



PLASTIC WELDING

Plastic Fabrication

Swiss
made 

Extrusion and hot-air hand welders

The right choice for the specialist







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!

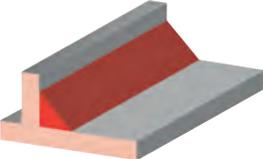
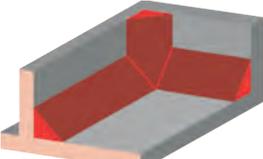
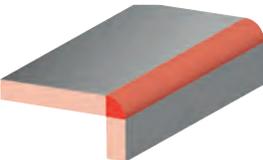
Reto Britschgi
Product Manager Plastic Fabrication

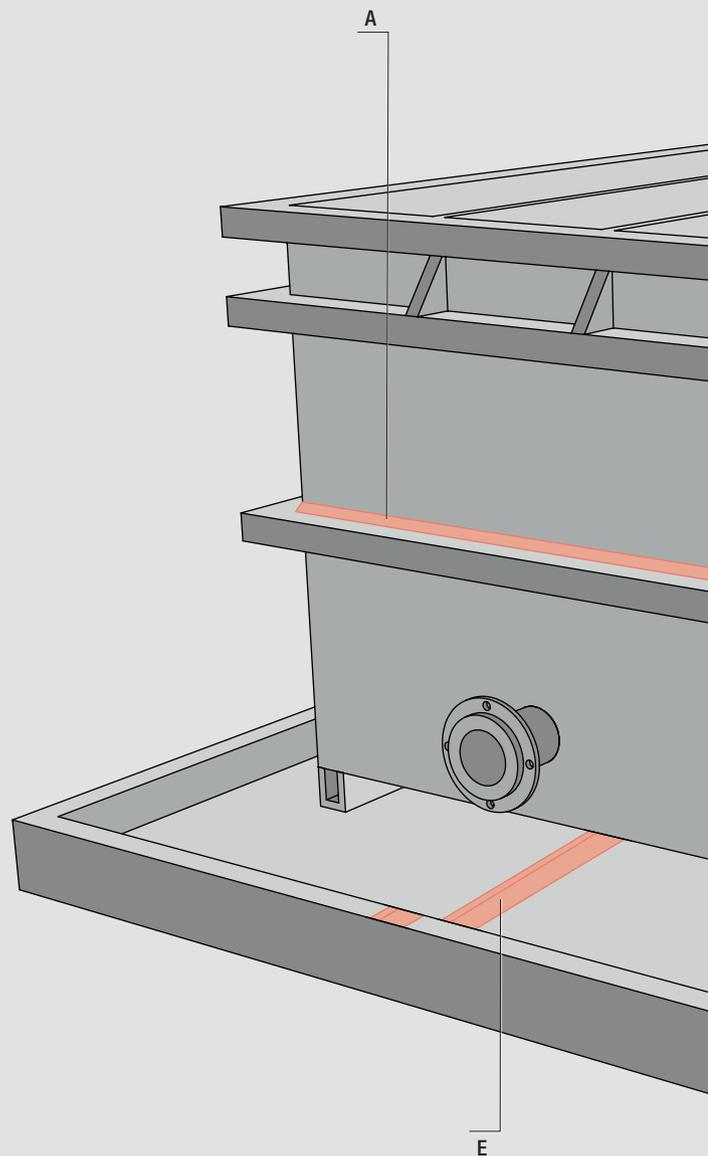
Plastic welding with Leister

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

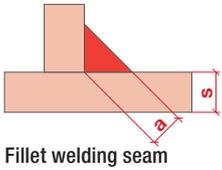
Welding seam geometries galvanic tank

A 	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.
B 	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.
C 	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).



Possibilities of welding seams

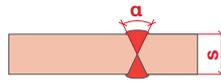
a = seam size s = material thickness α = milling angle



Fillet welding seam

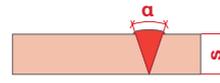


Corner outside seam



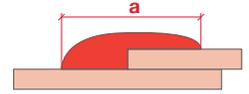
X-seam

s = 10 – 40 mm = α 60°
s = 50 – 60 mm = α 50°

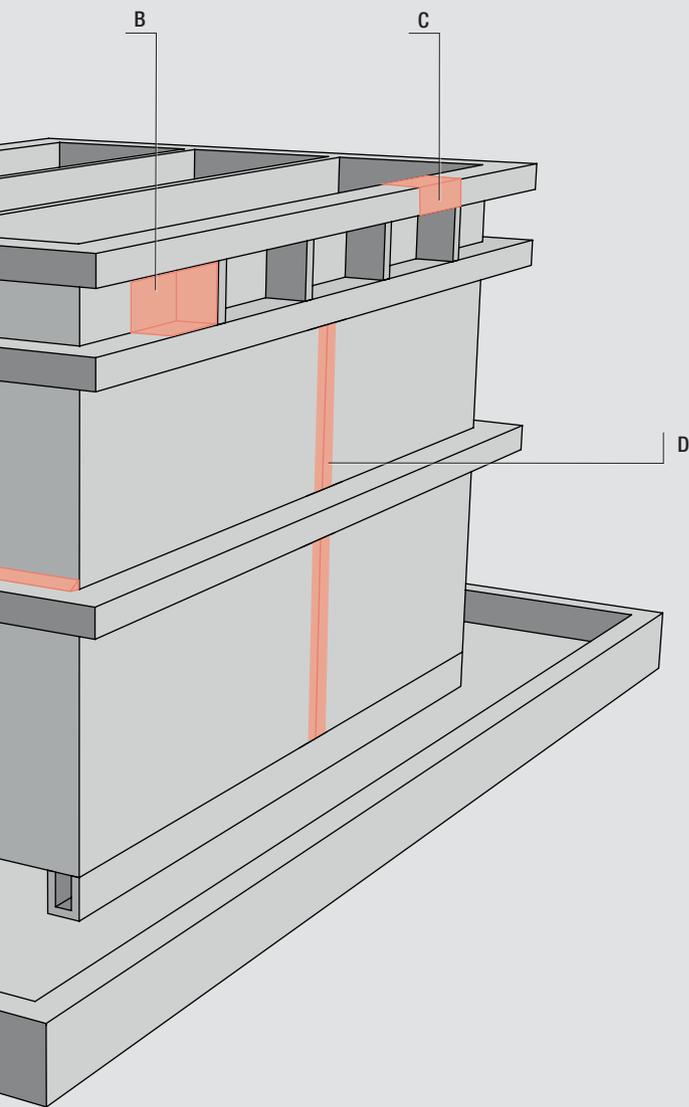


V-seam

s = 5 – 20 mm = α 60°
s = 25 – 30 mm = α 50°

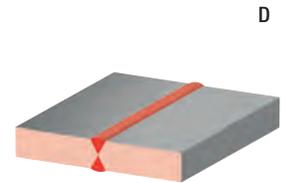


Overlap seam



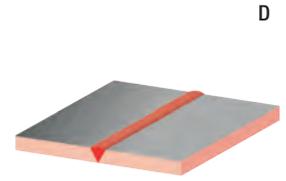
X-seam

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.



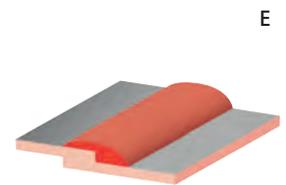
V-seam

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

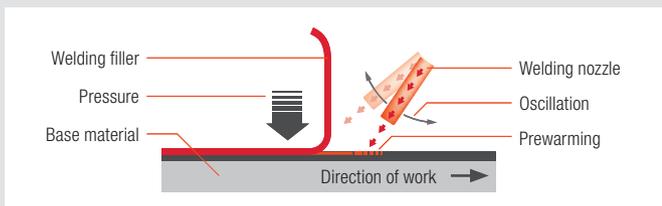
Thermal joining of plastics

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.

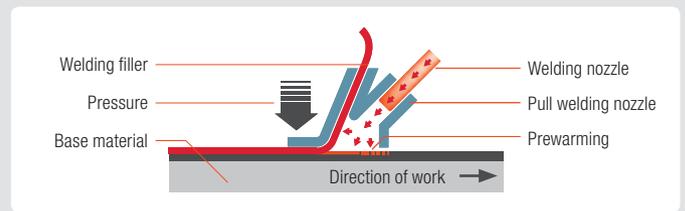
Hot gas welding with the torch separate from filler rod (WF)

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)

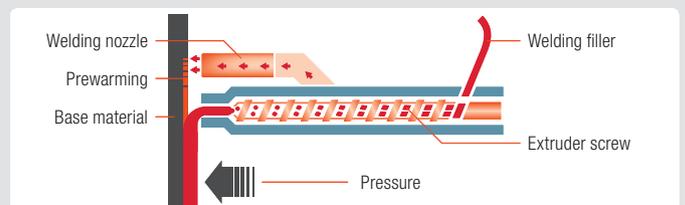
Hot gas extrusion welding is preferred over high-speed hot gas welding for wall thicknesses from about 6 mm. With extrusion welding, shorter working times, higher strength and lower internal stress is expected compared to manual welding. This leads to higher process reliability and greater efficiency.

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⁾ °F	Hot gas volume flow ²⁾ cfm	Welding speed ³⁾ inch/min	Welding force (N) with wire ø	
						0.12 inch	0.15 inch
Free hand welding (WF)	High-density polyethylene	PE-HD ⁴⁾	572 ... 608	1.4 ... 1.8	2.7 ... 3.5	0.3 ... 0.4	0.8 ... 1.0
	Polypropylene, Types 1, 2, 3	PP-H; PP-B; PP-R	581 ... 599	1.4 ... 1.8	2.4 ... 3.3	0.3 ... 0.4	0.8 ... 1.0
	Unplasticised polyvinyl chloride	PVC-U	626 ... 662	1.4 ... 1.8	4.3 ... 6.7	0.3 ... 0.4	0.8 ... 1.0
	Chlorinated polyvinyl chloride	PVC-C	644 ... 680	1.4 ... 1.8	2.2 ... 3.3	0.6 ... 0.8	0.8 ... 1.0
	Polyvinylidene fluoride	PVDF	662 ... 698	1.4 ... 1.8	1.8 ... 2.0	0.6 ... 0.8	1.0 ... 1.2
	Acrylonitrile butadiene styrene	ABS ⁶⁾	662	N/A	N/A	N/A	N/A
	Polycarbonate	PC ⁶⁾	662	N/A	N/A	N/A	N/A
	Polyamide	PA ⁶⁾	752	N/A	N/A	N/A	N/A
	Polybutylene terephthalate	PBT ⁶⁾	662	N/A	N/A	N/A	N/A
	Low-density polyethylene	PE-LD ⁶⁾	518	N/A	N/A	N/A	N/A
	Polyurethane	PUR (Thermoplast) ⁶⁾	572	N/A	N/A	N/A	N/A
	XENOY	XENOY PC/PBTB ⁶⁾	662	N/A	N/A	N/A	N/A
	Plasticised polyvinyl chloride	PVC-P ⁶⁾	662	N/A	N/A	N/A	N/A
	Polyethylene terephthalate glycol-modified	PETG ⁶⁾	392 ... 419	N/A	N/A	N/A	N/A
Draw welding (WZ)	Polyvinyl chloride	PE-HD	572 ... 644	1.6 ... 1.9	9.8 ... 13.8	0.6 ... 0.8	1.0 ... 1.4
	Polypropylene, Types 1, 2, 3	PP-H; PP-B; PP-R	572 ... 644	1.6 ... 1.9	9.8 ... 13.8	0.6 ... 0.8	1.0 ... 1.4
	Unplasticised polyvinyl chloride	PVC-U	662 ... 698	1.6 ... 1.9	9.8 ... 13.8	0.6 ... 0.8	1.0 ... 1.4
	Chlorinated polyvinyl chloride	PVC-C	698 ... 734	1.6 ... 1.9	7.0 ... 8.7	0.6 ... 1.0	1.2 ... 1.4
	Polyvinylidene fluoride	PVDF	689 ... 725	1.6 ... 1.9	7.9 ... 9.8	0.6 ... 1.0	1.2 ... 1.4
	Ethylene Chloro Tri Fluoro Ethylene	E/CTFE ⁵⁾	662 ... 716 ⁵⁾	1.8 ... 2.1 ⁵⁾	8.6 ... 9.8	0.4 ... 0.6	N/A
	Fluorinated ethylene propylene	FEP	716 ... 734	1.8 ... 2.1	2.4 ... 3.1	0.4 ... 0.6	N/A
	Tetrafluorethylen Perfluormethylvinylether	MFA	743 ... 761	1.8 ... 2.1	2.4 ... 3.1	0.4 ... 0.6	N/A
	Perfluoroalkoxy alkanes	PFA	752 ... 770	1.8 ... 2.1	2.7	0.4 ... 0.6	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	210 ... 300	300	300
	Polypropylene, Types 1, 2, 3	PP-H; PP-B; PP-R	210 ... 240	210 ... 300	300	300
	Unplasticised polyvinyl chloride	PVC-U	190 ... 200	330 ... 360	300	300
	Impact resistant polyvinyl chloride	PVC-HI	170 ... 180	280 ... 340	300	300
	Chlorinated polyvinyl chloride	PVC-C	195 ... 205	300 ... 360	300	300
	Polyvinylidene fluoride	PVDF	240 ... 260	280 ... 350	300	300
	Polyamide 6 ⁶⁾	PA 6	280	315	300	300
	Polycarbonate ⁶⁾	PC	270	315	270	300
	Acrylonitrile butadiene styrene ⁶⁾	ABS	265	300	150	300
	Polystyrene ⁶⁾	PS	245	280	300	300
	Polypropylen Athylen Propylen Terpolymer ⁶⁾	PP-EPDM	200 ... 230	200 ... 290	300	300
	Polyurethane (Thermoplast) ^{6) 7)}	PUR	180	260 ... 300	300	300

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⁾ Depending on the preheating

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...

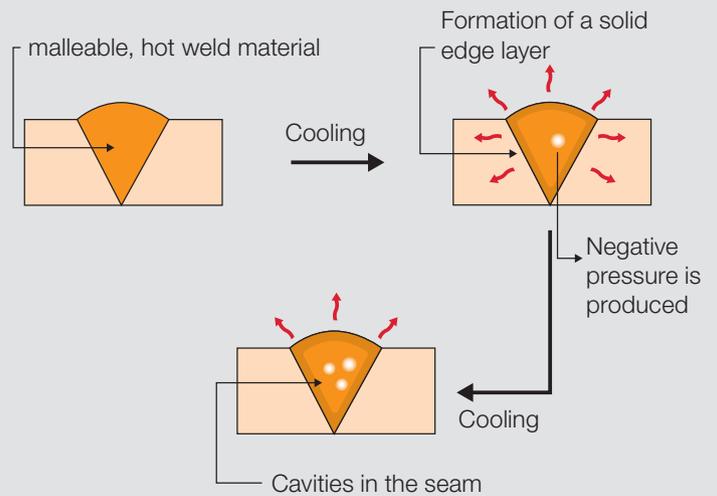
- ...the welding shoe is too short.
- ...the welding shoe is too cold.
- ...the surface over which the welding shoe glides is too rough.



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 www.collini.eu



Working boats mad of polypropylene



WELDPLAST S2



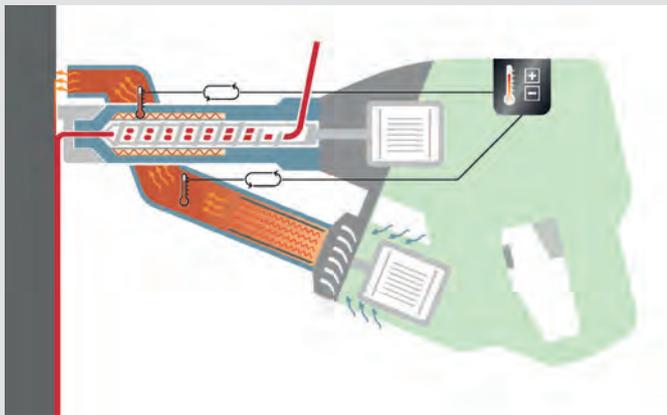
FUSION 3 C

WELDPLAST - Closed loop system

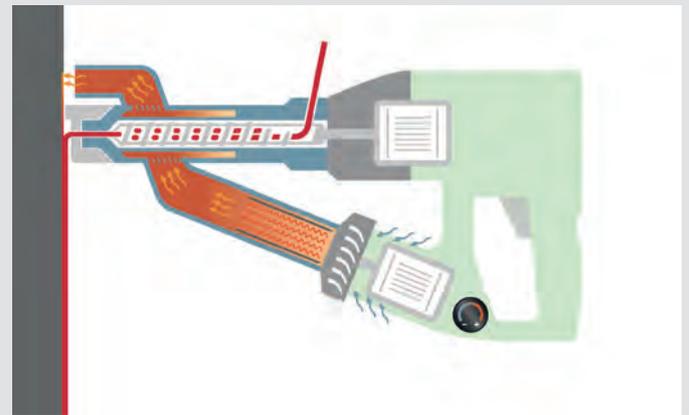
- Closed-loop control
- Little welding experience required
- Integrated display and temperature probe
- Precise temperature independent of environmental factors or quality of voltage source -> process reliability
- DVS-compliant

FUSION - Open loop system

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

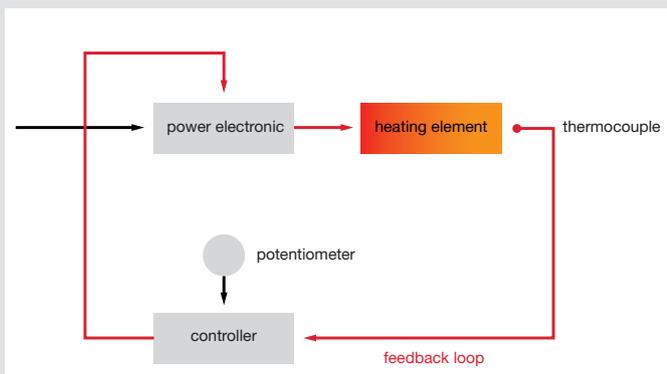


WELDPLAST

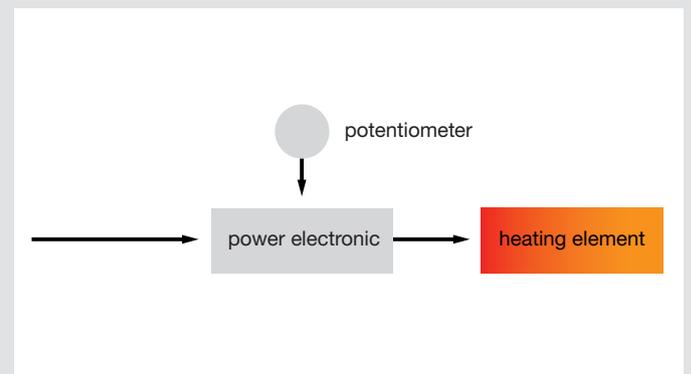


FUSION

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
-  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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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				Analog extrusion welders			
								
Device type	WELDPLAST S6	WELDPLAST S4	WELDPLAST S2	WELDPLAST S1	FUSION 3	FUSION 3C	FUSION 2	FUSION 1
Output (HDPE) lbs/hr	8.6 – 13.2	3.3 – 8.8	1.3 – 5.0	0.4 – 1.8	3.5 – 7.7	3.5 – 7.7	2.9 – 4.0	0.6 – 1.7
Material	HDPE, PP	HDPE, PP	HDPE, PP, PVC	PE, PP, PVC, etc.	HDPE, PP	HDPE, PP	HDPE, PP	PE, PP
Wall thickness inches	$\frac{19}{32} - 1 \frac{19}{32}$	$\frac{5}{16} - 1 \frac{13}{32}$	$\frac{5}{32} - \frac{13}{16}$	$\frac{5}{32} - \frac{13}{32}$	$\frac{5}{16} - 1$	$\frac{5}{16} - 1$	$\frac{1}{4} - \frac{19}{32}$	$\frac{5}{32} - \frac{13}{32}$
Welding rod Ø inches	$\frac{5}{32} - \frac{3}{16}$	$\frac{1}{8} - \frac{5}{32} / \frac{5}{32} - \frac{3}{16}$	$\frac{1}{8} - \frac{5}{32}$	$\frac{1}{8} - \frac{5}{32}$	$\frac{1}{8} - \frac{5}{32} / \frac{5}{32} - \frac{3}{16}$	$\frac{3}{16}$	$\frac{3}{16}$	$\frac{1}{8}$ or $\frac{5}{32}$
Weight lbs	31	18	13	10	16	15	13	7.5
Length inches	32	22	18	17	27	23	18	17
Voltage V~	230	230	230	120 / 230	230	230	230	120
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

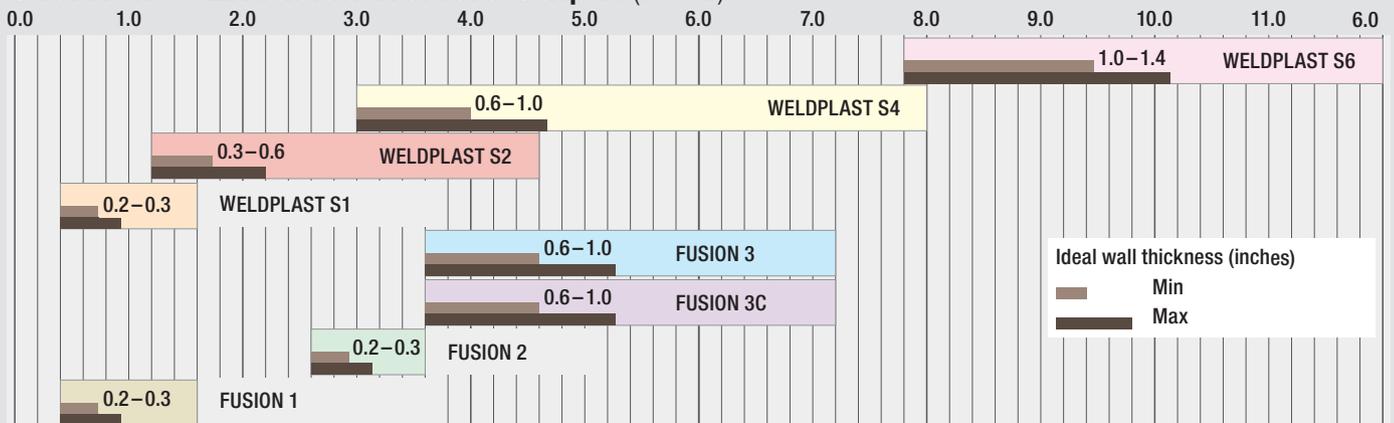
✓✓ very suitable ✓ suitable ○ unsuitable

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 (lbs/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

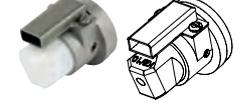
Voltage	V~	120
Power	W	1450
Materials		PE, PP
Welding rod Ø	inch	1/8 or 3/32 (3 or 4 mm)
Output Ø 3 HD-PE	lbs/hr	0.6 – 1.0
Output Ø 4 HD-PE	lbs/hr	0.7 – 1.7
Size (L × B × H)	inches	17.16 × 3.62 × 5.24 (9.29 with handle)
Weight	lbs	7.5
Conformity marking		CE
Protection class II		□

Article No.:

- 162.799 FUSION 1, 120 V / 1450 W, with US-plug
- 162.800 FUSION 1, 230 V / 1200 W, with EU-plug
- 163.165 FUSION 1, 230 V / 1200 W, with CEE-plug

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

Accessories FUSION 1

	163.793	Welding shoe CL14 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: The workhorse.

WELDPLAST S6 is the highest rated handheld extrusion welder. With an output of 13 lbs/hr, it is surprisingly maneuverable. It features a brushless, preheated motor, multifunction display and comfortable ergo-grip, making the S6 Leister's flagship extrusion welder.



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

Digitally regulated extrusion welder

WELDPLAST S6



- 13 lbs/hr output
- Highest possible preheating capacity
- Adjustable control wheel
- Maintenance-free hot-air blower
- Multifunctional display

Technical Data

Voltage	V~	230
Power	W	4600
Material		PE / PP
Welding rod	inches (mm)	Ø 5/32 or 3/16 (4 or 5 mm)
Output	lbs/hr	8.6 – 13.2
Size (L x W x H)	inches	33 x 5 x 10
Weight	lbs	31
Conformity mark		CE
Protection class I		⊕

Article No.:

134.318 WELDPLAST S6, 230 V / 4600 W, CEE 32A plug

Included with purchase: WELDPLAST S6, overlap welding shoe, storage case

Accessories WELDPLAST S6

		Welding shoe complete	
		146.239	2 1/8" x 1 9/16" x 2 1/16" blank shoe
		146.240	2 29/32" x 2" x 2 9/32" blank welding shoe
		146.241	1" (25 mm) overlap
		146.706	1 3/16" (30 mm) overlap
		146.242	1 3/8" (35 mm) overlap
		145.899	1 9/16" (40 mm) overlap
		146.245	25/32" (20 mm) V-seam
		146.246	1" (25 mm) V-seam
		146.247	1 3/16" (30 mm) V-seam
		146.232	25/32" fillet weld seam (a = 9/16"*)
		146.233	1" fillet weld seam (a = 11/16"*)
		146.234	1 3/16" fillet weld seam (a = 13/16"*)
		146.644	Corner outside seam 13/32" (10 mm)
		146.646	Corner outside seam 15/32" (12 mm)
		146.652	Corner outside seam 19/32" (15 mm)
		146.230	Corner seam Ø 9/16" (14 mm)
		146.218	Corner seam Ø 19/32" (15 mm)
		*a = Welding seam thickness	
		117.055	1 3/8" (35 mm) preheating nozzle, large
		136.859	2" (50 mm) preheating nozzle, XL
		117.790	Side hot-air guide
		149.744	Insulation sleeve / heat blanket WELDPLAST S6

General accessories



WELDPLAST S4: The workmate.

The WELDPLAST S4 is the first extrusion welder of its kind with a brushless, maintenance-free motor for generating preheated air. Output, of up to 8.8 lbs/hr, is 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	inches (mm)	$\varnothing \frac{1}{8} - \frac{5}{32}$ (3 - 4 mm) / $\varnothing \frac{5}{32} - \frac{3}{16}$ (4 - 5 mm)
Output	lbs/hr	4.9 – 8.8
Size (L x W x H)	inches	22 x 4 x 12
Weight	lbs	18
Conformity mark		CE
Protection class I		⊕

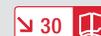
Article No.:

- 116.948 WELDPLAST S4, 230 V / 3680 W, $\varnothing \frac{1}{8} - \frac{5}{32}$ " (3 – 4 mm), Euro plug, blank welding shoe
- 146.813 WELDPLAST S4, 230 V / 3680 W, $\varnothing \frac{5}{32} - \frac{3}{16}$ " (4 – 5 mm), Euro plug, welding shoe K 15
- Included with purchase: WELDPLAST S4, preheating nozzle large, medium and small, storage case

Accessories WELDPLAST S4

	Welding shoe complete
	146.239 2 1/8" x 1 9/16" x 2 1/16" blank shoe
	146.240 2 29/32" x 2" x 2 9/32" blank welding shoe
	146.241 1" (25 mm) overlap
	146.706 1 3/16" (30 mm) overlap
	146.242 1 3/8" (35 mm) overlap
	145.899 1 9/16" (40 mm) overlap
	146.243 15/32" (12 mm) V-seam
	146.244 19/32" (15 mm) V-seam
	146.245 25/32" (20 mm) V-seam
	146.246 1" (25 mm) V-seam
	146.247 1 3/16" (30 mm) V-seam
	146.525 15/32" fillet weld seam (a = 5/16"**)
	146.231 19/32" fillet weld seam (a = 13/32"**)
	146.232 25/32" fillet weld seam (a = 9/16"**)
	146.233 1" fillet weld seam (a = 11/16"**)
	146.234 1 3/16" fillet weld seam (a = 13/16"**)
	146.642 Corner outside seam 5/16" (8 mm)
	146.644 Corner outside seam 13/32" (10 mm)
	146.646 Corner outside seam 15/32" (12 mm)
	146.652 Corner outside seam 19/32" (15 mm)
	146.230 Corner seam $\varnothing \frac{15}{32}$ " (12 mm)
	146.218 Corner seam $\varnothing \frac{25}{32}$ " (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
	Preheating nozzle
	117.053 Small 25/32" (20 mm)
	117.518 Medium 1" (25 mm)
	141.177 Large 1 3/8" (35 mm)
	149.723 Insulation sleeve / heat blanket 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
- Highly used worldwide worldwide

Technical Data

Voltage	V~	230
Power	W	3000
Material		PE / PP Other materials on request
Welding rod	inches (mm)	∅ 1/8 - 5/32 (3 – 4 mm)
Output ∅ 1/8" (3 mm)	lbs/hr	PE: 1.3 – 2.9 PP: 1.1 – 2.65
Output ∅ 5/32" (4 mm)	lbs/hr	PE: 2.2 – 4.4 PP: 2.0 – 4.4
Size (L x W x H)	inches	18 x 4 x 10
Weight	lbs	13
Conformity mark		CE
Protection class I		⊕

Article No.:

127.215 WELDPLAST S2, 230 V / 3000 W, Euro plug

Included with purchase: WELDPLAST S2, welding shoe raw part, 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	inches (mm)	∅ 1/8 - 5/32 (3 – 4 mm)
Output ∅ 1/8" (3 mm)	lbs/hr	PVC-U: 0.9 – 1.7 PE: 0.6 – 1.3
Output ∅ 5/32" (4 mm)	lbs/hr	PVC-U: 1.5 – 2.7 PE: 1.0 – 2.3
Size (L x W x H)	inches	18x 4x 10
Weight	lbs	13
Conformity mark		CE
Protection class I		⊕

Article No.:

135.724 WELDPLAST S2 PVC, 230 V / 3000 W, Euro plug

Included with purchase: WELDPLAST S2 PVC, 3 preheat nozzles, welding shoe K-8/10 (5/16 / 13/32") (Art. no. 146.236), storage case



The handy WELDPLAST S2 in action.



Even inside radiuses are easy to weld.

Accessories WELDPLAST S2

		Welding shoe complete	
		145.945	1 25/32" x 1 3/16" x 2 1/8" blank shoe
		145.946	2 29/32" x 2" x 2 9/32" blank welding shoe
		145.896	1" (25 mm) overlap
		145.947	1 3/16" (30 mm) overlap
		145.897	1 3/8" (35 mm) overlap
		145.912	3/16" / 1/4" (5 / 6 mm) V-seam
		145.915	5/16" / 13/32" (8 / 10 mm) V-seam
		145.907	15/32" (12 mm) V-seam
		145.903	19/32" (15 mm) V-seam
		145.909	25/32" (20 mm) V-seam
		145.916	1" (25 mm) V-seam
		145.943	3/16" / 1/4" fillet weld (a = 5/32"*)
		145.944	5/16" / 13/32" fillet weld (a = 9/32"*)
		145.815	15/32" fillet weld (a = 5/16"*)
		145.812	19/32" fillet weld (a = 13/32"*)
		145.940	25/32" fillet weld (a = 9/16"*)
		145.816	1" fillet weld (a = 11/16"*)
		146.643	Corner outside seam 5/16" (8 mm)
		146.645	Corner outside seam 13/32" (10 mm)
		146.649	Corner outside seam 15/32" (12 mm)
		146.651	Corner outside seam 19/32" (15 mm)
		145.811	Corner seam Ø 9/16" (14 mm)
		145.488	Corner seam Ø 25/32" (20 mm)
		* a = Welding seam thickness	
		139.460	45° angled adapter
		139.461	90° angled adapter
		154.002	Insulation sleeve / heat blanket 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	2 1/8" x 1 9/16" x 2 1/16" blank shoe
		146.240	2 29/32" x 2" x 2 9/32" blank shoe
		146.241	1" (25 mm) overlap
		146.706	1 3/16" (30 mm) overlap
		146.242	1 3/8" (35 mm) overlap
		146.248	3/16" / 1/4" (5 / 6 mm) V-seam
		146.249	5/16" / 13/32" (8 / 10 mm) V-seam
		146.243	15/32" (12 mm) V-seam
		146.244	19/32" (15 mm) V-seam
		146.235	3/16" / 1/4" fillet weld seam (a = 5/32"*)
		146.236	5/16" / 13/32" fillet weld seam (a = 9/32"*)
		146.525	15/32" fillet weld seam (a = 5/16"*)
		146.231	19/32" fillet weld seam (a = 13/32"*)
		146.642	Corner outside seam 5/16" (8 mm)
		146.644	Corner outside seam 13/32" (10 mm)
		146.646	Corner outside seam 15/32" (12 mm)
		146.652	Corner outside seam 19/32" (15 mm)
		146.230	Corner seam Ø 9/16" (14 mm)
		146.218	Corner seam Ø 25/32" (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
- Equipment-class-leading output power of 1.76 lbs/hr (HDPE)
- 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	inches (mm)	∅ 1/8" or 5/32" (3 or 4 mm)
Output	lbs/hr	0.44 – 1.76 (PVC up to 2.53 lbs/hr)
Size (L × W × H)	inches	17 × 4 × 10
Integrated welding profiles		HD-PE, PP, PVC-U, PVC-C, PVDF 10 free profile storage spaces
Weight	lbs	10
Conformity mark		CE
Protection class I		⊕

Article No.:

- 148.396 WELDPLAST S1, 230 V / 1600 W, ∅ 1/8" - 5/32" (3 – 4 mm), Euro plug
 148.395 WELDPLAST S1, 120 V / 1800 W, ∅ 1/8" - 5/32" (3 – 4 mm),
 without plug

Included with purchase: WELDPLAST S1, user manual, 4 pre-heating nozzles
 ∅ 9/16" (14 mm), K10 welding shoe, storage case

Accessories WELDPLAST S1

	149.430	Welding shoe complete Blank
	149.402	3/16" / 1/4" (5 / 6 mm) fillet weld
	148.627	5/16" / 13/32" (8 / 10 mm) fillet weld
	149.401	7/32" (12 mm) fillet weld
	149.388	1/8" / 5/32" (3 / 4 mm) V-seam
	149.383	3/16" / 1/4" (5 / 6 mm) V-seam
	149.385	5/16" / 13/32" (8 / 10 mm) V-seam
	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 ∅ 9/16" (14 mm)
	149.461	Hot-air tube, position 6h ∅ 5/8" (16 mm)
	149.467	Hot-air tube, position 9h/3h ∅ 9/16" (14 mm), standard
	149.469	Hot-air tube, position 9h/3h ∅ 5/8" (16 mm)
	154.107	Air nozzle set ∅ 9/16" (14 mm), standard
	154.106	Air nozzle set ∅ 5/8" (16 mm)
	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 8 lbs per hour.

Analog 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

Analog 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		Version Ø	
		1/8 - 5/32 (3-4mm)		5/32 - 3/16 (4 - 5mm)	
Welding rod Ø	inches	1/8	5/32	5/32	3/16
Output PE	lbs/hr	4.4 – 5.5	5.9 – 7.9	4.6 – 5.7	5.9 – 7.9
Output PP	lbs/hr	4.0 – 5.0	5.5 – 7.5	4.0 – 5.3	5.5 – 7.5
Voltage	V~	230			
Power	W	3500			
Material		PE / PP			
Size (L x W x H)	inches	26 x 4 x 7			
Weight	lbs	16			
Conformity mark		CE			
Protection class II		□			

Article No.:

118.300 FUSION 3, 230 V / 3500 W, welding rod Ø 1/8 - 5/32" (3 - 4 mm), Euro plug
 144.615 FUSION 3, 230 V / 3500 W, welding rod Ø 5/32 - 3/16" (4 - 5 mm), Euro plug

Included with purchase: FUSION 3, welding show overlap 1.18 inch, storage case

Technical Data		Version Ø		Version Ø	
		1/8 - 5/32 (3-4mm)		5/32 - 3/16 (4 - 5mm)	
Welding rod Ø	inches	1/8	5/32	5/32	3/16
Output PE	lbs/hr	4.4 – 5.5	5.9 – 7.9	4.6 – 5.7	5.9 – 7.9
Output PP	lbs/hr	4.0 – 5.0	5.5 – 7.5	4.0 – 5.3	5.5 – 7.5
Voltage	V~	230			
Power	W	3200			
Material		PE / PP			
Size (L x W x H)	inches	23 x 4 x 9			
Weight	lbs	15			
Conformity mark		CE			
Protection class II		□			

Article No.:

123.866 FUSION 3C, 230 V / 3200 W, welding rod Ø 1/8 - 5/32" (3 - 4 mm), Euro plug
 144.826 FUSION 3C, 230 V / 3200 W, welding rod Ø 5/32 - 3/16" (4 - 5 mm), Euro plug

Included with purchase: FUSION 3C, blank welding shoe, 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 1 $2\frac{25}{32}$ " \times 1 $\frac{3}{16}$ " \times 2 $\frac{1}{8}$ " blank shoe
	145.946 2 $2\frac{29}{32}$ " \times 2" \times 2 $\frac{9}{32}$ " blank welding shoe
	145.896 1" (25 mm) overlap
	145.947 1 $\frac{3}{16}$ " (30 mm) overlap
	145.897 1 $\frac{3}{8}$ " (35 mm) overlap
	145.912 $\frac{3}{16}$ / $\frac{1}{4}$ " (5 / 6 mm) V-seam
	145.915 $\frac{5}{16}$ / $\frac{13}{32}$ " (8 / 10 mm) V-seam
	145.907 $\frac{15}{32}$ " (12 mm) V-seam
	145.903 $\frac{19}{32}$ " (15 mm) V-seam
	145.909 $\frac{25}{32}$ " (20 mm) V-seam
	145.916 1" (25 mm) V-seam
	145.943 $\frac{3}{16}$ / $\frac{1}{4}$ " fillet weld (a = $\frac{5}{32}$ "*)
	145.944 $\frac{5}{16}$ / $\frac{13}{32}$ " fillet weld (a = $\frac{9}{32}$ "*)
	145.815 $\frac{15}{32}$ " fillet weld (a = $\frac{5}{16}$ "*)
	145.812 $\frac{19}{32}$ " fillet weld (a = $\frac{13}{32}$ "*)
	145.940 $\frac{25}{32}$ " fillet weld (a = $\frac{9}{16}$ "*)
	145.816 1" fillet weld (a = $\frac{11}{16}$ "*)
	146.643 Corner outside seam $\frac{5}{16}$ " (8 mm)
	146.645 Corner outside seam $\frac{13}{32}$ " (10 mm)
	146.649 Corner outside seam $\frac{15}{32}$ " (12 mm)
	146.651 Corner outside seam $\frac{19}{32}$ " (15 mm)
	145.811 Corner seam \varnothing $\frac{9}{16}$ " (14 mm)
	145.488 Corner seam \varnothing $\frac{25}{32}$ " (20 mm)
	* a = Welding seam thickness
	148.817 45° angled adapter
	148.816 90° angled adapter
	149.421 Insulation sleeve / heat blanket FUSION 3
	149.420 Insulation sleeve / heat blanket FUSION 3C

* a = Welding seam thickness

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



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.

Analog extrusion welder

FUSION 2



- At 18 inches, 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	°F	up to 640
Plastification temperature	°F	up to 570
Welding rod	inches (mm)	∅ 5/32 (4 mm)
Output PE	lbs/hr	2.9 – 4.0
Size (L × W × H)	inches	18 × 4 × 10
Weight	lbs	13
Conformity mark		CE
Protection class II		□

Article No.:

- 150.102 FUSION 2, 120 V / 2800 W, CEE plug
119.200 FUSION 2, 230 V / 2800 W, Euro plug

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

Accessories FUSION 2

	Welding shoe complete	
	145.945	1 25/32" × 1 3/16" × 2 1/8" blank shoe
	145.946	2 29/32" × 2" × 2 9/32" blank welding shoe
	145.896	1" (25 mm) overlap
	145.947	1 3/16" (30 mm) overlap
	145.897	1 3/8" (35 mm) overlap
	145.912	3/16" / 1/4" (5 / 6 mm) V-seam
	145.915	5/16" / 13/32" (8 / 10 mm) V-seam
	145.907	15/32" (12 mm) V-seam
	145.903	19/32" (15 mm) V-seam
	145.943	3/16" / 1/4" fillet weld (a = 5/32"*)
	145.944	5/16" / 13/32" fillet weld (a = 9/32"*)
	145.815	15/32" fillet weld (a = 5/16"*)
	145.812	19/32" fillet weld (a = 13/32"*)
146.643	Corner outside seam 5/16" (8 mm)	
146.645	Corner outside seam 13/32" (10 mm)	
146.649	Corner outside seam 15/32" (12 mm)	
146.651	Corner outside seam 19/32" (15 mm)	
145.811	Corner seam ∅ 9/16" (14 mm)	
145.488	Corner seam ∅ 25/32" (20 mm)	
		* a = Welding seam thickness
	147.602 45° angled adapter	
	147.601 90° angled adapter	
	166.524 Insulation sleeve / heat blanket FUSION 2	

General accessories



Automated, modular, customized – WELDPLAST 200-i / 600-i

LEISTER offers you two modules for automated extrusion welding and 3D printing. WELDPLAST 200-i and 600-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 / 600-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



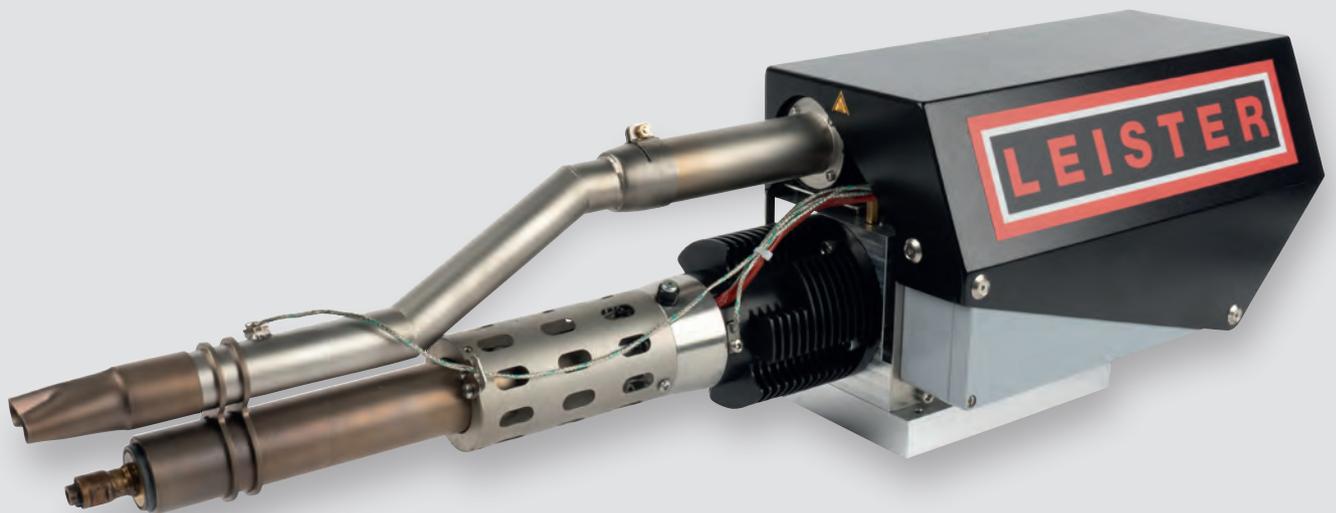
Controlled

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 / 600-i – robotic extrusion welding and 3D printing designed for automated continuous operation

Built-in extruder module

WELDPLAST 200-i / 600-i



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

Technical data		WELDPLAST 200-i	WELDPLAST 600-i
Heating voltage	V~	230	230
Heating power	W	600	800
Welding rods / filament Ø	inches	0.12 – 0.16	0.16 – 0.2
Output Ø 4 HD-PE	lbs/hr	4.4	8.82
Plastic		HD-PE, LD-PE, PP, PVC-U, PVC-C, PVDF, ECTFE, ABS, PC, PA, PS, PUR	HD-PE, LD-PE, PP
Weight full disassembly	lbs	33.07	48.5
Dimensions full disassembly (L x W x H)	inches	25.98 x 7.52 x 8.27	34.49 x 7.52 x 8.27
Protection class I		⊕	⊕

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

WELDPLAST 200-i

	163.322	Extruder module 200-i
	163.575	Connection kit 200-i / 600-i
	164.414	Preheated air kit 200-i
	139.869	LHS 21S Classic
	140.455	LHS 21S Premium
	140.459	LHS 21S System

WELDPLAST 600-i

	163.326	Extruder module 600-i
	163.575	Connection kit 200-i / 600-i
	164.415	Preheated air kit 600-i
	139.872	LHS 21L Classic
	140.457	LHS 21L Premium
	140.461	LHS 21L System



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>134.567 230 V / 2600 W, WELDPLAST S6</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>Pre-heat reflector</p> <p>136.231 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>116.367 WELDPLAST S6</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>PLASTFIX lends the weld seam the necessary holding pressure.</p>	
	<p>152.676 Welding Gauge</p>		
	<p>154.259 Scraper blade</p>		
	<p>154.026 Contour scraper</p>		





TRIAC ST: Design meets experience

The TRIAC ST 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 its robust design, reliability, versatility, and user-friendly features, like its predecessor the TRIAC S. A prominent feature is the two-component handle, which is not only attractive, but also gives the user perfect grip. The low weight—of less than one kilogram (2.2 lbs)—ensures perfect weight balance.

