

LEISTER Variant Hot Air Automatic Welder

Order No. 4R8/4R9



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

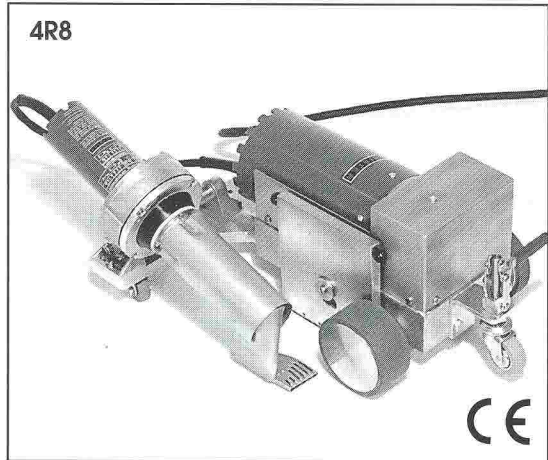


APPLICATION

LEISTER Variant (4R8) Automatic Overlap Welder

- Overlap welding of single ply roofing membranes made of PVC, PE, ECB, EPDM, CSPE and Modified Bitumen.
- Overlap welding of foils and coated materials.

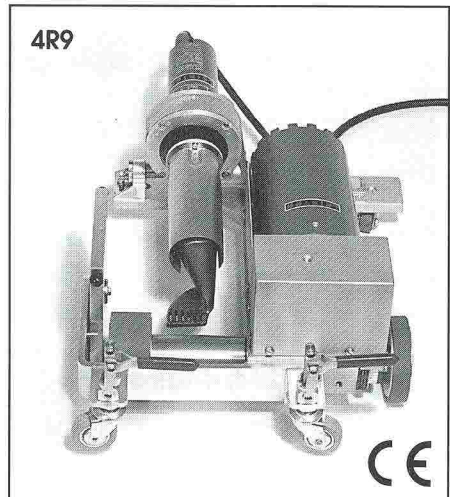
Width of welding seam:
40 mm or 20 mm



LEISTER Variant (4R9) Automatic Overlap Welder

- Overlap welding of single ply roofing membranes made of PVC, PE, ECB, EPDM, CSPE and Modified Bitumen **for areas near edges.**

Width of welding seam: 40 mm





WARNING



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



Incorrect use of the Hot Air Automatic Welders can present a **fire and explosion hazard**.



CAUTION



The **voltage rating** stated on the tool should correspond to the mains voltage.



For personal protection, we strongly recommend the tool be connected to an **RCCB (Residual Current Circuit Breaker) / GFCI (Ground Fault Circuit Interrupter)** before using it on building sites.



Do not touch the element housing and nozzle when hot as it can **cause burns**.



The equipment should **not** be operated without **supervision**.



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

TEST SIGNS



and others

TECHNICAL DATA

electrical safety double insulated

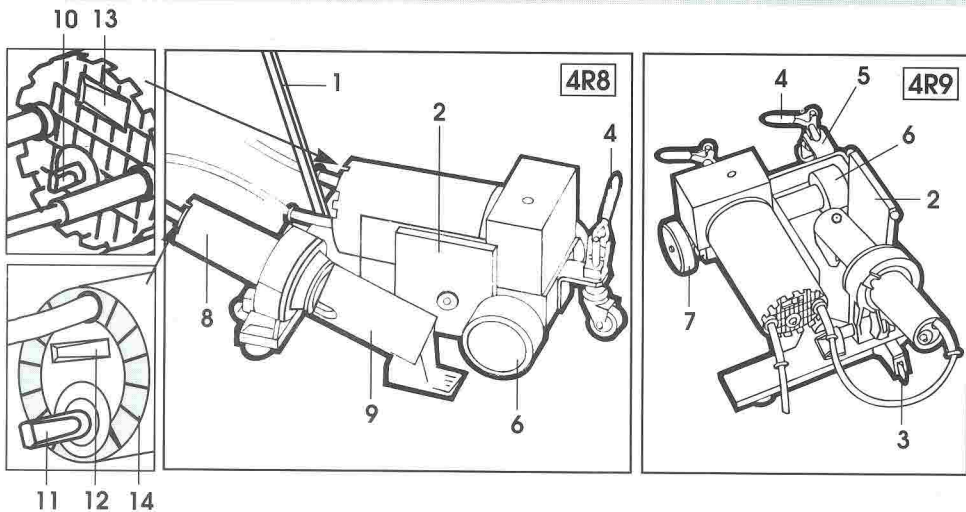
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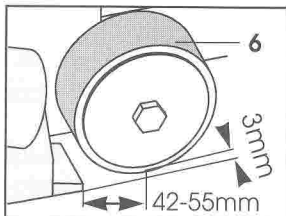
Voltage	V~	230 / 400 ★	230 / 400 ★
Frequency	Hz	50 / 60	50 / 60
Capacity	W	4200 / 5200	4200 / 5200
Temperature	°C	20 - 650	20 - 650
Air flow	l/min.	400 - 600	400 - 600
Drive speed	m/min.	0,5 - 12,0	0,5 - 12,0
Noise level	dB (A)	67	67
Size	mm	610x395x270	620x410x270
Weight	kg	18,9	22,5

★ Mains voltage cannot be switched over

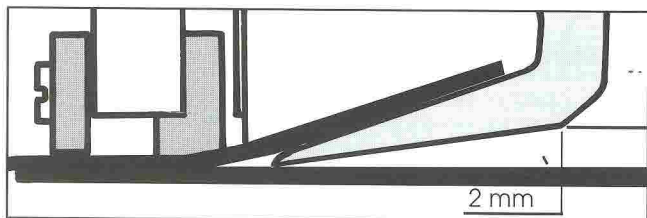


Operating Condition

- The basic adjustment of the **nozzle (9)** is set at the factory (details A and B).
- Attach the **guiding handle (1)**.
- Lift up the **brass plate/roller installation (2)**. Lift up the **guide roller (3)**.
- Move the **welder (8)** right out and swivel it upwards until it locks.
- Connect tool to the mains.



Detail A



Detail B

Positioning of tool

- Operate the **lever (4)** of the **lifting device (5)**, in order to put the **pressure roller (6)** and the **drive wheel (7)** in neutral.
- Position the automatic welder on the overlap of the material to be welded. At the same time, the outside edge of **pressure (6)** must be level with the edge of the overlap of the material to be welded.
- Operate the **lever (4)** to make the automatic welder ready for use.
- Adjust the **guide roller (3)** to the edge of the overlap, so that the automatic welder sits parallel to the welding line.
- Lower the **brass plate/roller installation (2)**. Lower the **guide roller (3)**.

Welding parameter

- Adjust the welding speed via the **potentiometer (10)**.
- The tool's own weight produces the contact pressure.
- Adjust the welding temperature via the **potentiometer (11)** and switch on the **Hot Air blower (12)**, letting it warm up for about 5 minutes.

Welding procedure

- Lower the **welder (8)** and guide it between the overlapped sheets as far as it will go, at the same time switching on the **drive motor (13)**.
- The automatic welder is guided along the overlap by the **guiding handle (1)**. Keep watching the position of the **guide roller (3)**.
- Regulate the welding procedure. If necessary alter the welding speed with the **potentiometer (10)**.
- After the welding process, move the **welder (8)** right out and swivel it upwards until it locks.
- Switch off **drive motor (13)**.
- After completion of the welding operation, set the **potentiometer (11)** to zero, to let the Hot Air blower cool down. Then switch off the **Hot Air blower (12)**.

TRAINING

The LEISTER Company and its authorized Service Centres offer welding courses world-wide free of charge. If necessary, the customer will also receive training on site.

MAINTENANCE

- The machine's **air filter (14)** should be cleaned when dirty with a fine brush.
- A wire brush should be used for cleaning the **welding nozzle (9)**.

SERVICE AND REPAIR

- The carbon brushes in the motors should be checked after about 1000 hours running time by your Service Centre.
- Repairs should only be carried out by authorized **LEISTER Service Centres**. These guarantee a specialized and reliable **repair service within 24 hours** using original spare parts. The LEISTER Company refuses any guarantee and liability for repairs which have not been carried out by one of the authorized LEISTER Service Centres using LEISTER spare parts.

NOTICE

- The LEISTER Company rejects any guarantee for tools which are not in their original condition. Under no circumstances should LEISTER tools be altered or changed.

Your authorized Service Centre is: