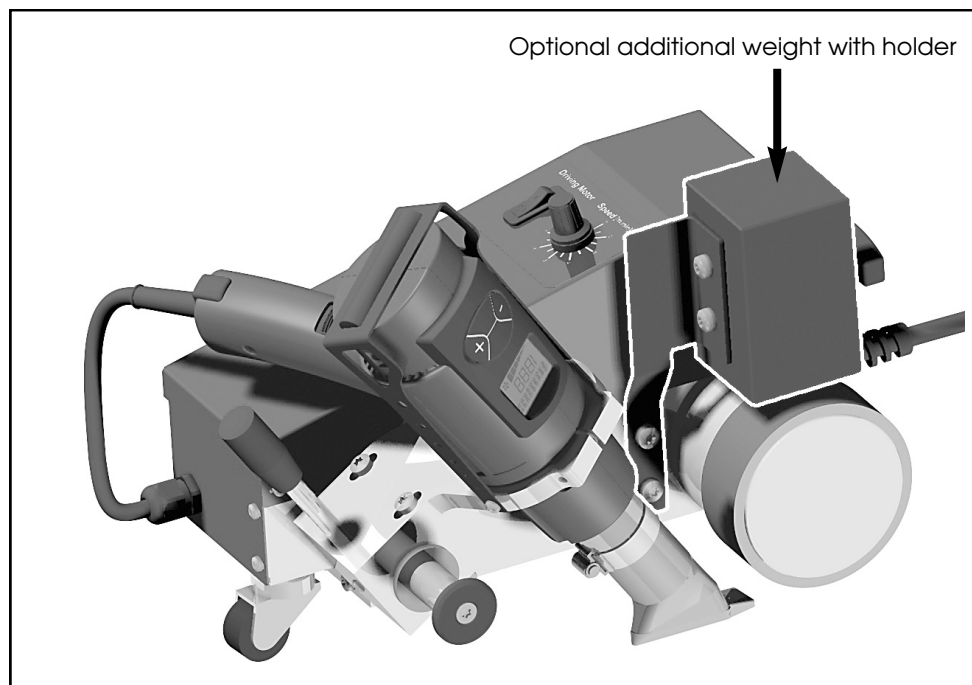


FOILER

Automatic hot-air welding machine

Automatic Overlap Welding Machine

- For overlap welding of industrial fabrics (PVC, PP, PE, etc...)
- Welding seam width 20 or 30 mm



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



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 end of 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.



Connect tool to a **receptacle with protective earth terminal**. Any disconnection of the protective conductor in or outside the tool is dangerous!

Use line/mains extension cables with protective earth/ground conductor and adequate cross sectional area only!



Caution



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

In the case of a **power cut**, the **Drive switch (11)** and **air blower switch (13)** has to be set to **0**.



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



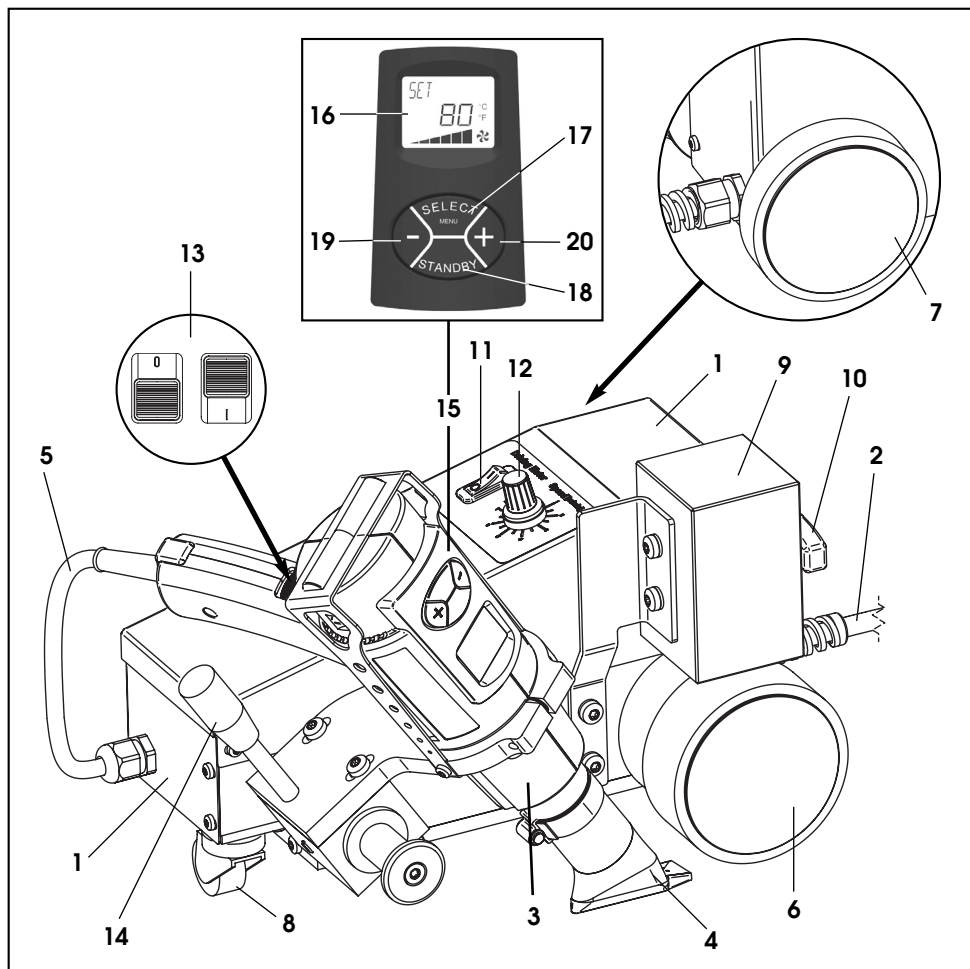
The tool must be operated **under supervision**. Heat can ignite flammable materials which are not in view. The machine may only be used by **qualified specialists** or under their supervision. Children are not authorized to use this machine.



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

Technical data

Voltage	V~	230
Frequency	Hz	50 / 60
Capacity	W	2100
Temperature	°C	80 – 530
Air flow (20°C)	l/min.	200 – 270
Drive speed	m/min.	1.0 – 7.5
Noise emission level	L _{PA} (dB)	76
Dimensions	mm	445□276□280
Weight	kg	10.8
Protection class I		Ⓢ



Main components

1. Housing/chassis
2. Power supply cord
3. Hot air blower
4. Welding nozzle
5. Connection cable
6. Drive/pressure roller
7. Drive roller
8. Steering roller
9. Additional weight (optional)
10. Carrying handle

Operating components

11. Drive switch
12. Potentiometer for welding speed
13. Air blower switch
14. Positioning lever
15. Terminal
16. Display
17. Button SELECT Menu
18. Button STANDBY/COOL DOWN
19. Button MINUS
20. Button PLUS

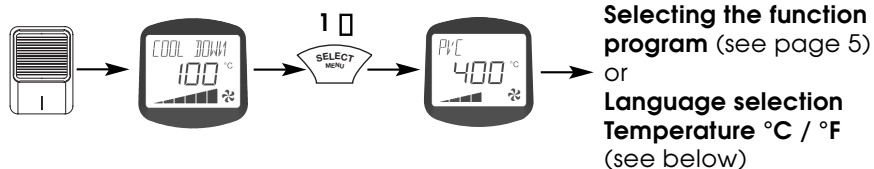
Observe the mains voltage

The voltage of the power source must correspond with the value given on the nameplate of the unit. Extension cords must have a conductor cross section of $3 \times 1.5 \text{ mm}^2 \text{ min.}$

Switching on

Set the **air blower switch (13)** to I. Push 1 x on button **SELECT (17)**.

The heating process starts with the last-saved settings. Select the desired program or program the temperature and air flow as required.