Product advantage



1

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

Perfect weight:
Weighing less than 2.2 lbs, 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



1

3

4

5



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, easily can 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
Frequency	Hz	50 / 60
Power	W	1600
Temperature	°F	104 – 1292
Air volume (68°F)	cfm	8.5 (17.7 cfm at max. temp)
Dynamic pressure	Pa	3000
Ø Nozzle holder	inches	1.24
Emission	dB(A)	67
Size (L × Ø)	inches	13 × 4, handle Ø 2
Weight	lbs	2 (without power cord)
Conformity mark	CE	
Approval mark	UL LISTED	
Protection class II	□	

Article No.:

- 141.228 TRIAC ST, 120 V / 1600 W for push-fit nozzles with US plug / UL
- 141.227 TRIAC ST, 230 V / 1600 W for push-fit nozzles with Euro 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
Frequency	Hz	50 / 60
Power	W	1600
Temperature	°F	104 – 1148
Air volume (68°F)	cfm	5.7 – 8.5 (17.7 cfm at max. temp)
Dynamic pressure	Pa	1600 – 3000
Ø Nozzle holder	inches	1.24
Emission	dB(A)	67
Size (L × Ø)	inches	13 × 4, handle Ø 2
Weight	lbs	2 (without power cord)
Conformity mark	CE	
Approval mark	UL LISTED	
Protection class II	□	

Article No.:

- 141.316 TRIAC AT, 120 V / 1600 W, with US plug, °F
- 141.382 TRIAC AT, 120 V / 1600 W, with US plug, °C

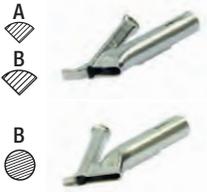


Quick welding.



Draw welding with combination nozzle.

Accessories TRIAC ST / TRIAC AT

	<p>100.303 Ø 0.2" (5 mm), tubular nozzle, push-fit 105.575 Ø 0.2 × 3.9" (5 × 100 mm), tubular nozzle, push-fit 106.982 Ø 0.2 × 5.9" (5 × 150 mm), extension nozzle, push-fit</p>		<p>105.622 Ø 0.2" (5 mm) tubular nozzle, screw-on</p>
	<p>105.576 tubular nozzle Ø 0.2" (5 mm), 90° curved</p>		<p>106.988 Tacking nozzle, screw-on</p>
	<p>106.996 Tacking nozzle, push-fit on Ø 0.2" (5 mm) tubular nozzle</p>		<p>126.552 Ø 0.16" (4 mm) drawing nozzle, screw-on for fluoroplastics</p>
 <p>D</p>	<p>105.431 0.12" (3 mm) speed weld nozzle, with small air-slide, push-fit on Ø 0.2" (5 mm) tubular nozzle 105.432 0.16" (4 mm) speed weld nozzle, with small air-slide, push-fit on Ø 0.2" (5 mm) tubular nozzle 105.433 0.2" (5 mm) speed weld nozzle, with small air-slide, push-fit on Ø 0.2" (5 mm) tubular nozzle</p>	 <p>D</p>	<p>113.666 Ø 0.12" (3 mm) drawing nozzle with tacking tip, screw-on 113.399 Ø 0.16" (4 mm) drawing nozzle with tacking tip, screw-on 113.876 Ø 0.12" (3 mm) drawing nozzle without tacking tip, screw-on 113.874 Ø 0.16" (4 mm) drawing nozzle without tacking tip, screw-on</p>
 <p>C</p>	<p>107.139 0.18" × 0.5" speed weld nozzle for fillet weld, push-fit on Ø 0.2" (5 mm) tubular nozzle 107.137 0.31" (8 mm) speed weld nozzle for tape welding, push-fit on Ø 0.2 (5 mm) tubular nozzle</p>	 <p>A B</p>	<p>Drawing nozzle triangular-shaped, with tacking tip, screw-on 113.670 With tacking tip, screw-on 0.22" (5.7 mm), profile A 113.877 Without tacking tip, screw-on 0.22" (5.7 mm), profile A 106.986 Without tacking tip, screw-on 0.28" (7 mm) profile B 106.987 Without tacking tip 0.28 × 0.22" (7 × 5.7 mm)</p>
 <p>A B B</p>	<p>Speed weld nozzle, push-fit on Ø 0.2" (5 mm) tubular nozzle 106.992 0.22" (5.7 mm), profile A 106.993 0.28" (7 mm), profile B 106.989 Ø 0.12" (3 mm) 106.990 Ø 0.16" (4 mm) 106.991 Ø 0.2" (5 mm)</p>		<p>107.344 5.31" (135 mm) welding mirror, push-fit</p>
	<p>156.470 Speed weld nozzle bend Ø 0.2" (5 mm), push-fit on 0.2" (5 mm) tubular nozzle</p>		<p>143.833 Nozzle adapter for screw-on nozzles</p>
			<p>143.332 Protection tube for screw-on nozzles (for TRIAC ST until april 2017) 156.092 Protection tube for screw-on nozzles (for TRIAC ST from mai 2017)</p>
			<p>144.134 Protection tube for screw-on nozzles (for TRIAC AT)</p>
			<p>141.375 Connection adapter M14 for Ø 0.83 inches nozzle with plug</p>
			<p>Heating element for 142.718 TRIAC ST / TRIAC AT, 120 V / 1550 W 142.717 TRIAC ST / TRIAC AT, 230 V / 1550 W 100.702 TRIAC S, 120V / 1600 W</p>

HOT JET S: Small and powerful.

As Leister's most compact hot-air hand tool, the light weight of the 1.3 lb HOT JET S (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



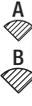
- The smallest Leister hot-air hand tool
- Stepless, electronically controlled temperature
- Stepless, electronically controlled air flow
- Low noise
- Flexible, integrated tool stand

Technical data		
Voltage	V~	120
Frequency	Hz	50 / 60
Power	W	460
Temperature	°F	104 – 1112
Air volume (68°F)	cfm	1.4 – 3.9 (7.1 at max. temp)
Pressure static	Pa	230 – 1600
Ø Nozzle holder	inches	0.8
Emission	dB(A)	59
Size (L x Ø)	inches	9 x 3, Handle Ø 1.6
Weight	lbs	1.3 (without power cord)
Conformity mark	CE	
Approval mark	UL LISTED	
Protection class II	□	

Article No.:

- 100.859 HOT JET S, 120 V / 460 W with US plug (UL)
- 100.861 HOT JET S, 120 V / 460 W, with US plug

Accessories HOT JET S

	107.144 Ø 0.2" (5 mm) tubular nozzle, push-fit
	105.567 Ø 0.2 x 6" (5 x 150 mm) extension nozzle, straight
	105.566 Ø 0.3" (8 mm) tubular nozzle, straight
	106.996 Tacking nozzle, push-fit on Ø 0.2" or 3/16" (5 mm) tubular nozzle
	106.989 0.12" or 1/8" (3 mm) speed welding nozzle, push-fit on Ø 0.2" (5 mm) tubular nozzle
	106.990 0.16" or 5/23" (4 mm) speed welding nozzle, push-fit on Ø 0.2" (5 mm) tubular nozzle
	106.991 0.2" or 3/16" (5 mm) speed welding nozzle, push-fit on Ø 0.2" (5 mm) tub. nozzle
	156.470 Speed weld nozzle bend Ø 0.2" (5 mm), push-fit on 0.2" (5 mm) tubular nozzle
	106.992 0.22" (5.7 mm) A profile speed welding nozzle, push-fit
	106.993 0.28" (7 mm) B profile speed welding nozzle, push-fit
	105.431 0.12" or 1/8" (3 mm) speed welding nozzle, with small air-slide, push-fit on Ø 0.2" (5 mm) tubular nozzle
	105.432 0.16" or 5/32" (4 mm) speed welding nozzle, with small air-slide, push-fit on Ø 0.2" (5 mm) tubular nozzle
	105.433 0.2" or 3/16" (5 mm) speed welding nozzle, with small air-slide, push-fit on Ø 0.2" (5 mm) tubular nozzle
	107.137 0.3" (8 mm) speed welding nozzle for tape welding, push-fit on Ø 0.2" (5 mm) tubular nozzle



HOT JET S the small companion for filigree work.

