



PLASTIC WELDING

# Plastic Welding General Catalog Version 2.1

The only  
choice for  
professionals.





Leister Technologies AG, Corporate Center, Kaegiswil, Switzerland



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Leister Technologies GmbH,  
Aachen, Germany



Leister Technologies LLC,  
Itasca, IL, USA



Leister Technologies KK,  
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Leister Technologies Ltd.,  
Shanghai, China

### Leister delivers performances.

Leister is the worldwide leader in the field of plastic welding and industrial hot air applications. For over 60 years. 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, dense network of sales and service centers all over the globe, you will find a Leister partner guaranteed. We are local worldwide.





**LEISTER**

### Plastic Welding

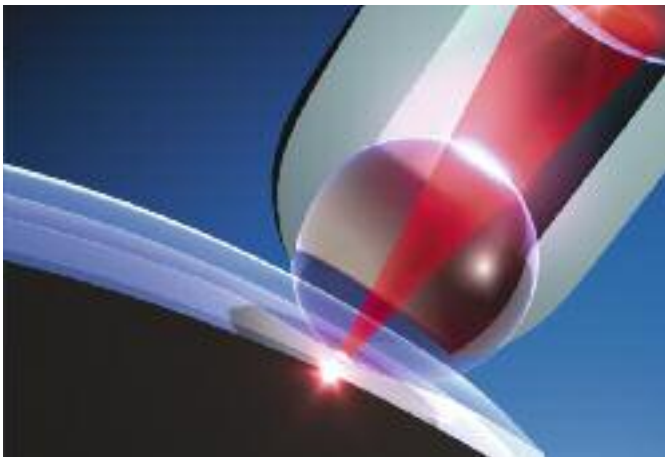
For decades now, we have been the worldwide market leader. The performance and reliability of our products makes Leister the first choice. Our tools are used in roofing, billboards and tarpaulins, civil engineering, tunneling and landfills, plastic fabrication, flooring and shrinking.



**LEISTER**

### Process Heat

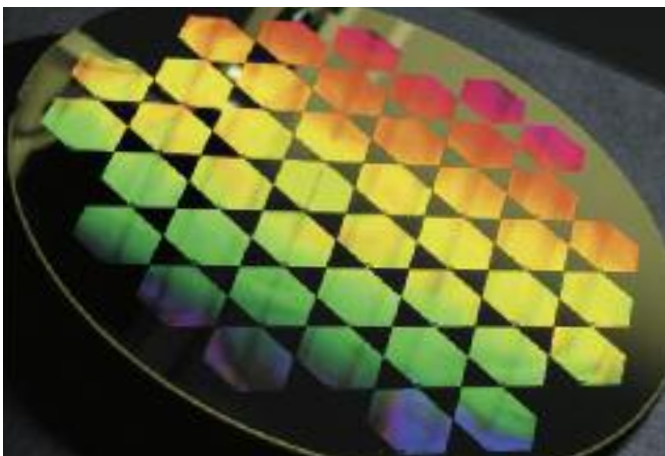
Whether for activation, heating, curing, melting, shrinking, welding, sterilization, drying or warming: hot-air is increasingly deployed in industrial processes. Leister customers profit from our extensive engineering knowledge and benefit from our advice in the conceptual design of hotair applications.



**NOVOLAS™**

### Lasersystems

Our innovative solutions for precision welding of plastics open up new production methods in the automotive manufacturing, in medical and sensor technology, electronics, as well as in microsystems technology. The laser systems can also be used for process heat applications.



**a:etris**

### Company of the Leister Group

In tomorrow's world, the smallest of structures will play a huge role! In order for our customers to keep ahead of the field in the future, we are already developing and producing micro-mechanical sensors and micro-optical components in our cleanroom today.

### Plastic welding with Leister

Leister Technologies AG provides the appropriate and 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 and under adverse conditions.

### Testing and certification

Our products are designed and developed to comply with nationally and internationally recognized standards. This includes both products 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 marking of conformity.

### 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 comprehensive testing for process analysis and documentation of the results.

### More than 120 Sales and Service Centers in over 90 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 120 sales and service centers in more than 90 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.



Front cover: VARIANT T1 for billboards and tarpaulins (p. 50 / 51)









<b>Roofing</b> <b>Billboards / Tarpaulins</b> <b>Civil Engineering / Tunneling / Landfills</b> <b>Plastic Fabrication</b> <b>Flooring / Interior Decoration</b>	Hot air tools Blowers General accessories Welding rods	08 – 35
<b>Roofing</b>	Automatic welders Testing instruments	36 – 47
<b>Billboards / Tarpaulins</b>	Automatic welders	48 – 57
<b>Civil Engineering / Tunneling / Landfills</b>	Automatic welders Extrusion welders Testing instruments	58 – 73
<b>Plastic Fabrication</b>	Extrusion welders Welding rods	74 – 87
<b>Flooring / Interior Decoration</b>	Hot air welder Grooving machine	88 – 93



Hot Air Tools



Roofing



Billboards / Tarpaulins



Civil Engineering / Tunneling / Landfills



Plastic Fabrication



Flooring / Interior Decoration









## Hot Air Tools

Product overview	10
TRIAC S	11
TRIAC AT	12 / 13
TRIAC BT	14 / 15
Accessories TRIAC S / AT / BT Push-Fit	16 / 17 / 18
Accessories TRIAC BT	19
HOT JET S	20 / 21
GHIBLI	22
SONORA S1	23
ELECTRON	24 / 25
FORTE S3	26
HOTWIND PREMIUM	27
LABOR S	28
WELDING PEN R / WELDING PEN S	29
DIODE PID / DIODE S	30













## Blowers

MINOR	31
ROBUST	32

## Accessories

Hot Air Tools general accessories	33 / 34
Welding rods	35

## Product overview

												
Type	TRIAC S	TRIAC AT	TRIAC BT	HOT JET S	GHIBLI	SONORA S1	ELECTRON	FORTE S3	HOTWIND PREMIUM	LABOR S	WELDING PEN R / S	DIODE PID / S
Max. voltage V~	230	230	230	230	230	230	400	2x230/3x400	230	230	230	230
Max. power W	1600	1600	1600	460	2000	2000	5500	10 000	3700	800 / 900	1000	1600
Temperature °C	20 – 700	40 – 700	20 – 700	20 – 600	20 – 600	80 – 650	20 – 650	20 – 650	20 – 650	20 – 600	20 – 600	20 – 600
Size mm (L x Ø) Handle mm (Ø)	340 x 90 56	335 x 90 56	330 x 90 56	235 x 70 40	195x85x160 57	230 x 200	320 x 95 64	390 x 132 215	232x106x179	180 x 54 40	270 x 43 32	265 x 57 40
Weight kg (without cord)	1.1	1.0	1.0	0.4	0.9	0.6	1.3	4.4	2.2	0.15	1.0	1.15
Conformity Marking	CE	CE	CE	CE	CE	CE	CE	CE	CE	CE	CE	CE
Approval Mark	ES		ES	ES	ES	ES	ES	ES	ES	ES	ES	ES
Certification Scheme	CCA		CCA, CB	CCA	CCA	CCA	CCA	CCA	CCA	CCA	CCA	CCA
Protection Class II	□	□	□	□	□	□	□	□	□	□	□	□
<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	11	12	14	20	22	23	24	26	27	28	29	30



MINOR blower (p. 31) and  
ROBUST (p. 32) for external  
air supply.



# TRIAC S: The best multi-purpose hot air tool.

The reliable, robust and proven hot air tool with stepless temperature adjustment. Whether for indoor or outdoor use, the TRIAC S is suitable for any application.

## Hot air tool

## TRIAC S



A specialist produces perfect welding seams using a reliable TRIAC S.

- Leister best-seller!
- Robust and reliable
- Adaptor tube with heat protection
- Electronic heating element protection
- Multiple replacements of carbon brushes possible
- Suitable for on-site use

### Technical Data

Voltage	V~	230
Power	W	1600
Temperature	°C	20 – 700
Size (L x Ø)	mm	340 x 90, handle Ø 56
Weight	kg	1.1 (without 3 m cord)
Conformity Marking	CE	
Approval Mark	S	
Certification Scheme	CCA	
Protection Class II	□	

### Article No.:

100.705	TRIAC S 230 V / 1600 W for push-fit nozzles with Euro plug
100.706	TRIAC S 230 V / 1600 W for screw-on nozzles with Euro plug
100.709	TRIAC S 230 V / 1600 W for push-fit nozzles with Australian plug
112.230	TRIAC S 230 V / 1600 W for push-fit nozzles with UK plug black
109.987	TRIAC S 120 V / 1600 W for push-fit nozzles with UK plug yellow

The handy storage case provides plenty of room for the required equipment.



➔ Accessories pages 16 / 17 / 18

# TRIAC AT: Robust and intelligent.

The TRIAC AT is an intelligent hot air 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. The TRIAC AT incorporates an ergonomic design, secure handling and a modern look. Every tool undergoes stringent quality checks prior to leaving the factory in Switzerland.

## Product features

1		<b>Everything easily:</b> Intuitive handling with proven «e-Drive» operating unit.
2		<b>Everything automatically:</b> The set temperature reaches its level automatically, voltage fluctuations are compensated.
3		<b>Everything under control:</b> The temperature measurement probe guarantees a precise temperature.
4		<b>Everything flexible:</b> The air volume can be adjusted independently.



5		<b>Everything really clean:</b> The air filters on both sides can easily be removed and cleaned.
6		<b>Everything really cool:</b> Protective tube for greater work safety.
7		<b>Everything handled perfectly:</b> Soft and lightweight body ensures optimum handling.



This high-quality hot air tool is equipped for any use. 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. No question, the new TRIAC AT is sure to impress!

## Hot air tool

### TRIAC AT



Whether on the roof, for civil engineering, plastic fabrication or for billboards, tarps, flooring and shrinking, the TRIAC AT is an all-purpose tool for any application:



- 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~	230	120	100
Power	W	1600	1600	1400
Temperature	°C	40 – 700		
Size (L x Ø)	mm	335 x 90, handle Ø 56		
Weight	kg	1 (without 3 m cord)		
Conformity marking	CE			
Protection class II	□			

#### Article No.:

141.314	TRIAC AT 230 V / 1600 W, with EU plug
141.316	TRIAC AT 120 V / 1600 W, with US plug, °F
141.382	TRIAC AT 120 V / 1600 W, with US plug, °C
141.317	TRIAC AT 100 V / 1400 W, with JP plug
141.319	TRIAC AT 120 V / 1600 W, with UK plug
141.320	TRIAC AT 230 V / 1600 W, with UK plug
141.321	TRIAC AT 230 V / 1600 W, with AUS plug
141.322	TRIAC AT 230 V / 1600 W, with CH plug
141.323	TRIAC AT 230 V / 1600 W, with CN plug

➔ Accessories pages 16 / 17 / 18

## TRIAC BT: Versatile and safe.

The TRIAC BT fulfills all of the functionality and design requirements necessary for successful plastic welding. It is the optimal tool for indoor use. The TRIAC BT, constructed from high-quality material, weighs in at just one kilogram making it the lightest tool in its class.

### Hot air tool

#### TRIAC BT Push-Fit



- Optimal for indoor use
- Lightweight and easy to handle
- Ergonomic handle for strain-free welding
- Electronically protected heating element
- Integrated universal nozzle
- Built-in start-up protection in the event of power interruption

#### Technical Data

Voltage	V~	230
Power	W	1600
Temperature	°C	20 – 700
Size (L × Ø)	mm	330 × 90, handle Ø 56
Weight	kg	1.0 (without 2 m cord)
Conformity Marking	CE	
Approval Mark	S	
Certification Scheme	CCA, CB	
Protection Class II	□	

#### Article No.:

- 145.035 TRIAC BT Push-Fit, 230 V / 1600 W, with Euro plug
- 145.036 TRIAC BT Push-Fit, 120 V / 1600 W, with US plug
- 145.037 TRIAC BT Push-Fit, 230 V / 1600 W, with CN plug
- 145.038 TRIAC BT Push-Fit, 230 V / 1600 W, with AUS plug

Included with purchase: TRIAC BT, storage case

### Hot air tool

#### TRIAC BT tarpaulin welding kit



Included with purchase.

#### Technical Data

Voltage	V~	230
Power	W	1600
Temperature	°C	20 – 700
Size (L × Ø)	mm	370 × 90, handle Ø 56
Weight	kg	1.0 (without 2 m cord)
Conformity Marking	CE	
Approval Mark	S	
Certification Scheme	CCA, CB	
Protection Class II	□	

#### Article No.:

- 136.937 TRIAC BT 230 V / 1600 W tarpaulin kit 20 mm with Euro plug
- 136.938 TRIAC BT 230 V / 1600 W tarpaulin kit 40 mm with Euro plug

Included with purchase: Spare heating element, 40 mm pressure roller, storage case

➔ Accessories pages 16 / 17 / 18

➔ Accessories page 19





Easy handling for precise welding in plastic fabrication...



...and billboards.

## Hot air tool

### TRIAC BT plastic fabrication kit



Included with purchase.

#### Technical Data

Voltage	V~	230
Power	W	1600
Temperature	°C	20 – 700
Size (L x Ø)	mm	370 x 90, handle Ø 56
Weight	kg	1.0 (without 2 m cord)
Conformity Marking	CE	
Approval Mark	S	
Certification Scheme	CCA, CB	
Protection Class II	□	

#### Article No.:

136.939 TRIAC BT 230 V / 1600 W plastic welding kit with Euro plug

Included with purchase: TRIAC BT, spare heating element, tacking nozzle, 5.7 mm profile A speed welding nozzle, storage case

## Hot air tool

### TRIAC BT floor welding kit



Included with purchase.

#### Technical Data

Voltage	V~	230
Power	W	1600
Temperature	°C	20 – 700
Size (L x Ø)	mm	370 x 90, handle Ø 56
Weight	kg	1.0 (without 2 m cord)
Conformity Marking	CE	
Approval Mark	S	
Certification Scheme	CCA, CB	
Protection Class II	□	

#### Article No.:

136.936 TRIAC BT 230 V / 1600 W floor welding kit with Euro plug

Included with purchase: TRIAC BT, spare heating element, 5 mm speed welding nozzle and speed welding nozzle with small air-slide (for PUR materials), storage case

➔ Accessories page 19










➔ Accessories page 19



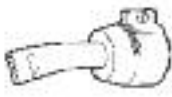




TRIAC S while overlap welding on the roof..

## Accessories TRIAC S / TRIAC AT / TRIAC BT Push-Fit





### Roofing

	<b>107.124</b>	20 mm angled nozzle, 90° push-fit
	<b>107.125</b>	20 mm angled nozzle, 60° push-fit
	<b>107.132</b>	Wide slot nozzle, push-fit, 40 mm
	<b>107.130</b>	40 mm, 60° angle
	<b>107.133</b>	40 mm, perforated
	<b>128.535</b>	30 mm, 45° angle
	<b>107.129</b>	60 mm wide slot nozzle for bitumen, push-fit
	<b>107.131</b>	80 mm wide slot nozzle, push-fit
	<b>107.123</b>	20 mm wide slot nozzle, push-fit
	<b>100.303</b>	Ø 5 mm tubular nozzle, push-fit
3  4  5 	<b>106.989</b>	3 mm speed weld nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>106.990</b>	4 mm speed weld nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>106.991</b>	5 mm speed weld nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>100.689</b> <b>142.637</b> <b>136.916</b>	230 V / 1550 W heating element for TRIAC S TRIAC AT TRIAC BT Push-Fit

### Billboards / Tarpaulins

	<b>107.123</b>	20 mm wide slot nozzle, angled, push-fit
	<b>105.487</b>	20 mm wide slot nozzle, bent and angled, push-fit
	<b>107.132</b>	Wide slot nozzle, push-fit 40 mm
	<b>107.130</b>	40 mm, 60° angle
	<b>107.133</b>	40 mm, perforated
	<b>128.535</b>	30 mm, 45° angle
	<b>107.124</b>	20 mm angled nozzle, 90°, push-fit
	<b>107.125</b>	20 mm angled nozzle, 60°, push-fit
	<b>105.492</b>	20 mm wide slot nozzle, straight jaw, 120° bent at right angle
	<b>100.689</b> <b>142.637</b> <b>136.916</b>	230 V / 1550 W heating element for TRIAC S TRIAC AT TRIAC BT Push-Fit

### Civil Engineering / Tunnel / Landfills sites

	<b>107.123</b>	20 mm wide slot nozzle, push-fit
	<b>107.132</b>	40 mm wide slot nozzle, push-fit
	<b>107.135</b>	40 mm wide slot nozzle, push-fit PTFE-coated, push-fit
	<b>100.689</b> <b>142.637</b> <b>136.916</b>	230 V / 1550 W heating element for TRIAC S TRIAC AT TRIAC BT Push-Fit






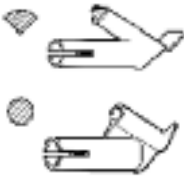





TRIAC S in use welding a future a storage reservoir.




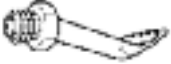


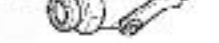
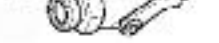






TRIAC AT shrinking a cable connection.

## Accessories TRIAC S / TRIAC AT / TRIAC BT Push-Fit

### Plastic fabrication (with push-fit nozzle)

	<b>100.303</b> Ø 5 mm, tubular nozzle for versions with push-fit
	Speed weld nozzle, push-fit on Ø 5 mm tubular nozzle <b>106.992</b> 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>107.348</b> Tool rest
	<b>107.344</b> 135 mm (5.31 in) welding mirror, push-fit
	230 V / 1550 W heating element for <b>100.689</b> TRIAC S <b>142.637</b> TRIAC AT <b>136.916</b> TRIAC BT Push-Fit
	<b>143.833</b> Nozzle adapter for screw-on nozzles

### Plastic fabrication (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 drawing nozzle
	<b>113.399</b> Ø 4 mm drawing nozzle with tacking tip, screw-on
	<b>113.876</b> Ø 3 mm drawing nozzle
	<b>113.874</b> Ø 4 mm drawing nozzle without tacking tip, screw-on
	<b>113.670</b> 5.7 mm drawing nozzle triangular-shaped, with tacking tip, screw-on
	<b>113.877</b> 5.7 mm, profile A, triangular-shaped drawing nozzle without tacking tip, screw-on
	<b>106.986</b> 7 mm, profile B
	<b>106.987</b> 7 x 5.5 mm
	<b>126.552</b> Ø 4 mm drawing nozzle, screw-on for fluoroplastics
	230 V / 1550 W heating element for <b>100.689</b> TRIAC S <b>142.637</b> TRIAC AT <b>136.916</b> TRIAC BT Push-Fit






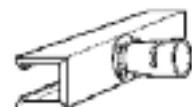






Well balanced design for precise welding of floor coverings.

## Accessories TRIAC S / TRIAC AT / TRIAC BT Push-Fit

### Flooring / interior design

	<b>100.303</b> Ø 5 mm, tubular nozzle for versions with push-fit nozzles
	<b>106.982</b> Ø 5 mm extension nozzle, 150 mm
3 	<b>106.989</b> 3 mm speed weld nozzle push-fit on Ø 5 mm tubular nozzle
4 	<b>106.990</b> 4 mm speed weld nozzle push-fit on Ø 5 mm tubular nozzle
5 	<b>106.991</b> 5 mm speed weld nozzle push-fit on Ø 5 mm tubular nozzle
3 	<b>105.431</b> 3 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle
4 	<b>105.432</b> 4 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle
5 	<b>105.433</b> 5 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle
	<b>107.139</b> 4.5 x 12 mm speed weld nozzle for fillet weld, push-fit on Ø 5 mm tubular nozzle
	<b>107.137</b> 8 mm speed weld nozzle for tape welding, push-fit on Ø 5 mm tubular nozzle
	230 V / 1550 W heating element for <b>100.689</b> TRIAC S <b>142.637</b> TRIAC AT <b>136.916</b> TRIAC BT Push-Fit

### Shrinking / soldering / vehicle repairs

	<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>106.996</b> Tacking nozzle, push-fit on Ø 5 mm tubular nozzle
	<b>106.997</b> Ø 6 mm rotary burr (for drilling machine)
	<b>106.992</b> 5.7 mm speed weld nozzle, push-fit on Ø 5 mm tubular nozzle
	230 V / 1550 W heating element for <b>100.689</b> TRIAC S <b>142.637</b> TRIAC AT <b>136.916</b> TRIAC BT Push-Fit

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











Working fatigue-free on truck tarp with the TRIAC BT.










Draw welding on a plastic fabrication application with the TRIAC BT.

## Accessories TRIAC BT kits





### Plastic fabrication

	<b>106.996</b>	Tacking nozzle, push fit
3 	<b>106.989</b>	3 mm speed welding nozzle, push-fit
4 	<b>106.990</b>	4 mm speed welding nozzle, push-fit
5 	<b>106.991</b>	5 mm speed welding nozzle, push-fit
	<b>106.992</b>	5.7 mm, A profile speed welding nozzle, push-fit
 A-profile B-profile	<b>106.993</b>	7 mm, B profile speed welding nozzle, push-fit




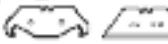

### Flooring

	<b>107.139</b>	4.5 x 12 mm speed welding nozzle, push-fit
3 	<b>106.989</b>	3 mm speed welding nozzle, push-fit
4 	<b>106.990</b>	4 mm speed welding nozzle, push-fit
5 	<b>106.991</b>	5 mm speed welding nozzle, push-fit
3 	<b>105.431</b>	3 mm speed welding nozzle, with small air-slide, push-fit
4 	<b>105.432</b>	4 mm speed welding nozzle, with small air-slide, push-fit
5 	<b>105.433</b>	5 mm speed welding nozzle, with small air-slide, push-fit

### Billboards and tarpaulins

	<b>140.160</b>	40 mm ball pressure roller with bearings (silicone)
	<b>140.599</b>	5 spare rolls
	<b>140.161</b>	28 mm ball pressure roller with bearings (silicone)
	<b>140.598</b>	5 spare rolls

### General accessories

	<b>136.916</b>	230 V / 1550 W heating element for
	<b>116.586</b>	Storage case
	<b>137.855</b>	Leister cutter with four spare blades
	<b>138.902</b>	10 x 10 hook-shaped spare blades
	<b>138.539</b>	10 x 10 trapezoid-shaped spare blades

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

# HOT JET S: Small and powerful.

As the most compact Hot air 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 tool

### HOT JET S



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













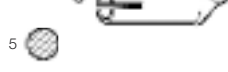

#### Technical Data

Voltage	V~	230
Power	W	460
Temperature	°C	20 – 600
Pressure static	Pa	max. 1600 (16 mbar)
Size (L x Ø)	mm	235 x 70, handle Ø 40
Weight	kg	0.4 (without 3 m cord)
Conformity Marking	CE	
Approval Mark	3	
Certification Scheme	CCA	
Protection Class II	□	

#### Artikel-No.:

100.648	HOT JET S 230 V / 460 W with Euro plug
112.229	HOT JET S 230 V / 460 W with UK plug (black)
100.854	HOT JET S 230 V / 460 W with AUS plug
100.861	HOT JET S 120 V / 460 W with USA 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 profile speed welding nozzle, push-fit
	<b>106.993</b>	7 mm, B profile 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.

	<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>100.818</b> 230 V / 435 W heating element
	<b>143.831</b> Nozzle adapter for screw-on nozzles

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.



The GHIBLI forming electrical cables.

### Hot air 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~	230
Power	W	2000
Temperature	°C	20 – 600
Pressure static	Pa	Step 2: 1500 (15 mbar) Step 3: 2100 (21 mbar)
Size (L × W × H)	mm	195 × 85 × 160, handle Ø 57
Weight	kg	0.9 (without 3 m cord)
Conformity Marking	CE	
Approval Mark	S	
Certification Scheme	CCA	
Protection Class II	□	

#### Article No.:

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

Additional versions available upon request.

## Accessories GHIBLI

	<b>106.998</b>	20 mm wide slot nozzle 20 mm, 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, push-fit
	<b>107.309</b>	35 x 20 mm sieve reflector, push-fit
	<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>107.007</b>	De-horning nozzle
	<b>107.345</b>	135 mm welding mirror, PTFE-coated
	<b>115.513</b>	230 V / 1800 W heating element



# SONORA S1: Handy and gentle.

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



Ergonomic design for strain-free car wrapping.

## Hot air tool

### SONORA S1



- Lightweight and compact
- High stability in head-handle position 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





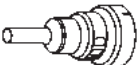

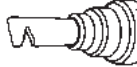


Voltage	V	230
Power	W	2000
Temperature	°C	80 – 650
Size	mm	230 x 200
Weight	kg	0.6 (without 2 m cord)
Conformity Marking	CE	
Approval Mark	Ⓢ	
Certification Scheme	CCA	
Protection Class II	□	

#### 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 x 10 mm sieve reflector
	<b>107.308</b>	50 x 35 mm sieve reflector



Included with purchase

## ELECTRON: Compact and powerful.

The versatile power tool. Due to its wide range of accessories, the ELECTRON is the tool on every specialists' wishlist.



Welding of bitumen sheeting using the powerful ELECTRON with a wide slot nozzle.

Hot air tool

### ELECTRON



- Powerful
- Compact
- Robust
- Construction site approved

#### Technical Data




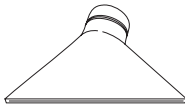

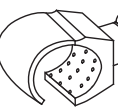
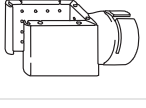
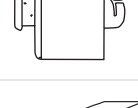

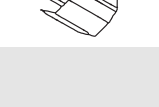

Voltage	V~	120 / 230 / 400
Power	W	2700 / 3400 / 5500
Temperature	°C	20 – 650
Pressure static	Pa	3000 (30 mbar)
Size (L x Ø)	mm	320 x 95, handle Ø 64
Weight	kg	1.3 (without 3 m cord)
Conformity Marking		CE
Approval Mark		3
Certification Scheme		CCA
Protection Class II		□

#### Article No.:

107.781	ELECTRON 230 V / 3400 W with Euro plug
107.788	ELECTRON 400 V / 5500 W, with 16A CEE plug
110.889	ELECTRON 120 V / 2700 W with 32A UK plug
116.055	ELECTRON 230 V / 3400 W with scraper nozzle, with Euro plug

Additional versions available upon request.

