

LEISTER X-84

Hot Air Automatic Welder



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

APPLICATION

LEISTER X-84 Automatic Overlap Welder

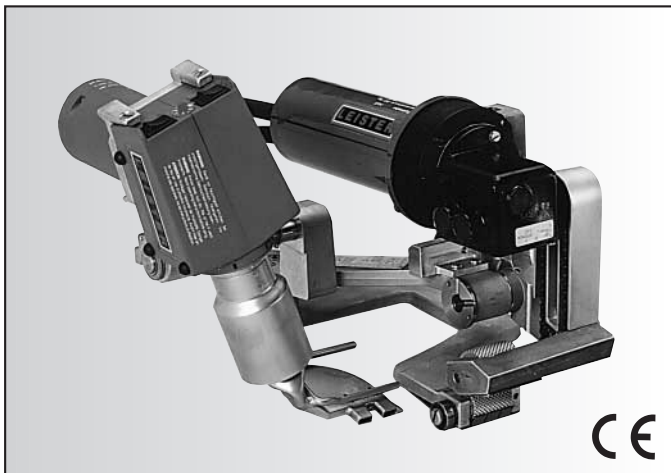
- Overlap welding of PVC-, PE, PP, ECB and EVA foils
- Overlap welding of geomembranes made of PVC, TPO and ECB up to 3 mm thick

Width of welded seam:

2x10mm, test channel 10mm

1x30mm without test channel

Maximum overlap: 80 mm





WARNING



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



Incorrect use of hot air blowers can cause **fire and explosion hazard**, especially near combustible materials and explosive gases.



Do not touch the element housing and nozzle when they are hot as they can cause **burns**. Let the tool cool down. Do not point hot air flow in the direction of people or animals.



CAUTION



The **voltage rating** stated on the tool must correspond to the line/mains voltage.



For personal protection on building sites we **strongly recommend** the tool be connected to a **GFCI** (Ground Fault Circuit Interrupter) or a **RCCB** (Residual Current Circuit Breaker) .



The tool must be operated **with supervision**. Warmth can reach combustible materials, which are out of sight.



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

TEST SIGNS

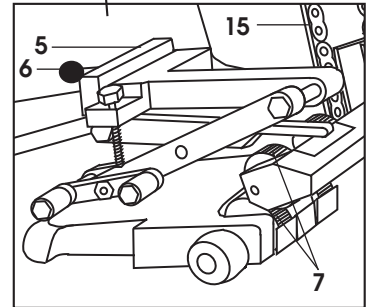
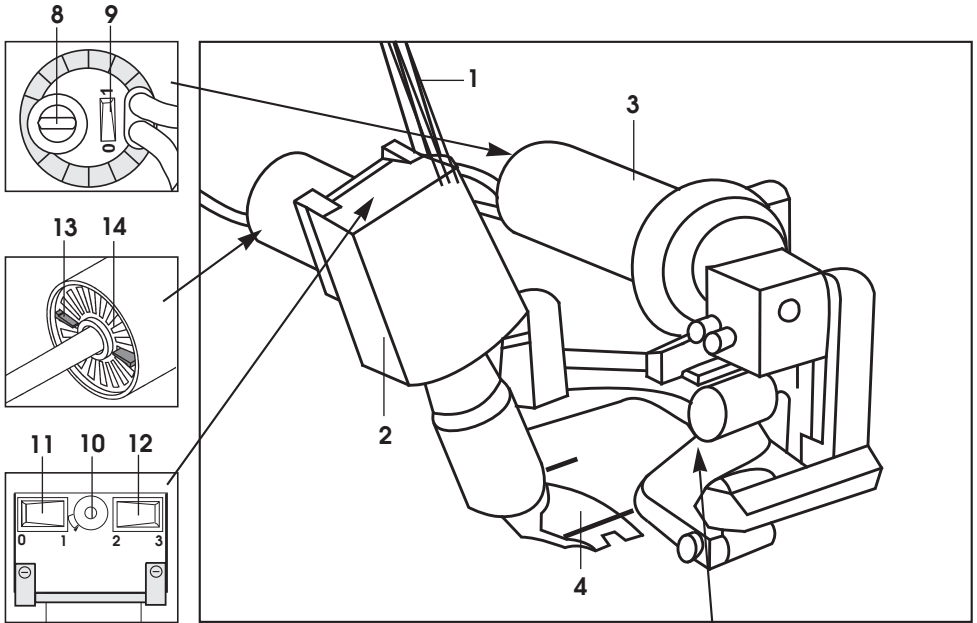


TECHNICAL DATA

electrical safety double insulated

Voltage	V~	120 / 230 ★
Frequency	Hz	50 / 60
Capacity	kW	1,9/2,3/2,9
Temperature	°C	20 – 600
Air flow	l/min.	220
Drive speed	m/min.	0,5 – 3,5
Noise level	dB (A)	67
Size	mm	300×310×250
Weight	kg	5,9

★ Mains voltage cannot be switched over



Operating Condition

The Automatic Hot Air Welder is set at the factory for the required material type and thickness.

- Attach the **guiding handle (1)**.
- Move the **welder (2)** out and swivel it upwards until it locks.
- Connect tool to the mains.

Positioning of tool

- Release the **pressure rollers (7)** with **ball handle (6)** on the **locking device (5)**.
- Move the automatic welder in between the overlapped material.

Welding parameter

- Adjust the welding speed via the **potentiometer (8)**. **Switch on (9)** to drive.
- The contact pressure is set at the factory or by an authorized LEISTER Service Centre.
- Adjust the welding temperature with the **potentiometer (10)**, switch on the **Hot Air blower (11)**, set the **two-step switch for air flow (12)** to step 3 and allow about 5 minutes for warming up. If necessary the air flow can be reduced using the **two-step switch (12)** and the **air slide (13)**.

Welding procedure

- Lower the **welder (2)** and guide the **nozzle (4)** between the overlapped sheets as far as it will go; at the same time, by pulling up the **handle (3)** clamp the **pressure rollers (7)** (the welding procedure begins).
- Check the welding process. If necessary adjust welding speed with the **potentiometer (8)**.
- Guide the automatic welder along the overlap by the **guiding handle (1)** or **handle (3)** along the welding seam.
- After welding, lift the **handle (3)** slightly and release the **ball handle (6)**, pull the **welder (2)** with **nozzle (4)** out of the overlap and swivel it upwards.
- After completion of the welding operation, switch off the **drive motor (9)**, set the **potentiometer for temperature control (10)** to zero, to let the **welder (2)** cool down. Then switch off the **Hot Air Blower (11)**.

TRAINING

The LEISTER Company and its authorised Service Centres offer welding and introductory training courses free of charge.

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 **pressure rollers (7)** and **nozzle (4)**.
- Treat the **chain (15)** with a suitable spray or oil.
- Check power supply cord and plug for any possible electrical or mechanical damages.

SERVICE AND REPAIR

- The tool should be checked after a maximum of approx. 1000 hours running time by an authorised Service Centre.
- Repairs have to be carried out by authorised **LEISTER Service Centres** only. They guarantee a specialized and reliable **repair service within 24 hours** using original LEISTER spare parts.

GUARANTEE AND LIABILITY

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

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

Your authorized Service Centre is: