Flooring and Interior Decoration

Everything for welding to the floor
Dear Leister customers

Vinyl sheet flooring installers need reliable welding tools, and reliable results are a must as it is not cost effective to test every welded seam. Leister floor tools and automatic welders provide the highest quality repeatable results by supplying constant temperature, pressure, and speed during operation.

A floor that is properly welded is critical when it comes to hygienically sensitive surfaces. This is why most floors in public buildings such as hospitals or schools need to be welded properly, as well as in public transportation facilities such as planes, trains, or buses. A high-quality weld is also required in residential construction or offices in order to satisfy design requirements or to achieve a specific design.

Leister’s ergonomic floor tools will support you in any situation and guarantee reliable and economic operation. We maintain a global and close-knit service and distribution network that provides fast, reliable service.

Over the following pages, please view our extensive flooring installation tool selection through which Leister can support you in your work.

I hope you enjoy reading our brochure!

Silvan Horand
Flooring Product Manager
Welding and Pointing

For flooring applications with surface areas that have hygienic requirements which are also exposed to moisture (wet rooms) or in rooms subject to intensive wet cleaning, properly welded floors are a must.

The Welding Process

Adhesive recommended by the manufacturer is required installing linoleum and rubber. Usually 3 to 5 mm welding rod of the same material, that is recommended by the manufacturer is used for welding PVC or TPU surfaces.

Before welding, the seam edges are grooved to approx. 2/3 of the thickness of the surface and then heat seam welded with the welding rod.

It is important that the welding rod is fully melted into the milled surface created by the groover. The rod is then trimmed level to the surface in two steps using the Leister quarter-moon knife: In the first stage, the rod is trimmed using the half moon knife and slide immediately after welding/pointing. A second pass is made with the knife once the welded seam has completely cooled down. This prevents the welding rod from being trimmed below the level flooring material and produces an even, flush surface.

Welding in 4 Steps

Grooving

The flooring material must be glued to the substrate using the adhesive recommended by the manufacturer.

**Caution:** Before grooving, the adhesive between the substrate (screed) and the floor covering must be dry.

A groove is then milled in the floor covering using the GROOVER.

**Caution:** Work step by step: Groove first, then weld.

Different blades are used depending on the floor welding application.

**Caution:** This will depends upon the welding and the properties of the flooring material.

The cutting depth is determined based on the following (Fig. 1):

- A maximum of half of the welding rod diameter.
- No more than 2/3 of the flooring material thickness

Welding – preparation

The milled groove must be positioned in the center of the seam, otherwise the weld will not be adequate (Fig. 2).

**Caution:** Before beginning the weld, a separate weld test must always be performed to verify the heat, speed and temperature settings are correct for each application.

The welding parameters must be set so that a weld bead forms (Fig. 3).

<table>
<thead>
<tr>
<th>Material</th>
<th>Manual welding temperature</th>
<th>Automatic welding temperature</th>
</tr>
</thead>
<tbody>
<tr>
<td>Linoleum</td>
<td>Approx. 300–400°C</td>
<td>Approx. 400–450°C</td>
</tr>
<tr>
<td>PUR/TPU:</td>
<td>Approx. 350–400°C</td>
<td>Approx. 450–500°C</td>
</tr>
<tr>
<td>PVC:</td>
<td>Approx. 350–450°C</td>
<td>Approx. 450–550°C</td>
</tr>
</tbody>
</table>

A welding nozzle with a narrow air outlet must be used in order to avoid any impairment to the surface covering.

**Caution:** An impairment only becomes visible after several cleaning cycles.

Short welded seams are more easily welded with a TRIAC ST/AT or the HOT JET S than a MINIFLOOR or UNIFLOOR machine.
**Welding – implementation**
Welding with an automatic welder (UNIFLOOR / MINIFLOOR) is recommended for time savings and precise / repeatable welded seam results.
- Constant (high) speed
- Constant pressure
- Constant temperatures (UNIFLOOR E / MINIFLOOR with TRIAC AT)

**Manual welding (TRIAC / HOT JET S / GHIBLI)**
Recommended for short grooves, repairs, or transitions.
For a consistent weld quality, the following must be taken into consideration:
- As constant a speed as possible
- As constant a pressure as possible
- Constant temperature (TRIAC AT)

**Cutting – step 1**
The first detachment procedure takes place when the welding rod is not yet cool using a sharpened quarter-moon knife and a slide attachment.

**Caution:** It is essential that the welding wire is cut in two stages. This prevents the weld from sagging below the level surface. (Fig. 4).

**Cutting – step 2**
The second trimming procedure only takes place when the welded seam has cooled down. The cut is made flush to the surface covering using the quarter moon knife again.

The second cut takes place after the first cut and after a rest period.
- Rest period for linoleum: approx. 15 minutes
- Rest period for PVC: approx. 5 minutes

The surface is now able to bear a load and can be cleaned (Fig. 5).
- Rest period for linoleum until it can bear a full load: approx. 12 hours
- Rest period for PVC until it can bear a full load: approx. 1 hour
The benefits of Leister at a glance:

Robust device components
- Lower cost of ownership due to maintenance-free brushless drive and blower motors
- Durable high quality heating elements
- Corrosion-resistant weights

Performance
- Faster welding speeds and precise repeatable results
- An automatic welder can also shorten the process by eliminating steps in the process
- Leister tools with digital settings compensate for power quality issues and eliminate power problems that are typical at industrial locations and construction sites.

Service
- Support and device demonstration by our field service representatives
- Everything available from a single source thanks to a wide product range
- Tight distribution network with short delivery times
- Leister guarantees for 7 years after a tool is discontinued
- Fast repair and service
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Hot-Air Hand Tools

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Flooring / Interior Decoration

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Promotes the life of the floor.

For aseptic applications.

Suitable for frequent cleaning.
### Overview

**Hot-air hand tools**

<table>
<thead>
<tr>
<th>Typ</th>
<th>TRIAC ST</th>
<th>TRIAC AT</th>
<th>ELECTRON ST</th>
<th>HOT JET S</th>
</tr>
</thead>
<tbody>
<tr>
<td>Area of application</td>
<td>for welding elastic floor coverings</td>
<td>for welding elastic floor coverings</td>
<td>for welding elastic floor coverings</td>
<td>for welding elastic floor coverings</td>
</tr>
<tr>
<td>Electronic</td>
<td>Open loop</td>
<td>Close loop</td>
<td>Open loop</td>
<td>Open loop</td>
</tr>
<tr>
<td>Catalog page</td>
<td>10 / 11</td>
<td>11</td>
<td>12 / 13</td>
<td>14</td>
</tr>
</tbody>
</table>

*The parameters listed are purely reference values (room temperature 20°C). A test weld which takes into account the information provided by the material manufacturer is absolutely essential.

### Closed-loop system

The closed-loop technology means that the parameters are kept constant at all times, even in the event of voltage fluctuations, enabling reliable welding in the building site environment.
### Overview