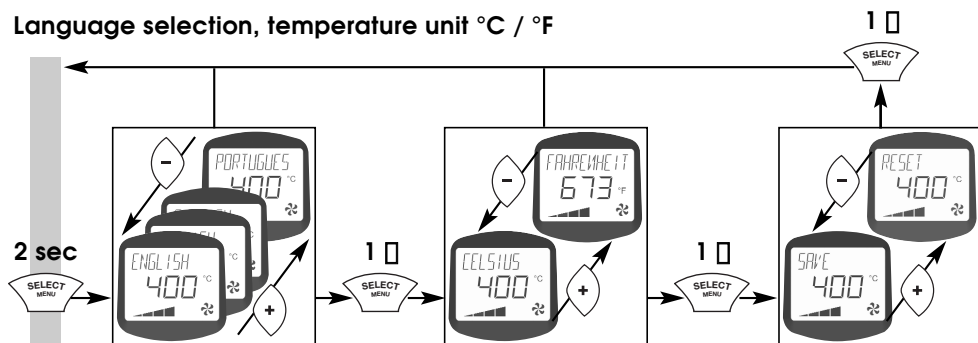
Switching off

To cool down the unit, have it operate on **COOL DOWN** (see «Settings»). When the unit has cooled off, set the **air blower switch (13)** to 0.

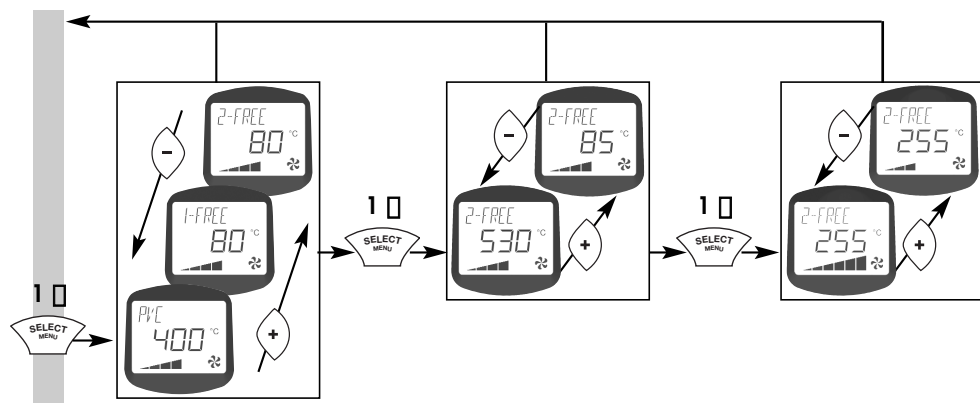
Adjusting the settings on the terminal (15)

Begin the selection with the **button SELECT Menu (17)**. Note: When an indication flashes in the **display (16)**, a change can be initiated with either **button PLUS (20)** or **button MINUS (19)**. Repeated actuation of **button SELECT (17)** leads to the next step.

Language selection, temperature unit °C / °F



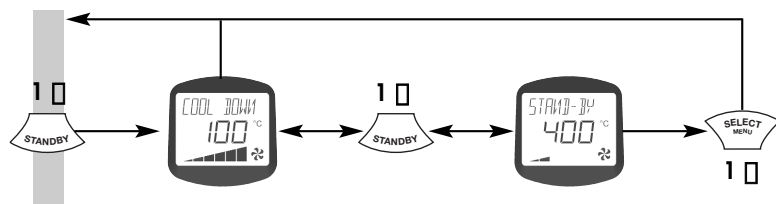
Selecting the function program



1. Welding PVC
2. 1-Free setting
3. 2-Free setting

The buttonword of the selected function program is indicated by flashing. Longer text begins to move after 2 seconds and returns to the buttonword after 2 passes. Within this period, the button **SELECT Menu (17)** can be pressed again to adjust the temperature or the air flow.

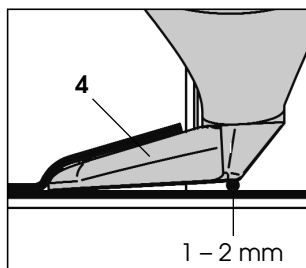
Selecting STANDBY or COOL DOWN



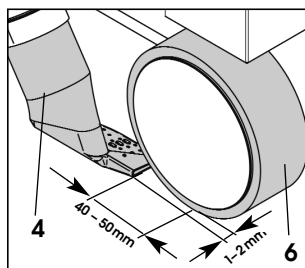
- Press 2 **button STANDBY (18)** when interrupting your work for short time. The energy absorption is reduced.
- At the end of your work, always select **COOL DOWN** with **button STANDBY (18)**. When the unit has cooled off, switch it off with the **air blower switch (13)** and pull the plug from the receptacle.

