

LEISTER

PLASTIC WELDING

Plastic Fabrication



Extrusion and hot-air hand welders

The right choice for the specialist

 / swiss
made





Dear Leister customers

The selection of machines and equipment greatly influences the quality and success of your work. That is why we offer solutions that you can always count on and with which you are guaranteed to be able generate added value.

Our goal is to exceed your expectations. All of our devices and machines are designed and produced in Switzerland, because for us, quality and innovation are the highest priority. We have more than 70 years of experience in the fields of plastic welding and industrial process heat applications, and are constantly expanding this. Through direct contact with you in your workshop, at the construction site and through social media, we collect the necessary input that we then incorporate into the next generation of devices. Our engineers and designers combine your ideas with the latest technology to create unique products that meet your requirements. Here, we place particular importance on functionality, ergonomics and durability. That is why you can count on a reliable welder in all locations and environments.

We maintain a global and close-knit service and distribution network which enables us to serve you quickly and easily. Our expert distributors and own associations ensure that you can access our services across the globe.

In the following pages, see for yourself how our extensive product range will be able to support you in your work. You will also find a great deal of useful information on plastic welding in the brochure. Motivated by our principle, "Leister. We know how," we are eager to share our experience with you in order to make your work easier.

I hope you enjoy reading our brochure!

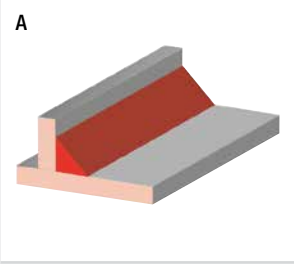
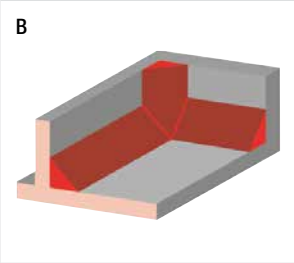
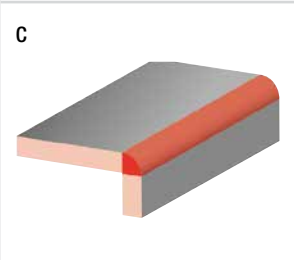
Reto Britschgi
Product Manager Plastic Fabrication

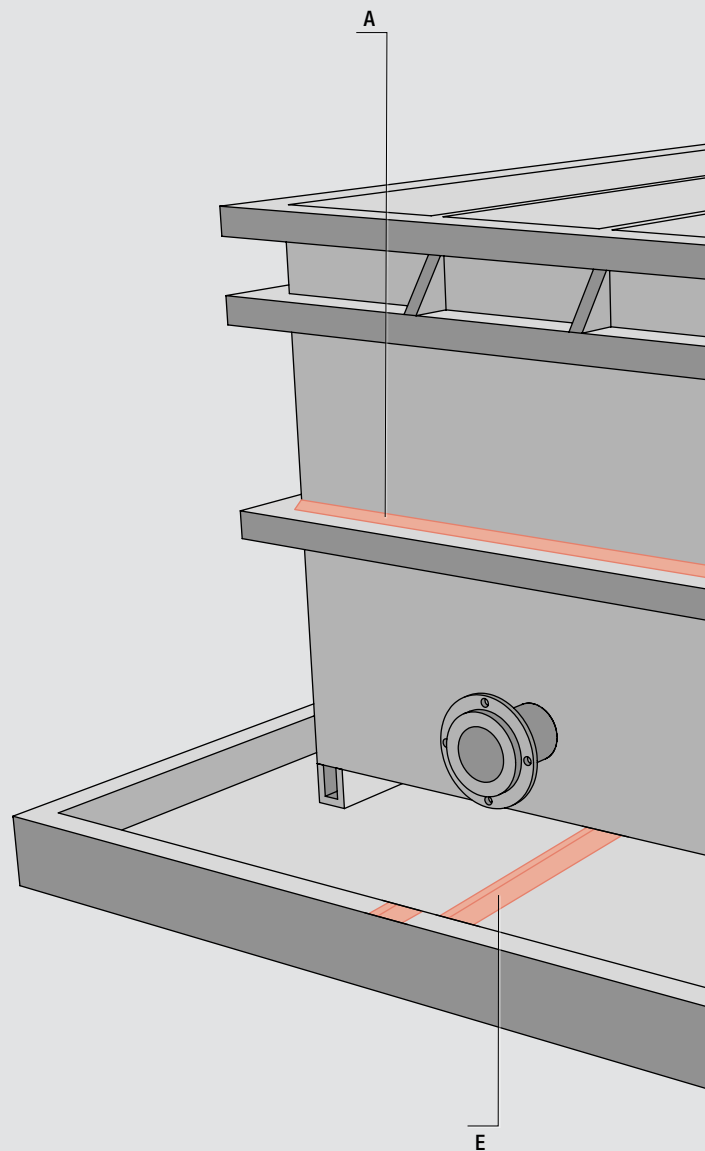
Plastic welding with Leister

With plastic welding, workpieces made of thermoplastic are joined inseparably to one another using a combination of thermal energy and pressure. Central factors are welding speed and the length of the welding process. Plastic welding is used in many areas: For the processing of tarpaulins and plastic sealing sheets, on the roof, in earthworks, hydraulic engineering or tunnel construction, for floor coverings, in vehicle repairs and in equipment construction.

Know-how

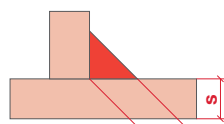
Welding seam geometries galvanic tank

	<p>A</p> <p>Fillet weld The fillet weld is one of the most frequently-use seam geometries. It is produced by welding two workpieces that meet in a T-joint.</p>
	<p>B</p> <p>Interior corner seam Interior corner seams are generally used on difficult-to-reach locations. Free forms and spline-shaped weld seam geometries are welded most efficiently like this.</p>
	<p>C</p> <p>Corner seam appearance The outer corner seam is a fillet weld in which the weld seam runs along the edge of the workpieces which are standing together. Consequently, the weld is made along the outer longitudinal side (edge).</p>

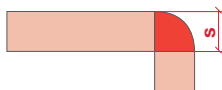


Possibilities of welding seams

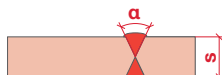
a = seam size s = material thickness α = milling angle



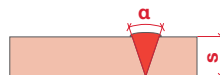
Fillet welding seam
 $a = s \cdot 0.7$



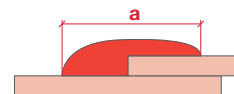
Corner outside seam



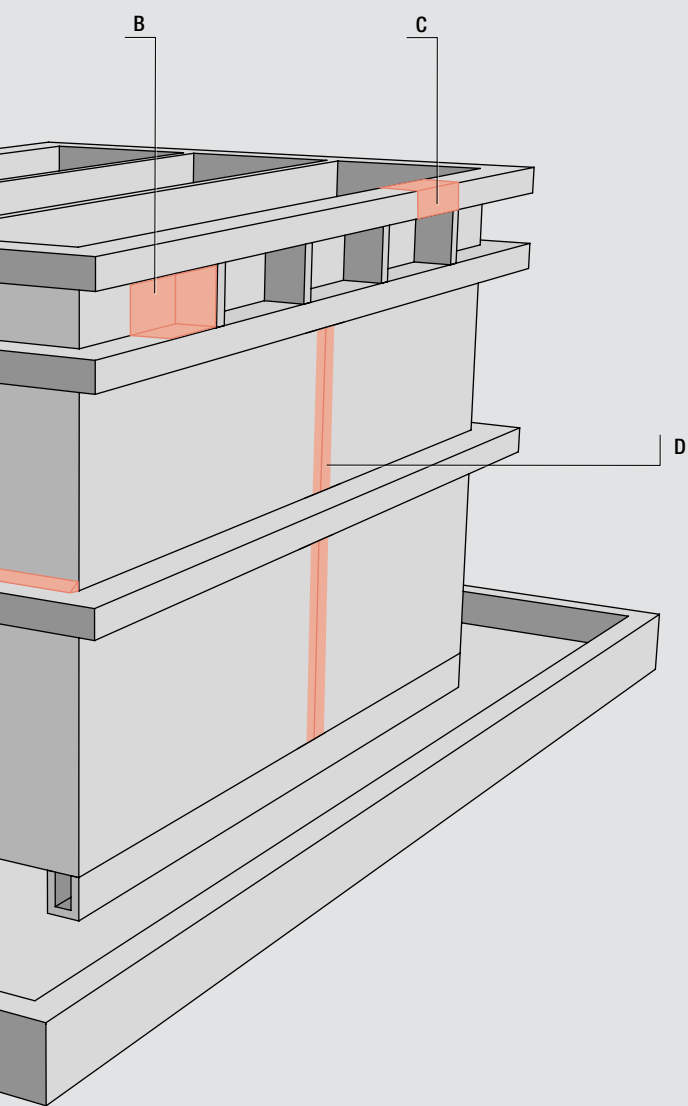
X-seam
 $s = 10 - 40 \text{ mm} = \alpha 60^\circ$
 $s = 50 - 60 \text{ mm} = \alpha 50^\circ$



V-seam
 $s = 5 - 20 \text{ mm} = \alpha 60^\circ$
 $s = 25 - 30 \text{ mm} = \alpha 50^\circ$

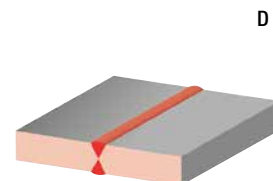


Overlap seam



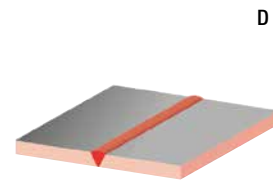
X-seam

The double-V seam is also known as an X-seam. It is a type of butt weld and consists of a combination of two V-seams on each of the two sides of the components to be joined.



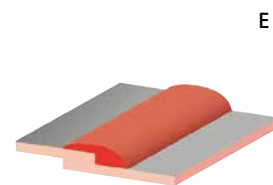
V-seam

In order to achieve the V-shaped angle that is typical for the V-seam, the workpieces are either beveled or positioned at an appropriate angle to each other.



Lap seam

Lap seams are mainly used for plastic sheets. Here, the sheets are arranged on top of each other and the weld seam is laid on the upper exposed material edge.





FUSION 2, compact and powerful

know-how

Thermal joining of plastics

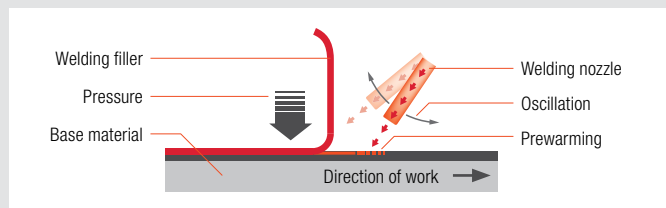
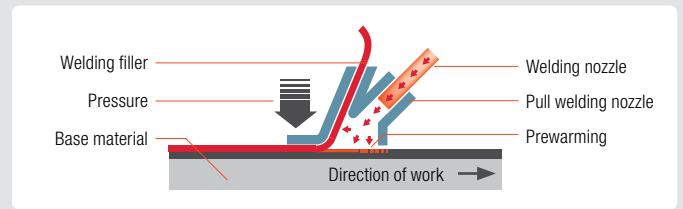
Plastic welding requires a correspondence between the three welding parameters temperature, pressure and speed. In contrast to other joining methods, welding can achieve high resiliency and a strong, homogeneous welding seam. Plastic compounds are extremely robust and perfectly sealed when processed correctly. They can also be repaired without a loss of strength.

Hot gas welding with the torch separate from filler rod (WF)

Hot gas welding with the torch separate from filler rod is used primarily for areas that are difficult to access and for short seams. This welding process is preferred for processing amorphous plastics, in particular PVC. Especially with manual welding, pay special attention to maintaining uniform pressure and constant speed.

During welding, press the wire by hand vertically onto the groove. The force applied depends on the base material chosen and the dimension of the welding wire. Apply the heat flowing out of the tubular nozzle alternately to the welding wire and to the joint in an oscillating motion in the direction of welding until the end of the seam is reached. When realized correctly with the right temperature and appropriate pressure, a welding seam is formed on both sides of the weld bead in the form of a uniform double bead.

Hold the welder with one hand, and with the other hand, press the welding wire into the nozzle. The nozzle design divides the hot gas, which in this way heats both the base material and the fill material. The latter is led through a preheating chamber and plasticized shortly before the two materials meet. The presser flap on the end of the nozzle is responsible for the welding force. You can finish the resulting weld seam using a suitable scraper after the welding process.



Hot gas extrusion welding (WE)

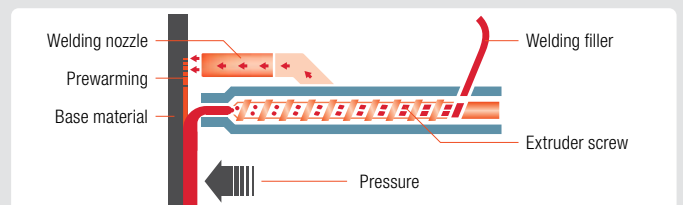
Hot gas extrusion welding is preferred over high-speed hot gas welding for wall thicknesses from about 6 mm. With extrusion welding, shorter working times, higher strength and lower internal stress is expected compared to manual welding. This leads to higher process reliability and greater efficiency.

For this, you require a welding shoe corresponding to the welding geometry and a welding filler consisting of the same material as the base material, which is plasticized in the extruder.

First, put joining surfaces into the thermoplastic state using hot air. Immediately press the extrudate onto the surfaces or into the joint using the welding shoe. Depending on the working position, you should apply different intensities of pressure. Welding speed is determined by the quantity of extrudate and by the dimensions of the weld seam. In addition, it must correspond to the prewarming of the base material.

High-speed hot gas welding (WZ)

High-speed hot gas welding requires a high-speed welding nozzle that corresponds to the shape of the fill material. The process is faster, more uniform, and consequently more efficient than pendulum welding. Furthermore, larger cross-sectional surfaces of the welding wire can be processed in one pass. This leads to less residual stress and thus to a lower welding effort.



Welding parameters for hand welding

Based on DVS 2207-3

Welding Process	Materials	Abbreviations	Hot gas temperature ¹⁾ °C	Hot gas volume flow ²⁾ l/min	Welding speed ³⁾ mm/min	Welding force (N) with wire ø	
						3mm	4mm
Free hand welding (WF)	High-density polyethylene	PE-HD ⁴⁾	300 ... 320	40 ... 50	70 ... 90	8 ... 10	20 ... 25
	Polypropylene, Types 1, 2, 3	PP-H; PP-B; PP-R	305 ... 315	40 ... 50	60 ... 85	8 ... 10	20 ... 25
	Unplasticised polyvinyl chloride	PVC-U	330 ... 350	40 ... 50	110 ... 170	8 ... 10	20 ... 25
	Chlorinated polyvinyl chloride	PVC-C	340 ... 360	40 ... 50	55 ... 85	15 ... 20	20 ... 25
	Polyvinylidene fluoride	PVDF	350 ... 370	40 ... 50	45 ... 50	15 ... 20	25 ... 30
	Acrylonitrile butadiene styrene	ABS ⁶⁾	350	N/A	N/A	N/A	N/A
	Polycarbonate	PC ⁶⁾	350	N/A	N/A	N/A	N/A
	Polyamide	PA ⁶⁾	400	N/A	N/A	N/A	N/A
	Polybutylene terephthalate	PBT ⁶⁾	350	N/A	N/A	N/A	N/A
	Low-density polyethylene	PE-LD ⁶⁾	270	N/A	N/A	N/A	N/A
	Polyurethane	PUR (Thermoplast) ⁶⁾	300	N/A	N/A	N/A	N/A
	XENOY	XENOY PC/PBTB ⁶⁾	350	N/A	N/A	N/A	N/A
	Plasticised polyvinyl chloride	PVC-P ⁶⁾	350	N/A	N/A	N/A	N/A
	Polyethylene terephthalate glycol-modified	PETG ⁶⁾	200 ... 215	N/A	N/A	N/A	N/A
Draw welding (WZ)	High density polyethylene	PE-HD	300 ... 340	45 ... 55	250 ... 350	15 ... 20	25 ... 35
	Polypropylene, Types 1, 2, 3	PP-H; PP-B; PP-R	300 ... 340	45 ... 55	250 ... 350	15 ... 20	25 ... 35
	Unplasticised polyvinyl chloride	PVC-U	350 ... 370	45 ... 55	250 ... 350	15 ... 20	25 ... 35
	Chlorinated polyvinyl chloride	PVC-C	370 ... 390	45 ... 55	180 ... 220	15 ... 25	30 ... 35
	Polyvinylidene fluoride	PVDF	365 ... 385	45 ... 55	200 ... 250	15 ... 25	30 ... 35
	Ethylene Chloro Tri Fluoro Ethylene	E/CTFE ⁵⁾	350 ... 380 ⁵⁾	50 ... 60 ⁵⁾	220 ... 250	10 ... 15	N/A
	Fluorinated ethylene propylene	FEP	380 ... 390	50 ... 60	60 ... 80	10 ... 15	N/A
	Tetrafluorethylen Perfluormethylvinylether	MFA	395 ... 405	50 ... 60	60 ... 80	10 ... 15	N/A
	Perfluoroalkoxy alkanes	PFA	400 ... 410	50 ... 60	70	10 ... 15	N/A

¹⁾ Measured 5mm in the nozzle, in the centre of the nozzle opening.

²⁾ Drawn-in cold air volume at the ambient pressure.

³⁾ Depending on the welding filler material diameter and the welding groove geometry.

⁴⁾ PE 63, PE 80, PE 100

⁵⁾ Nitrogene recommended

⁶⁾ LEISTER empiric parameters

Please note:

The indicated welding parameter may vary depending on the ambient temperature and the material configuration.

Test welds need to be done and the parameter aligned accordingly! Leister takes no responsibility for poor quality welding!

Welding parameters for extrusion welding

Based on DVS 2207-4

Welding Process	Materials	Abbreviations	Material temperature ¹⁾ °C	Hot gas temperature ²⁾ °C	Hot gas volume flow ³⁾ l/min	Welding speed ⁵⁾ mm/min
Extrusion welding (WE)	High-density polyethylene	PE-HD ⁴⁾	210–230	250–300	150–400	200–350
	Polypropylene, Types 1, 2, 3	PP-H; PP-B; PP-R	210–240	250–300	150–400	200–350
	Unplasticised polyvinyl chloride	PVC-U	190–200	330–360	150–400	200–350
	Impact resistant polyvinyl chloride	PVC-HI	170–180	280–340	150–400	200–350
	Chlorinated polyvinyl chloride	PVC-C	195–210	300–360	150–400	200–350
	Polyvinylidene fluoride	PVDF	240–260	280–350	150–400	200–350
	Polyamide 6 ⁶⁾	PA 6	280	315	150–400	200–350
	Polycarbonate ⁶⁾	PC	270	315	270	200–350
	Acrylonitrile butadiene styrene ⁶⁾	ABS	265	300	150	200–350
	Polystyrene ⁶⁾	PS	245	280	150–400	200–350
	Polypropylen Athylen Propylen Terpolymer ⁶⁾	PP-EPDM	200–230	200–290	150–400	200–350
	Polyurethane (Thermoplast) ^{6) 7)}	PUR	180	260–300	150–400	200–350

¹⁾ Measured with an insert thermometer at the extrudate outlet of the hand extruder.

²⁾ Measured 5mm in the nozzle, in the centre of the nozzle opening.

³⁾ Drawn-in cold air volume at the ambient pressure.

⁴⁾ PE 63, PE 80, PE 100

⁵⁾ Cold air intake volume at ambient pressure, depending on the output volume.

⁶⁾ LEISTER empiric parameters

⁷⁾ Welding rod has to be predried

Please note:

The indicated welding parameter may vary depending on the ambient temperature and the material configuration.

Test welds need to be done and the parameter aligned accordingly! Leister takes no responsibility for poor quality welding!

Know-how

Welding errors

In addition to a failure to adhere to the welding parameters, the following errors can lead to cavities, vacuoles and poor weld quality:

- Excessively high temperature
- Residual moisture in the welding filler
- Excessively high air humidity
- Wet hands
- Excessively cold welding shoe
- Low-quality plastic



Rough surfaces on the seam can therefore be because...

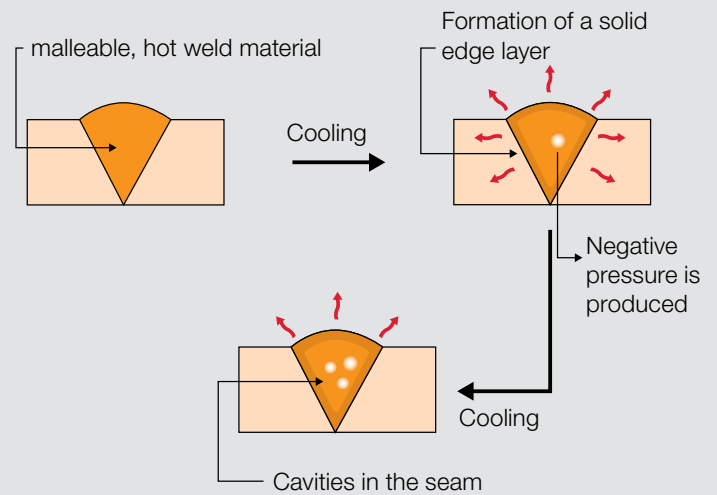
- ...the welding shoe is too short.
- ...the welding shoe is too cold.
- ...the surface over which the welding shoe glides is too rough.