**Flooding**

<table>
<thead>
<tr>
<th>Typ</th>
<th>GROOVY</th>
<th>GROOVER</th>
<th>MINIFLOOR</th>
<th>UNIFLOOR</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Area of application</strong></td>
<td>Gouging tool for elastic floor coverings</td>
<td>Grooving machine for elastic floor coverings</td>
<td>Drive unit for welding elastic floor coverings</td>
<td>Welder for welding elastic floor coverings</td>
</tr>
<tr>
<td><strong>Groove wide</strong></td>
<td>mm 2.5 / 3.5</td>
<td>2.5 / 2.8 / 3.5 / 4.0</td>
<td>2.5 - 4.0</td>
<td>2.5 - 4.0</td>
</tr>
<tr>
<td><strong>Groove depth</strong></td>
<td>mm 0.5 - 2.5</td>
<td>0.0 - 4.0</td>
<td>2.5 - 4.0</td>
<td>2.5 - 4.0</td>
</tr>
<tr>
<td><strong>Speed</strong></td>
<td>m/min</td>
<td>Phase 1 (Linoleum) 4 - 6</td>
<td>Phase 2 (PVC, TPU, PU) 8 - 12</td>
<td>0.5 - 4.5</td>
</tr>
<tr>
<td><strong>Temperature</strong></td>
<td>°C</td>
<td>-</td>
<td>-</td>
<td>40 - 620 (with TRIAC AT)</td>
</tr>
<tr>
<td><strong>Air flow range</strong></td>
<td>%</td>
<td>-</td>
<td>-</td>
<td>20 - 100 (with TRIAC AT)</td>
</tr>
<tr>
<td><strong>Voltage</strong></td>
<td>V</td>
<td>-</td>
<td>120 / 230</td>
<td>100 - 230</td>
</tr>
<tr>
<td><strong>Frequency</strong></td>
<td>Hz</td>
<td>-</td>
<td>50 / 60</td>
<td>50 / 60</td>
</tr>
<tr>
<td><strong>Power</strong></td>
<td>W</td>
<td>-</td>
<td>Phase 1 (Linoleum) 350</td>
<td>Phase 2 (PVC, TPU, PU) 700</td>
</tr>
<tr>
<td><strong>Weight</strong></td>
<td>kg</td>
<td>0.29</td>
<td>6.7</td>
<td>5.3</td>
</tr>
<tr>
<td><strong>Size</strong></td>
<td>mm</td>
<td>180 x 42 x 92</td>
<td>240 x 205 x 255</td>
<td>310 x 225 x 245</td>
</tr>
<tr>
<td><strong>Cable length</strong></td>
<td>m</td>
<td>-</td>
<td>3</td>
<td>3</td>
</tr>
</tbody>
</table>

#### Startup parameters*

<table>
<thead>
<tr>
<th>Materials</th>
<th>Linoleum (Phase 1) PVC, TPU, PU (Phase 2)</th>
<th>Linoleum PVC, TPU, PU</th>
<th>Linoleum PVC, TPU, PU</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Speed</strong></td>
<td>m/min</td>
<td>5</td>
<td>10</td>
</tr>
<tr>
<td><strong>Temperature</strong></td>
<td>°C</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td><strong>Air flow range</strong></td>
<td>%</td>
<td>-</td>
<td>-</td>
</tr>
</tbody>
</table>

*The parameters listed are purely reference values (room temperature 20°C). A test weld which takes into account the information provided by the material manufacturer is absolutely essential.

### Weld Geometries / Welding Methods

#### Draw Welding (Speed Welding)

**Hand tools**

This welding method requires the use of a speed welding nozzle. Preheat the surfaces to the appropriate temperature. The surfaces are plasticized by hot air and joined under consistent downward pressure.
TRIAC ST – Design meets experience

The new TRIAC ST from Leister 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 comfort, being reliable versatile and user friendly, like its predecessor the TRIAC S. A prominent feature here is the two-component handle, which is not only attractive, but also gives the user perfect grip. The low weight of less than 1 kg/2.18 lbs ensures a perfect weight balance.

Product advantage

1. Ergonomic handling:
The 2-component handle and perfect tool balance ensure ideal grip and optimum working even under the toughest conditions.

2. Perfect weight:
Weighing less than 1 kg, the TRIAC ST is even lighter than its predecessor.

3. Always keeps a cool head:
There is an actively cooled protective tube for greater work safety.

4. Welding power:
Thanks to the optimized, highly robust motor, TRIAC ST guarantees high welding power.

5. Reliability:
A new temperature manager and a high dust resistance provide the heating elements with a long service life.

Swiss thoroughness:
The air filters, located on either side, can easily 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**

**TRIAC AT**

- 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 / 230
- **Frequency** Hz 50 / 60
- **Power** W 1600 / 1600
- **Temperature** °C 40 – 700
- **Air volume (20°C)** l/min 240 (500 at max. temp)
- **Dynamic pressure** Pa 3000
- **Ø Nozzle holder** mm 31.5
- **Emission** dB(A) 67
- **Size (L × Ø)** mm 338 × 90, handle Ø 56
- **Weight** kg <1 (without power cord)

**Conformity mark**

**Approval mark**

**Protection class II**

**Article No.:**

- 141.308 TRIAC ST, 120 V / 1600 W for push-fit nozzles with UK-plug
- 141.309 TRIAC ST, 230 V / 1600 W for push-fit nozzles with UK-plug
- 141.311 TRIAC ST, 230 V / 1600 W for push-fit nozzles with CH plug
- 141.227 TRIAC ST, 230 V / 1600 W for push-fit nozzles with Euro plug
- 144.013 TRIAC ST, 230 V / 1600 W for screw-on nozzles with Euro plug
- 153.891 TRIAC ST, 220 V / 1600 W for push-fit nozzles with KR-plug

**Technical data**

- **Voltage** V~ 120 / 230
- **Frequency** Hz 50 / 60
- **Power** W 1600 / 1600
- **Temperature** °C 40 – 620
- **Air volume (20°C)** l/min 160 – 240 (500 at max. temp)
- **Dynamic pressure** Pa 1600 – 3000
- **Ø Nozzle holder** mm 31.5
- **Emission** dB(A) 67
- **Size (L × Ø)** mm 338 × 90, handle Ø 56
- **Weight** kg 1 (without power cord)

**Conformity mark**

**Approval mark**

**Protection class II**

**Article No.:**

- 141.319 TRIAC AT, 120 V / 1600 W, with UK-plug
- 141.320 TRIAC AT, 230 V / 1600 W, with UK-plug
- 141.314 TRIAC AT, 230 V / 1600 W, with Euro-plug
- 141.322 TRIAC AT, 230 V / 1600 W, with CH-plug
- 142.737 TRIAC AT, 230 V / 1600 W for screw-on nozzles with Euro plug
- 148.005 TRIAC AT, 220 V / 1600 W, for push-fit nozzles with KR-plug
ELECTRON ST – Strong, compact and handy

The new ELECTRON ST is a real powerhouse among Leister’s hand tools. The appearance of this tool has been modeled after the new TRIAC range. For the user, this means improved ergonomics and, as a result, the ability to work in more comfort. Existing ELECTRON nozzles fit the new model.

Product advantages

1. Powerful: Suitable for any application thanks to its outstanding power rating of up to 3400 W.

2. Perfekte Ergonomie: 100 lighter and with a 2-component handle that’s nearly 8 mm slimmer than its predecessor.

3. Infinitely adjustable: Easy air temperature adjustment up to 650 °C.

4. Clean: Air filters, located on either side, can be removed and cleaned in no time at all.

5. Compatible: All predecessor nozzles fit the ELECTRON ST.
Hot-air hand tool

ELECTRON ST

- Suitable for construction sites
- Leister’s most powerful hand tool
- Easy-clean air filter
- Carbon stop and heating element protection provide automatic protective measures
- Sturdy tool case supplied