Operating condition

- Check the **welding nozzle (4)** basic setting. (Detail A and Detail B).
- Connect the tool to the mains. The mains voltage must correspond with the voltage rating stated on the tool.



Detail A



Detail B

Operating Instructions

- Perform a test welding according to the welding instructions of the material manufacturer and the national standards or guidelines. Check the test welding. Adapt the welding temperature (welding parameters) as required.

Tool positioning

- Turn **hot air blower (3)** using **positioning lever (14)** up to the stop.
- Position the automatic welding machine on the overlap of the material to be welded. The outside edge of **drive/pressure roller (6)** must line up with the overlap edge of the material to be welded.

Welding parameters

- Set **potentiometer for welding speed (12)** to the required value.
- Set the **air blower switch (13)** to position I. Set temperature and air flow to the required value (see page 5) and heat up for about 5 minutes.
- The contact pressure is effected through the weight of the automatic hot air welding machine itself. Use the additional weight accessory as required (see assembly of additional weight, page 7).

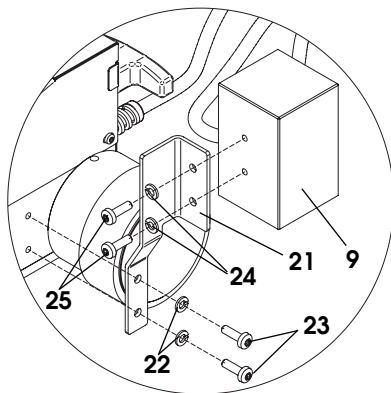
Welding procedure

- Turn the **hot air blower (3)** up to the stop using **positioning lever (14)** and at the same time turn on the **drive switch (11)** (the welding process starts).
- Supervise the welding process. As necessary correct the welding speed with the **potentiometer (12)**. Lead the automatic welding machine by its chassis along the length of the overlap.
- When welding has finished, swing up the **hot air blower (3)** to the stop by means of the **positioning lever (14)**.
- Switch off the **drive switch (11)**.
- After completing welding work, press the button **STANDBY (18)**, so that the **hot air blower (3)** cools down. Then turn off the **air blower switch (13)**.
- Disconnect the tool from the mains.

Assembly of additional weight

- Fasten the **additional weight holder (21)** to the FOILER machine with **spring washer (22)** and **Lens head screw (23)**.
- Fasten the **additional weight (9)** to the **additional weight holder (21)** with **spring washer (24)** and **lens head screw (25)**.

9. Additional weight
21. Additional weight holder
22. Spring washer
23. Lens head screw M6 × 20
24. Spring washer
25. Lens head screw M6 × 20



Accessories

- Only Weldy accessories should be used.
- Additional weight with holder

Training

- Leister Technologies Ltd. and their authorised service centres offer welding courses.

Maintenance, Service and Repair

- For safe and efficient working, always keep the unit and its ventilation slots clean.
- Clean **welding nozzle (4)** with wire brush.
- Check **mains connection (2)** and plug for electrical and mechanical damage.

If the unit should fail despite the care taken in manufacture and testing, repair should be carried out by an authorized customer service centres using original spare parts.

Warranty

- For this tool, we generally provide a warranty of six (6) months from the date of purchase (verified by invoice or delivery document). Damage that has occurred will be corrected by replacement or repair. Heating elements are excluded from this warranty.
- Additional claims shall be excluded, subject to statutory regulations.
- Damage caused by normal wear, overloading or improper handling is excluded from the guarantee.
- Guarantee claims will be rejected for tools that have been altered or changed by the purchaser.

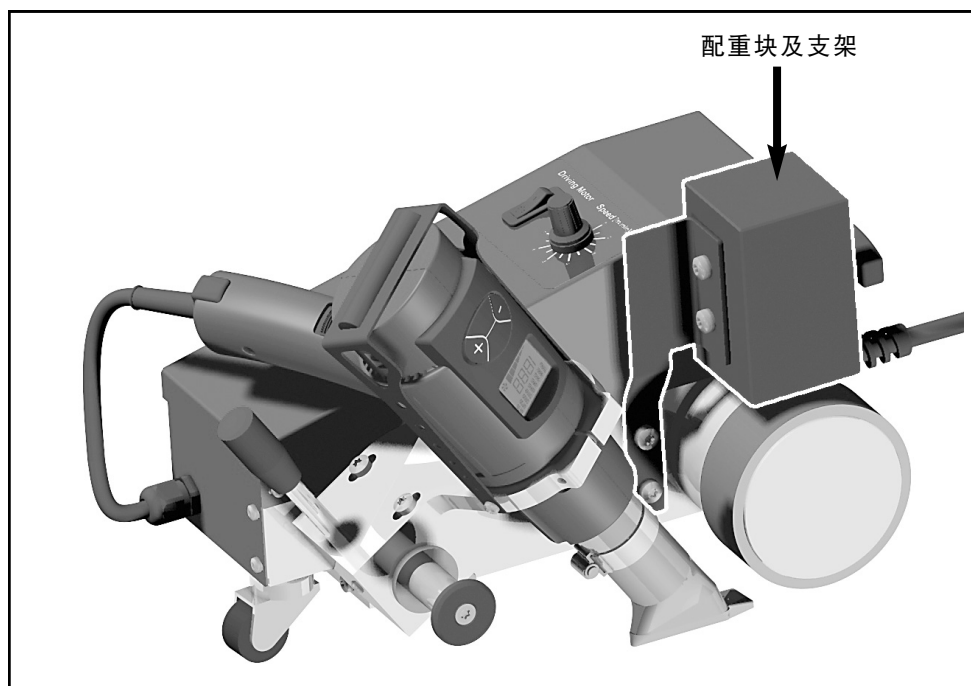
Technical data and specifications are subject to change without prior notice.

Your authorized service centre is:

FOILER 塑料热风自动焊接机

交叠式自动焊接机

- 用于塑料涂层工业织物的焊接(PVC, PP, PE等)
- 焊缝宽度为 20 或 30 mm



请在使用之前仔细阅读使用说明，并妥善保留说明书以备将来参考。



警告



危险!

拔下电源线之前请勿打开机器外壳，否则内部的带电元件有可能造成危险。



不正确地使用机器可能会引起**火灾和爆炸事故**，尤其当附近有易燃品或易爆气体时更是如此。



谨防烧伤! 机器冷却之前，请勿碰触加热管和焊接风嘴。当机器处于加热状态时，请勿将风嘴指向人或其它动物以免造成误伤。



将机器连接到**接有地线保护的插座**上。机器内部或外部的任何保护性导线的失效都有可能发生危险!
当使用绕线盘上的电源线时，最好也采取接地保护措施；此外，电源线要有足够的横截面积!



注意



使用的电压必须与机器铭牌上面标明的**额定电压**相一致。在**电源断开**的情况下，**驱动开关 (11)** 和**风机开关 (13)** 必须置于 **0** 位。



