

LEISTER Unifloor E

Automatic hot air welding machine

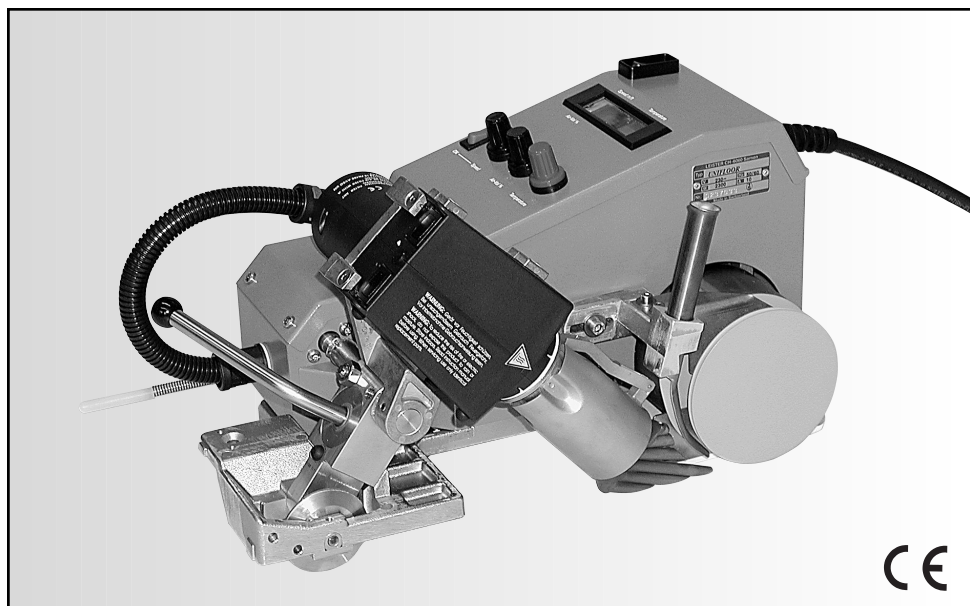


Please read the operating instructions carefully before use and keep for future reference.

APPLICATION

LEISTER Unifloor E Flooring Automatic Welding Machine

- Welding of PVC coverings and melt welding of linoleum floor coverings.





WARNING



Danger! Unplug the tool before opening it, as live components and connections are exposed.



Incorrect use of hot air tools can present a **fire and explosion hazard**, particularly in the proximity of flammable materials and explosive gases.



Danger of getting burned! Do not touch the heater tube and nozzle when they are hot. Let the tool cool down. Do not point the hot air flow in the direction of people or animals.



Only connect the tool to a **receptacle with protective earth conductor**. Any disconnection of the protective earth conductor, in or outside the tool is dangerous!
Only use extension lead with protective earth conductor.



CAUTION



The **rated voltage** stated on the tool must correspond with the mains voltage.



For personal protection, we strongly recommend the tool to be connected to an **RCCB** (Residual Current Circuit Breaker) before using it on construction sites.



The tool must be operated **under supervision**. Heat can ignite flammable materials which are not in view.



Protect the tool **from damp and wet**.

Approval Marks



TECHNICAL DATA

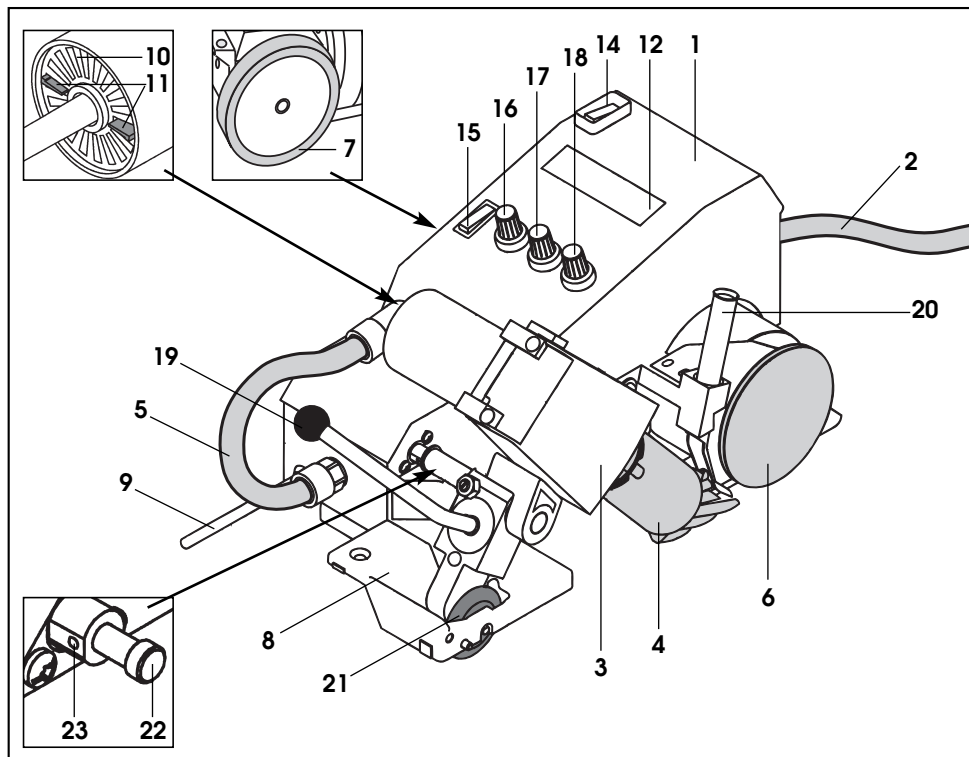
Protection Class I



CCA certified

		230 ★	120 ★	100 ★
Voltage	V~	50 / 60	50 / 60	50 / 60
Frequency	Hz	2300	1800	1500
Capacity	W	20 – 620	20 – 620	20 – 620
Temperature	°C	max. 300	max. 250	max. 250
Air flow (50-100%)	l/min.	1.0 – 7.5	1.0 – 7.5	1.0 – 7.5
Drive speed	m/min.	67	65	65
Noise emission level	L _{PA} (dB)	420×270×215	420×270×215	420×270×215
Dimensions	mm	14	14	14
Weight	kg			

★ Mains voltage is not reversible



Main components

1. Housing
2. Mains cable
3. Hot air blower
4. Welding nozzle
5. Connection hose
6. Welding rod pressure roller
7. Drive roller
8. Chassis
9. Wall switch-off
10. Air filter
11. Manual air vane
12. Display

Operating components

14. Main switch
15. Drive switch
16. Potentiometer for welding speed
17. Potentiometer for air flow
18. Potentiometer for air temperature
19. Swivel lever

Steering equipment

20. Welding rod guide tube
21. Guide roller

Automatic drive

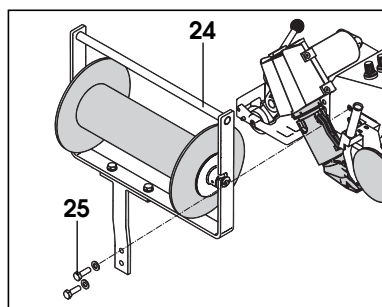
22. Switch pin
23. Set screw

Operational condition: Accessories

- If the **welding rod de-reeler (24)** and **lifting device (26)** are available:
 - Attach **welding rod de-reeler (24)** to the Unifloor E tool using **cheese head screw M8 × 20 (25)**.
 - Attach **lifting device (26)** to the tool using **socket head cap screw M6 × 30 (27)**.

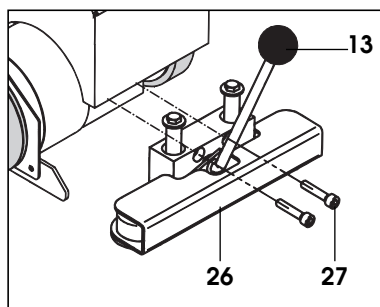
Accessories

Welding rod de-reeler



Accessories

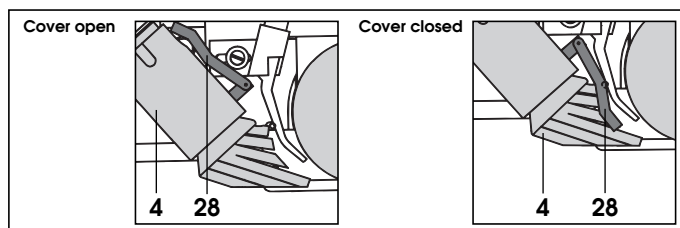
Lifting device



Operating condition

- Check the nozzle setting: the nozzle must be positioned at a distance of about 2 - 3 mm from the floor cover and welding rod.
- When welding linoleum, lower the **cover (28)** on to the **welding nozzle (4)** (see Detail A).

Detail A



• Automatic drive

Automatic drive is adjusted as required, depending on nozzle position, by means of **switch pin (22)** and **set screw (23)**.

- Connect tool to the mains. Mains voltage must correspond with the voltage rating stated on the tool.
- Switch on tool using **main switch (14)**. **Hot air blower (3)** starts automatically.

• Important: under voltage

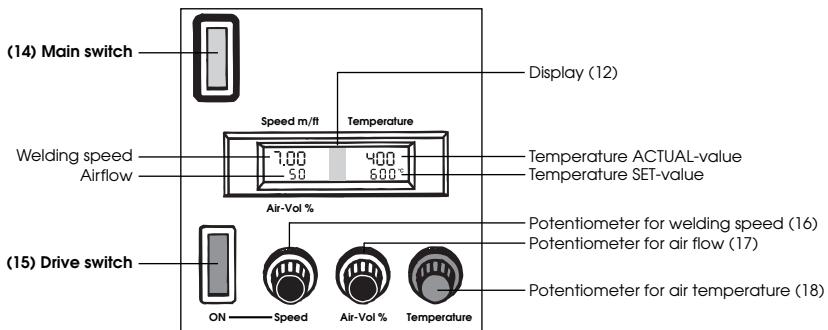
If the maximum temperature is not reached, reduce the airflow by means of the **manual air vane (11)** and **potentiometer for air flow (17)**.

Tool positioning

- Swivel **hot air blower (3)**, using **swivel lever (19)** up to the stop.
- Operate **lifting device (26)** by means of **lifting device lever (13)** so that **welding rod pressure roller (6)** and **drive roller (7)** are at no-load.
- Position automatic welding machine over the joint to be welded.
- Insert welding rod through **welding rod guide tube (20)** and pull under the **welding rod pressure roller (6)** and place it in the joint.
- The **guide roller (21)** must run in the welding joint.
- Activate **lifting device (26)** by means of **lifting device lever (13)** so that the automatic welding machine is ready to start.

Welding parameters

- Set **potentiometer for welding speed (16)** to required value.
- Set **potentiometer for air flow (17)** to required value.
- Set **potentiometer for air temperature (18)** to required value.
- The pressure derives from the actual weight of the automatic hot air welding machine.



Welding procedure

- Swivel **hot air blower (3)** up to the stop using **swivel lever (19)**. The welding process starts automatically via automatic drive.
- If necessary, the tool can be started manually by means of the **drive switch (15)**.
- Check the welding process:
 - Guide roller (21) must run in the joint.
 - The welding bead must be visible. Adjust welding parameters using the **potentiometers (16), (17) and (18)** if necessary.
- **Wall switch-off (9)**
When contact with the wall, is made drive and heater are switched off automatically.
- After finishing welding swing up the **hot air blower (3)** to the stop using **swivel lever (19)**. The welding process stops automatically.
- After completing welding work, set **potentiometer for air temperature (18)** to zero so that **hot air blower (3)** cools down.
- Switch off the tool at the **main switch (14)**.
- Disconnect the tool from the mains.

ACCESSORIES

- Only LEISTER accessories should be used.
- **Welding rod de-reeler (24)**
- **Lifting device (26)**

TRAINING

- LEISTER Process Technologies and its authorised Service Centres offer free welding courses and training.

MAINTENANCE

- Clean the tool's **air filter (10)** with a brush when dirty.
- Clean **welding nozzle (4)** with wire brush.
- Check **mains cable (2)** and plug for electrical and mechanical damage.

SERVICE AND REPAIR

- Have your Service Centre check the motor brushes after about 1,000 hours of operation.
- Repairs should only be carried out by authorised **LEISTER Service Centres**. They guarantee a correct and reliable **repair service within 24 hours** using original spare parts in accordance with the circuit diagrams and spare parts lists.

GUARANTEE AND LIABILITY

- Guarantee and liability are in accordance with the guarantee certificate as well as with the currently valid general business and sales conditions.
- LEISTER Process Technologies rejects any guarantee claims for tools which are not in their original condition. The tools must never be altered or changed.

Technical data and specifications are subject to change without prior notice.

Your authorized Service Centre is:

Service Record LEISTER Unifloor E

This document should be handed to the authorised LEISTER Service Center for updating when repaired or serviced. This document is to be retained and kept by the owner of the tool.

Technical Data**Automatic hot air welding machine Type****Order Number****Serial Number****Rated Voltage** **V****Rated Power** **W****Sold** **Date****Service**

1. Date Service Centre Signature

2. Date Service Centre Signature

3. Date Service Centre Signature

4. Date Service Centre Signature

5. Date Service Centre Signature

6. Date Service Centre Signature

Repair

1. Date Service Centre Signature

2. Date Service Centre Signature

3. Date Service Centre Signature