Technical data

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Unit</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage</td>
<td>V</td>
<td>230 / 230 / 200 / 120</td>
</tr>
<tr>
<td>Frequency</td>
<td>Hz</td>
<td>50 / 60</td>
</tr>
<tr>
<td>Power</td>
<td>W</td>
<td>2300 / 3400 / 3000 / 2400</td>
</tr>
<tr>
<td>Temperature</td>
<td>°C</td>
<td>40 – 650</td>
</tr>
<tr>
<td>Air volume (20°C)</td>
<td>l/min</td>
<td>360 (700 at max. temp)</td>
</tr>
<tr>
<td>Dynamic pressure</td>
<td>Pa</td>
<td>3400</td>
</tr>
<tr>
<td>Ø Nozzle holder</td>
<td>mm</td>
<td>50</td>
</tr>
<tr>
<td>Emission</td>
<td>dB(A)</td>
<td>67</td>
</tr>
<tr>
<td>Size (L × Ø)</td>
<td>mm</td>
<td>338 × 90, handle Ø 56</td>
</tr>
<tr>
<td>Weight</td>
<td>kg</td>
<td>1.1 (without power cord)</td>
</tr>
<tr>
<td>Conformity mark</td>
<td></td>
<td>CE</td>
</tr>
<tr>
<td>Approval mark</td>
<td></td>
<td>UK</td>
</tr>
<tr>
<td>Protection class II</td>
<td></td>
<td>II</td>
</tr>
</tbody>
</table>

Article No.

145.567 ELECTRON ST, 230 V / 3400 W for push-fit nozzles with Euro plug
149.673 ELECTRON ST, 230 V / 2300 W for push-fit nozzles with Euro plug
145.563 ELECTRON ST, 120 V / 2400 W for push-fit nozzles with UK plug
145.568 ELECTRON ST, 230 V / 3400 W for push-fit nozzles with UK plug
154.839 ELECTRON ST, 220 V / 3400 W for push-fit nozzles with KR-plug

Accessories ELECTRON ST

<table>
<thead>
<tr>
<th>Article No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>107.270</td>
<td>Wide slot nozzle 150 × 12 mm, push-fit</td>
</tr>
<tr>
<td>142.281</td>
<td>Scraper nozzle</td>
</tr>
<tr>
<td>148.933</td>
<td>Protective tube</td>
</tr>
<tr>
<td>145.606</td>
<td>Heating elements 230 V / 3300 W</td>
</tr>
<tr>
<td>149.675</td>
<td>230 V / 2200 W</td>
</tr>
<tr>
<td>145.604</td>
<td>120 V / 2300 W</td>
</tr>
</tbody>
</table>

13
HOT JET S: Small and powerful.

As the most compact hot-air hand tool from Leister, the HOT JET S’ low weight of 600 grams (including cord and slim handle) ensures high-powered, fatigue-free welding.

Especially suited to facilitate tasks in difficult to access areas.

**Technical data**

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage V~</td>
<td>120 / 230</td>
</tr>
<tr>
<td>Frequency Hz</td>
<td>50 / 60</td>
</tr>
<tr>
<td>Power W</td>
<td>460 / 460</td>
</tr>
<tr>
<td>Temperature °C</td>
<td>40 – 600</td>
</tr>
<tr>
<td>Air volume (20°C) l/min</td>
<td>40 – 110 (200 at max. temp)</td>
</tr>
<tr>
<td>Pressure static Pa</td>
<td>230 – 1600</td>
</tr>
<tr>
<td>Ø Nozzle holder mm</td>
<td>21.3</td>
</tr>
<tr>
<td>Emission dBA</td>
<td>59</td>
</tr>
<tr>
<td>Size (L × Ø) mm</td>
<td>235 × 70, handle Ø 40</td>
</tr>
<tr>
<td>Weight kg</td>
<td>0.4 (without power cord)</td>
</tr>
</tbody>
</table>

**Conformity mark**

- CE

**Protection class II**

**Article No.:**

- 100.648 HOT JET S, 230 V / 460 W, with Euro plug
- 100.862 HOT JET S, 120 V / 460 W, without plug
- 100.854 HOT JET S, 230 V / 460 W, with AUS plug
- 140.030 HOT JET S, 220V / 460W for push-fit nozzles with KR-plug

**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

**Accessories HOT JET S**

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>107.144</td>
<td>Ø 5 mm, tubular nozzle, 15° angled</td>
</tr>
<tr>
<td>131.867</td>
<td>Ø 5 mm, tubular nozzle, 90° angled</td>
</tr>
<tr>
<td>105.567</td>
<td>Ø 5 × 150 mm extension nozzle, straight</td>
</tr>
<tr>
<td>105.431</td>
<td>3 mm speed welding nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle</td>
</tr>
<tr>
<td>105.432</td>
<td>4 mm speed welding nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle</td>
</tr>
<tr>
<td>105.433</td>
<td>5 mm speed welding nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle</td>
</tr>
</tbody>
</table>
MINIFLOOR – efficient and affordable for everyone!