Bad example

Base material and welding filler made of polyolefins can absorb moisture. The thicker the seam, the more frequently these phenomena occur. For this reason, you should store materials in a dry place and in their original packaging. You should avoid temperature differences between the welding parts to prevent the formation of condensation. Very thick welding seams must be welded in several work steps.

Vacuoles are caused by the excessively fast cooling of large weld seam cross-sections.



Good example

Fields of application

Hot gas welding with the torch separate from filler rod, high-speed hot gas welding and hot gas extrusion welding are used in many areas.

General tank construction

Plastic is preferred for producing receptacles and tanks. Depending on the storage medium, they have significant advantages over metallic materials.

Galvanic

Galvanic processes are usually carried out using chemicals. The baths must also be resistant to thermal and electrical influences.

Water management

Fresh water and service water infrastructures place high demands on hygiene and corrosion. Thermoplastics offer stable behavior in this respect.

Ventilation

Ventilation systems in industrial environments often transport aggressive media. A long-term solution is only possible with the right plastic.

Maritime Industry

Boats, rafts and floating docks made of polyolefins are positively buoyant by nature, extremely robust and resistant to salt water.

Aquaculture, greenhouse beds

Aquaculture and greenhouses are very demanding in terms of microbes, fungi and chemical influences. Containers and pipes must be leaktight and capable of being sterilized.

Pipeline construction

Polyethylene is the preferred material for unpressurized pipelines and for jacket tubes for long-distance pipelines. It is very durable against mechanical stress and can be processed extremely flexibly.

Plastic repair

Expertly performed repairs on thermoplastics restore 100% of the original function.



Storage tanks made of polyethylene



Galvanic bath made of polypropylene
© Collini collini.eu



Working boats mad of polypropylene



WELDPLAST S2



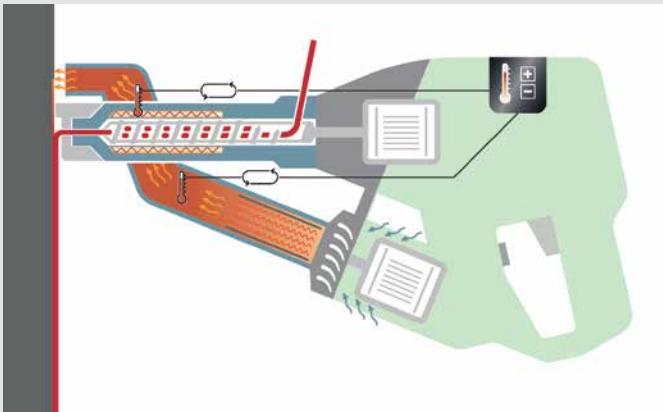
FUSION 3 C

WELDPLAST - Closed loop system

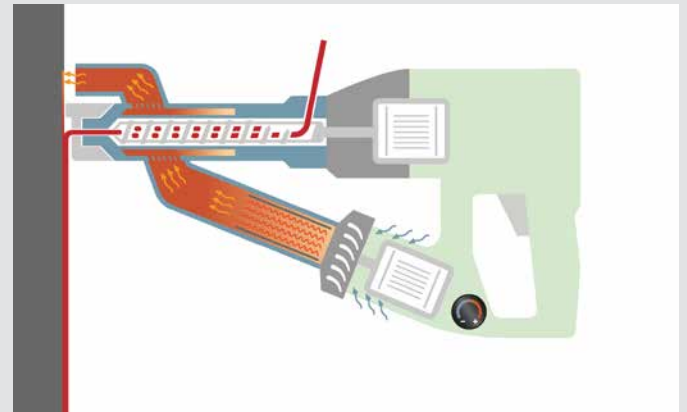
- Closed-loop control
- Little welding experience required
- Integrated display and temperature probe
- Precise temperature independent of environmental factors or quality of voltage source -> process reliability
- DVS-compliant

FUSION - Open loop system

- Open-loop control
- Requires more welding experience
- Neither display nor temperature probe
- Temperature depends on environmental factors and voltage source

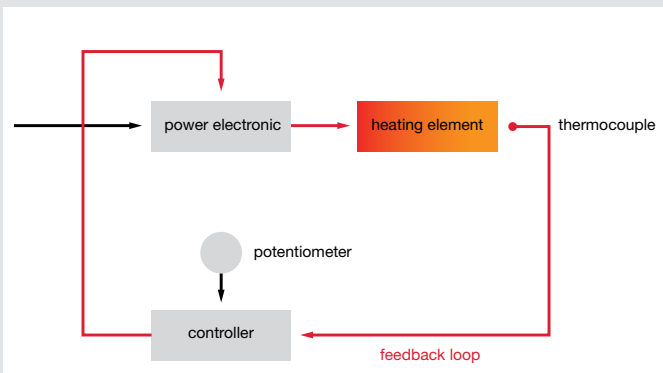


WELDPLAST

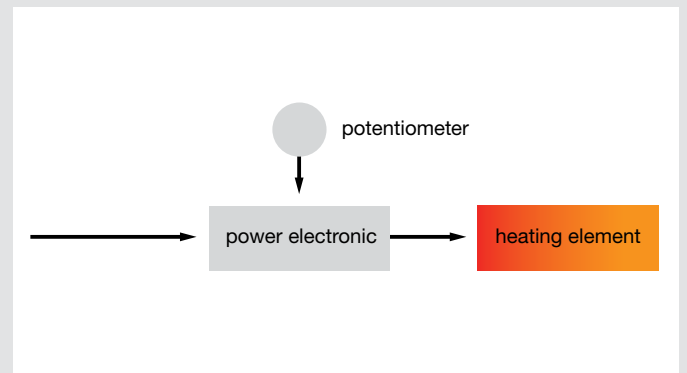


FUSION

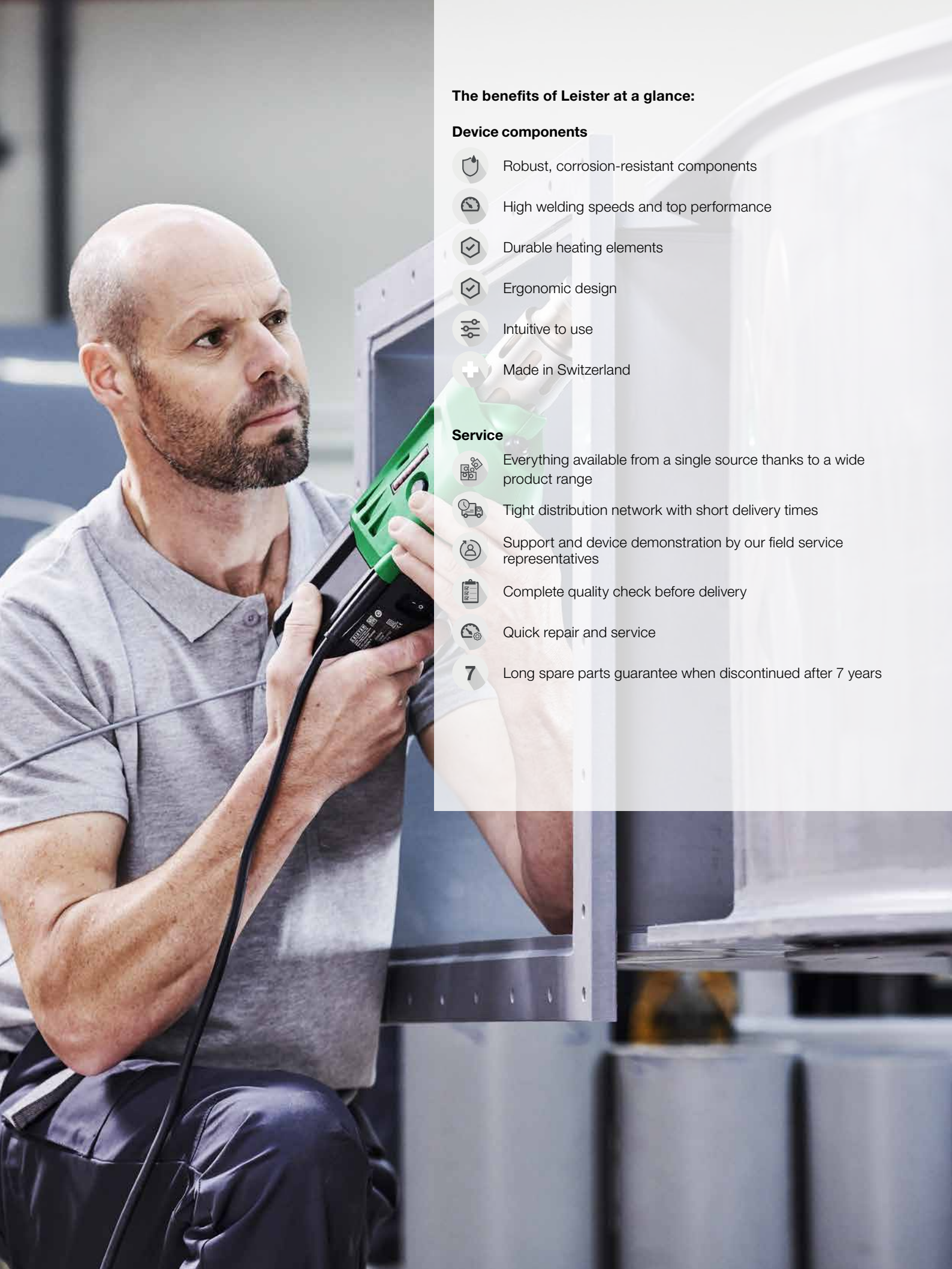
Closed loop system



Open loop system















The benefits of Leister at a glance:

Device components

-  Robust, corrosion-resistant components
-  High welding speeds and top performance
-  Durable heating elements
-  Ergonomic design
-  Intuitive to use
-  Made in Switzerland

Service

-  Everything available from a single source thanks to a wide product range
-  Tight distribution network with short delivery times
-  Support and device demonstration by our field service representatives
-  Complete quality check before delivery
-  Quick repair and service
-  7 Long spare parts guarantee when discontinued after 7 years



Air purification system, Spain. Material: HD-PE



The Wave House, San Diego. Material: PVC



Electroplating tank, Turkey. Material: PP

Plastic Fabrication

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Hot-Air Hand Tools

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The right tool for every application

LEISTER hand extruders differ in their method of process control, output volume and design. To achieve optimal welding results, it is important to choose the right tool. Decisive selection criteria are the plastics to be processed, the thickness of the welding material, the product requirements and the welder's expertise. The following two tables serve as a selection guide. For more detailed information, please contact your LEISTER sales partner.

Product comparison

	Digitally regulated extrusion welders				Air heated extrusion welders			
								
Device type	WELDPLAST 600	WELDPLAST S4	WELDPLAST S2	WELDPLAST S1	FUSION 3	FUSION 3C	FUSION 2	FUSION 1
Output (HDPE) kg/hr	3.9 – 6	1.5 – 4	0.6 – 2.3	0.2 – 0.8	1.8 – 3.6	1.8 – 3.6	1.3 – 1.8	0.2 – 0.8
Material	HD-PE, PP	HD-PE, PP	HD-PE, PP, PVC	PE, PP, PVC, etc.	HD-PE, PP	HD-PE, PP	HD-PE, PP	PE, PP
Wall thickness mm	20 – 40	15 – 25	10 – 20	5 – 12	15 – 25	15 – 25	10 – 15	5 – 12
Welding rod Ø mm	4 – 5	3 – 4 / 4 – 5	3 – 4	3 – 4	3 – 4 / 4 – 5	3 – 4 / 4 – 5	4	3 – 4
Weight kg	14	8.7	5.8	4.7	7.2	6.9	5.9	3.4
Length mm	821	560	450	435	690	588	450	435
Voltage V~	230	230	230	230 / 120	230	230	230	230
Screw extruder	yes	yes	yes	yes	yes	yes	yes	yes
Container construction	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓
Pipeline construction	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓	✓✓
Landfills / civil engineering	✓✓	✓✓	✓	○	✓✓	✓	○	○
Brushless blower	yes	yes	yes	yes	no	no	no	no
Remarks	1	1	1	1	2	2	2	3
Catalog page	 20	21	22 / 23	24	25 / 26	25 / 26	27	18 / 19

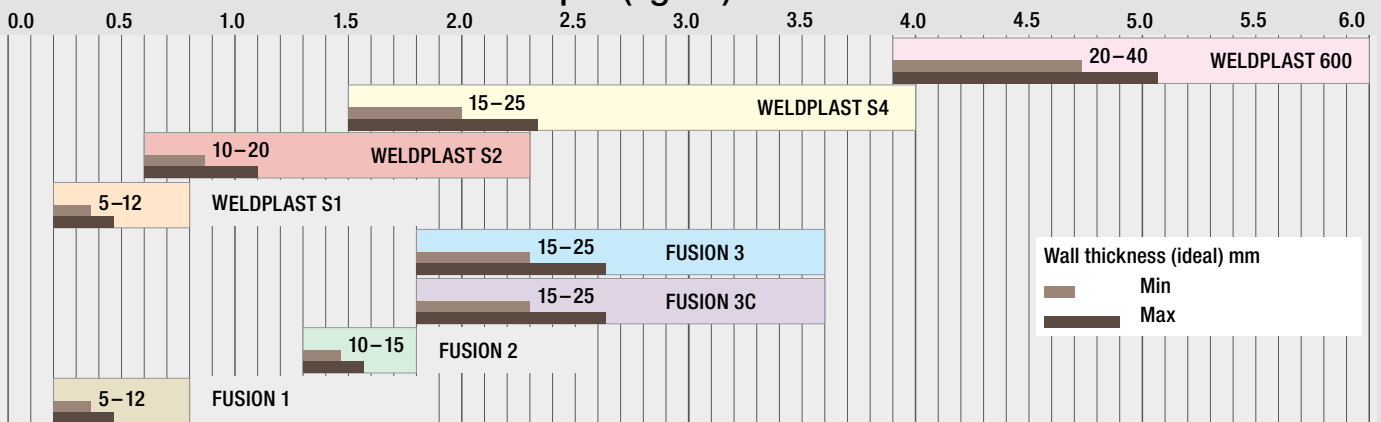
✓✓ very suitable ✓ suitable ○ unsuitable

1: Air and Plast temperatures electronically controlled with integrated display.

2: Hot air heated extruder temperature controlled manually.

3: Warm air heated extruder, air temperature electronically controlled with integrated display.

Overview of Extrusion Welders Output (kg/hr)









Ingeniously simple – FUSION 1

Your satisfaction is our goal. Which is why we are developing welding devices to meet your requests and requirements. And with the usual LEISTER quality, of course. The reduced design of the FUSION 1 offers increased maneuverability when welding. Flexibility guarantees an optimally mountable handle. Ingeniously simple extrusion welding – FUSION 1.

Digitally regulated extrusion welder

FUSION 1

1		Rod shape: Reduced design for increased maneuverability in small spaces
2		Double-sided wire intake: For more flexibility when welding
3		LED light: To illuminate the welding area
4		Handle: Can be mounted for one-handed welding





FUSION 1 – More flexibility during welding thanks to its slim design

Digitally regulated extrusion welder

FUSION 1



- **Controlled:** Automatically controlled air temperature
- **Suspension device:** Effortlessly weld longer by hanging up the device
- **Compact and slimline:** Thanks to integrated air guide

Technical data

Voltage	V~	230
Power	W	1200
Materials		PE, PP
Welding rod Ø	mm	3 – 4
Output Ø 3 HD-PE	kg/h	0.2 – 0.5
Output Ø 4 HD-PE	kg/h	0.3 – 0.8
Size (L × B × H)	mm	435 × 92 × 133 (236 with handle)
Weight	kg	3.4
Conformity marking		CE
Protection class II		□

Article No.:

162.799	FUSION 1, 120 V / 1450 W, US plug
162.800	FUSION 1, 230 V / 1200 W, EU plug
163.165	FUSION 1, 230 V / 1200 W, CEE 3/16
163.163	FUSION 1, 230 V / 1200 W, CH plug
163.164	FUSION 1, 230 V / 1200 W, AU plug
166.367	FUSION 1, 220 V / 1100 W, KR plug

Included with purchase: FUSION 1, case, welding shoe, Allen key, instruction manual, handle

Accessories FUSION 1

	163.793	Welding shoe CL14 IA
	172.570	Welding shoe small CL8 IA
	163.778	Welding shoe K5/6 IA
	163.780	Welding shoe K8/10 IA
	163.779	Welding shoe K12 IA
	163.782	Angled welding shoe AK-10 70°
	163.784	Angled welding shoe AK-10 30°
	163.785	Angled welding shoe AV-10 30°
	163.786	Welding shoe Rohling IA
	162.665	Insulation sleeve

General accessories



WELDPLAST S6: Powerful hand extruder.

The powerful WELDPLAST 600 hand extruder is Leister's most powerful extruder. Thanks to its high output rate, it's a convincing choice for welding large tanks and containers.



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

Digitally regulated extrusion welder

WELDPLAST 600



- 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	3680
Material		PE / PP
Welding rod	mm	∅ 4 or ∅ 5
Output	kg/h	3.9–6.0
Size (L × W × H)	mm	809 × 140 × 273
Weight	kg	12.2
Conformity mark		CE
Protection class I		⊕

Article No.:

170.461 WELDPLAST 600, 230V/3680W, industrial plug

Included with purchase: WELDPLAST 600, overlap welding shoe, storage case

Accessories WELDPLAST 600

		146.239	Welding shoe complete 54 × 40 × 52 mm blank welding shoe
		146.240	74 × 50 × 58 mm blank welding shoe
		146.241	25 mm overlap
		146.706	30 mm overlap
		146.242	35 mm overlap
		145.899	40 mm overlap
		146.245	20 mm V-seam
		146.246	25 mm V-seam
		146.247	30 mm V-seam
		146.232	20 mm fillet weld seam (a = 14 mm*)
		146.233	25 mm fillet weld seam (a = 17.5 mm*)
		146.234	30 mm fillet weld seam (a = 21 mm*)
		146.644	Corner outside seam 10 mm
		146.646	Corner outside seam 12 mm
		146.652	Corner outside seam 15 mm
		146.230	Corner seam ∅ 14 mm
		146.218	Corner seam ∅ 20 mm
		*a = Welding seam thickness	
		117.055	35 mm preheating nozzle, large
		136.859	50 mm preheat nozzle, XL Large
		170.495	Insulating cuff WELDPLAST 600/605
		173.307	Guide handle

General accessories



WELDPLAST S4: The workmate.

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



The powerful WELDPLAST S4 in use

Digitally regulated extrusion welder

WELDPLAST S4



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

Technical Data

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

Article No.:

- 116.948 WELDPLAST S4, 230 V / 3680 W, 3 – 4 mm, Euro plug, blank welding shoe
- 146.813 WELDPLAST S4, 230 V / 3680 W, 4 – 5 mm, Euro plug, welding shoe K 15
- Included with purchase: WELDPLAST S4, preheat nozzle large, medium and small, storage case

Accessories WELDPLAST S4

	146.239	54 x 40 x 52 mm blank welding shoe
	146.240	74 x 50 x 58 mm blank welding shoe
	146.241	25 mm overlap
	146.706	30 mm overlap
	146.242	35 mm overlap
	145.899	40 mm overlap
	146.243	12 mm V-seam
	146.244	15 mm V-seam
	146.245	20 mm V-seam
	146.246	25 mm V-seam
	146.247	30 mm V-seam
	146.525	12 mm fillet weld seam (a = 8.5 mm*)
	146.231	15 mm fillet weld seam (a = 10 mm*)
	146.232	20 mm fillet weld seam (a = 14 mm*)
	146.233	25 mm fillet weld seam (a = 17.5 mm*)
	146.234	30 mm fillet weld seam (a = 21 mm*)
	146.642	Corner outside seam 8 mm
	146.644	Corner outside seam 10 mm
	146.646	Corner outside seam 12 mm
	146.652	Corner outside seam 15 mm
	146.230	Corner seam Ø 14 mm
	146.218	Corner seam Ø 20 mm
		* a = Welding seam thickness
	144.904	Angled adapter 45°
	145.704	Angled adapter 90°
		Caution: You must use welding shoes with an integrated air guide for this.
	117.064	Side hot-air guide
	117.065	Top hot-air guide
	117.053	Preheat nozzle
	117.518	20 mm, small
	141.177	25 mm, medium
	149.723	35 mm, large
	149.723	Insulation sleeve WELDPLAST S4

General accessories



WELDPLAST S2 / S2 PVC: The masterpieces.

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

Digitally regulated extrusion welder

WELDPLAST S2



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

Technical Data

Voltage	V~	230
Power	W	3000
Material		PE / PP Other materials on request
Welding rod	mm	Ø 3 oder 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 – 2.0 PP: 0.9 – 2.0
Size (L x W x H)	mm	450 x 98 x 260
Weight	kg	5.8
Conformity mark		CE
Protection class I		⊕

Article No.:

127.215	WELDPLAST S2, 230 V / 3000 W, EU plug
140.707	WELDPLAST S2, 230 V / 3000 W, CN plug
146.341	WELDPLAST S2, 200 V / 2400 W, w/o plug
156.131	WELDPLAST S2, 230 V / 3000 W, CEE 3/16
176.839	WELDPLAST S2, 230 V / 3000 W, CH plug

Included with purchase: 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 oder Ø 4
Output Ø 3 mm	kg/h	PVC-U: 0.9 – 1.7 PE: 0.6 – 1.3
Output Ø 4 mm	kg/h	PVC-U: 1.5 – 2.7 PE: 1.0 – 2.3
Size (L x W x H)	mm	450 x 98 x 260
Weight	kg	5.8
Conformity mark		CE
Protection class I		⊕

Article No.:

135.724	WELDPLAST S2 PVC, 230 V / 3000 W, EU plug
140.708	WELDPLAST S2 PVC, 230 V / 3000 W, CN plug
146.342	WELDPLAST S2 PVC, 200 V / 2400 W, w/o plug
156.804	WELDPLAST S2 PVC, 230 V / 3000 W, CEE 3/16
169.929	WELDPLAST S2 PVC, 220 V / 2750 W, KR plug

Included with purchase: storage case



The handy WELDPLAST S2 in action



Even inside radiuses are easy to weld

Accessories WELDPLAST S2

		Welding shoe complete	
		145.945	45 × 30 × 54 mm blank welding shoe
		145.946	74 × 50 × 58 mm blank welding shoe
		145.896	25 mm overlap
		145.947	30 mm overlap
		145.897	35 mm overlap
		145.912	5 / 6 mm V-seam
		145.915	8 / 10 mm V-seam
		145.907	12 mm V-seam
		145.903	15 mm V-seam
		145.909	20 mm V-seam
		145.916	25 mm V-seam
		145.943	5 / 6 mm fillet weld (a = 4.2 mm*)
		145.944	8 / 10 mm fillet weld (a = 7 mm*)
		145.815	12 mm fillet weld (a = 8.5 mm*)
		145.812	15 mm fillet weld (a = 10 mm*)
		145.940	20 mm fillet weld (a = 14 mm*)
		145.816	25 mm fillet weld (a = 17.5 mm*)
		146.643	Corner outside seam 8 mm
		146.645	Corner outside seam 10 mm
		146.649	Corner outside seam 12 mm
		146.651	Corner outside seam 15 mm
		145.811	Corner seam Ø 14 mm
		145.488	Corner seam Ø 20 mm
		* a = Welding seam thickness	
		139.460	45° angled adapter
		139.461	90° angled adapter
		154.002	Insulation sleeve WELDPLAST S2
		161.119	Support clamp WELDPLAST S2



With the WELDPLAST S2 perfect welds are possible

Accessories WELDPLAST S2 PVC

		Welding shoe complete	
		146.239	54 × 40 × 52 mm blank welding shoe
		146.240	74 × 50 × 58 mm blank welding shoe
		146.241	25 mm overlap
		146.706	30mm overlap
		146.242	35 mm overlap
		146.248	5 / 6 mm V-seam
		146.249	8 / 10 mm V-seam
		146.243	12 mm V-seam
		146.244	15 mm V-seam
		146.235	5/6 mm fillet weld seam (a = 4.2 mm*)
		146.236	8/10 mm fillet weld seam (a = 7 mm*)
		146.525	12 mm fillet weld seam (a = 8.5 mm*)
		146.231	15 mm fillet weld seam (a = 10 mm*)
		146.642	Corner outside seam 8 mm
		146.644	Corner outside seam 10 mm
		146.646	Corner outside seam 12 mm
		146.652	Corner outside seam 15 mm
		146.230	Corner seam Ø 14 mm
		146.218	Corner seam Ø 20 mm
		* a = Welding seam thickness	
		133.850	Top hot-air guide



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

General accessories



WELDPLAST S1: Outstandingly compact.

With the new WELDPLAST S1 compact extruder, you can achieve perfect seam quality.



Nozzle welding made easy with the WELDPLAST S1

Digitally regulated extrusion welder

WELDPLAST S1



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

Technical Data

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

Article No.:

- 148.396 WELDPLAST S1, 230 V / 1600 W, Ø 3 – 4 mm, EU plug
- 148.395 WELDPLAST S1, 120 V / 1800 W, Ø 3 – 4 mm, w/o plug
- 148.394 WELDPLAST S1, 100 V / 1500 W, Ø 3 – 4 mm, EU plug
- 156.140 WELDPLAST S1, 230 V / 1600 W, UK plug
- 169.928 WELDPLAST S1, 220 V / 1500 W, KR plug
- 177.272 WELDPLAST S1, 230 V / 1600 W, CEE 3/16

Included with purchase: WELDPLAST S1, 4 pre-heating nozzles Ø 14 mm, welding shoe K10, storage case

Accessories WELDPLAST S1

	149.430	Welding shoe complete Blank
	149.402	Fillet weld 5 / 6
	148.627	Fillet weld 8 / 10
	149.401	Fillet weld 12
	149.388	V-seam 3 / 4
	149.383	V-seam 5 / 6
	149.385	V-seam 8 / 10
	149.364	Corner For additional welding shoes, see Weldplast S2 PVC
	152.720	Nozzle extension
	153.143	Angled adapter 45°
	153.236	Angled adapter 90°
	149.600	Top hot-air guide
	149.456	Hot-air tube, position 6h Ø 14 mm
	149.467	Hot-air tube, position 9h/3h Ø 14 mm (standard)
	154.107	Air nozzle set Ø 14 mm (standard)
	154.002	Insulation sleeve WELDPLAST S1/S2

General accessories



FUSION 3: Long and slim.

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

FUSION 3C: Short and handy.

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

Air heated extrusion welder

FUSION 3



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

Technical Data

		Version Ø 3 – 4		Version Ø 4 – 5	
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 mark		CE			
Protection class II		□			

Article No.:

118.300 FUSION 3, 230 V / 3500 W, Ø 3 – 4 mm, EU plug
 144.615 FUSION 3, 230 V / 3500 W, Ø 4 – 5 mm, EU plug
 140.020 FUSION 3, 230 V / 3500 W, Ø 3 – 4 mm, CEE 3/16
 143.835 FUSION 3, 230 V / 3500 W, Ø 4 – 5 mm, CEE 3/16

Included with purchase: FUSION 3, storage case

Air heated extrusion welder

FUSION 3C



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

Technical Data

		Version Ø 3 – 4		Version Ø 4 – 5	
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	3200			
Material		PE / PP			
Size (L × W × H)	mm	588 x 98 x 225			
Weight	kg	6.9			
Conformity mark		CE			
Protection class II		□			

Article No.:

123.866 FUSION 3C, 230 V / 3200 W, Ø 3 – 4 mm, EU plug
 144.826 FUSION 3C, 230 V / 3200 W, Ø 4 – 5 mm, EU plug
 173.794 FUSION 3C, 230 V / 3200 W, Ø 3 – 4 mm, without shoe, industrial plug
 140.028 FUSION 3C, 230 V / 3200 W, Ø 3 – 4 mm, CEE 3/16
 143.837 FUSION 3C, 230 V / 3200 W, Ø 4 – 5 mm, CEE 3/16
 166.365 FUSION 3C, 220 V / 3000 W, Ø 3 – 4 mm, KR plug
 176.838 FUSION 3C, 230 V / 3200 W, Ø 3 – 4 mm, CH plug

Included with purchase: FUSION 3C, storage case



Perfectly stored in the case



FUSION 3C during the welding of a fillet weld

Accessories FUSION 3 / 3C

		Welding shoe complete
		145.945 45 × 30 × 54 mm blank welding shoe
		145.946 74 × 50 × 58 mm blank welding shoe
		145.896 25 mm overlap
		145.947 30 mm overlap
		145.897 35 mm overlap
		145.912 5 / 6 V-seam
		145.915 8 / 10 mm V-seam
		145.907 12 mm V-seam
		145.903 15 mm V-seam
		145.909 20 mm V-seam
		145.916 25 mm V-seam
		145.943 5 / 6 mm fillet weld (a = 4.2 mm*)
		145.944 8 / 10 mm fillet weld (a = 7 mm*)
		145.815 12 mm fillet weld (a = 8.5 mm*)
		145.812 15 mm fillet weld (a = 10 mm*)
		145.940 20 mm fillet weld (a = 14 mm*)
		145.816 25 mm fillet weld (a = 17.5 mm*)
		146.643 Corner outside seam 8 mm
		146.645 Corner outside seam 10 mm
		146.649 Corner outside seam 12 mm
		146.651 Corner outside seam 15 mm
		145.811 Corner seam Ø 14 mm
		145.488 Corner seam Ø 20 mm
		* a = Welding seam thickness
		148.817 45° angled adapter
		148.816 90° angled adapter
		149.421 Insulation sleeve FUSION 3
		149.420 Insulation sleeve FUSION 3C

* a = Welding seam thickness

The insulation sleeve protects the machine from heat loss, as well as protects the operator from direct contact with the extruder.



FUSION 2: The small powerhouse.

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



In operation during container construction in China

Air heated extrusion welder

FUSION 2



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

Technical Data

Voltage	V~	230 / 120
Power	W	2800
Material		PE / PP
Air temperature	°C	up to 340
Plastification temperature	°C	up to 300
Welding rod	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
Conformity mark		CE
Protection class II		

Article No.:

119.200	FUSION 2, 230 V / 2800 W, EU plug
150.102	FUSION 2, 120 V / 2800 W, CEE 3/16
139.197	FUSION 2, 230 V / 2800 W, CEE 3/16
166.366	FUSION 2, 220 V / 2600 W, KR plug
176.837	FUSION 2, 230 V / 2800 W, CH plug

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

Accessories FUSION 2

	Welding shoe complete
	145.945 45 x 30 x 54 mm blank welding shoe
	145.946 74 x 50 x 58 mm blank welding shoe
	145.896 25 mm overlap
	145.947 30 mm overlap
	145.897 35 mm overlap
	145.912 5 / 6 V-seam
	145.915 8 / 10 mm V-seam
	145.907 12 mm V-seam
	145.903 15 mm V-seam
	145.943 5 / 6 mm fillet weld (a = 4.2 mm*)
	145.944 8 / 10 mm fillet weld (a = 7 mm*)
	145.815 12 mm fillet weld (a = 8.5 mm*)
	145.812 15 mm fillet weld (a = 10 mm*)
146.643 Corner outside seam 8 mm	
146.645 Corner outside seam 10 mm	
146.649 Corner outside seam 12 mm	
146.651 Corner outside seam 15 mm	
145.811 Corner seam ∅ 14 mm	
145.488 Corner seam ∅ 20 mm	
* a = Welding seam thickness	
	147.602 45° angled adapter
	147.601 90° angled adapter
	166.524 Insulation sleeve FUSION 2

General accessories



Automated, modular, customized – WELDPLAST 200-i / 610-i

LEISTER offers you two modules for automated extrusion welding and 3D printing. WELDPLAST 200-i and 610-i are set up to allow both simple and fully automated expansion and can be mounted on robots or integrated into machines. This modular design allows you to bring your projects to fruition without making any compromises.

Built-in extruder module

WELDPLAST 200-i / 610-i



Customized
Depending on requirements – choose between extruder modules which can be extended to meet specific needs



Modular
Select an extruder module and simply add the relevant hot air and communication components



Controlled
Monitor and control all parameters such as temperatures and emissions

The drive and communication components of both extruder modules, which can be freely chosen by the user, can be tailored fully to meet individual needs. By incorporating additional sensors, the process can be controlled and monitored as required.

Electrical and mechanical adaptation points are already set up so that the modules for various processes such as those requiring preheated air can be integrated.

State-of-the-art industrial interfaces or similar interfaces can be installed to aid communication.





WELDPLAST 200-i / 610-i – robotic extrusion welding and 3D printing designed for automated continuous operation

Built-in extruder module

WELDPLAST 200-i / 610-i



- **Automated:** Designed for automated continuous operation
- **Up to date:** All components are compliant with current industry standards

Technical data		WELDPLAST 200-i	WELDPLAST 610-i
Voltage	V~	230	230
Heating power	W	600	1600
Welding additive	mm	3 – 4	4 – 5
Material output ø 3 mm	kg/h	0.1–1.4	
Material output ø 4 mm	kg/h	0.1–2.0	0.1–4.0
Material output ø 5 mm	kg/h		0.1–8.4
Welding materials		HDPE, LDPE, LLDPE, PVC-U, ABS, PVC-C, PU, PC, PS	HDPE, LDPE, LLDPE, PP
Dimensions full disassembly (L x W x H)	mm	660 x 191 x 220	876 x 191 x 210
Protection class I		⊕	⊕

Included with purchase: Extrusion module, CAD data, parts list, operating manual, suggested electrical diagram

WELDPLAST 200-i

	163.322	WELDPLAST 200-i, 230V
	163.575	Connection kit 200-i/610-i
	164.414	Air heater kit 200-i
	139.869	LHS 21S CLASSIC, 230V/1kW
	140.455	LHS 21S PREMIUM, 230V/1kW
	140.459	LHS 21S SYSTEM, 230V/1kW

WELDPLAST 610-i

	172.580	WELDPLAST 610-i, 230V
	163.575	Connection kit 200-i/610-i
	164.415	Air heater kit 610-i
	139.872	LHS 21L CLASSIC, 230V/3.3kW
	140.457	LHS 21L PREMIUM, 230V/3.3kW
	140.461	LHS 21L SYSTEM, 230V/3.3kW



Check the weld seam dimension easily

General accessories hand extruder

	<p>Tool rest</p> <p>131.451 WELDPLAST S2 / S2 PVC / FUSION 2 FUSION 3C</p> <p>148.923 WELDPLAST S1</p> <p>160.454 WELDPLAST S4 / WELDPLAST S6 / FUSION 3</p>		<p>Heating element</p> <p>109.984 230 V / 2200 W, WELDPLAST S4 / S2 / S2 PVC</p> <p>113.268 230 V / 1100 + 1100 W, FUSION 3</p> <p>123.561 230 V / 1750 W, FUSION 2 / 3C</p> <p>149.265 230 V / 1000 W, WELDPLAST S1</p> <p>149.529 120 V / 1100 W, WELDPLAST S1</p> <p>149.530 100 V / 1050 W, WELDPLAST S1</p> <p>151.026 120 V / 1750 W, FUSION 2</p>
	<p>136.231 Pre-heat reflector WELDPLAST S1/S2 / S2 PVC / S4 / S6 FUSION 2 / 3 / 3C</p>		<p>144.095 Welding rod de-reeler</p>
	<p>134.361 Air filter WELDPLAST S1 / S2 / S2 PVC (included with purchase)</p> <p>143.776 Textile dust filter WELDPLAST S1 / S2 PVC (in combination with Air filter) (not included with purchase)</p> <p>135.082 Air filter FUSION 2 / 3C</p> <p>155.829 Air filter WELDPLAST S2</p>		<p>Storage case (included with purchase)</p> <p>169.851 WELDPLAST 600</p> <p>123.173 WELDPLAST S4 / FUSION 3</p> <p>119.540 WELDPLAST S2 / S2 PVC / S1 / FUSION 2 / 3C</p>
	<p>153.009 Corner Press Tool</p>		
	<p>152.676 Welding Gauge</p>		
	<p>154.259 Scraper blade</p>		
	<p>154.026 Contour scraper</p>		
	<p>136.961 Temperature measuring device G1200</p>		
	<p>136.962 Insertion probe type K, Ø 3 × 100 mm</p> <p>136.963 Insertion probe type K, Ø 1.5 × 100 mm</p>		
	<p>142.570 Tool case 229 × 199 × 55 suitable for article 136.961</p>		

PLASTFIX lends the weld seam the necessary holding pressure.





WOODS

PLASTIC

TRIAC ST: Design meets experience

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

Product advantage



1
Ergonomic handling:
 The 2-component handle and perfect tool balance ensure ideal grip and optimum working even under the toughest conditions.

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



2
Always keeps a cool head:
 There is an actively cooled protective tube for greater work safety.



3
Welding power:
 Thanks to the optimized, highly robust motor, TRIAC ST guarantees high welding power.

2



4
Reliability:
 A new temperature manager and a high dust resistance provide the heating elements with a long service life.



5
Swiss thoroughness:
 The air filters, located on either side, can easily be removed and cleaned. This ensures optimum air flow and maximum power output.

Optimum protection:
 The filters offer active protection against moisture and dust.

TRIAC AT: Robust and intelligent.

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

Hot-air hand tool

TRIAC ST



- Suitable for the work site
- Functional design: two-component handle grip and optimum center of gravity ensure good ergonomics
- Quick clean air filters
- Automatic carbon stop and heating element protection provide automatic protective measures

Technical data		
Voltage	V~	120 / 230
Frequency	Hz	50 / 60
Power	W	1600 / 1600
Temperature	°C	40 – 700
Air volume (20°C)	l/min	240 (500 at max. temp)
Dynamic pressure	Pa	3000
Ø Nozzle holder	mm	31.5
Emission	dB(A)	67
Size (L × Ø)	mm	338 × 90, handle Ø 56
Weight	kg	<1 (without power cord)
Conformity mark	CE	
Approval mark		
Protection class II		
Article No.:		
141.308	TRIAC ST, 120 V / 1600 W for push-fit nozzles with UK-plug	
141.309	TRIAC ST, 230 V / 1600 W for push-fit nozzles with UK-plug	
141.311	TRIAC ST, 230 V / 1600 W for push-fit nozzles with CH plug	
141.227	TRIAC ST, 230 V / 1600 W for push-fit nozzles with Euro plug	
144.013	TRIAC ST, 230 V / 1600 W for screw-on nozzles with Euro plug	
153.891	TRIAC ST, 220 V / 1600 W for push-fit nozzles with KR-plug	

Hot-air hand tool

TRIAC AT



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

Technical data		
Voltage	V~	120 / 230
Frequency	Hz	50 / 60
Power	W	1600 / 1600
Temperature	°C	40 – 620
Air volume (20°C)	l/min	160 – 240 (500 at max. temp)
Dynamic pressure	Pa	1600 – 3000
Ø Nozzle holder	mm	31.5
Emission	dB(A)	67
Size (L × Ø)	mm	338 × 90, handle Ø 56
Weight	kg	1 (without power cord)
Conformity mark	CE	
Approval mark		
Protection class II		
Article No.:		
141.319	TRIAC AT, 120 V / 1600 W, with UK-plug	
141.320	TRIAC AT, 230 V / 1600 W, with UK-plug	
141.314	TRIAC AT, 230 V / 1600 W, with Euro-plug	
141.322	TRIAC AT, 230 V / 1600 W, with CH-plug	
142.737	TRIAC AT, 230 V / 1600 W for screw-on nozzles with Euro plug	
148.005	TRIAC AT, 220 V / 1600 W, for push-fit nozzles with KR-plug	



Quick welding



Draw welding with combination nozzle

Accessories TRIAC ST / TRIAC AT

	100.303 Ø 5 mm, tubular nozzle, push-fit		105.622 Ø 5 mm, tubular nozzle, screw-on
	105.575 Ø 5 × 100 mm, tubular nozzle, push-fit		106.988 Tacking nozzle, screw-on
	106.982 Ø 5 × 150 mm, extension nozzle, push-fit		126.552 Ø 4 mm drawing nozzle, screw-on for fluor plastics
	105.576 tubular nozzle Ø 5 mm, 90° curved		113.666 Ø 3 mm drawing nozzle with tacking tip, screw-on
	106.996 Tacking nozzle, push-fit on Ø 5 mm tubular nozzle		113.399 Ø 4 mm drawing nozzle with tacking tip, screw-on
	105.431 3 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle		113.876 Ø 3 mm drawing nozzle without tacking tip, screw-on
	105.432 4 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle		113.874 Ø 4 mm drawing nozzle without tacking tip, screw-on
	105.433 5 mm speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle		113.670 Drawing nozzle triangular-shaped with tacking tip, screw-on 5.7 mm, profile A
	107.139 4.5 × 12 mm speed weld nozzle for fillet weld, push-fit on Ø 5 mm tubular nozzle		113.877 Without tacking tip, screw-on 5.7 mm, profile A
	107.137 8 mm speed weld nozzle for tape welding, push-fit on Ø 5 mm tubular nozzle		106.986 Without tacking tip, screw-on 7 mm, profile B
	Speed weld nozzle, push-fit on Ø 5 mm tubular nozzle		143.833 Nozzle adapter for screw-on nozzles
	106.992 5.7 mm, profile A		143.332 Protection tube for screw-on nozzles (for TRIAC ST until april 2017)
	106.993 7 mm, profile B		156.092 Protection tube for screw-on nozzles (for TRIAC ST from mai 2017)
	106.989 Ø 3 mm		144.134 Protection tube for screw-on nozzles (for TRIAC AT)
	106.990 Ø 4 mm		141.375 Connection adapter M14 for Ø 21 mm nozzle with plug
	106.991 Ø 5 mm		142.717 Heating element for TRIAC ST / TRIAC AT, 230 V / 1550 W
	156.470 Speed weld nozzle bend Ø 5 mm, push-fit on Ø 5 mm tubular nozzle		142.718

HOT JET S: Small and powerful.

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



Popular for repair work: HOT JET S

Hot-air hand tool

HOT JET S



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

Technical data

Voltage	V~	120 / 230
Frequency	Hz	50 / 60
Power	W	460 / 460
Temperature	°C	40 – 600
Air volume (20°C)	l/min	40 – 110 (200 at max. temp)
Pressure static	Pa	230 – 1600
Ø Nozzle holder	mm	21.3
Emission	dB(A)	59
Size (L x Ø)	mm	235 x 70, handle Ø 40
Weight	kg	0.4 (without power cord)
Conformity mark	CE	
Approval mark		
Protection class II		

Article No.:

100.648	HOT JET S, 230 V / 460 W, with Euro plug
100.862	HOT JET S, 120 V / 460 W, without plug
100.854	HOT JET S, 230 V / 460 W, with AUS plug
140.030	HOT JET S, 220V/ 460W for push-fit nozzles with KR-plug

Accessories HOT JET S

	107.144 Ø 5 mm tubular nozzle, push-fit
	106.996 Tacking nozzle, push-fit on Ø 5 mm tubular nozzle
	106.989 3 mm speed welding nozzle, push-fit on Ø 5 mm tubular nozzle
	106.990 4 mm speed welding nozzle, push-fit on Ø 5 mm tubular nozzle
	106.991 5 mm speed welding nozzle, push-fit on Ø 5 mm tubular nozzle
	156.470 Speed weld nozzle bend Ø 5 mm, push-fit on Ø 5 mm tubular nozzle
	106.992 5.7 mm, A profilee speed welding nozzle, push-fit
	106.993 7 mm, B profilee speed welding nozzle, push-fit
	107.137 8 mm speed welding nozzle for tape welding, push-fit on Ø 5 mm tubular nozzle
	143.831 Nozzle adapter for screw-on nozzles
	100.818 230 V / 435 W heating element



PENWELD A illuminated plastic welding

The PENWELD A external-air welder is suitable for precise plastic welding in apparatus and tank construction. The work light integrated in the handle keeps the welding zone under control even in dark sections.

External air hand tool

PENWELD A



- Rotating connection for flexibility when working
- Specific hose characteristics for better usability
- Service friendly junction box
- Choice between application-optimized variations
- Constant welding thanks to precise temperature



Integrated LED work light

Technical data

Voltage	V~	120 V; 230
Frequency	Hz	50 / 60
Power	W	1000 – 1550
Temperature	°C	60 – 600
Temperature setting stepless		Yes
Display		Yes
Outdoor use		Yes
Nozzle connection (Ø)		31.5 mm; M14
Size (L x Ø)	mm	254.0 – 282.0 x 54, handle Ø 37
Conformity mark		CE UK
Protection class II		□

Article No.:

- 173.367 PENWELD 305-A, 230 V / 1000 W, 3 m, M14, EU plug
- 173.368 PENWELD 305-A, 120 V / 1000 W, 3 m, M14, US plug
- 173.369 PENWELD 305-A, 230 V / 1000 W, 3 m, M14, CH plug
- 173.370 PENWELD 305-A, 230 V / 1000 W, 8 m, M14, EU plug
- 173.371 PENWELD 305-A, 230 V / 1000 W, 8 m, M14, CH plug
- 173.376 PENWELD 500-A, 230 V / 1550 W, 3 m, EU plug
- 173.377 PENWELD 500-A, 120 V / 1550 W, 3 m, US plug
- 175.598 PENWELD 505-A, 230 V / 1550 W, 8 m, M14, EU plug
- 177.344 PENWELD 500-A, 230 V / 1550 W, 3 m, CN plug
- 177.346 PENWELD 505-A, 230 V / 1550 W, 8 m, M14, CN plug



Intuitively operable



Logically designed

The handy, robust PENWELD S external-air welder is intentionally simple in design to enable intuitive operation and withstand heavy loads. Different device variants cover individual needs.



External air hand tool

PENWELD S



- Robust and simple construction
- Short and light for longer working periods
- Recessed rotary knob against accidental adjustment
- High quality, sturdy hose

Technical data

Voltage	V~	120 V; 230
Frequency	Hz	50 / 60
Power	W	1000 – 1550
Temperature	°C	60 – 600
Temperature setting stepless		Yes
Display		No
Outdoor use		Yes
Nozzle connection (∅)		31.5 mm; M14
Size (L × ∅)	mm	254.0 – 275.0 × 54, handle ∅ 37
Conformity mark		CE UK
Protection class II		□

Article No.:

173.372	PENWELD 305-S, 230 V / 1000 W, 3 m, M14, EU plug
173.373	PENWELD 305-S, 230 V / 1000 W, 3 m, M14, CH plug
173.374	PENWELD 305-S, 120 V / 1000 W, 3 m, M14, US plug
173.375	PENWELD 305-S, 230 V / 1000 W, 8 m, M14, EU plug
173.378	PENWELD 500-S, 230 V / 1550 W, 3 m, EU plug
173.379	PENWELD 500-S, 120 V / 1550 W, 3 m, US plug
177.345	PENWELD 500-S, 230 V / 1550 W, 3 m, CN plug

Accessories PENWELD S

	105.622 ∅ 5 mm tubular nozzle, 15° screw-on
	106.988 Tacking nozzle, screw-on
	113.666 ∅ 3 mm round drawing nozzle with tacking tip, screw-on 113.399 ∅ 4 mm round drawing nozzle, with tacking tip, screw-on
	113.876 ∅ 3 mm round drawing nozzle without tacking tip, screw-on 113.874 ∅ 4 mm round drawing nozzle, without tacking tip, screw-on
	113.670 Triangular drawing nozzle with tacking tip, screw-on, 5.7 mm, profile A 113.877 without tacking tip, screw-on 5.7 mm, profile A 106.986 without tacking tip, screw-on 7 mm, profile B 106.987 without tacking tip, screw-on 7 × 5.5 mm
	126.552 ∅ 4 mm drawing nozzle, screw-on for floor plastics
	Angular adapter for screw-on nozzles, screw-on 127.726 30° 127.727 45°
	170.881 Tool stand PENWELD
	172.330 One-touch fitting G3/8" 172.333 One-touch fitting G1/2"
	172.331 Coupler plug ∅ 14 mm

AIRSTREAM 100: Mobile with strong air supply.

The mobile AIRSTREAM 100 blower supplies the right amount of air for Leister's DIODE, PENWELD and LABOR heat guns. A suitable adapter is included in the scope of delivery to easily connect the heat guns.



Air compressor for mobile use

Blower

AIRSTREAM 100



- Mobile
- Generates clean, filtered air
- Low maintenance and long service life
- Separate device switch to handle tool with ease
- Safely stored thanks to the tool rack

Accessories AIRSTREAM 100

	172.330 One-touch fitting G3/8"
	172.331 Coupler plug Ø 14 mm

Technical Data

Voltage	V~	230
Power	W	72
Frequency	Hz	50
Air volume	L/min	80 (Total)
Emission	dB(A)	< 48
Size (L x B x H)	mm	440 x 228 x 227
Weight	kg	7.2
Conformity mark		CE
Protection class I		⊥

Article-No.:

171.350	AIRSTREAM 100, 230 V / 72 W, CH-plug
171.351	AIRSTREAM 100, 230 V / 72 W, EU-plug



AIRSTREAM ST: The quiet and efficient air supply unit.

With its plug & play functionality, all you need to do is plug in the AIRSTREAM ST for a constant supply of clean, dry air – for welding constructions with the highest cleanliness requirements.



AIRSTREAM ST, the quiet air supply unit





Blower

AIRSTREAM ST



- Quiet operating mode
- Cool-Down-Mode
- Low energy consumption
- Two hand tools can be connected
- Compatible mit PENWELD, DIODE and LABOR
- Flow meter
- Brushless technology

Accessories AIRSTREAM ST

	159.535 Roller set
	159.481 Air hose connection set
	172.331 Coupler plug $\varnothing 14\text{mm}$
	172.333 One-touch fitting G1/2>

Technical Data

Voltage	V~	230
Power	W	215
Frequency	Hz	50
Air volume	L/min	200 (Total)
Emission	dB(A)	< 48
Size (L x B x H)	mm	600 x 250 x 362
Weight	kg	24
Conformity mark		CE
Protection class I		⊕

Article-No.:

158.822	AIRSTREAM ST, 230 V / 215 W, EU-plug
161.052	AIRSTREAM ST, 230 V / 215 W, CH-plug



Easy parallel operation.

ROBUST: The powerhouse.

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



ROBUST blower, serving as the external air supply

Blower

ROBUST



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

Technische Daten

Frequency	Hz	50	60
Power	W	250	250
Air volume (20 °C)	l/min	1200	1300
Static pressure	kPa	8.0	10.5
Max. ambient temperature	°C	60	60
Max. air inlet temperature	°C	60	60
Noise emission level	dB(A)	62	62
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 mark			
Protection class I		⊕	⊕

Artikel-Nr.:

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

Accessories ROBUST

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



External air hand tool

DIODE S



- Operated with MINOR or ROBUST blower or with compressed air
- Cooled heating element tube
- Suitable for field applications when used in combination with a MINOR blower

Technical data

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

Article No.:

101.279	DIODE S, 230 V / 2000 W, EU plug
101.280	DIODE S, 230 V / 2000 W, M14, EU plug
101.281	DIODE S, 230 V / 1600 W, EU plug
101.282	DIODE S, 230 V / 1600 W, M14, EU plug
101.291	DIODE S, 120 V / 1600 W, US plug
101.292	DIODE S, 120 V / 1600 W, M14, US plug
101.293	DIODE S, 120 V / 1600 W, CEE 3/16
177.270	DIODE S, 230 V / 1600 W, M14, CN plug

Additional versions available upon request

Hand tool and blower

DIODE S with MINOR



MINOR blower and DIODE S

- Ideal for assembly work

Technical data

Voltage	V~	120 / 230
Power	W	1600
Temperature	°C	20 – 600
Size (L × Ø)	mm	265 × 57, handle Ø 40
Weight	kg	2.5 kg (with 3 m cord / 1.5 m air hose)
Conformity mark	CE	
Protection class II		

Article No.:

101.441	DIODE S / MINOR, 230 V / 1700 W, 1.5 m, EU plug
101.447	DIODE S / MINOR, 120 V / 1700 W, US plug
101.449	DIODE S / MINOR, 100 V / 1500 W, JP plug
108.870	DIODE S / MINOR, 230 V / 1700 W, 1.5 m, M14, EU plug
136.241	DIODE S / MINOR, 230 V / 1700 W, CN plug

Additional versions available upon request



The MINOR blower as an air supply for the DIODE S

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 S or LABOR S.

Accessories DIODE S

With push-fit nozzle

	100.303 Ø 5 mm tubular nozzle, for versions with nozzles, push-fit
	106.992 Speed welding nozzle, push-fit on Ø 5 mm tubular nozzle 5.7 mm, profile A
	106.993 7 mm, profile B
	106.989 3 mm
	106.990 4 mm
	106.991 5 mm
	156.470 5 mm bent
	106.996 Tacking nozzle, push-fit on Ø 5 mm tubular nozzle
	143.833 Nozzle adapter for screw-on nozzles
	100.689 Heating element DIODE S, 230 V / 1550 W
	100.702 Heating element DIODE S, 120 V / 1600 W

With screw-on nozzle

	105.622 Ø 5 mm tubular nozzle, screw-on
	106.988 Tacking nozzle, screw-on
	113.666 Ø 3 mm round drawing nozzle with tacking tip, screw-on
	113.399 Ø 4 mm round drawing nozzle, with tacking tip, screw-on
	113.876 Ø 3 mm round drawing nozzle without tacking tip, screw-on
	113.874 Ø 4 mm round drawing nozzle, without tacking tip, screw-on
	113.670 Triangular drawing nozzle, with tacking tip, screw-on, 5.7 mm
	113.877 Without tacking tip, screw-on 5.7 mm, profile A
	106.986 Without tacking tip, screw-on 7 mm, profile B
106.987 7 x 5.5 mm	
	126.552 4 mm drawing nozzle, screw-on, for fluor plastics
	141.375 Connection adapter M14 for Ø 21.3 mm nozzle with plug

Blower

MINOR



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

Technical data

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

Article No.:

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

Additional versions available upon request

LABOR S: Small and handy.

Developed for laboratory use but also eminently suitable for small welding tasks where access is difficult.



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

External Air Hand tool

LABOR S



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

Accessories LABOR S

	107.144 Ø 5 mm tubular nozzle, push-fit
 A B	106.992 Speed weld nozzle, push-fit on Ø 5 mm tubular nozzle 106.993 5.7 mm, profilee A 106.989 7 mm, profilee B 106.990 3 mm 106.991 4 mm 106.991 5 mm 156.470 5mm bent
	106.996 Tacking nozzle, push-fit on Ø 5 mm tubular nozzle
	143.831 Nozzle adapter for screw-on nozzles
	107.146 Ø 2 mm soldering nozzle
	107.151 Ø 4 mm soldering nozzle
	107.148 Ø 3 × 1.5 mm soldering nozzle, oval
	105.622 Ø 5 mm tubular nozzle, screw-on
	106.988 Tacking nozzle, screw-on
 D	113.666 Ø 3 mm round drawing nozzle with tacking tip, screw-on
	113.399 Ø 4 mm round drawing nozzle, with tacking tip, screw-on
	113.876 Ø 3 mm round drawing nozzle without tacking tip, screw-on
	113.874 Ø 4 mm round drawing nozzle, without tacking tip, screw-on
 A B	113.670 Triangular drawing nozzle, with tacking tip, screw-on, 5.7 mm
	113.877 Without tacking tip, screw-on 5.7 mm, profile A
	106.986 Without tacking tip, screw-on 7 mm, profile B
	106.987 7 × 5.5 mm
	126.552 4 mm drawing nozzle, screw-on, for floor plastics
	101.581 230 V / 800 W heating element

Technical data

Voltage	V~	230
Power	W	800 / 900
Temperature	°C	20 – 600
Size (L × Ø)	mm	180, handle Ø 32
Weight	kg	0.15 (without air hose and without cordl)
Conformity mark	CE	
Approval mark		
Protection class II	□	

Article No.:

- 101.716 LABOR S with connection box, 230 V / 800 W with Euro plug, air hose 3 m
 - 101.754 LABOR with MINOR blower, 230 V / 900 W with Euro plug, air hose 1.5 m
- Additional versions available upon request



Remove the oxide layer from the welding rod



With the contour scraper, perfect weld seam pre- and post-processing is achieved

Hot-air hand tools

General accessories

	106.976 28 mm pressure roller (PTFE)		137.855 Leister cutter with four spare blades
	106.972 Brass pressure roller with ball bearings		138.902 Hooked blade for LEISTER-cutter (10 dispenser with 10 pcs=100 pcs)
	152.676 Weld seam template		138.539 Straight-edge blade for LEISTER-cutter (10 dispenser with 10 pcs = 100 pcs)
	157.544 Leister Universal scissors 260 mm with special shaft grinding		151.382 Kehlfix
	154.259 Scraper blade		153.009 Plastfix
	154.026 Contour scraper		160.353 Cable cord roller 25 m, with 1 x CEE 400V and 2 x EU socket 230V
	106.997 Ø 6 mm rotary burr for drilling machine, for car repairs		161.152 Cable cord roller 25 m, with 1 x CEE 400 V and 2 x T23 CH socket 230 V
	116.798 Brass brush		161.207 Cable cord roller 25 m, with 1 x CEE 400 V and 2 x Typ E with ground pin socket 230 V
	142.647 Brass brush Ø 3 mm		164.048 Cable cord roller 45 m, 4 x 230 V, EU socket
	107.348 Tool rest for TRIAC AT, TRIAC ST, LABOR S		160.015 Cable extension cord 15 m PUR 5 x 2.5 mm ² , with CEE 400V plug
			159.239 Cable extension cord 15 m PUR 3 x 2.5 mm ² , with EU plug 230V
			136.961 Temperature measuring device G1200
			136.962 Insertion probe type K, Ø 3 x 100 mm
			136.963 Insertion probe type K, Ø 1.5 x 100 mm
			142.570 Tool case 229 x 199 x 55 suitable for article 136.961

More at the new accessories catalog at leister.com/accessories



Welding rods

Article		Profile	Colour	kg
Welding accessories PE				
104.283	HDPE welding rod	A	■	3
104.294	HDPE welding rod	A	□	3
104.284	HDPE welding rod	B	■	5
104.299	HDPE welding rod	B	□	5
106.650	HDPE welding band	C	□	1
104.300	LDPE welding rod	A	■	3
161.612	HDPE welding rod	D	■	2
116.918	HDPE welding rod	D	■	2
Welding accessories PP				
104.287	PP welding rod	A	■	3
104.301	PP welding rod	A	■	3
106.642	PPs welding rod, flame resistant	A	■	3
104.288	PP welding rod	B	■	5
126.356	PP welding band	C	□	2
161.611	PP welding rod	D	■	2
Welding accessories PVC				
104.296	PVC-U welding rod	A	□	3
104.278	PVC-U welding rod	A	■	3
106.641	PVC-U welding rod	A	■	3
104.280	PVC-U welding rod	B	■	5
104.279	PVC-U welding rod	B	■	5
109.925	PVC-U welding rod	D	■	4
104.302	PVC-P welding rod (soft)	A	□	3
Welding accessories ABS				
104.295	ABS welding rod	A	□	3
113.587	ABS welding rod	A	■	3
107.027	ABS welding band	C	□	1

Article		Profile	Colour	kg
Welding accessories div.				
104.297	PA welding rod	A	■	3
104.313	PC welding rod / ABS / ALPHA (Honda)	A	■	3
104.308	PUR welding rod	A	■	3
106.654	Xenoy welding band	C	■	2
104.304	PVDF welding rod	A	□	3
104.303	POM welding rod	A	□	3
112.185	PC/PBTX Xenoy welding rod	A	□	3
Test bundles				
107.036	Test bundle bodywork welding rods, each consisting of profile A pieces of 37 cm single marked 6× HDPE, 6× PP, 6× PA, 6× ABS, 6× PCABS / ALPHA Honda, 6× PC / PBTP / Xenoy	A		
107.037	Test bundles standard each consisting of profile A pieces of 37 cm single marked 5× PVC-U, 5× PVC-P, 5× PP, 5× ABS, 5× HDPE, 3× PC, 3× PA, 3× POM, 3× LDPE, 3× PC / ABS / ALPHA Honda / PBTP / Xenoy	A		
107.040	Test bundle welding band each consisting of profile C pieces of 37 cm single marked 9× HDPE, 8× 2 mm white, 9× PP, 8× 2 mm natural, 9× ABS, 8× 2 mm white / PBTP / Xenoy grey	C		

Profile sizes

Profile A	Profile B	Profile C	Profile D

Dimensions in mm

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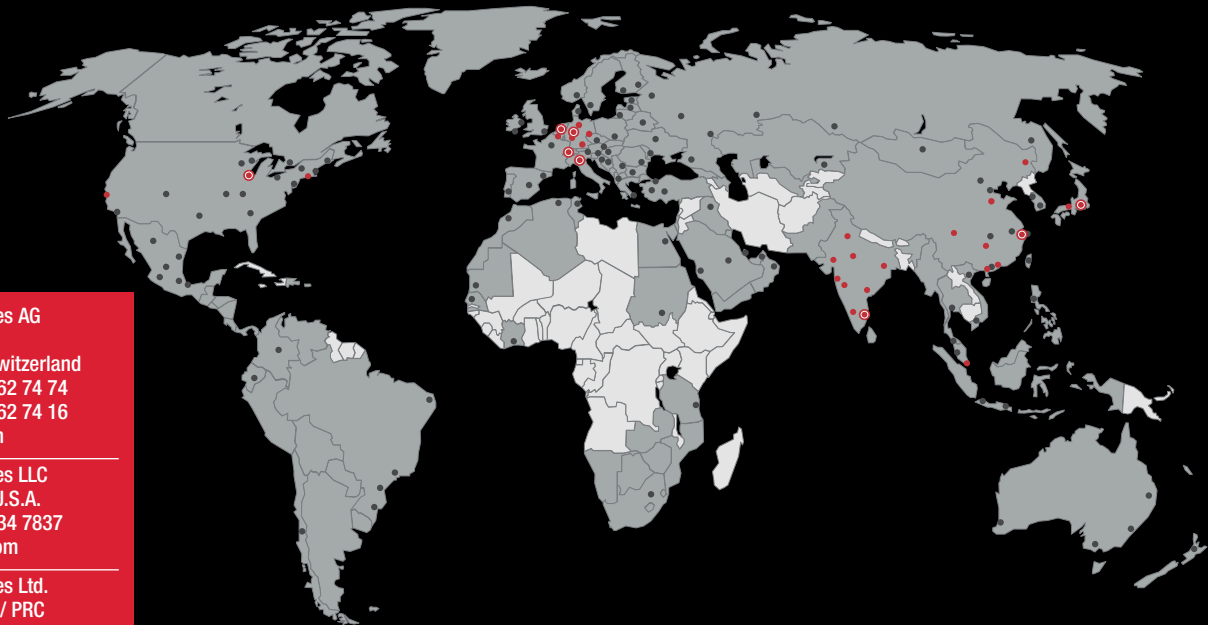
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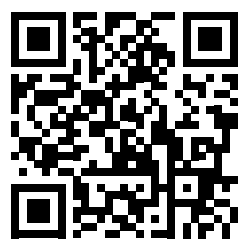
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