为了保护操作者的人身安全，强烈建议在使用设备之前安装**漏电保护器 (RCCB)**。



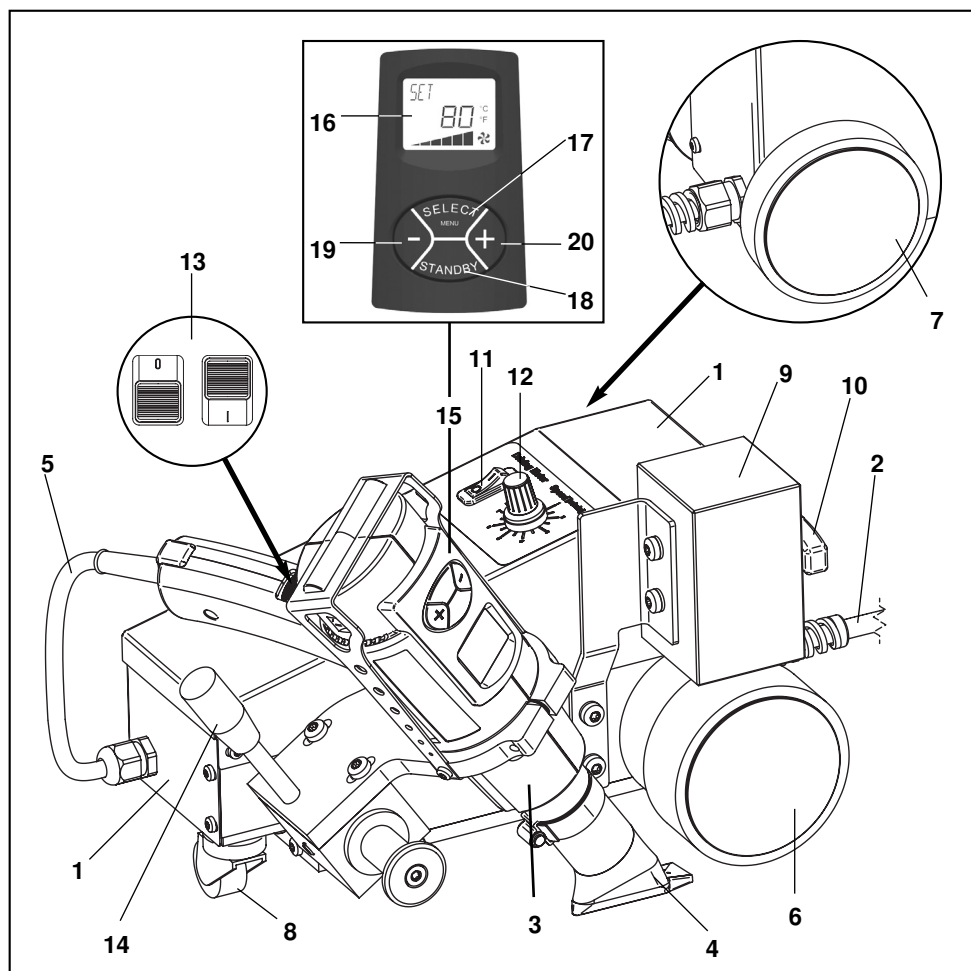
设备运行过程中，操作者必须在现场监控其使用情况。机器产生的热可能会引燃不为人注意到的易燃品。设备操作者必须有相应的资格认证，或者在他们的指导下由其他人进行操作。严禁儿童使用机器。



机器**严禁浸水**，**雨淋**或置于**潮湿**的环境之中。

技术参数

电压	V~	230
频率	Hz	50 / 60
功率	W	2100
温度	°C	80 – 530
风量 (20 °C)	l/min.	200 – 270
驱动速度	m/min.	1.0 – 7.5
噪音值	L _{PA} (dB)	76
外观尺寸	mm	445□276□280
重量	kg	10.8
保护等级 I		⚡



主要组成部分

1. 外壳/底盘
2. 电源线
3. 热风机
4. 焊接风嘴
5. 连接线
6. 驱动/压力轮
7. 驱动轮
8. 导向轮
9. 配重块 (可选组件)
10. 搬移用手柄

操作部分组件

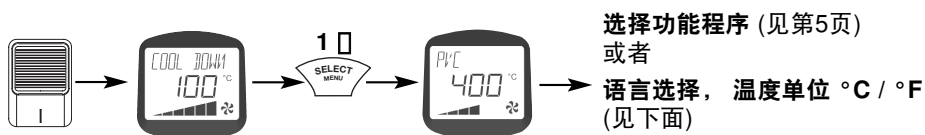
11. 驱动开关
12. 焊接速度调节旋钮
13. 风机开关
14. 风嘴定位杆
15. 参数调节终端
16. 显示器
17. 选择菜单按钮
18. 待机/冷却按钮
19. 减小功能按钮
20. 增大功能按钮

检查电源电压

电源电压必须和设备铭牌上所标电压相一致。当使用绕线盘时，其导线的横截面积最小应为 $3 \times 1.5 \text{ mm}^2$ 。

开机 将风机开关 (13) 置于 I 位置。按一次选择按钮 (17)。

加热过程执行上次开机后保存的工艺参数。请选择所需要的程序，或者根据要求调整程序中相关的温度和风量等工艺参数。



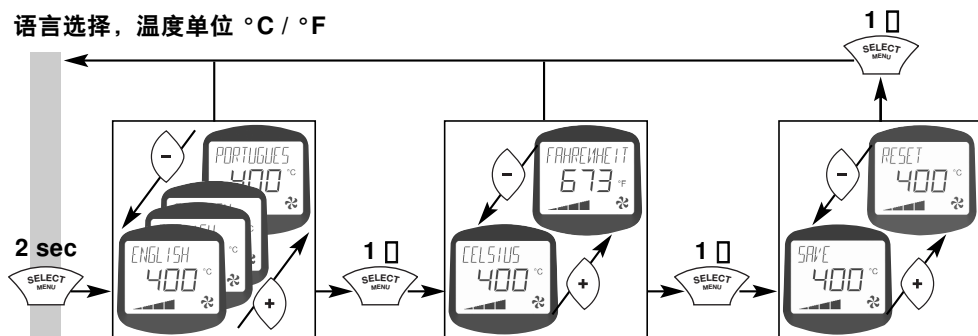
关机

为使机器尽快冷却，须使设备在冷却功能程序的状态下运行(见«设置»)。完全冷却之后，将风机开关 (13) 置于 0 位。

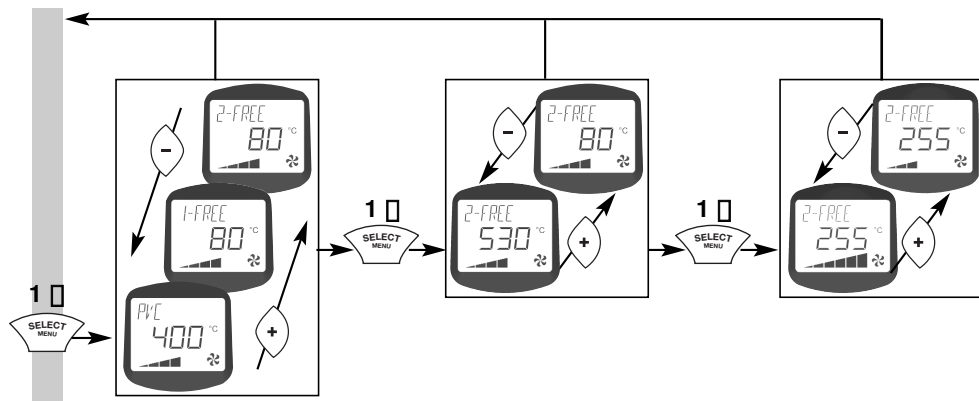
调节终端 (15) 的设置

通过选择菜单按钮 (17) 进行选择。注意：当提示信息在显示屏 (16) 中闪烁时，才能通过调节增大按钮 (20)或减小按钮 (19) 改变相关的参数。重复激活按钮 (17) 以进行下一步操作。

语言选择，温度单位 °C / °F



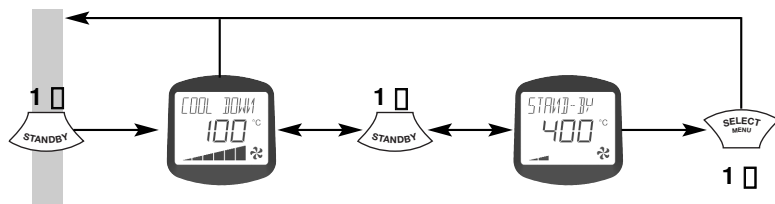
选择功能程序



1. 焊接PVC
2. 1-自由设置
3. 2-自由设置

功能程序选定之后，其标题会在显示屏上闪烁出现。如果标题内容较长，它们会在2秒钟后在显示屏上相应位置移动从而全部显示，该部分内容显示两遍，然后继续只显示功能程序标题。在这段时间之内，再次按下**选择菜单 (17)** 按钮以调节温度或者风量。

选择待机或冷却



- 当需要暂时中止工作时，按两次**待机按钮 (18)**，以降低功率消耗。
- 当工作结束时，必须通过**待机按钮 (18)** 选择冷却功能操作。当机器完全冷却之后，断开风机电源开关，然后从插座上拔出主电源线。