	<p>107.139 0.18 × 0.5" (4.5 × 12 mm) speed welding nozzle for fillet weld, push-fit on Ø 0.2" (5 mm) tubular nozzle</p>
	<p>107.305 0.6 × 1" (15 × 25 mm) ironing nozzle</p>
	<p>143.831 Nozzle adapter for screw-on nozzles</p>
	<p>114.734 Ski repair nozzle with base plate</p>
	<p>103.607 120 V / 435 W heating element</p>
	<p>131.867 Ø 0.2" (5 mm), tubular nozzle, 90° angled, push-fit</p>

Small and handy: The HOT JET S is perfect when welding complicated details.



WELDING PEN: Slim and flexible.

The WELDING PEN is a hot-air hand tool optimized for draw welding. Due to its slim design and swiveling external air supply, the Welding Pen makes hard work easy.



WELDING PEN R, combined with angle adapters, make welding possible even in very tight spaces.

External air hand tool

WELDING PEN R / WELDING PEN S



- Digital temperature display (WELDING PEN R)
- Connection makes working easier
- Cooled heating element tube
- Used in combination with ROBUST blower, AIRSTREAM ST or compressed air

Technical data		
Voltage	V~	120
Power	W	600
Temperature	°F	68 – 1112
Size (L x Ø)	inches	11 x 2, handle Ø 1
Weight	lbs	2 (with 10 ft cord / air hose and Y-connection)
Conformity mark	CE	
Protection class II	□	
Article No.:		
114.576	WELDING PEN R, 120 V / 600 W, with US plug, 2.7 yards hose	
113.708	WELDING PEN S, 120 V / 600 W, with US plug, 2.7 yards hose	
145.865	WELDING PEN S, 120 V / 600 W, 29 ft. 6 in. hose - no plug	
114.380	WELDING PEN R, 230 V / 1000 W, with Euro plug, 2.7 yards hose	
113.081	WELDING PEN S, 230 V / 1000 W, with Euro plug, 2.7 yards hose	
114.926	WELDING PEN R, 230 V / 1000 W, with Euro plug, 6.6 m hose	
114.274	WELDING PEN S, 230 V / 1000 W, with Euro plug, 6.6 m hose	
114.927	WELDING PEN R, 230 V / 1000 W, with Euro plug, 9.8 m hose	
114.273	WELDING PEN S, 230 V / 1000 W, with Euro plug, 9.8 m hose	

Accessories WELDING PEN R / S

	105.622	Ø 0.2" (5 mm) tubular nozzle, 15° screw-on
	106.988	Tacking nozzle, screw-on
	113.666	Ø 0.12" (3 mm) round drawing nozzle with tacking tip, screw-on
	113.399	Ø 0.16" (4 mm) round drawing nozzle, with tacking tip, screw-on
	113.876	Ø 0.12" (3 mm) round drawing nozzle without tacking tip, screw-on
	113.874	Ø 0.16" (4 mm) round drawing nozzle, without tacking tip, screw-on
	113.670	Triangular drawing nozzle with tacking tip, screw-on, 0.22" (5.7 mm) profile A
	113.877	without tacking tip, screw-on 0.22" (5.7 mm), profile A
	106.986	without tacking tip, screw-on 0.28" (7 mm), profile B
	106.987	without tacking tip, screw-on 0.28 x 0.22" (7 x 5.5 mm)
	126.552	Ø 0.16" (4 mm) drawing nozzle, screw-on for fluor plastics
	127.726	Angular adapter for screw-on nozzles, screw-on 30°
	127.727	45°
	141.375	Connection adapter M14 for Ø 0.84" (21.3 mm) nozzle with plug
	113.597	120 V / 600 W heating element for WELDING PEN R and WELDING PEN S

Swiveling air hose for easy working.



AIRSTREAM ST: Quiet and efficient air supply unit.

Plug-in the AIRSTREAM ST for a constant, quiet supply of clean, dry, air. Need to work with two hand tools in parallel? No problem, thanks to the simultaneous power and air supply, you can connect up to two hand tools in parallel. The AIRSTREAM includes a handle and integrated tool tray, and casters (optional) for easy mobility. The AIRSTREAM ST is a highly practical solution!



1 **Dual operation:**
The two tool connections enable simultaneous use of two hand tools, or in series with independent settings.



2 **The quick-change artist:**
Easily integrates into a workspace, or under a bench, by removing the handle and flipping the integrated tool tray upside-down, or adding the optional casters for portability.



3 **Quality is measurable:**
Adjustable air flow for optimal welding results as airflow determines energy transfer and weld quality.



4 **Automated cooldown cycle:**
Hand tools last longer when cared for properly. The AIRSTREAM automatically cools down the connected tools when power is switched off. When the switch is turned "on," the tools automatically return to previous temperature and airflow settings as well.





AIRSTREAM ST, the quiet air supply unit.

Blower

AIRSTREAM ST



- Quiet operation
- Cooldown mode
- Low energy consumption
- Two hand tools can be connected
- Compatible with WELDING PEN, DIODE and LABOR
- Flow meter
- Brushless technology

Accessories AIRSTREAM ST

	<p>159.535 Caster set</p>
	<p>159.481 Air hose connection set</p>

Technical Data

Voltage	V~	230
Power	W	215
Frequency	Hz	50
Air volume	cfm	7.06 (Total)
Emission	L _{pA} (dB)	< 48 (with 10 ft hose)
Size (L × W × H)	inches	24 × 10 × 14 (with handle)
Weight	lbs	53
Conformity mark		CE
Protection class I		⊕

Scope of delivery:

Air supply unit, hose transition pieces, clips, quick guide

Article-No.:

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



Easy parallel operation.

ROBUST: The powerhouse.

Versatile and operable at high ambient temperatures of up to 140 °F. Despite its small size, the ROBUST is a real powerhouse. This blower can supply air for up to three hot-air hand tools simultaneously.



ROBUST blower, serving as the external air supply for the WELDING PEN.

Blower

ROBUST



- High-performance, compact design
- Sound-suppression
- Can be integrated at any position
- Can be used as an external air supply to 1 WELDING PEN R or up to max. 3 DIODE S/ PID or max. 3 LABOR S (with 107.281 hose adapter)

Technische Daten

Frequency	Hz	50	60
Power	W	250	250
Air volume (68 °F)	cfm	42	46
Static pressure	psi	1.16	1.52
Max. ambient temperature	°F	140	140
Max. air inlet temperature	°F	140	140
Noise emission level	dB(A)	62	62
Protection (IEC 60529)		IP 54	IP 54
Outside diameter air inlet	Ø inches	1.5 (38 mm)	1.5 (38 mm)
Outside diameter air outlet	Ø inches	1.5 (38 mm)	1.5 (38 mm)
Weight	lbs	18	18
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
10 ft cord / Euro plug	Article No.:	103.432		

Accessories ROBUST

	107.354	Stainless steel filter, push-fit on air intake
	107.281	Ø 1.5" (38 mm) hose connection adapter, 3 output each 0.55" (14 mm)
	113.859	Ø 0.55" (14 mm) air hose
	101.031	Ø 0.55" (14 mm) hose clip for air hose

DIODE PID / S: The powerful pair.

There are two options for high-quality work: The closed-loop DIODE PID provides the perfect welding temperature at all times. The DIODE S easily puts you in control with a manual temperature knob.



Convenient wire welding using the powerful and lightweight DIODE PID.

External air hand tool

DIODE PID / DIODE S



- Operated with MINOR or ROBUST blower or with compressed air
- Digitally controlled and displayed temperatures (DIODE PID)
- Cooled heating element tube
- Suitable for field applications when used in combination with a MINOR blower

Technical data		
Voltage	V~	120
Power	W	1600
Temperature	°F	68 – 1112
Size (L x Ø)	inches	10 x 2, handle Ø 1.6
Weight	lbs	3 lbs (with 10 ft cord / 10 ft air hose)
Conformity mark	CE	
Protection class II	□	

- Article No.:**
- 101.291 DIODE S, 120 V / 1600 W, for push-fit nozzles, with US plug
 - 101.292 DIODE S, 120 V / 1600 W, for screw-on nozzles, with US plug
 - 101.311 DIODE PID, 120 V / 1600 W, for push-fit nozzles, with US plug
 - 101.281 DIODE S, 230 V / 1600 W, for snap-fit nozzles, with Schuko plug
 - 101.303 DIODE PID, 230 V / 1600 W, for snap-fit nozzles, with Schuko plug

Additional versions available upon request

Hand tool and blower

DIODE PID / DIODE S with MINOR



- MINOR blower and DIODE PID with screw-on drawing nozzle.
- Ideal for assembly work

Technical data		
Voltage	V~	120
Power	W	1600
Temperature	°F	68 – 1112
Size (L x Ø)	inches	10 x 2, handle Ø 1.6
Weight	lbs	6 lbs (with 10 ft cord / 5 ft air hose)
Conformity mark	CE	
Protection class II	□	

- Article No.:**
- 101.447 DIODE S, 120V / 1700 W, for push-fit nozzles, connected to MINOR 5 ft air hose, US plug

Additional versions available upon request



The MINOR blower as an air supply for the DIODE PID.

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 PID / DIODE S or LABOR S.

Accessories DIODE PID / DIODE S

With push-fit nozzle

	100.303 Ø 0.2" (5 mm) tubular nozzle, for versions with push-fit nozzles
	100.300 Heater tube for push-fit nozzles
	100.304 Heater tube for screw-on nozzles
	Speed welding nozzle, push-fit on Ø 0.2" (5 mm) tubular nozzle
A	106.992 0.22" (5.7 mm), profile A
B	106.993 0.28" (7 mm), profile B
	106.989 0.12" (3 mm)
	106.990 0.16" (4 mm)
	106.991 0.2" (5 mm)
	156.470 0.2" (5 mm) bent
	106.996 Tacking nozzle, push-fit on Ø 0.2" (5 mm) tubular nozzle
	143.833 Nozzle adapter for screw-on nozzles
	100.650 120 V / 1600 W heating element for DIODE PID
	100.702 120 V / 1600 W heating element for DIODE S

With screw-on nozzle

	105.622 Ø 0.2" (5 mm) tubular nozzle, screw-on
	106.988 Tacking nozzle, screw-on
	113.666 Ø 0.12" (3 mm) round drawing nozzle with tacking tip, screw-on
	113.399 Ø 0.16" (4 mm) round drawing nozzle, with tacking tip, screw-on
D	113.876 Ø 0.12" (3 mm) round drawing nozzle without tacking tip, screw-on
	113.874 Ø 0.16" (4 mm) round drawing nozzle, without tacking tip, screw-on
	113.670 Triangular drawing nozzle, with tacking tip, screw-on, 0.22" (5.7 mm)
A	113.877 Without tacking tip, screw-on 0.22" (5.7 mm), profile A
B	106.986 Without tacking tip, screw-on 0.28" (7 mm), profile B
	106.987 0.28 x 0.22" (7 x 5.5 mm)
	126.552 0.16" (4 mm) drawing nozzle, screw-on, for fluor plastics
	141.375 Connection adapter M14 for Ø 0.84" (21.3 mm) nozzle with plug

Blower

MINOR



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

Technical data

Voltage	V~	120
Power	W	100
Air volume (68°F)	cfm	14.1
Pressure static	psi	0.58
Air outlet (external)	inches	0.6 (15 mm)
Size (L x Ø)	inches	9 x 4, handle Ø 2.5
Weight	lbs	2.5 (with 10 ft cord)
Conformity mark	CE	
Protection class II	□	

Article No.:

108.749 MINOR, 120 V / 100 W, with US 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, AIRSTREAM ST, MINOR or with compressed air
- Ideal for mobile use when coupled with MINOR blower

Technical data

Voltage	V~	120
Power	W	600 / 700
Temperature	°F	68 – 1112
Size (L × Ø)	inches	7 × 2, handle Ø 1.3
Weight	lbs	0.33 (without air hose and without cord)
Conformity mark	CE	
Approval mark		
Protection class II		

Article No.:

- 101.721 LABOR S w/junction box, 120 V / 600 W w/US plug, 10 ft PVC hose, UL
- 101.740 LABOR S w/junction box, 120 V / 600 W, w/US plug, 10 ft silicon hose, UL

Additional versions available upon request

Accessories LABOR S

	107.144	Ø 0.2" (5 mm) tubular nozzle, push-fit
	106.992	Speed weld nozzle, push-fit on Ø 0.2" (5 mm) tubular nozzle
	106.993	0.22" (5.7 mm), profile A
	106.989	0.28" (7 mm), profile B
	106.990	0.12" (3 mm)
	106.991	0.16" (4 mm)
	156.470	0.2" (5 mm) bent
	106.996	Tacking nozzle, push-fit on Ø 0.2" (5 mm) tubular nozzle
	143.831	Nozzle adapter for screw-on nozzles
	107.146	Ø 0.08" (2 mm) soldering nozzle
	107.151	Ø 0.16" (4 mm) soldering nozzle
	107.148	Ø 0.12 × 0.06" soldering nozzle, oval
	105.622	Ø 0.2" (4 mm) tubular nozzle, screw-on
	106.988	Tacking nozzle, screw-on
	113.666	Ø 0.12" (3 mm) round drawing nozzle with tacking tip, screw-on
	113.399	Ø 0.16" (4 mm) round drawing nozzle, with tacking tip, screw-on
	113.876	Ø 0.12" (3 mm) round drawing nozzle without tacking tip, screw-on
	113.874	Ø 0.16" (4 mm) round drawing nozzle, without tacking tip, screw-on
	113.670	Triangular drawing nozzle, with tacking tip, screw-on, 0.22" (5.7 mm)
	113.877	Without tacking tip, screw-on 0.22" (5.7 mm), profile A
	106.986	Without tacking tip, screw-on 0.28" (7 mm), profile B
	106.987	0.28" × 0.22" (7 × 5.7 mm)
	126.552	0.16" (4 mm) drawing nozzle, screw-on, for fluor plastics
	101.643	120 V / 600 W heating element



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 1.1" (28 mm) PTFE pressure roller		137.855 Leister cutter with four spare blades
	106.972 Brass pressure roller with ball bearings		138.902 Hooked blade for LEISTER-cutter (10 dispensers with 10 pcs=100 pcs)
	152.676 Weld seam template		138.539 Straight-edge blade for LEISTER-cutter (10 dispensers with 10 pcs = 100 pcs)
	157.544 Leister Universal scissors 10.2 inch with special shaft grinding		151.382 Kehlfix
	154.259 Scraper blade		153.009 Plastfix
	154.026 Contour scraper		160.353 Cable cord roller 27.3 yards (25 m), with 1 x CEE 400 V and 2 x EU socket 230 V
	106.997 Ø 0.23" (6 mm) rotary burr for drilling machine, for car repairs		161.152 Cable cord roller 27.3 yards (25m), with 1 x CEE 400 V and 2 x T23 CH socket 230 V
	116.798 Brass brush		161.207 Cable cord roller 27.3 yards (25m), with 1 x CEE 400 V and 2 x Typ E with ground pin socket 230 V
	142.647 Brass brush Ø 0.12" (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 16 yards (15 m) PUR 5 x 2.5 mm2, with CEE 400V plug
			159.239 Cable extension cord 16 yards 15 m PUR 3 x 2.5 mm2, with EU plug 230V

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



Welding rods

Article		Profile	Colour	lbs
Welding accessories PE				
104.283	HDPE welding rod	A	Black	6.6
104.294	HDPE welding rod	A	White	6.6
104.284	HDPE welding rod	B	Black	11
104.299	HDPE welding rod	B	White	11
106.650	HDPE welding band	C	White	2.2
104.300	LDPE welding rod	A	Black	6.6
161.612	HDPE welding rod	D	Black	4.4
116.918	HDPE welding rod	D	Light Green	4.4
Welding accessories PP				
104.287	PP welding rod	A	Light Green	6.6
104.301	PP welding rod	A	Black	6.6
106.642	PPs welding rod, flame resistant	A	Light Green	6.6
104.288	PP welding rod	B	Light Green	11
126.356	PP welding band	C	White	4.4
161.611	PP welding rod	D	Light Green	4.4
Welding accessories PVC				
104.296	PVC-U welding rod	A	White	6.6
104.278	PVC-U welding rod	A	Grey	6.6
106.641	PVC-U welding rod	A	Brown	6.6
104.280	PVC-U welding rod	B	Brown	11
104.279	PVC-U welding rod	B	Grey	11
109.925	PVC-U welding rod	D	Grey	8.8
104.302	PVC-P welding rod (soft)	A	White	6.6
Welding accessories ABS				
104.295	ABS welding rod	A	White	6.6
113.587	ABS welding rod	A	Black	6.6
107.027	ABS welding band	C	White	2.2

Article		Profile	Colour	lbs
Welding accessories div.				
104.297	PA welding rod	A	Black	6.6
104.298	PC welding rod	A	White	6.6
104.313	PC welding rod / ABS / ALPHA (Honda)	A	Black	6.6
104.308	PUR welding rod	A	Black	6.6
106.654	Xenoy welding band	C	Grey	4.4
104.304	PVDF welding rod	A	White	6.6
104.303	POM welding rod	A	White	6.6
112.185	PC/PBTP Xenoy welding rod	A	White	6.6

Test bundles

107.036 Test bundle bodywork welding rods, each consisting of profile A pieces of 14.6" single marked
6× HDPE, 6× PP, 6× PA, 6× PC, 6× ABS, 6× PCABS / ALPHA Honda, 6× PC / PBTP / Xenoy



107.037 Test bundles standard each consisting of profile A pieces of 14.6" 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, 3× PC / PBTP / Xenoy



107.040 Test bundle welding band each consisting of profile C pieces of 14.6" single marked
9× HDPE, 8× 0.08" white, 9× PP, 8× 0.08" natural, 9× ABS, 8× 0.08" white, 9× PC / PBTP / Xenoy grey



Profile sizes

Profile A	Profile B	Profile C	Profile D

Dimensions in inches

Legal Information

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