### Accessories ELECTRON


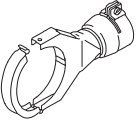





	<b>107.258</b>	70 x 10 mm wide slot nozzle, push-fit, <b>for bitumen</b>
	<b>107.134</b>	40 x 2 mm wide slot nozzle, push-fit, <b>for bitumen</b>
	<b>107.266</b>	75 x 2 mm wide slot nozzle, push-fit, <b>with tool stand (article 116.753)</b>
	<b>116.753</b>	Tool stand
	<b>107.270</b>	150 x 12 mm wide slot nozzle, push fit
	<b>107.229</b>	20 mm round nozzle
	<b>107.331</b>	70 x 70 mm folding reflector, push-fit
	<b>107.327</b>	85 x 85 mm sieve reflector, push-fit
	<b>107.333</b>	150 x 130 mm sieve reflector, push-fit
	<b>107.340</b>	45 x 250 mm shell reflector, push-fit
	<b>107.328</b>	60 x 75 mm folding reflector, push-fit



Accelerating the drying process of varnish, paint and body filler using the ELECTRON.



ELECTRON with scraping nozzle. Scrape color without solvents!

	<b>106.127</b>	Ø 65 mm sieve reflector
	<b>107.330</b>	125 x 22 mm folding reflector, push-fit
	<b>116.054</b>	Scraper nozzle, (only use in combination with heater tube, article no. 116.053)
	<b>107.347</b>	74 x 12 x 520 mm sword-shaped nozzle, rounded edges, PTFE-coated
	<b>107.346</b>	270 mm welding mirror, push-fit
	<b>107.348</b>	Tool rest
	<b>113.269</b>	230 V / 3400 W heating element
	<b>101.273</b>	400 V / 5500 W heating element



## FORTE S3: Flameless shrinking.

The most powerful hot air 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 tool

### FORTE S3



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

#### Technical Data

Voltage	V~	3x 230	3x 400
Power	kW	10	10
Temperature	°C	650	
Pressure static	Pa	1200 (12 mbar)	
Size (L x W x H)	mm	390 x 132 x 215	
Weight	kg	4.4 (without 10 m cord)	
Conformity Marking		CE	
Approval Mark		3	
Certification Scheme		CCA	
Protection Class II		□	

#### Article No.:

102.027 FORTE S3, 3x 400 V / 10 kW with 16A CEE plug  
 102.030 FORTE S3, 3x 230 V / 10 kW with 16A CEE plug

Additional versions available upon request.

## 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 up to 650 °C means that the HOTWIND can be used in a variety of ways.



The HOTWIND S is perfectly suited for drying and firing of color on plastic components.

### Hot air blowers

## 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. exhaust temperature	°C	650
Pressure static	Pa	1000
Size (L × W × H)	mm	332 × 106 × 179
Weight	kg	2.2 (without 3 m cord)
Conformity Marking	CE	
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

	<b>107.261</b>	Wide slot nozzle, push-fit (a × b)
	<b>107.260</b>	70 × 4 mm
	<b>107.259</b>	85 × 15 mm
	<b>107.259</b>	150 × 12 mm
	<b>105.977</b>	200 × 9 mm
	<b>107.263</b>	250 × 12 mm
	<b>107.262</b>	300 × 4 mm
	<b>105.992</b>	400 × 4 mm
	<b>105.991</b>	500 × 4 mm
	<b>125.317</b>	Flange connector, push-fit a = 90 mm
	<b>107.335</b>	Ø 150 mm sieve reflector, push-fit
	<b>107.248</b>	Stainless steel filter, push-fit on air intake
	<b>143.530</b>	230 V / 3600 W heating element
	<b>141.723</b>	Hand tool kit (handle and protective tube)

## LABOR S: Small and handy.

The fatigue-free LABOR S is a „jack of all trades“. It can be used to weld even difficult to access locations perfectly.



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

### Hot air 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. 31) or with compressed air
- Ideal for mobile use when coupled with MINOR blower

### Technical Data

Voltage	V~	230 / 120
Power	W	600 / 800 / 900
Temperature	°C	20 – 600
Size (L x Ø)	mm	180 x 54, handle Ø 40
Weight	kg	0.15 (without air hose and without cord)
Conformity Marking	CE	
Approval Mark	③	
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  
 101.723 LABOR S with junction box, 120 V / 600 W, 3 m PVC-hose, without plug  
 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, 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>101.581</b> 230 V / 800 W heating element
	<b>101.643</b> 120 V / 600 W heating element



# WELDING PEN: Slim and flexible.

The WELDING PEN is a hot air tool optimized for draw welding. Due to its slim design and the external air supply, by a swiveling air hose, work becomes nearly fatigue-free.



Draw welding using the compact and lightweight WELDING PEN R.

## Hot air tool

### WELDING PEN R / WELDING PEN S



- Used in combination with ROBUST blower or compressed air
- Digital temperature display (WELDING PEN R)
- Swiveling air hose connection
- Cooled heating element tube

Technical Data		
Voltage	V~	230 / 120
Power	W	1000 / 600
Temperature	°C	20 – 600
Size (L x Ø)	mm	270 x 43, handle Ø 32
Weight	kg	1.0 (with 3 m cord / air hose and Y-connection)
Conformity Marking	CE	
Approval Mark	E	
Certification Scheme	CCA	
Protection Class II	□	

#### Article No.:

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

Additional versions available upon request.

### Accessories WELDING PEN R / S

	<b>105.622</b> Ø 5 mm tubular nozzle, push-fit
	<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, without 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> 5.7 mm triangular drawing nozzle with tacking tip, screw-on
	<b>113.877</b> Triangular drawing nozzle, without tacking tip, screw-on 5.7 mm, profile A
	<b>106.986</b> 7 mm, profile B
	<b>106.987</b> 7 x 5.5 mm
	<b>126.552</b> Ø 4 mm drawing nozzle, screw-on for fluoroplastics
	<b>127.726</b> Angular adapter for screw-on nozzles, screw-on 30°
	<b>127.727</b> Angular adapter for screw-on nozzles, screw-on 45°
	<b>113.412</b> 230 V / 1000 W heating element for WELDING PEN R and WELDING PEN S
	<b>113.597</b> 120 V / 600 W heating element for WELDING PEN R and WELDING PEN S



Swiveling air hose for easy working.

## DIODE: The power couple.

There are two options for high-quality work: The closed-loop 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.

### Hot air tool

#### DIODE PID / DIODE S



- Operated with a 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~	230 / 120
Power	W	1600
Temperature	°C	20 – 600
Min. air flow (20° C)	l/min	40
Size (L x Ø)	mm	265 x 57, handle Ø 40
Weight	kg	1.15 (with 3 m cord / 3 m air hose)
Conformity Marking	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
101.304	DIODE PID, 230 V / 1600 W, screw-on, with Euro plug
101.313	DIODE PID, 120 V / 1600 W, for push-fit nozzles, with UK plug yellow
101.281	DIODE S, 230 V / 1600 W, push-fit, 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 yellow

Additional versions available upon request.

### Hot air 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 / 120
Power	W	1700
Temperature	°C	20 – 600
Min. air flow (20° C)	l/min	40
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 Marking	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, screw-on, 1.5 air hose, Euro-plug
111.265	DIODE S, snap-fit nozzles, connected to MINOR, 1.5 hose, UK plug yellow

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 <b>106.993</b> 5.7 mm, profile A <b>106.989</b> 7 mm, profile B <b>106.990</b> 3 mm <b>106.991</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>107.348</b> Tool rest
	<b>100.296</b> 230 V / 1550 W heating element for DIODE PID <b>100.689</b> for DIODE S

#### 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> 5.7 mm triangular drawing nozzle, with tacking tip, screw-on, Triangular drawing nozzle, without tacking tip, screw-on <b>113.877</b> 5.7 mm, profile A <b>106.986</b> 7 mm, profile B <b>106.987</b> 7 x 5.5 mm
	<b>126.552</b> 4 mm drawing nozzle, screw-on, for fluor plastics

#### 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 flow (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 Marking	CE	
Approval Mark	S	
Certification Scheme	CCA	
Protection Class II	□	

#### Article No.:

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

Additional versions available upon request.



## 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 to up to three hot air 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 / WELDING PENS S or up to max. 3 DIODE PID / DIODE S or max. 3 LABOR S (with 107.281 hose adapter)

### Technical data

Frequency	Hz	50	60
Power	W	250	250
Air flow (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
Outside diameter air inlet	Ø mm	38	38
Outside diameter air outlet	Ø mm	38	38
Weight	kg	8.0	8.0
Conformity Marking		CE	CE
Protection Classe I		⊕	⊕

### Article No.:

Voltage V~	50Hz	1 × 120	1 × 230	3 × 230 / 400
	60Hz			3 × 440 – 480
Without cord	Order no.	103.434		103.429
3 m cord / Euro plug	Order no.		103.432	

## Accessories ROBUST

	<b>107.354</b>	Stainless steel filter, push-fit on air intake
	<b>107.281</b>	Ø 38 mm hose connection adapter, 3 output each 14 mm
	<b>113.859</b>	Ø 14 mm air hose
	<b>101.031</b>	Ø 14 mm hose clip for air hose



28 mm pressure roller.



The hand pressure roller is an essential accessory for tunnel applications.

## Hot air tools

## General accessories

## Roofing

	<b>140.160</b>	40 mm silicone pressure roller with ball bearings
	<b>140.599</b>	5 spare rolls
	<b>140.161</b>	Pressure roller 28 mm, with ball bearings (silicone)
	<b>140.598</b>	5 spare rolls
	<b>106.974</b>	80 mm silicone pressure roller
	<b>106.972</b>	Brass pressure roller with ball bearings
	<b>106.976</b>	28 mm pressure roller (PTFE)
	<b>138.314</b>	Seam probe tester
	<b>111.346</b>	Chamfer plane with seven spare blades
	<b>111.348</b>	Spare blades kit containing ten blades
	<b>137.855</b>	Leister cutter with four spare blades
	<b>138.902</b>	10 x 10 spare blades hook-shaped
	<b>138.539</b>	10 x 10 spare blades trapezoid-shaped
	<b>116.586</b>	Storage case, for TRIAC AT, TRIAC BT, TRIAC S

## Billboards / Tarpaulins

	<b>106.974</b>	80 mm silicone pressure roller
	<b>140.160</b>	40 mm silicone pressure roller with ball bearings
	<b>140.599</b>	5 spare rolls
	<b>140.161</b>	28 mm silicone pressure roller with ball bearings
	<b>140.598</b>	5 spare rolls
	<b>106.981</b>	Pressure roller for custom seal
	<b>137.855</b>	Leister cutter with four spare blades
	<b>138.902</b>	10 x 10 spare blades hook-shaped
	<b>138.539</b>	10 x 10 spare blades trapezoid-shaped
	<b>116.586</b>	Storage case, for TRIAC AT, TRIAC BT, TRIAC S
	<b>116.798</b>	Brass brush



Store all your necessities in the practical storage case.

## Hot air tools

### General accessories

#### Flooring / Interior Decoration

	<b>106.972</b>	Pressure roller, with ball bearings (brass)
	<b>106.974</b>	80 mm silicone pressure roller
	<b>140.160</b>	40 mm silicone pressure roller with ball bearings
	<b>140.599</b>	5 spare rolls
	<b>140.161</b>	28 mm silicone pressure roller with ball bearings
	<b>140.598</b>	5 spare rolls
	<b>106.976</b>	28 mm pressure roller (PTFE)
	<b>106.969</b>	Spatula
	<b>122.541</b>	Trimming guide, to use with spatula (106.969)
	<b>106.966</b>	Hand grooving tool
	<b>106.968</b>	Spare blades for hand grooving tool
	<b>137.855</b>	Leister cutter with four spare blades
	<b>138.902</b>	10 x 10 spare blades hook-shaped
	<b>138.539</b>	10 x 10 spare blades trapezoid-shaped
	<b>116.586</b>	Storage case, for TRIAC AT, TRIAC BT, TRIAC S

#### Plastic Fabrication

	<b>107.348</b>	Tool rest for TRIAC AT, TRIAC BT, TRIAC S, ELECTRON
	<b>137.855</b>	Leister cutter with four spare blades
	<b>138.902</b>	10 x 10 spare blades hook-shaped
	<b>138.539</b>	10 x 10 spare blades trapezoid-shaped
	<b>116.586</b>	Storage case, for TRIAC AT, TRIAC BT, TRIAC S

#### Civil Engineering / Tunnel / Landfills

	<b>140.160</b>	40 mm silicone pressure roller with ball bearings
	<b>140.599</b>	5 spare rolls
	<b>140.161</b>	28 mm silicone pressure roller with ball bearings
	<b>140.598</b>	5 spare rolls
	<b>106.976</b>	28 mm pressure roller (PTFE)
	<b>137.855</b>	Leister cutter with four spare blades
	<b>138.902</b>	10 x 10 spare blades hook-shaped
	<b>138.539</b>	10 x 10 spare blades trapezoid-shaped
	<b>116.586</b>	Storage case, for TRIAC AT, TRIAC BT, TRIAC S





## 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

## Profile sizes

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

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 mm 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 mm 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 mm 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	





## Roofing

VARIMAT V2	38 / 39
UNIROOF E	40
TRIAC DRIVE PID / guiding help	41
X 84	42
BITUMAT B2	43
COMET SUB-ROOF	44
Roofing welders overview	45
EXAMO	46
Roofing hand tools overview	47

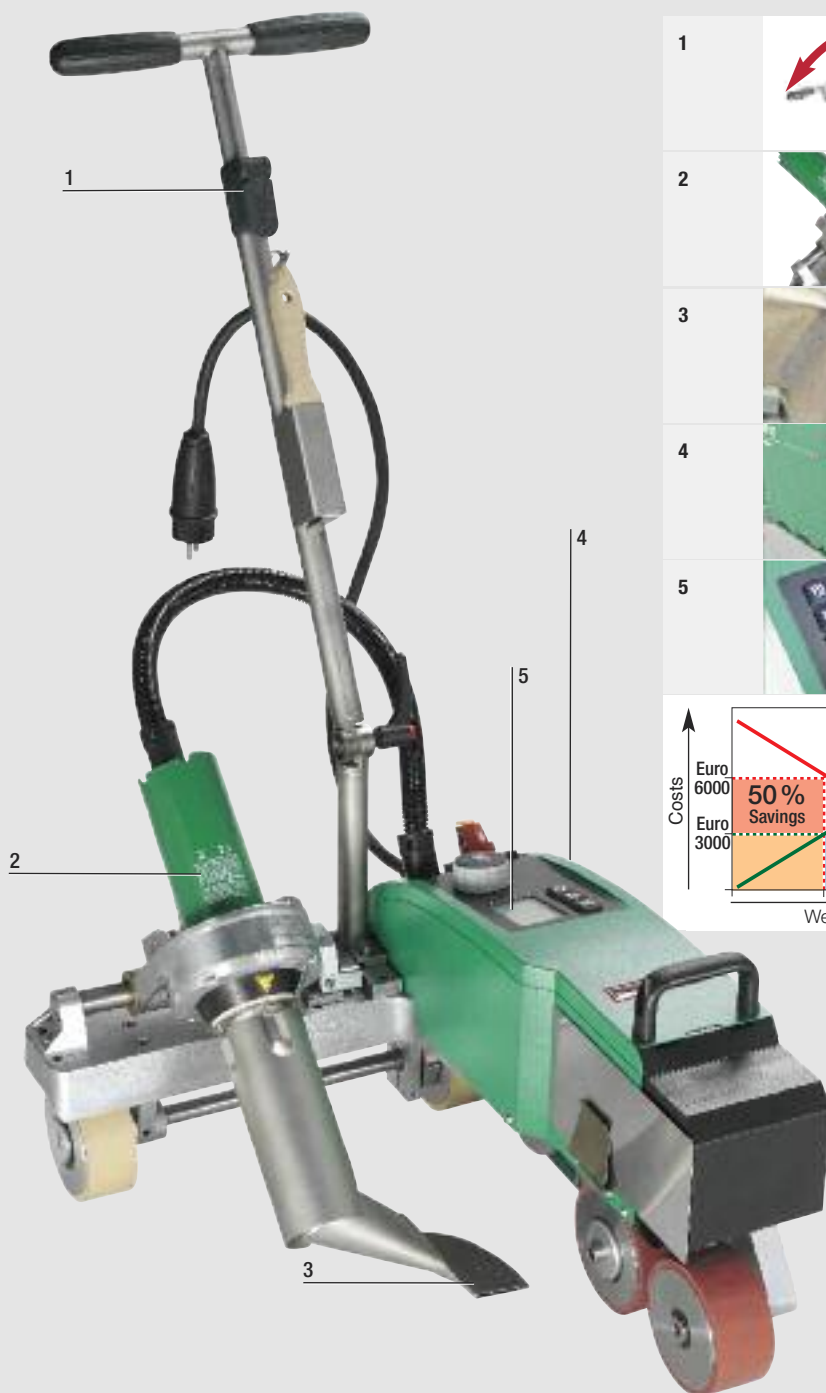







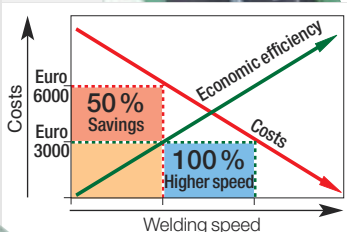
# VARIMAT V2: Fast and dependable.

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.

Hot air welder

## VARIMAT V2



1		<b>Ergonomic:</b> Height and angle of guide-bar can be adjusted easily.
2		<b>Maintenance-free:</b> High performance brushless blower motor, no brushes to change.
3		<b>High tech:</b> New welding nozzle with protected design for reliable welding quality.
4		<b>High speed:</b> New gear design allows speeds of up to 12 m/min.
5		<b>Intuitive:</b> Protected design. Easy-to-view display with "e-drive" and easy-to-store welding settings.
		<b>High potential savings:</b> Lower costs thanks to higher welding speed (cost calculations based on 20 000 m <sup>2</sup> at 5 m/min).  <b>Other welders:</b> 2.5 m/min. <b>VARIMAT V2:</b> 5.0 m/min.



Due to its slim line design, welding is possible even in close to edge spaces.



The reliable partner for overlap welding.

## Hot air welder

### VARIMAT V2



- 12 m/min maximum welding speed (depending on material)
- Guide bar minimizes back strain
- No brushes to replace means lower service costs
- User-friendly display with "e-Drive" (press and turn control) to recall preset and saved welding settings

#### Technical Data






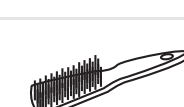

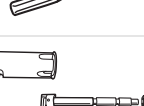
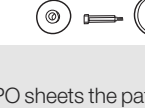

Voltage	V~	230	400
Power	W	4600	5700
Temperature	°C	20 – 620	
Speed	m/min	0.7 – 12	
Air flow range	%	50 – 100	
Width of welding nozzle	mm	40	
Size (L x W x H)	mm	640 x 430 x 330	
Weight	kg	35	
Conformity Marking		CE	
Approval mark		5	
Certification scheme		CCA	
Protection class I		⊕	

#### Article No.:

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

Additional versions available upon request.

### Accessories VARIMAT V2

	<b>113.995</b>	30 mm grip-nozzle
	<b>113.600</b>	40 mm grip-nozzle
	<b>107.067</b>	Additional weight for even more pressure
	<b>107.612</b>	Heating element 230 V / 4400 W
	<b>107.613</b>	400 V / 5500 W
	<b>139.048</b>	720 x 470 x 450 mm sturdy storage case multi-layer plate, green *
	<b>132.429</b>	2 welding plates for optimum welding start *
	<b>138.817</b>	Steel brush to clean nozzle *
	<b>110.714</b>	Maintenance set with size 5 screwdriver, size 2 and 8 pin wrenches and open-ended wrench size 17
	<b>146.514</b>	Solar Profil-Kit

\* Included with purchase

For TPO sheets the patented grip nozzle eliminates need for chemical pre-cleaning. (accessory)



## UNIROOF E: Small and strong.

The UNIROOF E is particularly suitable for edges, hard-to-reach areas and smaller roofs. The ideal addition to the VARIMAT V2.



The UNIROOF E climbs up even steep sloping roofs.

Hot air welder

### UNIROOF E



- Easy to carry thanks to its light weight (only 13 kg)
- Can be used anywhere with 10A / 230 V power supply
- Up to 30° incline
- A lot of power in a small package

#### Technical Data







Current	A	10
Voltage	V~	230
Power	W	2300
Temperature	°C	20 – 600
Speed	m/min	1 – 5
Width of welding nozzle	mm	30
Dimensions (L x W x H)	mm	420 x 270 x 210
Weight	kg	12.8 (with cord)
Conformity Marking	CE	
Approval mark	S	
Certification scheme	CCA	
Protection class I	⊕	

#### Article No.:

134.447 UNIROOF E, 230 V / 2300 W, 30 mm, Euro plug

Additional versions available upon request.

### Accessories UNIROOF E

	<b>125.685</b>	30 mm grip nozzle, for roughening and welding of TPO 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>103.604</b>	230 V / 2100 W heating element
	<b>126.448</b>	Storage case (included with purchase)
	<b>122.022</b>	Guide-bar, complete, adjustable



The storage case offers optimal protection. (included with purchase)



# TRIAC Drive PID: The handy one.

This tried and tested semi-automatic welding machine can be used in most applications. The increased welding speed compared with manual welding gives rise to higher productivity.



The TRIAC DRIVE PID allows even horizontal welding.

## Semi automatic welding machine

### TRIAC DRIVE PID



- Faster and more efficient than hand welding
- Small and compact
- Steplessly adjustable speed for high quality welding
- Can be used in the most confined spaces

#### Technical Data






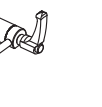





Voltage	V~	230
Power	W	1700
Temperature	°C	20 – 600
Speed	m/min	0.5 – 3
Width of welding nozzle	mm	40 / 30
Dimensions (L x W x H)	mm	300 x 230 x 380
Weight	kg	4.15 (with 3 m cord, without guide aid)
Conformity Marking		CE
Approval mark		§
Certification scheme		CCA
Protection class I		⊕

#### Article No.:

115.985	TRIAC DRIVE PID without guiding help, 230 V / 1700 W, outside, <i>without</i> grip, width of welding nozzle 40 mm, Euro plug
138.860	TRIAC DRIVE PID with guiding help, 230 V / 1700 W, inside, <i>without</i> grip, width of welding nozzle 30 mm, Euro plug
140.067	TRIAC DRIVE PID with guiding help, 230 V / 1700 W, inside, <i>without</i> grip, width of welding nozzle 30 mm, Euro plug, with extension for parapet

Additional versions available upon request.

## Accessories TRIAC DRIVE PID

	<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>138.570</b> 12 mm pressure roller, silicon
	<b>115.857</b> 30 mm pressure roller, silicon
	<b>115.921</b> 40 mm pressure roller, silicon
	<b>115.276</b> Single supporting carrier
	<b>115.281</b> Overlap welding nozzle, inside, push-fit 38 mm, <i>with</i> grip
	<b>115.279</b> 30 mm, <i>with</i> grip
	<b>115.703</b> 38 mm, <i>without</i> grip
	<b>115.701</b> 30 mm, <i>without</i> grip
	<b>100.296</b> 230 V / 1550 W heating element for TRIAC PID
	<b>138.549</b> Guiding help for TRIAC DRIVE PID, for easy horizontal welding, e.g. for parapets:  Included with purchase: - two 12 mm pressure rollers, silicone, - one 30 mm pressure roller, silicone, - one 30 mm overlap welding nozzle, inside, <i>without</i> grip
	<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)

## X 84: Lightweight and agile.

Weighing just 6.1 kilograms, the X84 is recommended for highpitched roofs; with its powerful drive, the X84 overcomes every slope with constant speed and welding quality.



The X84 is easy to operate and produces precise results.

### Hot air welder

## X 84



- Small, light and compact
- Suitable for uneven surfaces
- Constant welding pressure
- Controlled welding speed

#### Technical Data


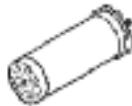

Voltage	V~	230
Power	W	2300
Temperature	°C	20 – 600
Speed	m/min	0.5 – 3.5
Welding pressure	N	250
Pressure static	Pa	Level 2: 1500 (15 mbar) Level 3: 2100 (21 mbar)
Width of welding nozzle	mm	30
Dimensions (L x W x H)	mm	300 x 310 x 250
Weight	kg	6.1 (with 3 m cord)
Conformity Marking	CE	
Approval mark	S	
Certification scheme	CCA	
Protection class II	□	

#### Article No.:

107.484 X 84 with guide-bar, 230 V / 2300 W, with CH plug

Additional versions available upon request.

## Accessories X 84

	<b>129.224</b>	Guide-bar, complete, adjustable
	<b>103.678</b>	230 V / 2100 W heating element
	<b>126.448</b>	Storage case (included with purchase)



The X 84 is the ideal machine when it comes to welding sub-roof membranes.

# 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 welding process is 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	
Dimensions (L x W x H)	mm	690 x 490 x 330	
Weight	kg	40 (with cord)	
Conformity Marking		CE	
Approval mark		Ⓢ	
Certification scheme		CCA	
Protection class I		Ⓢ	

#### Article No.:

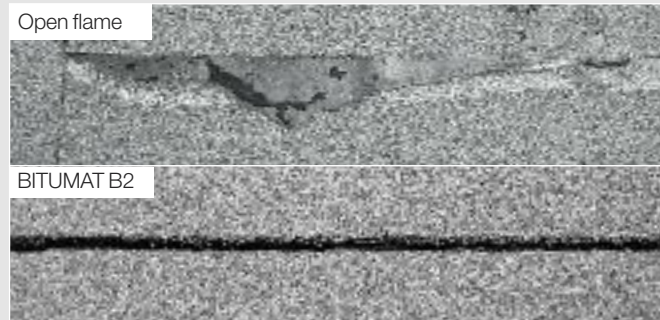
140.438	BITUMAT B2, 400 V / 6700 W, 75 mm, 16 A CEE plug
140.437	BITUMAT B2, 400 V / 6700 W, 100 mm, 16 A CEE plug
140.436	BITUMAT B2, 230 V / 6700 W, 75 mm, 32 A CEE plug
138.386	BITUMAT B2, 230 V / 6700 W, 100 mm, 32 A CEE plug

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 <i>without gap</i>
	<b>140.228</b>	75 mm pressure roller <i>without gap</i>
	<b>140.476</b>	Lifting device
	<b>140.489</b>	750 x 555 x 450 mm sturdy storage case, (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 shrinking of insulation because of air dam belt.





## 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 flamelessly welded edges. It is especially suitable for pre-fabrication of sub-roof membranes.



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
Dimensions (L x W x H)	mm	355 x 250 x 245
Weight	kg	7.7 (with 3 m cable)
Conformity Marking		CE
Approval mark		§
Certification scheme		CCA
Protection class I		⊕

#### Article No.:

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

Additional versions available upon request.

## Accessories COMET SUB-ROOF



**129.224** Guide-bar, complete, adjustable



**110.694** Fitting welding carriage

The fitting welding carriage transfers the drive to the sub-roof membrane located below. This enables friction-free, high-quality welding. The fitting 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.



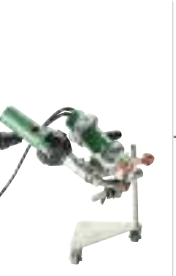





VARIMAT V2: The perfect welder for large areas.



Flameless modified bitumen welding with the BITUMAT B2.

## Overview Roofing Welders

						
<b>Materials</b>	<b>Plastic single plies</b>					<b>Modified bitumen</b>
<b>Type of welding machine</b>	<b>VARIMAT V2</b>	<b>UNIROOF E</b>	<b>TRIAC DRIVE PID with guiding help</b>	<b>X84</b>	<b>COMET SUB-ROOF</b>	<b>BITUMAT B2</b>
<b>Main application</b>	Large areas over 600 Yards <sup>2</sup>	Small areas, parapets under 600 Yards <sup>2</sup>	Details, pitched roofs	For sub-roof membranes	For pre-fabricators	Large areas
<b>Roof construction</b>						
Flat roof	✓✓✓	✓✓✓	✓✓✓	✓		✓✓✓
Sloping roof	✓	✓✓	✓✓	✓✓✓	✓✓	✓
Basic weld seams	✓✓✓	✓	✓	✓✓✓	✓✓✓	✓✓✓
Detail work	✓	✓✓✓	✓✓✓	✓	✓	✓
Special features	Operation with »e-Drive«	Up to 30° incline	Horizontal welding	Constant joining pressure	Indoor applications	No open flame
<b>Fastening</b>						
Mechanically fastened, hard substrate	X	X	X			X
Loosely laid, soft substrate				X	X	
<b>Parapet spacing in mm</b>	110	190 **	40	135	220	200
<b>Electronics</b>						
Controlled (close loop system)	X	X	X (blower)	X	X	
Controlled (open loop)			X (drive)			X
<b>Speed m/min.</b>						
Drive	0.7–12	1–5	0.5–3	0.5–3.5	0.8–6	0.8–12
Welding (depending on material)	4–8	2–3	1.5–3	1.5–2.5	3–6	3–6
<b>Weight kg</b>	35	12.8	4	6	7.7	40
<b>Welding technology</b>	Hot air*	Hot air	Hot air	Hot air	Hot-wedge	Hot air

✓✓✓ = Highly suitable, ✓✓ = Suitable, ✓ = Limited suitability

\* Brushless blower \*\* No gap necessary for laminated sheets

## 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 x W x H)	mm	750 x 270 x 190 (storage case)	1050 x 270 x 190 (storage case)
Weight	kg	14	17.5
Conformity Marking		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

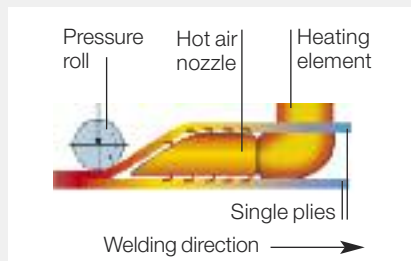


The memory stick ensures a verifiable evaluation of the welding results with the EXAMO USB.



## Welding technologies Roofing welders

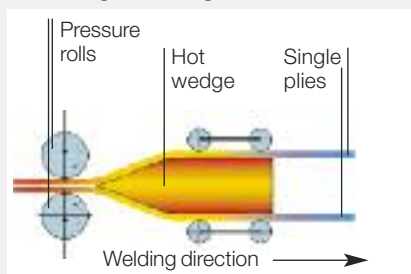
### Hot air welding



#### Heating by hot air

- VARIMAT V2
- UNIROOF E
- TRIAC DRIVE PID
- X 84
- BITUMAT B2





### Hotwedge welding



#### Heating by electrically heated wedge

- COMET SUB-ROOF

## Hot air tools for Roofing

	<b>TRIAC S</b>	<b>11</b>
	Accessories	16 / 17 / 18
	<b>TRIAC AT</b>	<b>12 / 13</b>
	Accessories	16 / 17 / 18
	<b>HOT JET S</b>	<b>20</b>
	Accessories	20 / 21
	<b>ELECTRON</b>	<b>24</b>
	Accessories	24 / 25
<b>General Roofing accessories</b>		<b>33</b>



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





## Billboards / Tarpaulins

VARIANT T1	50 / 51
UNIPLAN E / UNIPLAN S	52
UNIPLAN WEDGE	53
TAPEMAT	54
TAPEMAT SPRIEGEL	55
UNIMAT V TAPE	56
Billboards / Tarpaulins hot air tools overview	57














## VARIANT T1: Compact, fast and reliable.

The sturdy VARIANT T1 is distinguished by its outstanding top speed of up to 18 meters per minute. Combined with a slim, compact design, it allows a perfect view into the weld seam from all sides. Numerous new features of the VARIANT T1 have been made to facilitate smooth and ergonomic handling for daily use.

Hot air welder

### VARIANT T1



1		<b>Economical:</b> Up to 18 m/min welding speed and powerful, maintenance-free hot air blower.
2		<b>Easy handling:</b> Smooth lifting device and sturdy transport rollers for precise positioning.
3		<b>Reliable:</b> Constant, wrinkle-free welds thanks to process-optimised nozzle.
4		<b>Compact design:</b> The unmistakable Leister design guarantees a perfect view into the weld seam from all sides.
5		<b>Exceptional:</b> Electronics protected against the effects of unwanted high-frequency signals.
6		<b>Mobile:</b> Joint axis to compensate for slightly uneven floors.
7		<b>Very easy operation:</b> Simple operation using the proven Leister »e-Drive« operating concept.
8		<b>Ergonomic:</b> Adjustable guide bar to prevent back strain.
9		<b>Simple guidance:</b> Sturdy carrying and guide handles for ergonomically to guide and transport the device.
10		<b>Clever details:</b> Non-torsion cable fastening with spring clips on the guide rod or housing.
11		<b>Hem / piping welding kit:</b> Welding hems, hem pockets and piping in short time with easy-to-use accessories.



Constant, wrinkle-free overlap welds.



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

## Hot air welder

### VARIANT T1



- Top welding speed up to 18 m/min
- Perfect view into the weld seam
- Sturdy and durable for professional use
- Smooth lifting device for precise positioning
- Simple operation thanks to Leister »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
Weld seam width	mm	20 or 40
Dimensions (L x W x H)	mm	500 x 400 x 195
Weight	kg	22 (without 1.5 m cord)
Conformity Marking	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

	<b>142.650</b>	Hem / piping welding kit complete, comprising: 142.221 hold-down device 141.326 piping roll 140.530 Hem / piping add-on part
	<b>140.530</b>	Hem / piping add-on part
	<b>142.221</b>	Hold-down device
	<b>141.326</b>	Piping roll
	<b>139.438</b>	Additional weight 3 kg
	<b>137.843</b>	Upper part of T-handle guide bar
	<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 overlap pressure roller complete
	<b>138.938</b>	45 mm overlap pressure roller complete
	<b>107.612</b>	Heating element 230 V / 4400 W
	<b>107.613</b>	400 V / 5500 W
	<b>142.705</b>	Sturdy storage case

# 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



fig.: 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 x W x H)	mm	420 x 270 x 210
Weight	kg	11.5 (with 3 m cord)
Conformity Marking	CE	
Approval mark	S	
Certification scheme	CCA	
Protection class I	⊕	

#### Article No.:

- 114.221 UNIPLAN E 20 mm, 230 V / 2300 W, with Euro plug
- 114.318 UNIPLAN E 30 mm, 230 V / 2300 W, with Euro plug
- 115.049 UNIPLAN S 20 mm, 230 V / 2300 W, with Euro plug
- 115.050 UNIPLAN S 30 mm, 230 V / 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>122.022</b>	Guide bar complete
	<b>116.798</b>	Brass brush to clean nozzle
	<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
	<b>126.448</b>	Sturdy storage case (included with purchase)



# UNIPLAN Wedge: The quiet.

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



For accurately fitting weld seams of billboards.

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	20 – 420
Speed	m/min	1.0 – 7.5
Welding seam width	mm	20 or 30
Size (L × W × H)	mm	420 × 270 × 210
Weight	kg	11.5 (with 3 m cord)
Conformity Marking	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

Billboards / Tarpaulins

## 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.

### Hot air welder

## TAPEMAT



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




#### Technical Data

Voltage	V~	3 x 400
Power	kW	10
Temperature	°C	ca. 700
Maximal speed	m/min	20
Welding seam width	mm	50
Size (L x W x H)	mm	555 x 435 x 370
Weight	kg	40
Conformity Marking	CE	
Approval mark	S	
Certification scheme	CCA	
Protection class I	⏚	

#### Article No.:

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

## 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

# TAPEMAT SPRIEGEL: The sprinter.

With a speed of up to 20 meters per minute, the TAPEMAT SPRIEGEL is ideal for the fast and economical welding of tarpaulin bows for trucks.



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

Hot air welder

## TAPEMAT SPRIEGEL



- 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 x 400
Power	kW	10
Temperature	°C	ca. 700
Maximal speed	m/min	20
Welding seam width	mm	50
Size (L x W x H)	mm	555 x 435 x 370
Weight	kg	40
Conformity Marking	CE	
Approval mark	S	
Certification scheme	CCA	
Protection class I	⏏	

**Article No.:**

138.229

TAPEMAT Spriegel 100 mm, 400 V / 10 kW, with 16A CEE plug

133.597

TAPEMAT Spriegel 125 mm, 400 V / 10 kW, with 16A CEE plug

## 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
	<b>101.991</b>	3 x 400 V / 3 x 3300 W heating element

# UNIMAT V TAPE: The proven tape solution.

The UNIMAT V TAPE features an integrated lifting mechanism and automatic start to simplify your daily routine.



Optimized for 40 mm and 50 mm tape.

Hot air welder

## UNIMAT V TAPE



- High welding speed
- Digital display of set and actual values of welding speed, temperature and air flow
- No corrective action required thanks to the new guide roller
- Automatic start
- Integrated lifting mechanism

### Technical Data

Voltage	V~	230
Power	W	3680
Temperature	°C	20 – 620
Speed	m/min	1.5 – 12
Air flow range	%	50 – 100 (steplessly)
Welding seam / tape width	mm	40 or 50
Size (L x W x H)	mm	600 x 415 x 310
Weight	kg	28.0 (with 5 m cord)
Conformity Marking	CE	
Approval mark	S	
Certification scheme	CCA	
Protection class I	⊕	

### Article No.:








- 119.097 UNIMAT V TAPE 40 mm, 230 V / 3680 W, with Euro plug  
 119.096 UNIMAT V TAPE 50 mm, 230 V / 3680 W, with Euro plug

## Accessories UNIMAT V TAPE

	<b>115.192</b>	50 mm to 40 mm conversion kit, to weld 40 mm tape
	<b>115.193</b>	40 mm to 50 mm conversion kit, to weld 50 mm tape
	<b>114.418</b>	230 V / 2 x 1800 W heating element



## Hot air tools for Billboards / Tarpaulins

	TRIAC S	11
	Accessories	16 / 17 / 18
	TRIAC AT	12 / 13
	Accessories	16 / 17 / 18
	TRIAC BT	14 / 15
	Accessories	16 / 17 / 18 / 19
	HOT JET S	20
	Accessories	20 / 21
	GHIBLI / accessories	22
	SONORA S1 / accessories	23
	ELECTRON	24
	Accessories	24 / 25
General accessories for Billboards / Tarpaulins		33



The state-of-the-art VARIANT T1. (pages 50 / 51)





## Civil Engineering / Tunneling / Landfills

ASTRO / ASTRO USB	60 / 61
COMET / COMET USB	62
COMET / COMET USB accessories	63
TWINNY T / TWINNY T USB	64
TWINNY S / accessories	65
TRIAC DRIVE PID / accessories	66
EXAMO USB / accessories	67
WELDPLAST S6 / accessories	68
WELDPLAST S4 / accessories	69
WELDPLAST S2 / S2 TPO / accessories	70
FUSION 3 / FUSION 3C	71
FUSION 3 / FUSION 3C accessories	72
General accessories WELDPLAST / FUSION	72
Welding technologies overview	73
Civil Engineering / Tunneling / Landfills hot air tools overview	73

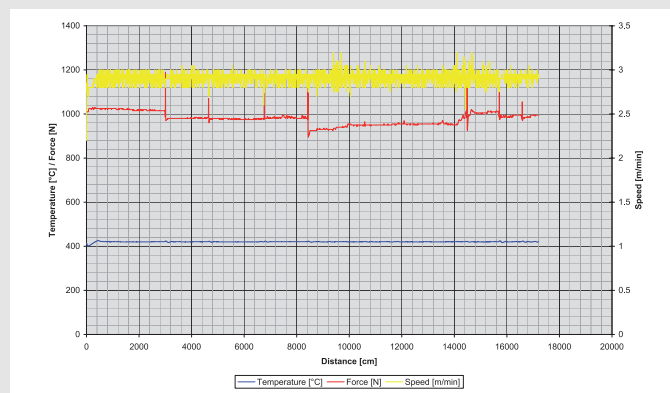
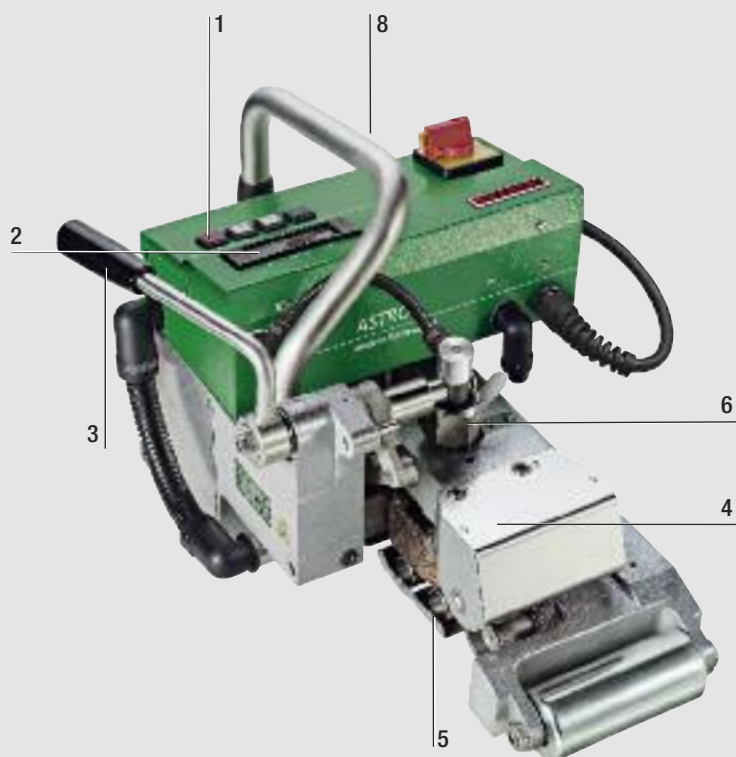


# ASTRO / ASTRO USB: The thoroughbred.

The ASTRO and ASTRO USB weld up to five meters per minute when used anywhere all over the world. Its robust design and easy handling make it the perfect work horse. 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> Safe workspace with limit value monitoring.	
8		<b>USB memory system</b> Easily record a permanent archive of all 1400 relevant welding parameters.
9		<b>Handy storage case</b> Convenient transport – perfect protection. (Included with purchase)





Fast and perfect!



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	20 – 420
Speed	m/min	0.8 – 5.0
Welding pressure	N	100 – 1500
Weld seam width	mm	2 x 15
Material thickness	mm	1.5 – 3.0
Size (L x W x H)	mm	430 x 270 x 310
Weight	kg	23.0 (with 3 m cable)
Conformity Marking	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, overlap 42 mm, with Euro plug, sturdy storage case

# Wedge welder ASTRO USB



- Digital display of pressure
- Acoustic alarm if limit value is exceeded
- Complete record of all relevant welding parameters
- USB memory system

## Technical Data

Voltage	V~	230
Power	W	1800
Temperature	°C	20 – 420
Speed	m/min	0.8 – 5.0
Welding pressure	N	100 – 1500
Weld seam width	mm	2 x 15
Material thickness	mm	1.5 – 3.0
Size (L x W x H)	mm	430 x 270 x 310
Weight	kg	23.0 (with 3 m cable)
Conformity Marking	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

# 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	20 – 420
Speed	m/min	0.8 – 3.2
Welding pressure	N	100 – 1000
Weld seam width	mm	2 x 15, with test channel
Material thickness	mm	0.5 – 3
Size (L x B x H)	mm	295 x 250 x 245
Weight	kg	7.5 (with 3 m cable)
Conformity Marking	CE	
Approval mark	S	
Protection class I	⊕	

### Article No.:

107.538	COMET, wedge 70 mm for PE, 230 V / 1500 W, test channel, Euro plug
107.547	COMET, wedge 50 mm for PE, 230 V / 1200 W, test channel, Euro plug
107.558	COMET, wedge 50 mm for PVC, 230 V / 1200 W, test channel, Euro plug
107.539	COMET, wedge 70 mm for PE, 120 V / 1500 W, test channel, yellow UK plug
107.553	COMET, wedge 50 mm for PE, 120 V / 1200 W, test channel, yellow UK plug
145.893	COMET, wedge 95 mm for PE, 230 V / 1850 W, test channel, Euro plug

Additional versions available upon request.

## Wedge welder COMET USB



- Digital display of welding pressure
- Complete record 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	20 – 420
Speed	m/min	0.8 – 3.2
Welding pressure	N	100 – 1000
Weld seam width	mm	2 x 15, with test channel
Material thickness	mm	0.5 – 3
Size (L x B x H)	mm	295 x 250 x 245
Weight	kg	7.5 (with 3 m cable)
Conformity Marking	CE	
Approval mark	S	
Protection class I	⊕	

### Article No.:

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


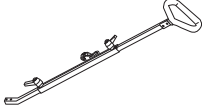




Comet operating in the tunnel ...



... 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 consist of hexagon spanner 8 / 10 / 13 / 17 mm and hexagon bolt 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 length	Material thickness	Wedge length	Material thickness	Wedge length	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	20 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.

## Combiwedge 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
Velocity	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 Marking	CE	
Approval mark	S	
Protection class I	⊕	

### Article No.:

- 107.562 TWINNY T for civil engineering, 230 V / 2300 W, with test channel, with combiwedge long, with Euro plug
- 107.564 TWINNY T for civil engineering, 230 V / 2300 W, with test channel, with combiwedge short, with Euro plug
- 111.190 TWINNY T for tunnel construction, 230 V / 2300 W, with test channel, with combiwedge short, with Euro plug
- 115.761 TWINNY T for civil engineering, 230 V / 2300 W, without test channel, with combiwedge long, with Euro plug
- 113.362 TWINNY T for civil engineering, 120V / 1900W, roller 50 mm, with test channel, with short combi-wedge, with UK plug

Additional versions available upon request.

## Combiwedge welder TWINNY T USB



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

### Technical Data

Voltage	V~	230
Power	W	2300
Temperature	°C	20 – 560
Velocity	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 Marking	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 combiwedge long, with Euro plug

Additional versions available upon request.



## TWINNY S: The lightweight.

Lightweight version, optimized for overhead welding, is ideal for thin materials used in civil engineering and tunnel construction. Leister offers a choice between replaceable combiwedges with or without test channel.



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

### Combiwedge 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~	230 / 120
Power	W	2900 / 1900
Temperature	°C	20 – 600
Speed	m/min	
Gear 256:1		0.2 – 2.5
Gear 144:1		1.4 – 4 (6)
Welding pressure	N	1000
Size (L x W x H)	mm	350 x 390 x 270
Weight	kg	6.5 – 6.9 (with 3 m cable)
Conformity Marking		CE
Approval mark		5
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, combiwedge long, Euro plug
119.030	TWINNY S for tunnel construction, drive 256:1, 230 V / 2900 W, with test channel, combiwedge short, Euro plug
119.027	TWINNY S for civil engineering, drive 256:1, 230 V / 2900 W, with test channel, combiwedge long, Euro plug
119.008	TWINNY S for civil engineering, drive 144:1, 230 V / 2900 W, with test channel, combiwedge short, Euro plug
128.808	TWINNY S for civil engineering, drive 144:1, 6 m/min, 230 V / 2900 W, with test channel, combiwedge short, Euro plug

Additional versions available upon request.




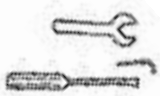


## Accessories TWINNY T / T USB / S

	<b>112.974</b>	Cross handle extremely light, material: aluminum
	<b>129.224</b>	Guide-bar, complete
	<b>100.517</b>	50 mm combiwedge short, with test channel
	<b>100.518</b>	50 mm combiwedge short, without test channel
	<b>100.519</b>	30 mm combiwedge short, with test channel
	<b>100.520</b>	30 mm combiwedge short, without test channel
	<b>100.525</b>	50 mm combiwedge long, complete, with test channel
	<b>100.526</b>	50 mm combiwedge long, complete, without test channel, slotted, perforated

## Accessories TWINNY T / T USB

	<b>103.604</b>	230 V / 2100 W heating element
	<b>103.602</b>	120 V / 1800 W heating element

## Accessories TWINNY S

	<b>101.905</b>	230 V / 2750 W heating element
	<b>101.910</b>	230 V / 2100 W heating element
	<b>101.913</b>	120 V / 1800 W heating element
	<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
	<b>126.448</b>	Storage case (included with purchase)

## TRIAC DRIVE: The climber.

This tried and tested semi-automatic welding machine can be used in most applications. The increased welding speed, compared with manual welding, gives rise to higher productivity.



Overhead welding made easy with the TRIAC DRIVE PID.

### Semi automatic welding machine

## TRIAC DRIVE PID



- Faster and additional efficiency than hand welding
- Small and compact
- Steplessly adjustable speed for high-quality welding
- Can be used in the most confined spaces

#### Technical Data

Voltage	V~	230
Power	W	1700
Temperature	°C	20 – 600
Speed	m/min	0.5 – 3
Width of welding nozzle	mm	40 / 30
Dimensions (L × W × H)	mm	300 × 230 × 380
Weight	kg	4.15 (with 3 m cable, without guide aid)
Conformity Marking	CE	
Approval mark	S	
Certification scheme	CCA	
Protection class I	⊕	

#### Article No.:

- 115.985 TRIAC DRIVE PID without guiding help, 230 V / 1700 W, outside, without grip, width of welding nozzle 40 mm, Euro plug
- 138.860 TRIAC DRIVE PID with guiding help, 230 V / 1700 W, inside, without grip, width of welding nozzle 30 mm, Euro plug

Additional versions available upon request.

## Accessories TRIAC DRIVE PID

	<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>138.570</b>	12 mm pressure roller, silicon
	<b>115.857</b>	30 mm pressure roller, silicon
	<b>115.921</b>	40 mm pressure roller, silicon
	<b>115.276</b>	Single supporting carrier
	<b>115.281</b>	Overlap welding nozzle, inside, push-fit
	<b>115.279</b>	38 mm, <i>with</i> grip
	<b>115.699</b>	30 mm, <i>with</i> grip
	<b>115.703</b>	12 mm, <i>without</i> grip
	<b>115.701</b>	38 mm, <i>without</i> grip
		Overlap welding nozzle, outside, push-fit
	<b>115.280</b>	38 mm, <i>with</i> grip
	<b>115.278</b>	30 mm, <i>with</i> grip
	<b>115.702</b>	38 mm, <i>without</i> grip
	<b>115.700</b>	30 mm, <i>without</i> grip
	<b>100.296</b>	230 V / 1550 W heating element for TRIAC PID
	<b>108.985</b>	Storage case (included with purchase)

# 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 lab or on-site with the EXAMO USB.

## Testing instrument

### EXAMO USB

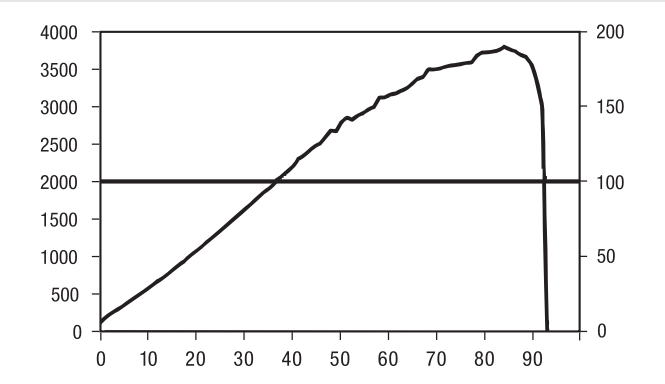


- Handy, robust and reliable
- Testing of elongation, peak force, tear force, test speed and position
- Construction-site approved
- With jaws also suitable for geo textiles (see accessories)

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 x W x H)	mm	750 x 270 x 190 (case)	1050 x 270 x 190 (case)
Weight	kg	14	17.5
Conformity Marking		2	2
Approval Mark		3	3
Protection Class I		1	1
<b>Article No.:</b>			
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>113.005</b>	Jaws for geo textiles left
	<b>113.006</b>	right



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

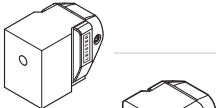

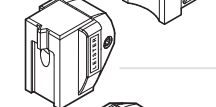
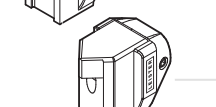
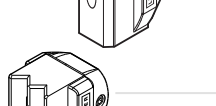
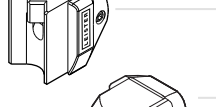
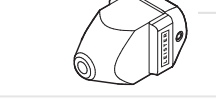


Voltage	V~	230
Power	W	4600
Material		PE / PP
Welding rod	mm	Ø 4 or Ø 5
Output	kg/h	3.9 – 6.0
Size (L x W x H)	mm	821 x 116 x 240
Weight	kg	14
Conformity Marking		CE
Approval mark		§
Protection class I		⊕

### Article No.:

134.318 Hand extruder WELDPLAST S6, 230V / 5300W, 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 x 40 x 52 mm blank welding shoe
	<b>146.241</b>	74 x 50 x 58 mm blank welding shoe
	<b>146.242</b>	25 mm overlap
	<b>145.899</b>	35 mm overlap
	<b>146.245</b>	40 mm overlap
	<b>146.246</b>	20 mm V-seam
	<b>146.247</b>	25 mm V-seam
	<b>146.232</b>	30 mm V-seam
	<b>146.233</b>	20 mm fillet weld seam (a = 14 mm*)
	<b>146.234</b>	25 mm fillet weld seam (a = 17.5 mm*)
	<b>146.644</b>	30 mm fillet weld seam (a = 21 mm*)
	<b>146.646</b>	Corner outside seam 10 mm
	<b>146.652</b>	Corner outside seam 12 mm
	<b>146.230</b>	Corner outside seam 15 mm
	<b>146.218</b>	Corner seam Ø 14 mm
	<b>144.905</b>	Corner seam Ø 20 mm
	<b>145.705</b>	45° angled adapter
	<b>117.055</b>	90° angled adapter
	<b>136.859</b>	35 mm preheating nozzle, large
	<b>117.790</b>	50 mm preheating nozzle, XL large
		Side hot air guide

\* a = welding seam thickness

Other accessories see page 72



# WELDPLAST S4: The workmate.

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 or Ø 4
Output	kg/h	1.5 – 4.0
Size (L x W x H)	mm	560 x 110 x 300
Weight	kg	8.7
Conformity Marking		CE
Approval mark		§
Certification scheme		CCA
Protection class I		⊕

### Article No.:

116.948 Hand extruder WELDPLAST S4, 230 V / 3680 W, with Euro plug

Included in delivery: WELDPLAST S4, blank welding shoe, 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
		74 x 50 x 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
	<b>117.064</b>	Side hot air guide
	<b>117.065</b>	Top hot air guide
	<b>117.053</b>	20 mm preheating nozzle, small
	<b>117.518</b>	25 mm preheating nozzle, medium
	<b>141.177</b>	35 mm preheating nozzle, large

\* a = welding seam thickness

Other accessories see page 72

## WELDPLAST S2: The master piece.

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		PE / PP
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 × W × H)	mm	450 × 98 × 260
Weight	kg	5.8
Conformity Marking		CE
Approval mark		§
Certification scheme		CCA
Protection class I		⚡

#### Article No.:

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

136.602 WELDPLAST S2, 230 V / 3000 W, TPO, Euro p

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

### Accessories WELDPLAST S2 / S2 TPO

	<b>145.945</b>	<b>Welding shoe complete</b> 50 × 30 × 38 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>	35 mm overlap
	<b>145.897</b>	40 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

Other accessories see page 72

# 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					
	mm	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 marking		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					
	mm	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 marking		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

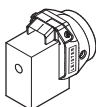


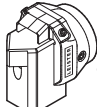


➔ Accessories page 70

➔ Accessories page 70








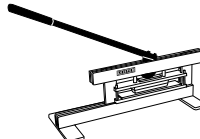





The FUSION 3 for comfortable working in awkward positions.

## Accessories FUSION 3 / FUSION 3C

	<b>145.945</b>	Welding shoe complete
	<b>145.946</b>	50 x 30 x 38 mm blank welding shoe 74 x 50 x 58 mm blank welding shoe
	<b>145.896</b>	25 mm overlap
	<b>145.947</b>	35 mm overlap
	<b>145.897</b>	40 mm overlap
	<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>145.905</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

## General accessories WELDPLAST / FUSION

	<b>118.804</b>	Tool rest WELDPLAST S4 / FUSION 3 / FUSION 3C
	<b>131.451</b>	Device rest WELDPLAST S2
	<b>136.231</b>	Pre-heat reflector WELDPLAST S4 / WELDPLAST S2 FUSION 3 / FUSION 3C
	<b>134.567</b> <b>109.984</b>	Heating element, 230 V / 2600 W, für WELDPLAST S6 230 V / 2200 W, für WELDPLAST S4 / S2
	<b>113.268</b> <b>123.561</b>	230 V / 1100 + 1100 W, for FUSION 3 230 V / 1750 W, for FUSION 3C

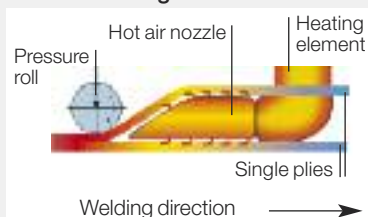
	<b>134.361</b>	Air filter set (included with purchase)
	<b>143.776</b>	Textile dust filter (not included with purchase)
	<b>135.082</b>	Air filter FUSION 3C
	<b>145.813</b>	COUPON CUTTER (including hexagon set, knife protection), test piece dimensions 150 x 20 mm
	<b>143.824</b>	Spare blade 150 x 20 mm
	<b>143.826</b>	Blade protection
	<b>143.828</b>	Cutting plate
	<b>146.883</b>	VACUUM BOX, 810 x 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> <b>119.540</b>	Storage case WELDPLAST S4 / FUSION 3 WELDPLAST S2 / S2 TPO / FUSION 3C (included with purchase)
	<b>116.367</b>	Ultra strong storage case WELDPLAST S6 (included with purchase)

\* a = welding seam thickness



## Welding technologies for welders in Civil Engineering / Tunneling / Landfills

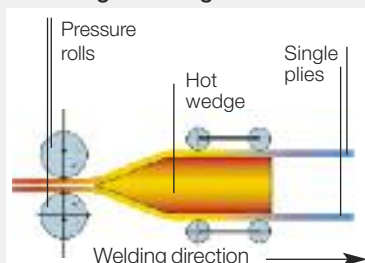
### Hot air welding



#### Heating by hot air

- TRIAC DRIVE

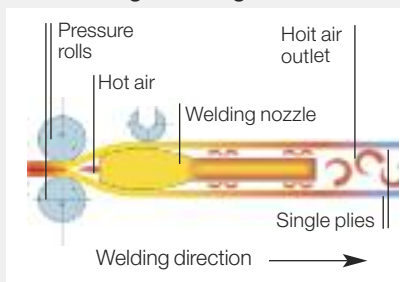
### Hotwedge welding



#### Heating by electrically heated wedge

- ASTRO
- ASTRO USB
- COMET
- COMET USB





### Combiwedge welding



#### Heating by hot air and hotwedge

- TWINNY T
- TWINNY T USB
- TWINNY S

## Hot air tools for Civil Engineering / Tunneling / Landfills

	TRIAC S	11
	Accessories	16 / 17 / 18
	TRIAC AT	12 / 13
	Accessories	16 / 17 / 18
	HOT JET S	20
	Accessories	20 / 21
	ELECTRON	24
	Accessories	24 / 25
General accessories for Civil Engineering / Tunneling / Landfills		34





## Plastic Fabrication

WELDPLAST S6	76
WELDPLAST S4	77
WELDPLAST S2 / S2 PVC	78 / 79
WELDPLAST S2 / S2 PVC accessories	80
FUSION 2	81
FUSION 3	82
FUSION 3C	83
WELDMAX / general accessories hand extruders	84
Overview of hand extruders	85
Welding rods	86
Plastic Fabrication hot air tools overview	87





## 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, preheated 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

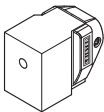
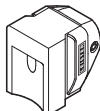

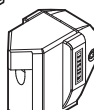
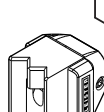


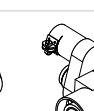




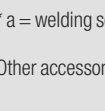
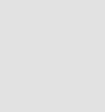
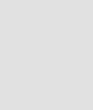



Voltage	V~	230
Power	W	4600
Material		PE / PP
Welding rod	mm	Ø 4 or Ø 5
Output	kg/h	3.9 – 6.0
Size (L x W x H)	mm	821 x 116 x 240
Weight	kg	14
Conformity Marking		CE
Approval mark		§
Protection class I		⊕

#### Article No.:

134.318 WELDPLAST S6, 230V / 5300W, CEE 32A plug

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

### Accessories WELDPLAST S6

Welding shoe complete	
	<b>146.239</b> 54 x 40 x 52 mm blank welding shoe
	<b>146.240</b> 74 x 50 x 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>146.245</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
	<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

Other accessories see page 84



## 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 or Ø 4
Output	kg/h	1.5 – 4.0
Size (L x W x H)	mm	560 x 110 x 300
Weight	kg	8.7
Conformity Marking		CE
Approval mark		§
Certification scheme		CCA
Protection class I		⊕

#### Article No.:

116.948 WELDPLAST S4, 230 V / 3680 W, with Euro plug

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

### Accessories WELDPLAST S4

	<b>146.239</b>	<b>Welding shoe complete</b>	54 x 40 x 52 mm blank welding shoe
	<b>146.240</b>		74 x 50 x 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
	<b>117.064</b>		Side hot air guide
	<b>117.065</b>		Top hot air guide
	<b>117.053</b>		20 mm preheating nozzle, small
	<b>117.518</b>		25 mm preheating nozzle, medium
	<b>141.177</b>		35 mm preheating nozzle, large

\* a = welding seam thickness

Other accessories see page 84

## WELDPLAST S2: The master piece.

The WELDPLAST S2 is a masterpiece of modern technology. While externally it fulfils the highest functionality requirements and design, its interior satisfies the high expectations concerning the material to be processed.

The WELSDPLAST S2 PVC has been especially designed to satisfy the high requirements regarding PVC extrusion welding. Perfect seam quality and integrated corrosion protection make it a reliable partner of today and tomorrow.

Digitally regulated extrusion welder

### WELDPLAST S2 / S2 PVC



1		Low-noise, high power transmission.
2		360° rotating welding shoe.
3		Material-optimized extruder screw.
4		Maintenance-free blower.
5		Freely adjustable swivel-mounted hand grip.
6		Ergonomic construction.
7		Dual-sided, twist-free wire intake.
8		Multifunctional display.



The WELDPLAST S2 on the practical tool rest.



The WELDPLAST S2 welds perfect seams even in awkward positions.

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   P: 0.9–2.0
Size (L × W × H)	mm	450 × 98 × 260
Weight	kg	5.8
Conformity marking	CE	
Approval mark	S	
Certification scheme	CCA	
Protection class I	⚡	

### Article No.:

127.215 WELDPLAST S2, 230 V / 3000 W, Euro plug  
136.602 WELDPLAST S2, 230 V / 3000 W, TPO, 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 × W × H)	mm	450 × 98 × 260
Weight	kg	5.8
Conformity Marking	CE	
Approval mark	S	
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

Accessories page 80

Accessories page 80


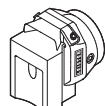
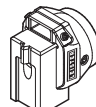
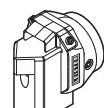






The handy WELDPLAST S2 in action.



Even inside radiuses are easy to weld.



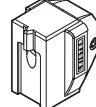
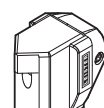
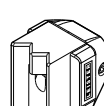
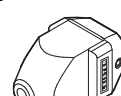

## Accessories WELDPLAST S2

	<b>145.945</b>	<b>Welding shoe complete</b>
	<b>145.946</b>	50 x 30 x 38 mm blank welding shoe
		74 x 50 x 58 mm blank welding shoe
	<b>145.896</b>	25 mm overlap
	<b>145.947</b>	35 mm overlap
	<b>145.897</b>	40 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

Other accessories see page 84

## WELDPLAST S2 PVC

	<b>146.239</b>	<b>Welding shoe complete</b>
	<b>146.240</b>	54 x 40 x 52 mm blank welding shoe
		74 x 50 x 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>146.248</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>146.245</b>	20 mm V-seam
	<b>146.246</b>	25 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>146.232</b>	20 mm fillet weld seam (a = 14 mm*)
	<b>146.233</b>	25 mm fillet weld seam (a = 17.5 mm*)
	<b>146.642</b>	Corner outside seam 8x 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

Other accessories see page 84



Succeed with perfect weld seams with the WELDPLAST S2.



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



# FUSION 2: The small powerhouse.

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



The FUSION 2 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

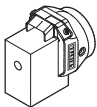


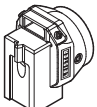
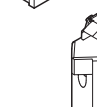




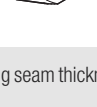


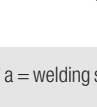

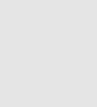
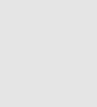
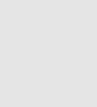


Voltage	V~	230
Power	W	2800
Material		PE / PP
Air temperature	°C	up to 340
Plastification temperature	°C	up to 300
Welding rod	Ø mm	4
Output PE	kg/h	1.3 – 1.8
Size (L x W x H)	mm	450 x 98 x 225
Weight	kg	5.9 (without cable)
Conformity marking		CE
Approval mark		Ⓢ
Certification scheme		CCA
Protection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

### Article No.:

119.200 FUSION 2, 230 V / 2800 W, Euro plug

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

## Accessories FUSION 2

	<b>145.945</b>	<b>Welding shoe complete</b>
	<b>145.946</b>	50 x 30 x 38 mm blank welding shoe
	<b>145.896</b>	74 x 50 x 58 mm blank welding shoe
	<b>145.947</b>	25 mm overlap
	<b>145.897</b>	35 mm overlap
	<b>145.912</b>	40 mm overlap
	<b>145.915</b>	5 / 6 V-seam
	<b>145.907</b>	8 / 10 mm V-seam
	<b>145.903</b>	12 mm V-seam
	<b>145.943</b>	15 mm V-seam
	<b>145.944</b>	5 / 6 mm fillet weld (a = 4.2 mm*)
	<b>145.812</b>	8 / 10 mm fillet weld (a = 7 mm*)
	<b>146.643</b>	15 mm fillet weld (a = 10 mm*)
	<b>146.645</b>	Corner outside seam 8 mm
	<b>146.649</b>	Corner outside seam 10 mm
	<b>146.651</b>	Corner outside seam 12 mm
	<b>145.811</b>	Corner outside seam 15 mm
	<b>145.488</b>	Corner seam Ø 14 mm
		Corner seam Ø 20 mm

\* a = welding seam thickness

Other accessories see page 84



Value must be protected ...

## FUSION 3: Long and slim.

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



Comfortable work on the ground with the FUSION 3.

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

	mm	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 × W × H)	mm	670 × 90 × 180			
Weight	kg	7.2			
Conformity marking		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

### Accessories FUSION 3

	<b>145.945</b>	<b>Welding shoe complete</b>
	<b>145.946</b>	50 × 30 × 38 mm blank welding shoe
	<b>145.896</b>	25 mm overlap
	<b>145.947</b>	35 mm overlap
	<b>145.897</b>	40 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

\* a = welding seam thickness

Other accessories see page 84

# FUSION 3C: Short and handy.

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



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

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					
	mm	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 × W × H)	mm	588 × 98 × 225			
Weight	kg	6.9			
Conformity marking		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					

## Accessories FUSION 3C

	<b>145.945</b>	<b>Welding shoe complete</b>
	<b>145.946</b>	50 x 30 x 38 mm blank welding shoe 74 x 50 x 58 mm blank welding shoe
	<b>145.896</b>	25 mm overlap
	<b>145.947</b>	35 mm overlap
	<b>145.897</b>	40 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>145.944</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

\* a = welding seam thickness

Other accessories see page 84



Perfectly stored in the case.  
**Article-No.: 119.540**  
(included with purchase)

## 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 hand extruder
- Ideal for confined spaces
- Separate, stepless temperature control for plastification unit and preheated air

#### Technical Data

Voltage	V~	230 / 120
Power	W	2200 / 1800
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 × B × H)	mm	443 × 94 × 255, handle Ø 57
Weight	kg	3.8
Conformity marking		CE
Approval mark		§
Certification scheme		CCA
Protection class II		□

#### Article No.:

- 110.272 WELDMAX, 230 V / 2200 W, with EU-plug, storage case  
 113.549 WELDMAX, 120 V / 1800 W, without plug, storage case

Additional versions on request

## Accessories WELDMAX

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

## General accessories hand extruder

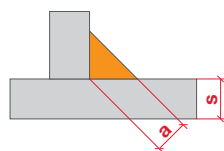
	<b>131.451</b>	Tool rest WELDPLAST S2 / S2 PVC
	<b>118.804</b>	WELDPLAST S4 / FUSION 3 / FUSION 3C
	<b>136.231</b>	Pre-heat reflector WELDPLAST S2 / S2 PVC / S4 FUSION 2 / 3 / 3C
	<b>134.567</b> <b>109.984</b>	Heating element, 230 V / 2600 W, WELDPLAST S6 230 V / 2200 W, WELDPLAST S4 / S2 / S2 PVC
	<b>113.268</b> <b>123.561</b> <b>112.638</b> <b>112.963</b>	230 V / 1100 + 1100 W, FUSION 3 230 V / 1750 W, FUSION 2 / 3C 230 V / 1400 W, WELDMAX 120 V / 1150 W, WELDMAX
	<b>134.361</b>	Air filter WELDPLAST S2 / S2 PVC (included with purchase)
	<b>143.776</b> <b>135.082</b>	Textile dust filter WELDPLAST S2 / S2 PVC (not included with purchase) Air filter FUSION 2 / 3C
	<b>144.095</b>	Welding rod de-reeler
	<b>116.367</b> <b>123.173</b> <b>119.540</b>	Storage case (included with purchase) WELDPLAST S6 WELDPLAST S4 / FUSION 3 WELDPLAST S2 / S2 PVC / FUSION 2 / 3C / WELDMAX

\* a = welding seam thickness



## Possibilities of welding seams

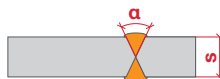
a = seam size s = material thickness  $\alpha$  = milling angle



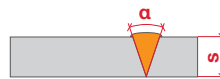
Fillet welding seam



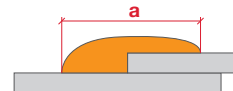
Corner outside seam



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			Air heated extrusion welders			Compact extrusion welder
							
Device type	WELDPLAST S6	WELDPLAST S4	WELDPLAST S2	FUSION 3	FUSION 3C	FUSION 2	WELDMAX
Output (HDPE) kg/h	3.9 – 6	1.5 – 4	0.6 – 2.3	1.8 – 3.6	1.8 – 3.6	1.3 – 1.8	0.3 – 0.8
Material	HD-PE, PP	HD-PE, PP	HD-PE, PP, PVC	HD-PE, PP	HD-PE, PP	HD-PE, PP	HD-PE, PP, PVDF
Wall thickness mm	15 – 40	8 – 35	4 – 20	8 – 25	8 – 25	6 – 15	4 – 10
Welding wire mm	4 – 5	3 – 4	3 – 4	3 – 5	3 – 5	4	4
Weight kg	14	8.7	5.8	7.2	6.9	5.9	3.8
Length mm	821	560	450	690	588	450	433
Voltage V~	230	230	230	230	230	230	230
Screw extruder	yes	yes	yes	yes	yes	yes	no
Container construction	33	33	33	33	33	33	33
Pipeline construction	33	33	33	33	33	33	33
Landfills / civil engineering	33	33	3	33	3	m	m
Brushless blower	yes	yes	yes	no	no	no	no
Remarks	1	1	1	2	2	2	1

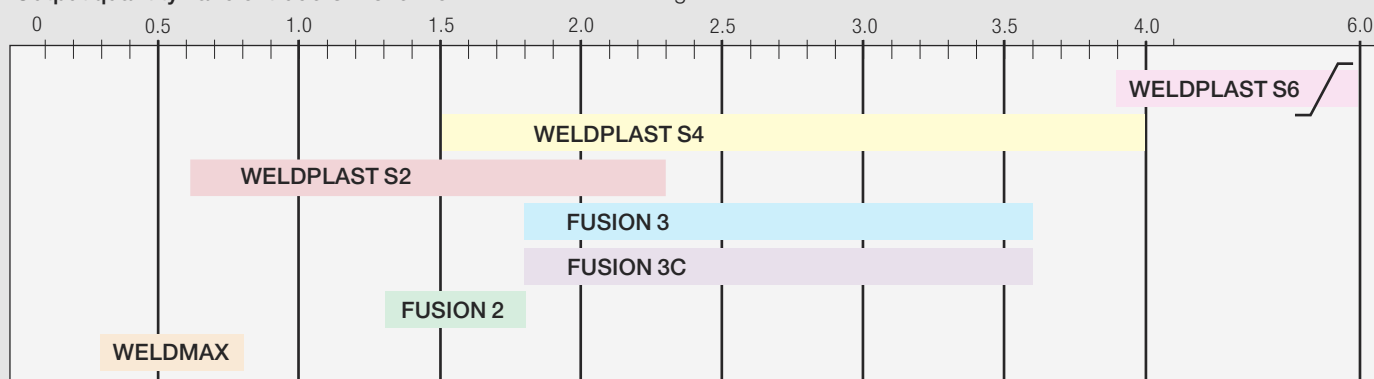
### Remarks

- 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.

33 = very suitable, 3 = suitable, m = unsuitable

### Output quantity hand extruders in overview

kg/h





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



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



The WELDPLAST S4 during outdoor use in Spain.

## Hot air tools for Plastic Fabrication

	TRIAC S	11
	Accessories	16 / 17 / 18
	TRIAC AT	12 / 13
	Accessories	16 / 17 / 18
	TRIAC BT	14 / 15
	Accessories	16 / 17 / 18
	GHIBLI / accessories	22
	LABOR S / accessories	28
	WELDING PEN R / WELDING PEN S / accessories	29
	DIODE PID / DIODE S	30
	MINOR blower	31
	ROBUST blower/ accessories	32
General accessories for Plastic Fabrication		34









## Flooring / Interior Decoration

UNIFLOOR E / UNIFLOOR S	90
GROOVER	91
Flooring welding procedures	92
Overview of hot air tools for Flooring / Interior Decoration	93



# 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

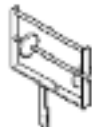




#### Technical Data

Voltage	V~	230
Power	W	2300
Temperature	°C	20 – 620
Speed	m/min	1.0 – 7.5
Air flow range	%	50 – 100
Size (L x W x H)	mm	420 x 270 x 215
Weight	kg	11.0 (with 3 m cord)
Conformity marking	CE	
Approval mark	S	
Certification scheme	CCA	
Protection class I	⏏	

#### Article No.:

138.493	UNIFLOOR E 230 V, including rod de-reeler, squeezed nozzle (PVC and PUR), with Euro plug
114.226	UNIFLOOR E 230 V, squeezed nozzle (PVC and PUR), with Euro plug
138.494	UNIFLOOR S 230 V, including rod de-reeler, squeezed nozzle (PVC and PUR), with Euro plug
115.032	UNIFLOOR S 230 V, squeezed nozzle (PVC and PUR), with Euro plug

### 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, optimised for PVC material
	<b>115.342</b>	Floor welding nozzle, for PVC + PUR material
	<b>103.394</b>	Floor welding nozzle air-knife, optimised for PUR material
	<b>103.604</b>	230 V / 2100 W heating element
	<b>126.448</b>	Storage case (included with purchase)



Perfectly stowed away in the provided 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, rotational, dual-level cutting speeds
- Adjustable guide roller for tracking accuracy
- Particulate- and dust-free operation with an additional fan and dust bag
- Milling as close to the edge possible

Technical Data		
Voltage	V~	230
Power	W	350 / 700 (2 levels)
Speed	min <sup>-1</sup>	Level 1: 14 500 (350 W) Level 2: 18 500 (700 W)
Groove depth adjustment	mm	0 – 4
Size (L × W × H)	mm	240 × 205 × 255
Weight	kg	6.7 (with 3 m cord)
Conformity marking	CE	
Approval mark	S	
Certification scheme	CCA	
Protection class II	□	

Article No.:	
108.393	GROOVER 230 V, tungsten carbide tipped blade Ø 110 x 3.5 mm, trapezium profile, with Euro plug
111.032	GROOVER 230 V, tungsten carbide tipped blade Ø 110 x 3.5 mm, round profile, with Euro plug
108.397	GROOVER 120 V, with UK plug yellow

## Accessories GROOVER

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

## Procedures for welding floor coverings



**Step 1:**  
Milling the groove  
with the GROOVER.  
(page 91)



**Step 2:**  
Inserting the welding rod into  
the groove with the UNIROOF E  
hot air welder.  
(page 90)










**Step 3:**  
Pulling out the inserted  
welding rod with trimmer  
and spatula.  
(page 34)



**Step 4:**  
Planing the projecting  
welding rod with the spatula.  
(page 34)



## Hot air tools for Flooring / Interior Decoration

	TRIAC S	11
	Accessories	16 / 17 / 18
	TRIAC AT	12 / 13
	Accessories	16 / 17 / 18
	TRIAC BT	14 / 15
	Accessories	16 / 17 / 18 / 19
	HOT JET S	20
	Accessories	20 / 21
	GHIBLI / accessories	22
	SONORA / accessories	23
	ELECTRON	24
	Accessories	24 / 25
General accessories for Flooring / Interior Decoration		34

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