

LEISTER Welding-Pen A LEISTER Welding-Pen S

Hot air tools



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

APPLICATION

The LEISTER Welding-Pen A and S are hot air tools that can be installed for continuous operation. They have an ergonomic shape and are light weight what makes them suitable as hand tools as well as for the installation into machines and vent constructions. The cooled heater tube as well as the LEISTER screw-on drawing nozzle with taking tip make the Welding Pen to a very efficient tool for plastic welding.

- Welding of thermoplastic materials and also single-ply flexible plastics in the form of boards, tubes, profiles, foams, tiles and sheets.
- The following procedures are possible:
Rod and melt welding by means of LEISTER nozzles
- The hot air tools Welding Pen A and S need an external air-supply (LEISTER blower or compressed air).



LEISTER Welding-Pen A

- Heating element protected against overheating
- Adaptor tube with heat protection
- Temperature steplessly adjustable by regulation of air flow



LEISTER Welding-Pen S

- Heating element protected against overheating
- Adaptor tube with heat protection
- Temperature steplessly adjustable with potentiometer



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



This tool is **CCA** certificated (CENELEC Certification Agreement).

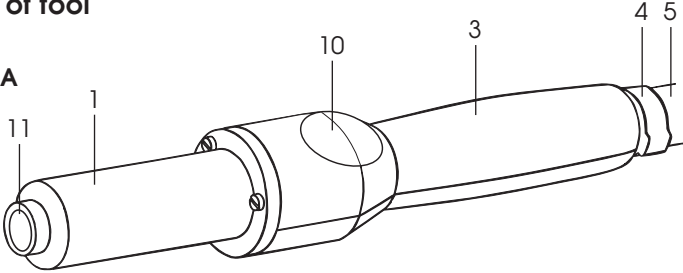
TECHNICAL DATA

Electrical safety: double insulated

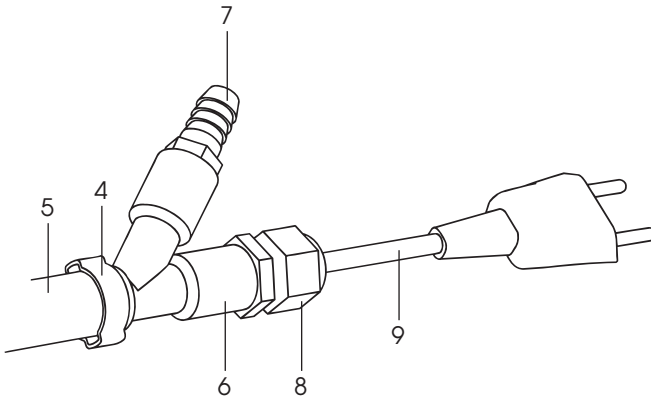
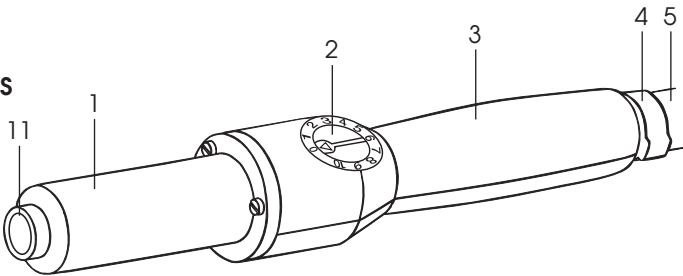
		Welding-Pen A		Welding-Pen S		
Voltage	V~	120	230	100	120	230
Frequency	Hz	50/60	50/60	50/60	50/60	50/60
Capacity	W	600	1000	450	600	1000
Temperature	°C	20 – 600	20 – 600	20 – 600	20 – 600	20 – 600
Air flow	l/min.	>70	>120	>40	>50	>60
Air pressure	Pa	max. 10 ⁵ (dynamic)				
Weight	g	1000 with 3m cable, air hose and Y-connection				
Size	mm	ø 32/43 × 270				
Mains voltage cannot be switched over						

Description of tool

Welding-Pen A



Welding-Pen S



- | | |
|---|---|
| 1. Heat protection tube | 7. Hose connection for air-supply G1/4" |
| 2. Potentiometer for temperature adjustment | 8. Cable screw fitting for mains supply M16 × 1.5 |
| 3. Handle | 9. Power-supply cord |
| 4. Hose clamp | 10. Cover |
| 5. Air hose | 11. Screwed nozzle joint |
| 6. Y-connection | |

AIR SUPPLY**Blower**

- Use an air filter, if air is dusty.
- Air flow can be adjusted by the LEISTER air flow adjuster.

Compressed air

- When using compressed air, an oil and water filter must be connected.
- Air flow can be adjusted by air flow adjuster.

OPERATION**Operating conditions LEISTER Welding-Pen A**

- Ⓐ Fit appropriate nozzle as required.
- Ⓐ Connect air supply with corresponding **hose connection (7)**.
- Ⓐ Adjust air flow by means of air flow adjuster or pressure reducing valve.
ATTENTION: Keep minimum required air flow according to data on page 2
- Ⓐ Connect tool to the mains.
- Ⓐ Set hot-air temperature by adjusting of air flow.
(Temperature must not exceed 600°C)
- Ⓐ Heat up tool for about 5 minutes.
- Ⓐ Let the tool cool down after use!

Operating conditions LEISTER Welding-Pen S

- Ⓔ Fit appropriate nozzle as required.
- Ⓔ Connect air supply with corresponding **hose connection (7)**.
- Ⓔ Adjust air flow by means of air flow adjuster or pressure reducing valve.
ATTENTION: Keep minimum required air flow according to data on page 2
- Ⓔ Connect tool to the mains.
- Ⓔ Adjust hot-air temperature by use of the potentiometer.
- Ⓔ Heat up too for about 5 minutes.
- Ⓔ Let the tool cool down after use!

Change of nozzle

- Let the tool cool down before changing the nozzle.
- Do not touch hot nozzle and only lay it on heat resistant surface because of fire hazard.
- Nozzles can easily be screwed (M14) onto the heat protection tube.
- Use only LEISTER nozzles.

ATTENTION! Do not operate tool without air supply!

Function of heat protection Welding-Pen A

- Heating element switches off automatically if there is no or not sufficient air flow (temperature >600°C)

Function of heat protection Welding-Pen S

- Heating element switches off automatically if there is no air flow.
- If there is not sufficient air flow, power will be electronically reduced and the temperature keeps steady at about 600°C. If the air flow falls below a certain value, the heating switches off automatically.

Measurements when protection of heating element has been activated

- Disconnect tool from the mains. There is an automatic reset of the circuit board after 5 seconds.
- Check air flow
- Check hose connections
- Increase air flow
- Connect tool to the mains

Accessories

- Only use LEISTER accessories
- LEISTER air flow adjuster
- PVC air hose
- Hose clamp for air hose
- Tubular nozzle \varnothing 5 mm
- Draw nozzles with tacking tip for: rod \varnothing 3 mm
rod \varnothing 4 mm
profiled rod 90 – 5.7 mm

TRAINING

LEISTER Process Technologies and their authorised Service Centres offer free welding courses and training. (see page 1).

MAINTENANCE

- Clean welding nozzles with a wire brush
- Check mains cable and plug

SERVICE AND REPAIR

- 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 according to connection diagrams and spare parts lists.

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: