

## foiler ETL

### **Automatic hot-air welding machine** **Automatic Overlap Welding Machine**

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



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)** have 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. **Laser beam pointed directly to the eye are prohibited.**

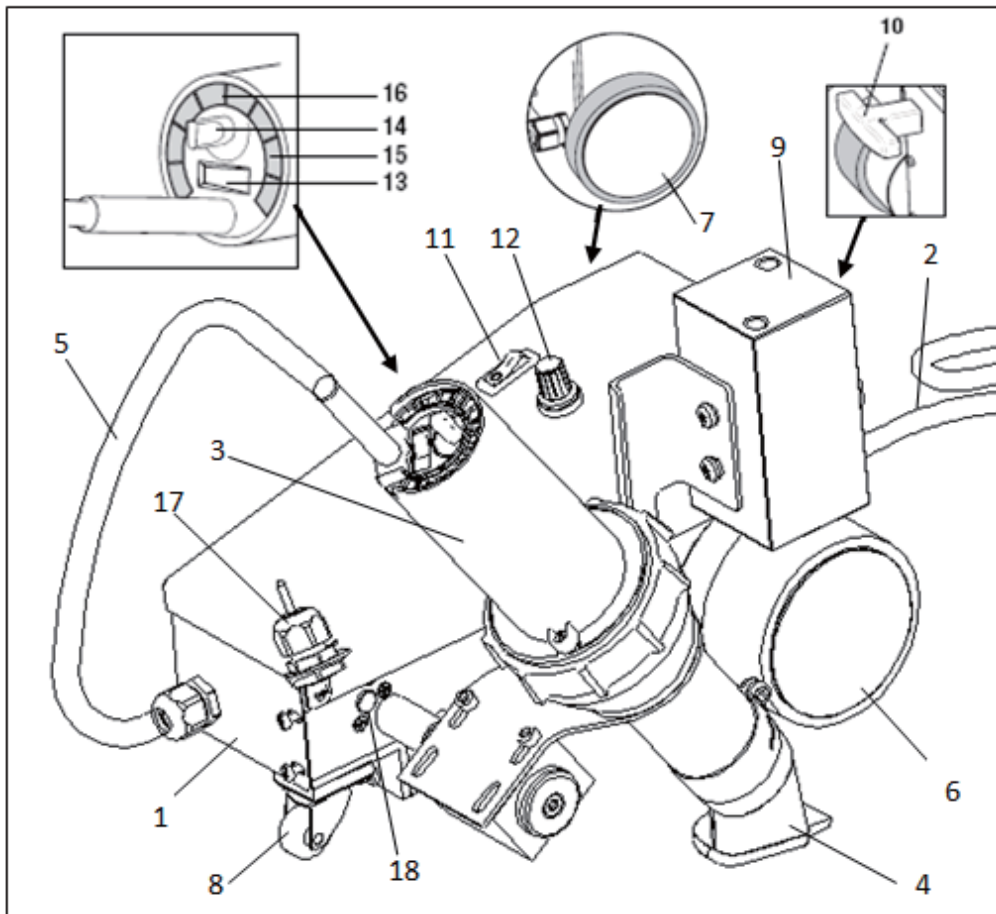


Protect the tool **from damp and wet**.

## Technical data

Voltage	V~	230
Frequency	Hz	50 / 60
Power consumption	W	1700
Temperature	°C	20 – 650
Air flow (20°C)	l/min.	200 – 270
Drive speed	m/min	1.0—7.5
Width of seam	mm.	20/30
Noise emission level	LpA(dB)	76
Dimensions	mm	445×276×280
Weight	Kg	10.8
Protection class I		⊕

## Product Structure



### Main components

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

### Operating components

12. Potentiometer for welding speed
13. Air blower switch
14. Potentiometer for temperature adjustment
15. Air filter
16. Air slide
17. Laser guide
18. Snap switch

# Putting into Operation

## Observe the mains voltage

- The power source voltage must correspond with the value given on the nameplate. Extension cords must have a conductor cross section of  $3 \times 2.5 \text{ mm}^2$  min.

## Switching Heating On:

- Set switch (13) position I. Adjust air flow as required with air slide (16). Adjust temperature as required with the potentiometer (14). The heat-up period is approx. 5 minutes.

## Laser beam guidance(Detail C):

- The laser beam is automatically started when power on.
- Adjust the laser beam direction by put your finger on the window of laser device and turn the device clockwise or anticlockwise till the beam line up with the edge of material.

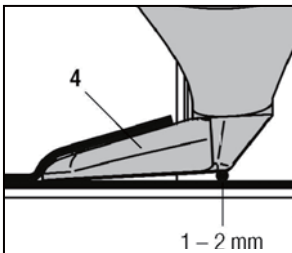
## Switching Heating Off:

- Turn the potentiometer (14) to position “0” in order to cool the tool down. When the tool has cooled down, set switch (13) to “0” .

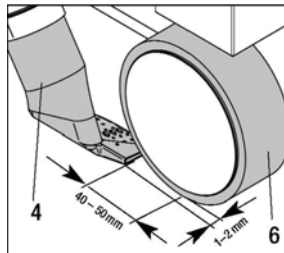
## Operating condition

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

Detail A



Detail B



Detail C



## Operating Instructions

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

## Tool position

- Swivel hot air blower (3) 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 be line up with the overlap edge of the material to be welded. The laserbeam must beline up withthe overlap edge of the material to be welded.

## Welding parameters

- Set potentiometer for welding speed (12) to required value.
- Set air blower switch (13) to position I. Set temperature and air flow to required values and heat up for about 5 minutes.
- The contact pressure is effected through the weight of automatic hot air welding machine itself.

- Use additional weight accessory as required (see assembly of additional weight).

### **Welding procedure**

- Swivel hot air blower (3) down to the stop and snap switch (18) be launched (the welding process starts).

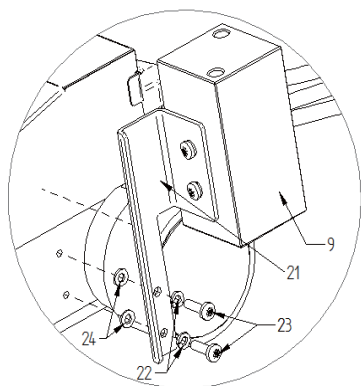
Don't need toturn on the drive switch (11), Only the drive switchfor debugging purposes.

- Supervise welding process. As necessary correct welding speed with potentiometer (12). Lead the automatic welding machine by its chassis along the length of the overlap and laser beam.
- When welding has finished, swing up hot air blower (3) to the stop.
- After completing welding work, turn potentiometer (14) to 0, so that the hot air blower (3) cools down. Then turn off the air blower switch (13).
- Disconnect the tool from the line/mains.

## **Additional weight**

### **Assembly of additional weight**

- Fasten additional weight holder assembly (9&21) to the foiler ETL machine with **spring washer (22)**、 **lens head screw (23)** and **flat washer(24)**.



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

## Accessories

- Only Weldy accessories must 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 line/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 centre using original spare parts.

## Warranty

- For this tool, we generally provide a warranty of twelve(12) 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 warranty
- Warranty 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:**

Beijing ChinaSigns Information Co., Ltd. (Sign-in-China.com)

Tel: +86-10-63705868

Add: F-4, Building 8, Section 12, Advanced Business Park (ABP),

Fax: +86-10-51118313

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