操作前准备

- 检查焊接风嘴 (4) 的安装位置。(见图 A 和图 B)
- 接通主电源，其电压必须与机器铭牌上面标明的额定电压相一致。

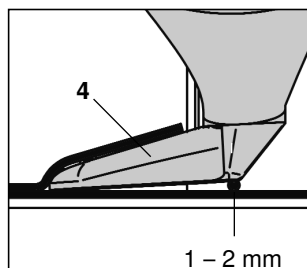


图 A

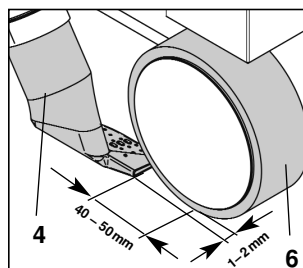


图 B

操作指导

- 根据相关国家的标准或规定以及材料供应商的建议，先对材料进行测试性焊接，检查焊接质量。必要时调节焊接温度（或其它焊接工艺参数）以满足工作要求。

机器定位操作与放置

- 通过定位杆 (14) 移动热风机 (3) 直至停止位置。
- 将机器放在材料交叠部分的端部，驱动/压力轮 (6) 的外部边缘必须和材料交叠部分的边缘对齐。

焊接工艺参数

- 将焊接速度调节旋钮 (12) 旋至所需要的数值。
- 将风机开关 (13) 置于 I 位，并将温度和风量设定为需要的数值 (见第 5 页)，然后加热 5 分钟左右。
- 接触压力通过热风自动焊接设备本身的自重提供。必要时，可选用配重块 (见第 7 页配重块附件组)。

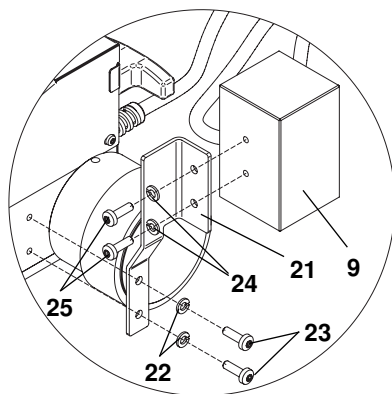
焊接程序

- 通过定位杆 (14) 移动热风机 (3) 直至停止位置，同时接通驱动开关 (11) (焊接过程开始)。
- 操作者应监控整个焊接过程。必要时可通过电位计旋钮 (12) 调节焊接速度。通过调节机器的底盘可引导设备在整个焊接过程中沿着预定的方向行走。
- 焊接过程完成之后，迅速移开定位杆 (14) 将热风机 (3) 重新放置在停止位置。
- 断开驱动开关 (11)。
- 整个焊接工作结束之后，按待机旋钮 (18)，热风机 (3) 冷却，然后断开风机开关 (13)。
- 断开机器主电源。

配重块附件组

- 用弹簧垫片 (22) 和内六角螺丝 (23) 将配重块支架 (21) 固定在 FOILER 机器上面。
- 用弹簧垫片 (24) 和内六角螺丝 (25) 将配重块 (9) 固定在支架 (21) 上面。

- 9. 配重块
- 21. 配重块支架
- 22. 弹簧垫片
- 23. 内六角螺丝 M6 × 20
- 24. 弹簧垫片
- 25. 内六角螺丝 M6 □ 20



附件

- 只允许使用莱丹公司的 Weldy 附件。
- 配重块须配合支架使用。

培训

- 莱丹塑料焊接技术（上海）有限公司及其授权的服务中心提供培训服务。

维护, 服务和维修

- 为了安全和有效率地使用机器，不工作时，请保持设备整体尤其是出风通路部位的清洁。
- 用软质的钢丝刷清洁**焊接风嘴 (4)**。
- 检查**电源线连接部位 (2)** 和插头，确认是否存在电性能和机械性能方面的损坏。

如果机器有故障，即使它还处在生产和测试过程之中，也必须交由授权的服务中心使用原装配件进行维修。

保修

- 一般情况下，自机器售出之日起，莱丹公司提供六（6）个月的保修期（通过发票或运单确认）。如有损坏，莱丹及其授权服务中心将负责更换零部件或维修。加热管不在保修范围之内。
- 根据相关的法律或其它规定，莱丹不接受另外的来自客户的权利要求。
- 由正常磨损，电压过载或人为操作不当等原因造成的损坏则不予保修。
- 如果客户事先改装或改变过设备，莱丹公司则不予提供保修。

技术参数和规格型号有时会有变化，莱丹不承担主动告知的义务。

您的授权服务中心是：