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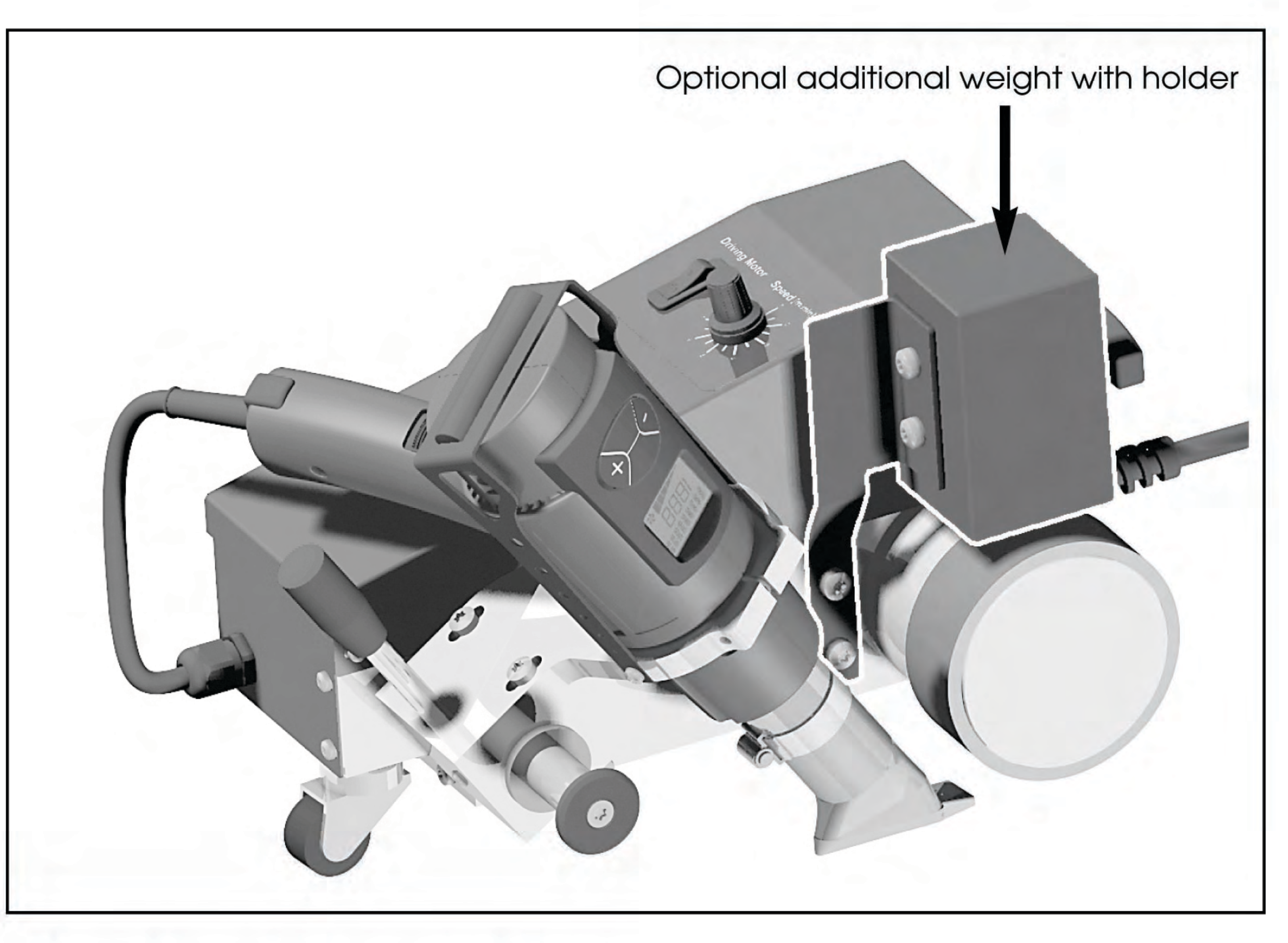
FOILER
Automatic hot-air welding machine

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.

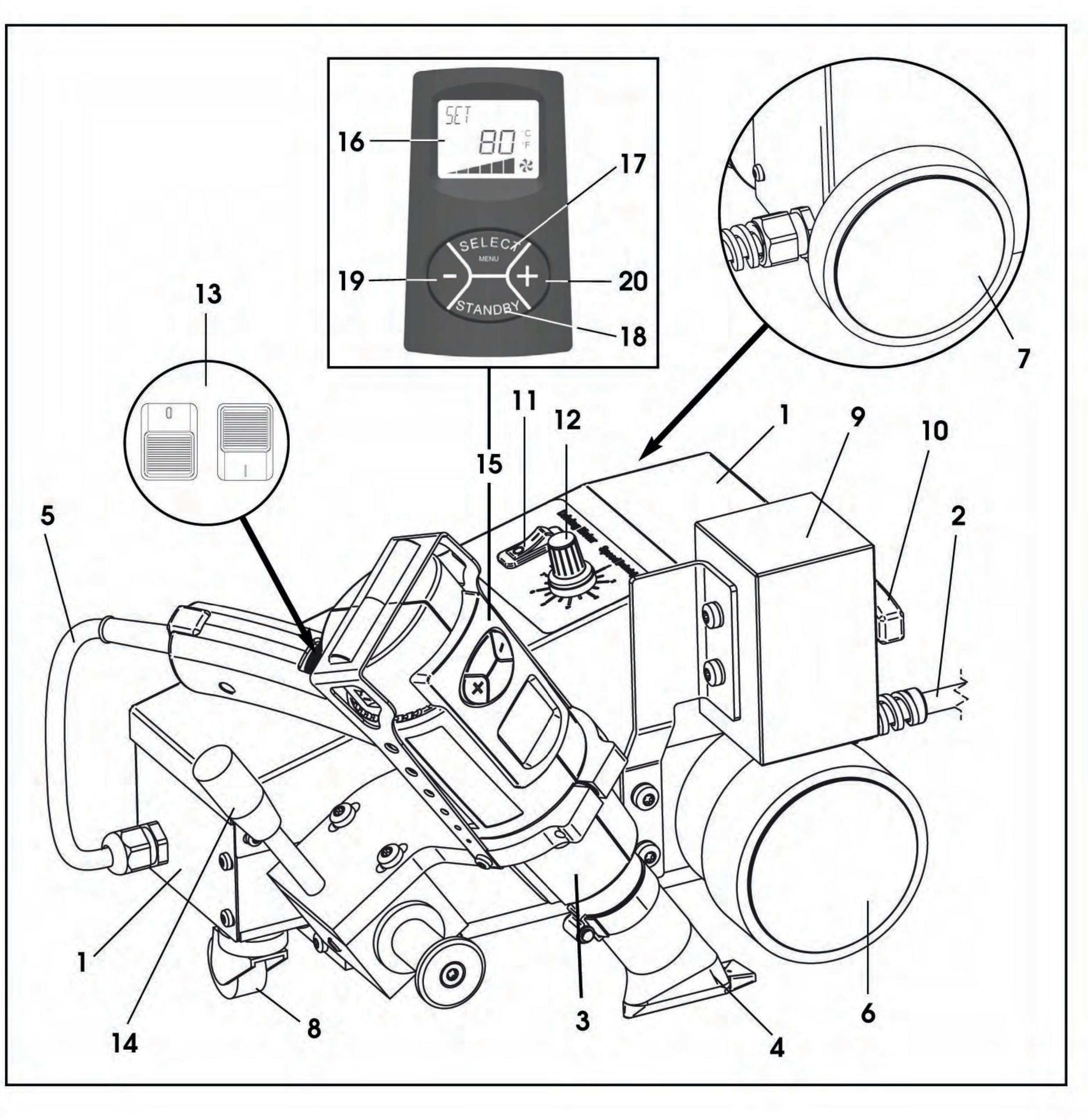
The tool must be operated **under supervision.**
Heat can ignite flammable materials which are not in view.
The machine may only be used by **qualified specialists** or under their supervision. Children are not authorized to use this machine.

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		⏚

Tool description FOILER



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

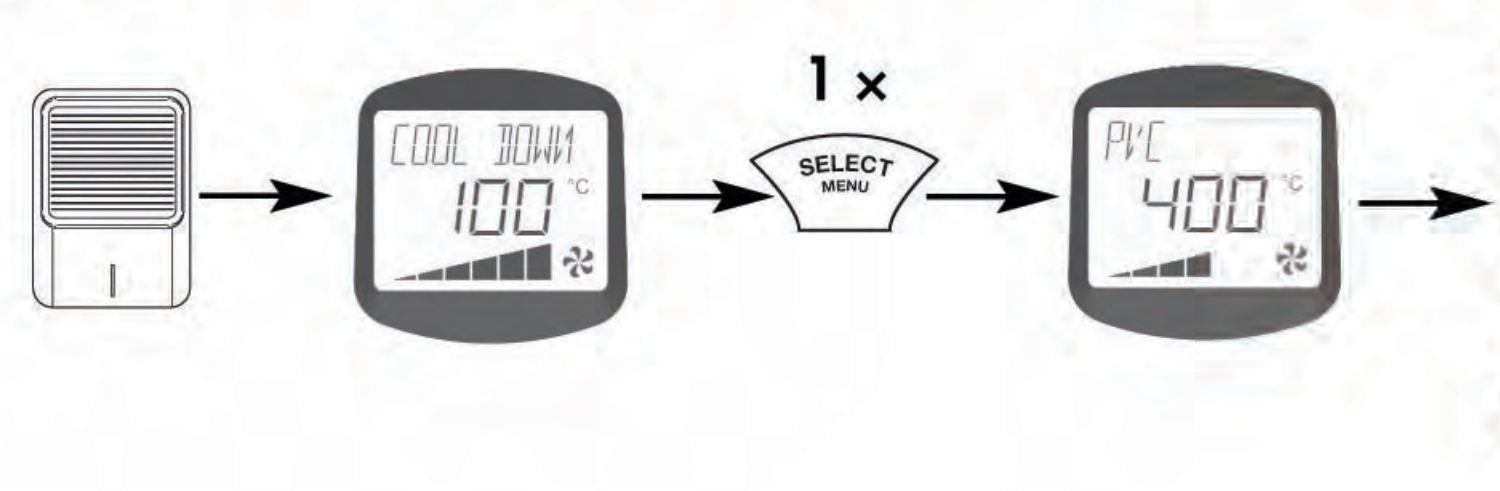
Putting into Operation FOILER

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 × 1.5 mm² 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.



Selecting the function program (see page 5)
or
Language selection Temperature °C / °F
(see below)

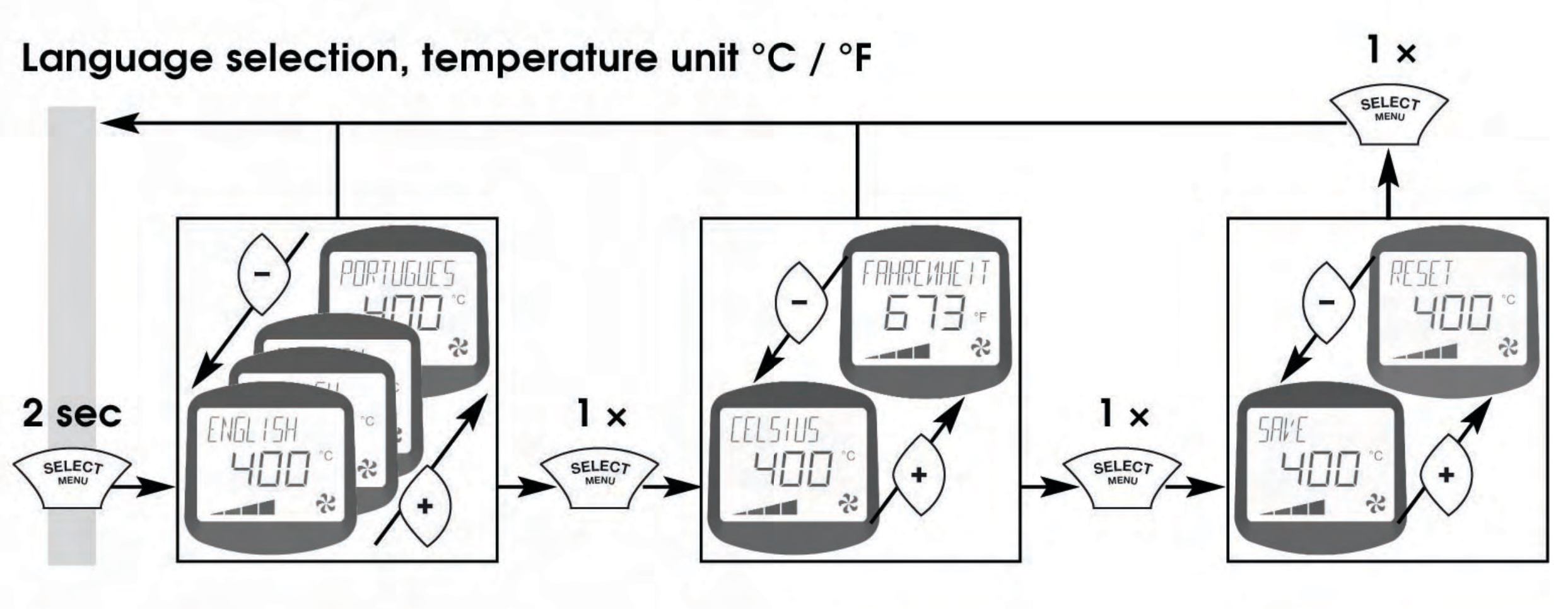
Switching off

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)

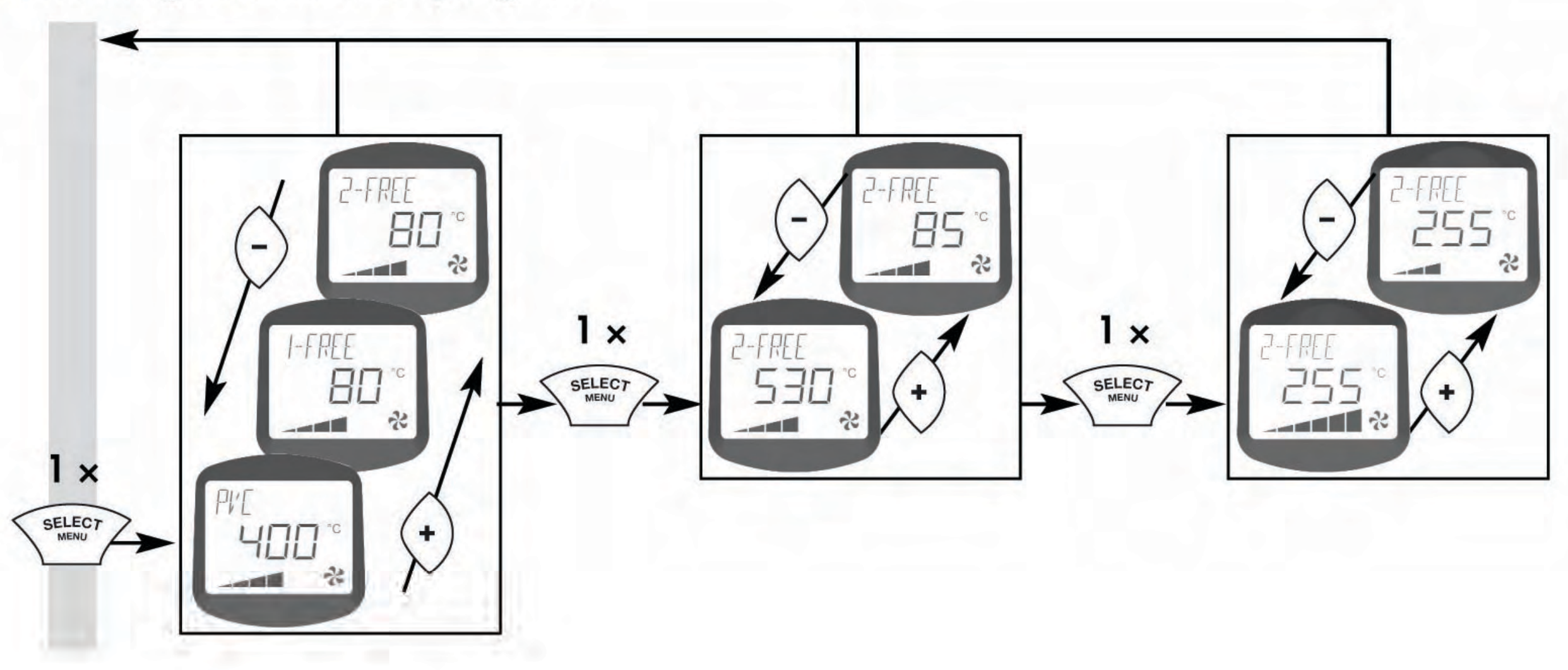
Begin the selection with the **button SELECT Menu (17)**. Note: When an indication flashes in the **display (16)**, a change can be initiated with either **button PLUS (20)** or **button MINUS (19)**. Repeated actuation of **button SELECT (17)** leads to the next step.

Language selection, temperature unit °C / °F



Putting into Operation FOILER

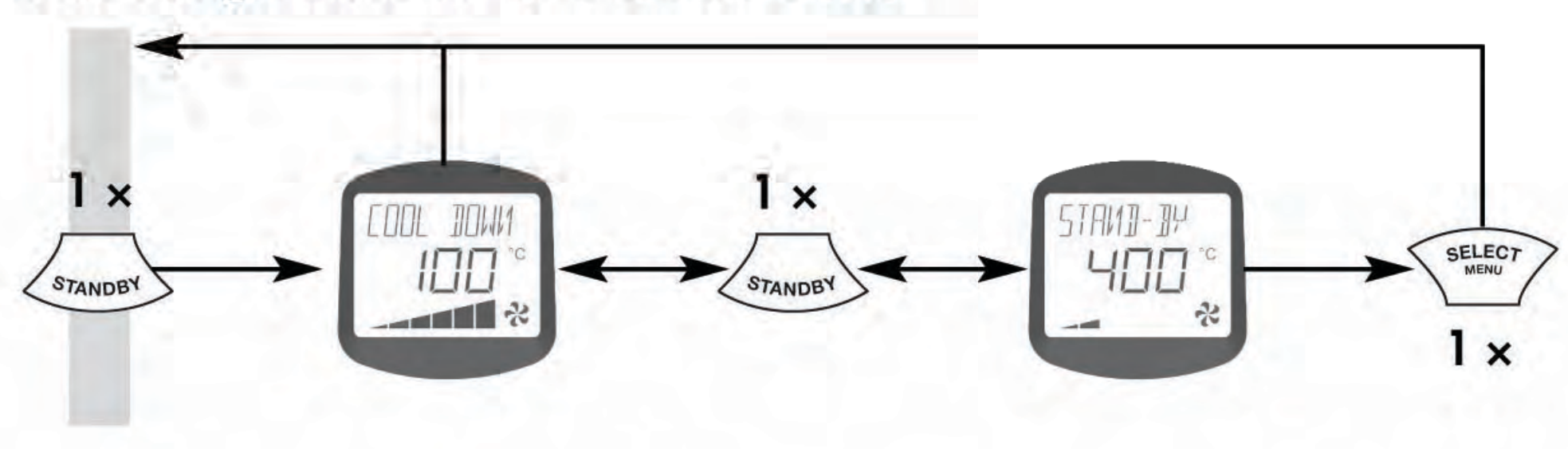
Selecting the function program



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

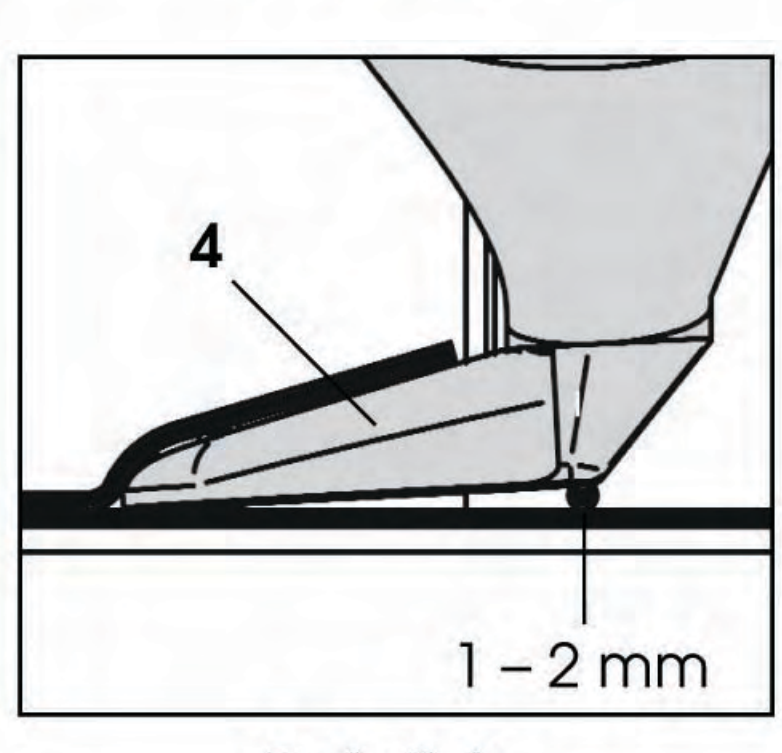


– Press 2 × **button STANDBY (18)** when interrupting your work for short time. The energy absorption is reduced.
– At the end of your work, always select **COOL DOWN** with **button STANDBY (18)**. When the unit has cooled off, switch it off with the **air blower switch (13)** and pull the plug from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

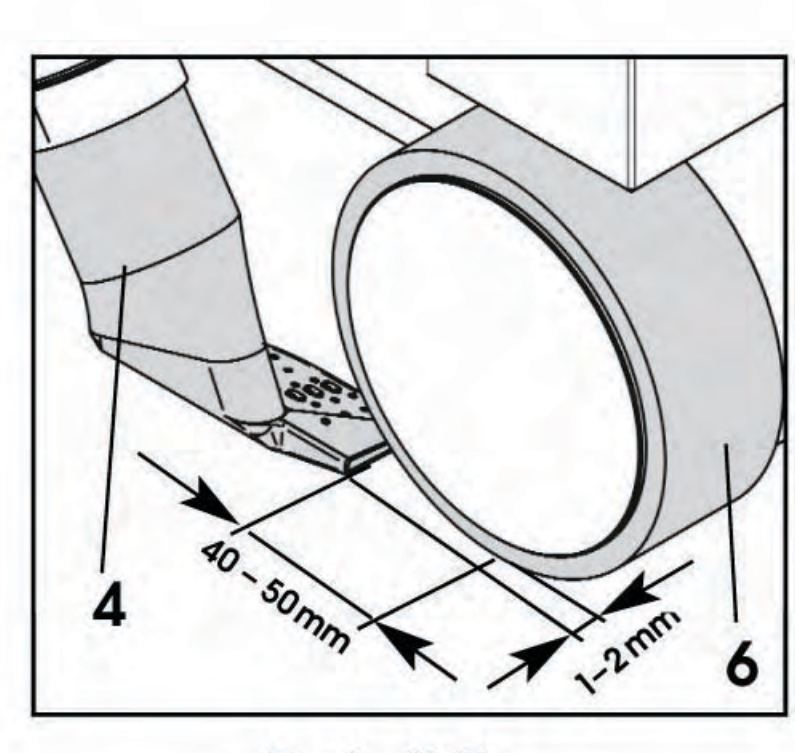
Putting into Operation FOILER

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

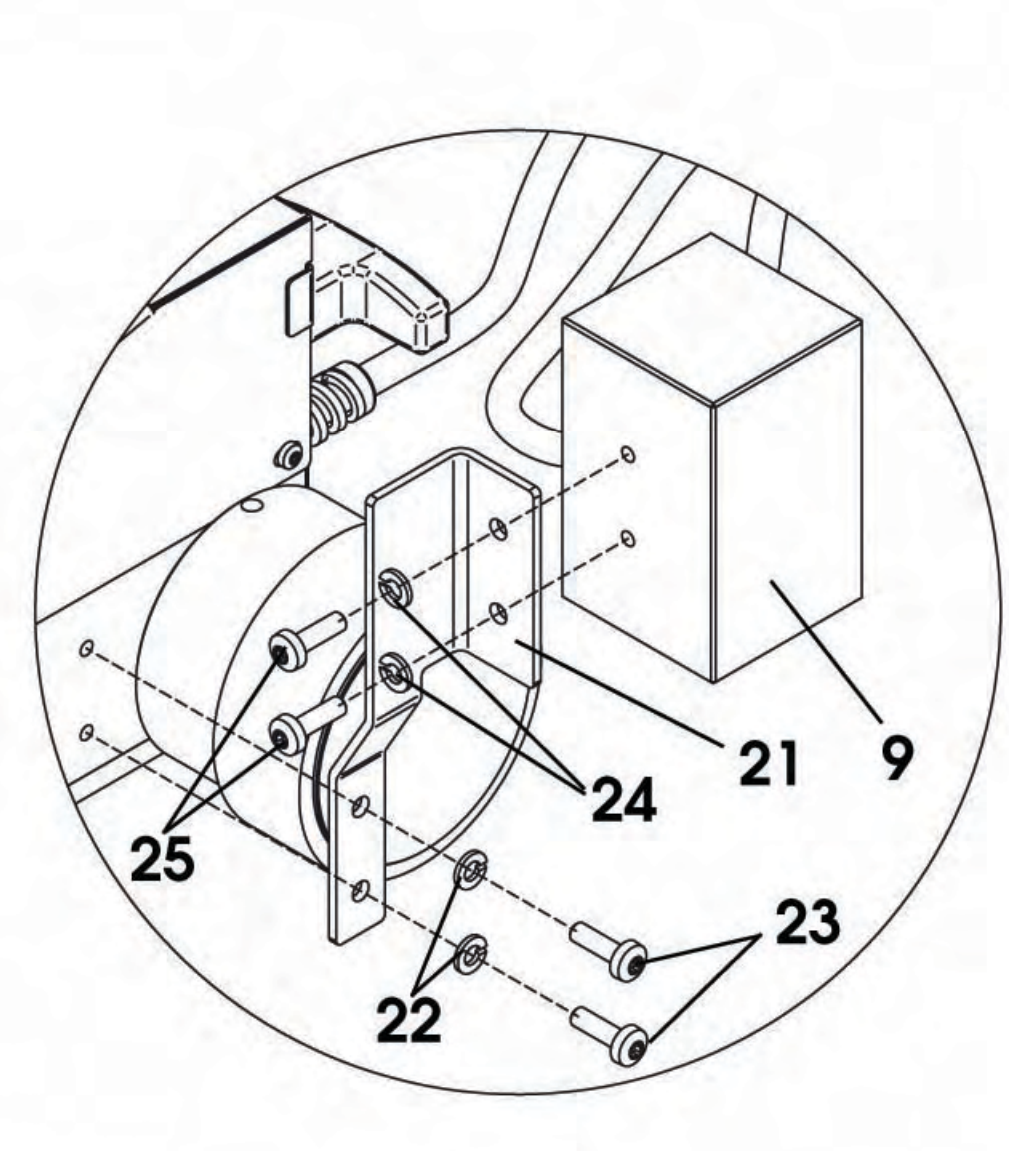
- Turn the **hot air blower (3)** up to the stop using **positioning lever (14)** and at the same time turn on the **drive switch (11)** (the welding process starts).
- Supervise the welding process. As necessary correct the welding speed with the **potentiometer (12).** Lead the automatic welding machine 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.

Additional weight accessories FOILER

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



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WELDY® made by Leister

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 caretaken in manufacture and testing, repair should be carried out by an authorized customer service centresing 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: