English

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LEISTER



UNIDRIVE 505

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en Operating instructions (Translation of the Original User Manual)

Congratulations on your purchase of the UNIDRIVE 505.

You have chosen a first-class semi-automatic hot-air welder. It was developed and produced in accordance with the latest state-of-the-art technology in the plastics-processing sealing sheet industry. It has also been manufactured using high-guality materials.



Please always store these operating instructions with the device.

UNIDRIVE 505 Hot-air welder



You can find more information on the UNIDRIVE 505 at leister.com

1. Application

1.1 Intended use

The UNIDRIVE 505 semi-automatic hot-air welder is designed for professional butt welding on a backing strip.

Welding procedures and types of materials

Butt welding of thermoplastic sealing sheets (e.g. PVC)

The legal provisions on health protection applicable in the respective country must be observed. Never use the semi-automatic hot-air welder in explosive or readily inflammable surroundings. Maintain sufficient distance from combustible materials or explosive gases at all times. Read the material safety data sheet from the manufacturer of the material and follow that company's instructions. Be careful not to burn the material during the welding process. Observe 😰 general safety instructions [1.3].



- Only operate the device **under supervision** as waste heat can reach flammable materials.
- The device should only be operated by trained specialists or under their supervision.
- Children are not permitted to operate the device.

1.2 Non-intended use

Any other use or any use beyond the type of use described is deemed non-intended use.

1.3 General safety information

Please observe the safety instructions provided in the individual chapters of these operating instructions as well as the following safety instructions.

Warning



Risk of death from electric shock due to dangerous electrical voltage

- The device is only to be connected to sockets and extension cables with a protective earth conductor.
- Protect the device from moisture and wet conditions.
- When used on a construction site, a residual current circuit breaker is mandatory.
- Prior to using the device for the first time, check the power cord, the plug, and the extension cable for electrical and mechanical damage.
- The device may only be opened by instructed, qualified personnel.
- **Repairs** should only be carried out by **authorized service points**. Restricted to use with **original** accessories and spare parts.



- Danger of fire and explosion with improper use in the vicinity of flammable materials and explosive gases.
- Avoid overheating of the material.
- Never place the device near combustible materials and/or explosive gases.
- Never place the device close to combustible materials and/or explosive gases while it is running and/or hot.
- Only use the device on fireproof surfaces.
- **Repairs** should only be carried out by **authorized service points**. Restricted to use with **original accessories and spare parts**.



Risk of burns due to hot equipment parts and hot air jet

- Do not touch the heating tube and nozzle when they are hot.
- Always allow the device to cool down first.
- Never point the hot air flow at people or animals.
- **Repairs** should only be carried out by **authorized service points**. Restricted to use with **original** accessories and spare parts.

Caution



• The local supply **voltage** must match the nominal **voltage** specified on the device.

2. Technical data

			UNIDRIVE 505 100-120V	UNIDRIVE 505 220-240V			
	Voltage	٧~	120	230			
(\mathfrak{T})	Capacity	W	1800	2300			
	Frequency	Hz	50/	50/60			
N=	Temperature	°C °F	- 100 - 212	100 - 560 212 - 1040			
0	Max. Ambient temperature	°C °F	6 14	65 149			
\otimes	Air volume	%	45 -	45 - 100			
\bigcirc	Drive	m/min ft/min	0.7 - 2.3 -	0.7 - 4.5 2.3 - 14.8			
»?	Noise level	dB (A)	70 (K	70 (K = 3)			
	Wi-Fi radio characteristic						
	RF frequency range	GHz	-				
	Transmit power 802.11 g	dBm	-	-			
ݣ	Weight	kg Ibs	4.	5 9			
Dimensions		a) mm inch	29 11	7 .7			
		b) mm inch	17 6.	173 6.8			
Ĺ	b	c) mm inch	27 10	75 1.8			
			CE				

We reserve the right to make technical changes.

3. Transport

Risk of excessive physical strain when carrying and lifting the device



- The weight of your UNIDRIVE 505, including the transport box, is around 7.5 kg (4.5 kg without transport box).
- For transporting the semi-automatic hot-air welder, use the transport box included in the scope of delivery and carry the transport box using the handle provided for this purpose.
- Comply with applicable national regulations regarding the carrying or lifting of loads.



Fire hazard when transporting while hot

- The hot air blower (6) reaches temperatures of 560 °C.
- Allow the **hot-air blower (6)** to cool down sufficiently prior to transport (see 1 Cool-down mode [9.3]).
- Never store flammable materials (such as plastic or wood) in the transport box.



• Never use the **carrying handle (4)** on the device or on the transport box for transporting with a crane, as this may cause the unit to fall.



To manually raise the semi-automatic hot air welder, use the carrying handle (4).

4. Your UNIDRIVE 505

4.1 Type plate and identification

The model and serial number are indicated on your device's **type plate (12)**. Please enter this information in your operating instructions and always reference it when addressing queries to our representatives or authorized Leister Service Centers.

Example:



4.2 Scope of delivery (standard equipment in the case)

- 1 × UNIDRIVE 505 drive
- $1 \times wire brush$
- 1 × safety Instructions
- 1 × Quick Reference Guide
- 1 × hexagonal pin spanner, size 3

4.3 Overview of device parts



- 1. Power cord
- 2. Housing
- 3. Operating unit
- 4. Carrying handle, top
- 5. Handle, side
- 6. Hot-air blower
- 7. Drive/pressure roller
- 8. Welding nozzle 30 mm
- 9. Support rollers
- 10. Undercarriage
- 11. Height adjustment
- 12. Type plate with model designation and series marking
- 13. Guide notch

5. Settings on the UNIDRIVE 505

5.1 Adjusting the Welding Nozzle

Set welding direction and angle





The direction of the arrow on the welding nozzle (8) defines the welding direction.



Align the welding nozzle (8) parallel to the drive/pressure roller (7).





Align symmetrically to the drive/pressure roller (7) and guide notch (13).

6. Commissioning your UNIDRIVE 505

6.1 Work environment and safety

Safety precautions



Risk of death from electric shock due to dangerous electrical voltage

- The device is only to be connected to sockets and extension cables with a protective earth conductor.
- Protect the device from moisture and wet conditions.
- When used on a construction site, a residual current circuit breaker is mandatory.
- Prior to using the device for the first time, check the power cord, the plug, and the extension cable for
 electrical and mechanical damage.
- The device may only be opened by instructed, qualified personnel.



Danger of fire and explosion with improper use in the vicinity of flammable materials and explosive gases.

- Avoid overheating of the material.
- Never place the device near combustible materials and/or explosive gases.
- Never place the device close to combustible materials and/or explosive gases while it is running and/or hot.
- Only use the device on fireproof surfaces.



Risk of burns due to hot equipment parts and hot air jet

- Do not touch the heating tube and nozzle when they are hot.
- Always allow the device to cool down first.
- Never point the hot air flow at people or animals.



Risk of inadvertently becoming caught and being pulled in due to moving parts

- Do not touch any moving parts.
- Do not wear loose articles of clothing such as scarves or shawls.
- Tie up long hair and protect it with a head covering.



Health risk due to harmful fumes

- Welding PVC materials creates harmful hydrogen chloride vapors.
- Always ensure good ventilation of the workplace when working.
- Read the material safety data sheet from the manufacturer of the material and follow that company's instructions.
- Be careful not to burn the material during the welding process.



Risk of tripping due to power cord

 The power cord (1) must be able to move freely and must not hinder the user or third parties during work (trip hazard).



The local supply voltage must match the nominal voltage specified on the device.



Caution

• Comply with national statutory requirements regarding occupational safety (securing personnel or devices).



Caution

• Only use the device on a fireproof surface.

Risk of excessive physical strain when carrying and lifting the device

- The weight of your UNIDRIVE 505, including the transport box, is around 7.5 kg (4.5 kg without transport box).
- For transporting the semi-automatic hot-air welder, use the transport box included in the scope of delivery and carry the transport box using the handle provided for this purpose.
- Comply with applicable national regulations regarding the carrying or lifting of loads.



Danger of falling

- There is a risk of falling when welding near sloping edges and corners.
- In such cases, the appliance must be secured against falling as described below.

Anti-fall protection when working in areas where there is a fall hazard

Attach the semi-automatic hot-air welder by the **carrying handle (4)** to an anchorage device with horizontal guides (such as rail or rope safety systems) as protection against falling.

With respect to the safety chain, care must be taken to ensure that all of the safety elements (carabiner hooks, ropes) have a minimum load-carrying capacity of 7 kN in every direction that can be anticipated. It is mandatory to use locking carabiners (twist-lock or screw types) to hook the unit. You must properly install and check all connections of the safety chain according to the manufacturer's specifications.



Before each use and after unusual occurrences, the **carrying handle (4)** that is used for fastening the safety rope must be inspected by an individual with expertise in this area. The **carrying handle (4)** is not permitted to exhibit any cracks, corrosion, notches or other material faults.



Caution

- Secure the semi-automatic hot air welder with the carrying handle (4) only.
- Never fasten the hot wedge welding machine to single anchoring points which allow ropes to sag. Always set the connection equipment to the shortest length possible in order to eliminate any chance of falling over the edge of the parapet.







Caution

- An uncontrolled fall must be avoided under all circumstances, as the securing point on the device is not designed for the shock of a fall.
- Please do not hesitate to contact the manufacturer if anything is unclear during installation or operation.

Power cord and extension cable

- The nominal voltage specified on the device (see 🕮 Technical data [2]) must match the supply voltage.
- The **power cord** (1) must be able to move freely and must not hinder the user or third parties during work (trip hazard).
- The extension cables must be authorized for the utilization site (e.g., outdoors) and be marked accordingly. Take the necessary minimum cross-section for extension cables into account as required.

On-site generators for power supply

When using on-site generators as a power supply, please ensure that the on-site generators are grounded and equipped with residual-current circuit breakers.

For the nominal output of the power plants, the formula " $1.5-2 \times nominal output of the semi-automatic hot-air welder" applies.$

6.2 Operating readiness

Check the basic setting of the welding nozzle (8).

- Check whether the material to be welded is clean between the overlap and on the upper and lower sides.
- Check whether the material to be welded is stapled. Double-sided, continuous stitching over the entire seam length is vital. The material must not be able to move sideways.
- Afterwards, check whether the welding nozzle (8) and the drive/pressure roller (7) are clean.
- If necessary, position the optionally available welding plate (see Di Scope of delivery [4.2]).

See the how-to videos on Leister's YouTube channel





Tool resting position

- Place the semi-automatic hot-air welder on a horizontal and fireproof surface.
- The semi-automatic hot-air welder is placed on its back for the resting position (heating, Cool-down mode).



6.3 Starting the device

• Once you have prepared the working area and the semi-automatic hot-air welder in accordance with the description, connect the device to the mains voltage.



After connection, the **start screen** appears briefly on the display of the **operating unit (3)** with the version number of the current software release and the device designation.



If the appliance was able to cool down beforehand, a static display of the set values of the last welding parameters set follows (the preset welding parameters are displayed when the appliance is started up for the first time).

At this stage, the heating, blower and drive are switched off.

• Now switch on the heating (*Heating on/off* button, 16).

6.4 Welding sequence

Preparing for welding



As soon as you have switched on the heating, you will see a **dynamic display of the current air temperature** (setpoint and actual value). All welding parameters (welding speed, temperature and air volume) can be set.

- The drive motor starts automatically as soon as the heating is activated.
- Check whether the correct drive direction (left or right) is set and compare it with the direction on the nozzle to
 match the arrow so that it matches the arrow on the display (see 3 Switch drive direction [9.5]).
- Make sure that the welding temperature has been reached before commencing work (the heating-up time is -three to five minutes).
- Now carry out test welds in accordance with the welding instructions of the material manufacturer and/or national standards or regulations and inspect the results. Adjust the welding profile as needed.



Risk of inadvertently becoming caught and being pulled in due to moving parts

- Do not touch any moving parts.
- Do not wear loose articles of clothing such as scarves or shawls.
- Tie up long hair and protect it with a head covering.

Commencing welding

- Insert the welding nozzle (8) between the adjoining and continuously pre-stapled sealing sheets.
- Guide the semi-automatic hot-air welder by the **handles on the side (5)** or on the **upper carrying handle (4)** along the overlap and also observe the position of the **drive/pressure rollers (7)** and the **guide notch (13)**.
- The welding speed, air volume, and air temperature can be adjusted at any time during welding (see 🔊 Setting welding parameters [9.2]).

Finishing welding

• After welding, pull the semi-automatic hot-air welder (vertically) out of the adjoining sealing sheets.

6.5 Switching off the device



Use the *Heating On/Off button (16)* to switch off the heating, so the **welding nozzle (8)** cools down.

This will trigger the cool-down mode.

- The blower switches off automatically after approx. 6 minutes.
- Disconnect the **power cord (1)** from the mains.



- Wait until the device has cooled down.
- Check the **power cord (1)** and plug for electrical and/or mechanical damage.
- Use a wire brush to clean the welding nozzle (8).

7. Quick Guide UNIDRIVE 505



Observe the safety instructions and warnings in the individual sections of these operating instructions.

7.1 Switching on/Starting

- 1. Connect the plug to the mains voltage.
- Switch on the heating with the *Heating On/Off* button (16); wait 3-5 minutes until the desired temperature is reached.
- 3. Insert the **welding nozzle (8)** between the adjoining and continuously pre-stapled sheets.

7.2 Switching off

- 1. Pull the welding nozzle (8) (vertically) out of the adjoining sheets.
- 2. Switch off the heating with the *Heating On/Off* button (16) and wait until the cooling process has finished (around 5 minutes).
- 3. Disconnect the plug from the mains voltage.



8. Operating unit UNIDRIVE 505

8.1 Function buttons



- 15 Drive on/off button
- 16 Heating on/off button
- 17 Minus/Plus buttons
- 18 Confirm button

Function buttons

Symbol	Designation	Function
	Drive On/Off (15) button	Switches drive on and off
<u><u><u></u><u></u><u></u><u></u><u></u><u></u><u></u><u></u><u></u><u></u><u></u><u></u><u></u><u></u><u></u><u></u><u></u><u></u></u></u>	Heating On/Off (16) button	Switches heating on and off
J.	Blower symbol	No function
-+	Minus/Plus buttons (17)	Setting the required setpoint in in increments of 0.1m/min, 10 °C or 5%
\bigcirc	Confirm button (18)	Switches between the setpoints to be set

8.2 Display

The display is subdivided into four areas:



During operation, the setpoints of the welding parameters (drive in m/min or ft/min, temperature in degrees Celsius or Fahrenheit), air volume in percent and, if applicable, information notes are displayed.

Use the *Confirm* button (18) to switch between the welding parameters and adjust the values individually with the *Minus/Plus* buttons (17).

8.3 Display symbols of the status display (Display 20)

Symbol	Meaning
*	Symbol for Cool-down mode
	Symbol for warning note, warning message or error message Let the device cool down (see also 🕲 Warning and error messages [10])
¥	Indicates service required. Symbol for hardware error message. The device is no longer ready for operation. Please contact your authorized Leister sales and service partner. (Note the respective error code in Chapter 🕲 Warning and error messages [10]).

8.4 Display symbols for the welding speed (Display 21)



Actual and setpoint value of the welding speed The arrow in the display for the welding speed indicates the drive direction.

8.5 Display symbols for the welding temperature (Display 22)



Welding temperature too low, heat-up process.

Up arrow shows that the desired **higher temperature has** not yet been reached. The flashing number designates the currently achieved actual value (430); the value below (450) shows the setpoint of the individual setting.



Welding temperature too high, cool-down process.

Down arrow shows that the desired **lower temperature** has not yet been reached. The flashing value designates the currently achieved actual value (470); the value below (450) shows the setpoint of the individual setting.

8.6 Display symbols for the air volume (Display 23)

IDD %

Actual and setpoint value of the air volume

8.7 Status LED display

Heating

The LED on the *Heating On/Off* button (16) displays the condition of the heating.

LED status Heating On/Off (16)	Condition
LED off	Heating is switched off.
LED flashes green	Heating is switched on, temperature is outside tolerance
LED continuously green	Heating is switched on, temperature is within tolerance

Drive

The LED on the Drive On/Off (15) button displays the condition of the drive.

LED status Drive On/Off (15)	Condition
LED off	Drive is switched off
LED continuously green	Drive is switched on

Heating and drive If both LEDs of the *Heating on/off (16) and the Drive on/off* button (15) are flashing simultaneously, there is an error (see 🕲 Error message [10]).

9. Settings and functions of the UNIDRIVE 505 software

9.1 Setting the parameter units

The units for the welding speed and for the temperature can be adjusted by you.

Temperature:	°C	or	°F
Speed:	$\frac{m}{min}$	or	<u>ft</u> min



- Hold down the Drive On/Off (15) and Heating On/Off (16) buttons and connect the power cord to the power supply. <u>"UNIT"</u> then appears on the display.
- Press the Confirm (18) button to confirm and use the Plus/Minus (17) buttons to set the desired units.
- Press the Confirm (18) button to confirm and use the Plus/Minus (17) buttons to select <u>SAVE</u>. Press the Confirm (18) button to confirm; the units are then saved.

The device then restarts automatically.

9.2 Setting the welding parameters

You can regulate the set values of the three welding parameters individually, even during operation. During operation, the selected range automatically switches to the row **welding speed (21)** after 5 seconds.

Proceed as follows:



Select:

Select the desired set value for drive, temperature or air with the Confirm (18) button.

Representation:

The selected area is indicated by a bar at the side

Setting:

Use the *Minus/Plus* buttons (17) to adjust the selected set value to match your requirements.

9.3 Cool-down mode

The heating is switched off during the cool down process. The set values cannot be changed during the cool down process.

If the air temperature is more than 60 $^{\rm o}{\rm C}$ when the device is switched on, the device switches automatically to Cool-down mode.

The cool-down process is finished when the air temperature is less than 100 °C for 2 minutes.

If you want to switch the heating on again, you must press the Heating On/Off button (16).

9.4 Monitoring welding parameters during runtime

Welding speed, air temperature and air volume are monitored continuously. If an actual value deviates from the set value according to the individual settings, this is indicated in the working display (see @ Display symbols of welding temperature [8.5]).

9.5 Switch drive direction

Hold down the Drive On/Off button (15) and the Minus or Plus button (17) for three seconds.

- Minus button clockwise
- Plus button counterclockwise

The direction of the arrow changes in the Welding speed display (21).

10. UNIDRIVE 505 warning and error messages

Error messages are shown on the display of the **operating unit (3)**.

If an error message appears, you cannot continue working.

The heating is switched off automatically and the drive is blocked. The corresponding error codes are displayed immediately on the display of the **operating unit (3)**. The first four digits indicate the error group. The second four digits indicate the detailed error.

Example:

Error:



Warning:



Error group	Description	Measures
0001	Electronics temperature measurement	Temperature >90 °C Let the device cool down
0004	Supply voltage	Connect the device to a different power socket If the error is still displayed, contact Leister Sales and Service Partners.
0008	Thermoelement/heating element	Contact Leister Sales and Service Partners
0100	Blower motor	Contact Leister Sales and Service Partners
0400	Drive motor	Contact Leister Sales and Service Partners

11. Frequently asked questions, causes and actions UNIDRIVE 505

The device switches on automatically after the blowers have been switched on:

If the air temperature is higher than 100 °C when the device is switched on – which can occur, for example, if the
device is disconnected from the power supply without the cooling process – the device automatically switches to
cool-down mode. The cool-down process is finished when the air temperature is less than 100 °C for 2 minutes.

Welding result of deficient quality:

- Check drive speed, welding temperature and air volume.
- Clean the welding nozzle (8) with a wire brush (see D Maintenance [12])
- Welding nozzle (8) set incorrectly (see 🕮 Setting the welding nozzles [5.1])
- Incorrect drive direction
- Incorrect device operation, contact salessupport@leister.com

After 5 minutes at the most, the set welding temperature has still not been reached:

- Check the supply voltage
- Reduce the air volume
- Check heating element

12. Maintenance



Risk of death from electric shock due to dangerous electrical voltage

- The device is only to be connected to sockets and extension cables with a protective earth conductor.
- Protect the device from moisture and wet conditions.
- When used on a construction site, a residual current circuit breaker is mandatory.
- Prior to using the device for the first time, check the power cord, the plug, and the extension cable for electrical and mechanical damage.
- The device may only be opened by instructed, qualified personnel.
- **Repairs** should only be carried out by **authorized service points**. Restricted to use with **original** accessories and spare parts.



Danger of fire and explosion with improper use in the vicinity of flammable materials and explosive gases.
Avoid overheating of the material.

- Never place the device near combustible materials and/or explosive gases.
- Never place the device close to combustible materials and/or explosive gases while it is running and/or hot.
- Only use the device on fireproof surfaces.
- **Repairs** should only be carried out by **authorized service points**. Restricted to use with **original** accessories and spare parts.

Risk of burns due to hot equipment parts and hot air jet

- Do not touch the heating tube and nozzle when they are hot.
- Always allow the device to cool down first.
- Never point the hot air flow at people or animals.
- **Repairs** should only be carried out by **authorized service points**. Restricted to use with **original** accessories and spare parts.



- The device must be cooled down for maintenance. The power cord must have been disconnected from the power supply.
- There may be a risk of injury from sharp edges due to possible material damage to the device due to corrosion or wear.
- You can extend the service life of your appliance by following the maintenance intervals.
- If the maintenance intervals are not observed, reliable welding is not guaranteed.
- Repairs must only be carried out by authorized Leister service centers.
- Do not use any aggressive cleaning agents or solvents to clean the device.
- Only use original Leister accessories.
- For more information, please visit leister.com.

12.1 Preventive maintenance

Time period (operating hours)	Monitoring and maintenance work	Spare parts	Tools
After using the device	Cleaning the welding nozzle		Wire brush
After using the device	Visual inspection of loose and missing parts, cracks		
Depending on use	Cleaning the device		Cloths, compressed air
Depending on use	Adjusting the nozzle		Hexagon socket
Depending on use	Pressure roller check	Replacement silicone roller	Hexagon socket

13. Accessories

For more information please visit leister.com.

14. Service and repair

Repairs shall be performed exclusively by authorized Leister sales and service partners. You will find the address of your authorized Leister sales and service partner on the last page of these operating instructions.

For more information please visit leister.com.

15. Training

The Leister Academy and its authorised Leister sales and service partners offer welding courses as well as product and application training.

For more information please visit leister.com.

16. Declaration of Conformity

Leister Technologies AG, Galileo-Strasse 10, 6056 Kaegiswil, Switzerland confirms that this product fulfills the requirements of the following EU Guidelines in the models that we have made available for purchase.

Directives: 2006/42/EC, 2014/30/EU, 2011/65/EU

Harmonized standards:

EN ISO 12100, EN 60335-1, EN 60335-2-45, EN 62233, EN 55014-1, EN 55014-2, EN 61000-3-2, EN 61000-3-3, EN 61000-6-2, EN IEC 63000

Name of authorized representative for documentation: Thomas Schäfer, Manager Product Conformity

Kaegiswil, 02/12/2025

Bruns was WyR

Bruno von Wyl, CTO

1.11/1

Pascal Bösch, VP R&D

17. Disposal



Do not dispose of electrical equipment with household refuse!

Electrical equipment, accessories and packaging should be recycled in an environmentally friendly manner. When you are disposing of our products, please observe the national and local regulations.

Warranty

- The guarantee or warranty rights granted for this device by the direct distribution partner/salesperson apply from
 the date of purchase. In the event of a guarantee or warranty claim (verification by invoice or delivery note), manufacturing or processing errors will be rectified by the sales partner through replacement delivery or repair. Heating
 elements are excluded from warranty obligations or guarantees.
- Other guarantee or warranty claims are excluded within the framework of mandatory law.
- Damage resulting from natural wear, overload, or improper handling is excluded from the warranty.
- Devices that have been converted or modified by the purchaser are not covered by any warranty or guarantee.
- Only use original Leister spare parts and accessories; otherwise, any warranty or guarantee claims will be invalidated.

♥ Sales and Service Partners



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