard each consisting of profile A pieces of 37 cm single marked 5x PVC-U, 5x PVC-P, 5x PP, 5x ABS, 5x HDPE, 3x PC, 3x PA, 3x POM, 3x LDPE, 3x PC / ABS / ALPHA Honda, 3x PC / PBTP / Xenoy	
107.040	Test bundle welding band each consisting of profile A pieces of 37 cm single marked 9x HDPE, 8x 2 mm white, 9x PP, 8x 2 mm natural, 9x ABS, 8x 2 mm white, 9x PC / PBTP / Xenoy grey	

## Profile sizes

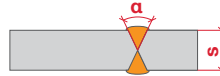
	<b>Profile A</b> Dimensions in mm
	<b>Profile B</b>



Fillet welding seam



Corner outside seam



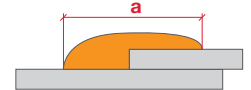
X-seam

s = 10 – 40 mm =  $\alpha$  60°  
s = 50 – 60 mm =  $\alpha$  50°








V-seam

s = 5 – 20 mm =  $\alpha$  60°  
s = 25 – 30 mm =  $\alpha$  50°

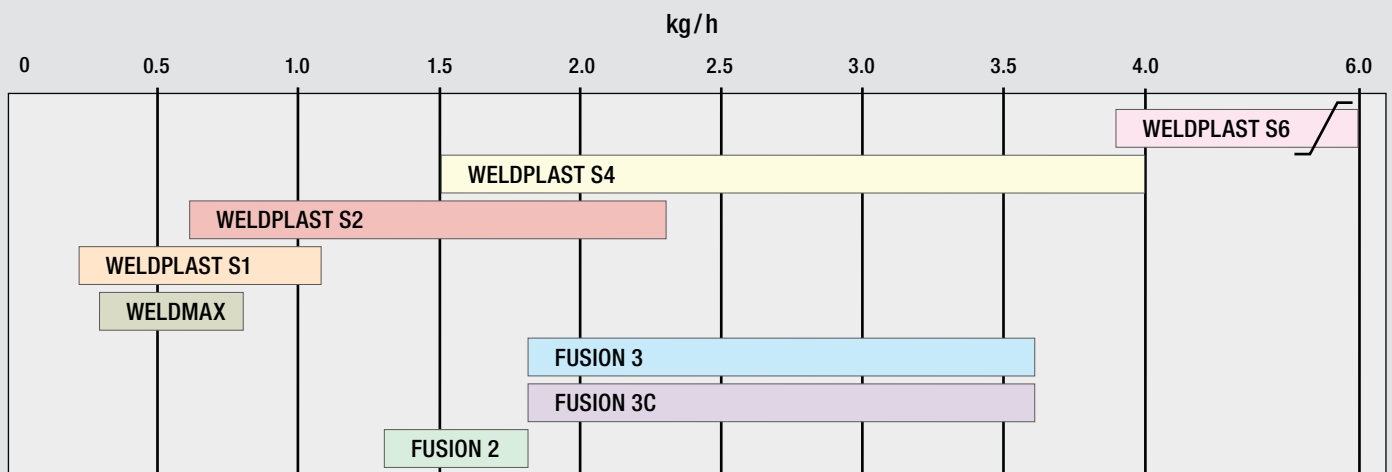


Overlap seam

## Product comparison

	Digitally regulated extrusion welders				Compact hand welder
					
Device type	WELDPLAST S6	WELDPLAST S4	WELDPLAST S2	WELDPLAST S1	WELDMAX
Output (HDPE) kg/h	3.9 – 6	1.5 – 4	0.6 – 2.3	0.2 – 0.8	0.3 – 0.8
Material	HD-PE, PP	HD-PE, PP	HD-PE, PP, PVC	PE, PP, PVC, etc.	HD-PE, PP, PVDF
Wall thickness mm	15 – 40	8 – 35	4 – 20	4 – 10	4 – 10
Welding rod $\varnothing$ mm	4 – 5	3 – 4 / 4 – 5	3 – 4	3 – 4	4
Weight kg	14	8.7	5.8	4.7	3.8
Length mm	821	560	450	435	433
Voltage V~	230	230	230	230 / 120	230 / 120
Screw extruder	yes	yes	yes	yes	no
Container construction	✓✓	✓✓	✓✓	✓✓	✓✓
Pipeline construction	✓✓	✓✓	✓✓	✓✓	✓✓
Landfills / civil engineering	✓✓	✓✓	✓	○	○
Brushless blower	yes	yes	yes	yes	no
Remarks	1	1	1	1	1

## Overview of Extrusion Welders Output





The WELDPLAST S2 welds perfect seams even in awkward positions.

#### Air heated extrusion welders



	FUSION 3	FUSION 3C	FUSION 2
<b>Device type</b>	FUSION 3	FUSION 3C	FUSION 2
<b>Output (HDPE) kg/h</b>	1.8 – 3.6	1.8 – 3.6	1.3 – 1.8
<b>Material</b>	HD-PE, PP	HD-PE, PP	HD-PE, PP
<b>Wall thickness mm</b>	8 – 25	8 – 25	6 – 15
<b>Welding rod mm</b>	3 – 4 / 4 – 5	3 – 4 / 4 – 5	4
<b>Weight kg</b>	7.2	6.9	5.9
<b>Length mm</b>	690	588	450
<b>Voltage V~</b>	230	230	230
<b>Screw extruder</b>	yes	yes	yes
<b>Container construction</b>	✓✓	✓✓	✓✓
<b>Pipeline construction</b>	✓✓	✓✓	✓✓
<b>Landfills / civil engineering</b>	✓✓	✓	○
<b>Brushless blower</b>	no	no	no
<b>Remarks</b>	2	2	2

- ✓✓ very suitable
- ✓ suitable
- unsuitable

#### Remarks:

- 1: Air and plast temperatures are shown via a display and can be separately and freely adjusted.
- 2: The air temperature is adjusted by means of a potentiometer (rotary dial).  
The heating of the plastic mass is performed by the pre-heating air.





## Flooring / Interior Decoration

UNIFLOOR E / UNIFLOOR S	92
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Welding rods	31

## Hot-Air Hand Tools

TRIAC ST	12 – 15
TRIAC AT	13 – 15
ELECTRON ST	16 / 17
HOT JET S	18 / 19
SONORA S1	21
General accessories	30



# UNIFLOOR E / S: A jack of all trades.

With the UNIFLOOR E you can weld floor coverings made of PVC-P, PE, linoleum and modified thermoplastics without any reconfiguration, up to 7.5 meters per minute.



UNIFLOOR E, the reliable partner for welding floor coverings.

Hot-air welder

## UNIFLOOR E / UNIFLOOR S

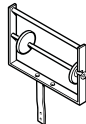
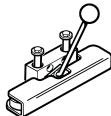



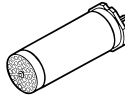


- Reproducible results thanks to digital display of set and actual values
- Electronically controlled heating
- Steplessly controlled air flow (only UNIFLOOR E)
- All floor coverings welded without reconfiguration
- Automatic start
- Integrated wall switch

### Technical Data

Voltage	V~	120 / 230
Power	W	2300
Temperature	°C	80 – 620
Speed	m/min	1.0 – 7.5
Air flow range	%	50 – 100
Size (L × W × H)	mm	420 × 270 × 215
Weight	kg	11.0 (with 3 m cable)
Conformity marking		CE
Approval mark		Ⓢ
Certification scheme		CCA
Protection class I		⊕

## Accessories UNIFLOOR E / UNIFLOOR S

	<b>115.054</b> Welding rod de-reeler
	<b>115.057</b> Trolley attachment
	<b>114.224</b> Floor welding nozzle, optimized for PVC material
	<b>115.342</b> Floor welding nozzle, for PVC + PUR material
	<b>103.394</b> Floor welding nozzle air-knife, optimized for PUR material
	<b>115.216</b> Air flap, for linoleum welding rod
	<b>117.235</b> 2/3 air flap, optimized for PUR material and linoleum welding rod
	<b>126.448</b> Storage case 605 x 486 x 312 mm plastic, green (included with purchase)
	<b>103.604</b> Heating element, 230 V / 2100 W
	<b>103.602</b> Heating element, 120 V / 1800 W

### Article No.:

138.493	UNIFLOOR E 230 V including rod de-reeler, squeezed nozzle (PVC and PUR), with Euro plug, storage case
115.345	UNIFLOOR E 230 V, squeezed nozzle (PVC and PUR), with Euro plug, storage case
138.494	UNIFLOOR S 230 V, including rod de-reeler, squeezed nozzle (PVC and PUR), with Euro plug, storage case
115.032	UNIFLOOR S 230 V, squeezed nozzle (PVC and PUR), with Euro plug, storage case
139.217	UNIFLOOR E 230 V including rod de-reeler, Air-Knife nozzle, 2/3 air flap (PUR), with Euro plug, storage case
115.024	UNIFLOOR E 120 V, squeezed nozzle (PVC and PUR), with Euro plug, storage case

# GROOVER: Dust-free milling.

The GROOVER grooving machine cuts welding grooves into thick, tough floor coverings made of PVC-P, PE and linoleum. The tool glides on three rollers and cuts a uniform grooving depth, even at high speeds.



Strong drive suitable for PVC, PUR and linoleum materials.

## Grooving machine GROOVER

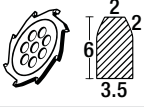
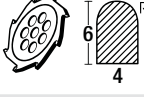
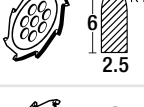


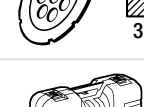



- Cuts grooves into of all types of floor coverings
- Extremely high, two stage cutting speeds
- Adjustable guide roller for tracking accuracy
- Reduced dust particles when used with dust bag
- Cutting close to the edge possible

### Technical Data

Voltage	V~	120 / 230
Power	W	350 / 700 (2 levels)
Speed	min-1	Level 1: 14500 (350 W) Level 2: 18500 (700 W)
Groove depth adjustment	mm	0 – 4
Size (L x W x H)	mm	240 x 205 x 255
Weight	kg	6.7 (with 3 m cable)
Conformity marking		CE
Approval mark		§
Certification scheme		CCA
Protection class II		□

## Accessories GROOVER

	<b>102.401</b> Ø 110 x 3.5 mm, tungsten carbide-tipped blade, trapezium profile
	<b>102.402</b> Ø 110 x 4 mm, tungsten carbide-tipped blade, round profile
	<b>102.404</b> Ø 110 x 2.5 mm, tungsten carbide-tipped blade, round profile
	<b>102.403</b> Ø 110 x 2.8 mm, tungsten carbide-tipped blade, round profile
	<b>102.405</b> Ø 110 x 3.5 mm, tungsten carbide-tipped blade, round profile
	<b>102.406</b> Ø 110 x 3.5 mm, diamond cutting blade, semi-round profile
	<b>126.448</b> Storage case (included with purchase)

### Article No.:

108.393	GROOVER 230 V, tungsten carbide tipped blade Ø 110 x 3.5 mm, trapezium profile, with Euro plug, storage case
111.032	GROOVER 230 V, tungsten carbide tipped blade Ø 110 x 3.5 mm, round profile, with Euro plug, storage case
108.397	GROOVER 120 V, tungsten carbide tipped blade Ø 110 x 3.5 mm, trapezium profile, with UK plug yellow, storage case

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Leister Technologies AG  
Galileo-Strasse 10  
CH-6056 Kaegiswil / Switzerland  
phone: +41 41 662 74 74  
fax: +41 41 662 74 16  
[leister@leister.com](mailto:leister@leister.com)

Leister Technologies LLC  
Itasca, IL 60143 / USA  
phone: +1 855 534 7837  
[info@leisterusa.com](mailto:info@leisterusa.com)

Leister Technologies Ltd.  
Shanghai 201 109 / PRC  
phone: +86 21 6442 2398  
[leister@leister.cn](mailto:leister@leister.cn)

Leister Technologis KK  
Yokohama 222-0033 / Japan  
phone: +81 45 477 36 37  
[info@leister.co.jp](mailto:info@leister.co.jp)

Leister Technologies Benelux BV  
3991 CE Houten / Nederland  
phone: +31 (0)30 2199888  
[info@leister.nl](mailto:info@leister.nl)

Leister Technologies Italia srl  
20090 Segrate / Italia  
phone: +39 02 2137647  
[info@leister.it](mailto:info@leister.it)

Leister Technologies India Pvt  
600 041 Chennai / India  
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