The MINIFLOOR turns your hot-air hand tool into an automatic welder within seconds; increases the weld quality, facilitates work, and reduces time considerably. Its use is worthwhile from weld lengths of 1.20 m/4 ft., and thanks to its lightweight design of 5.3 kg/12 lbs., the MINIFLOOR can be transported effortlessly.

<table>
<thead>
<tr>
<th>Hot-air welder</th>
<th>MINIFLOOR</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>1</strong></td>
<td><strong>Reverse compatibility:</strong> Thanks to the interchangeable inserts, even older TRIAC models can be connected without a hitch.</td>
</tr>
<tr>
<td><strong>2</strong></td>
<td><strong>Tool-free assembly of the de-reeler:</strong> even if the de-reeler is missing you may count on hassle-free handling, as well as smooth feeding of the welding rod into the “air-slide” of the speed welding nozzle.</td>
</tr>
<tr>
<td><strong>3</strong></td>
<td><strong>Incredibly fast:</strong> Despite its lightweight design, the MINIFLOOR offers a welding speed of about 2 m/6.5 ft per minute, nearly double the speed of manual welding.</td>
</tr>
<tr>
<td><strong>4</strong></td>
<td><strong>The quick-lock fastening system at the clamp allows for assembling / dismantling of the TRIAC in a matter of seconds.</strong> The power supply for the hand tool is integrated in the MINIFLOOR drive unit and you have the possibility to securely fasten the cable.</td>
</tr>
<tr>
<td><strong>5</strong></td>
<td><strong>The individually-adjustable, start-up delay of the MINIFLOOR drive unit enables modification of the startup according to individual needs.</strong> The long guide ensures outstanding precision along the seam.</td>
</tr>
<tr>
<td><strong>6</strong></td>
<td><strong>The 51 mm/2 inches minimum distance from the wall,</strong> ensures trouble-free welding around construction pipes and L-skirts. Due to its compact height, the MINIFLOOR seamlessly welds beneath obstacles with a minimum clearance of 295 mm /12 inches.</td>
</tr>
</tbody>
</table>
The MINIFLOOR is ideal for short joints and small projects.

**Hot-air welder / drive unit**

**MINIFLOOR Drive Unit**

- The only automatic welder with the possibility of connecting a hot-air hand tool in the simplest manner.
- Worthwhile from weld lengths of 1.20 m/4 ft.
- Swiss Quality you can rely on.
- Due to (51 mm/2 inches) minimum distance from the wall, there is only one required joint along the weld seam, and THAT saves time!
- Weighting in at 6.6 kg / 15 lbs (incl. TRIAC AT / nozzles) the MINIFLOOR is a lightweight and easily transportable solution.
- **NEW:** Improved directional stability!

### Technical Data

<table>
<thead>
<tr>
<th>MINIFLOOR</th>
<th>Drive Unit only</th>
<th>with TRIAC AT</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage</td>
<td>V–</td>
<td>100 – 230</td>
</tr>
<tr>
<td>Frequency</td>
<td>Hz</td>
<td>50/60</td>
</tr>
<tr>
<td>Power</td>
<td>W</td>
<td>5</td>
</tr>
<tr>
<td>Temperature</td>
<td>°C</td>
<td>40 – 620</td>
</tr>
<tr>
<td>Air flow range</td>
<td>%</td>
<td>20 – 100%</td>
</tr>
<tr>
<td>Drive speed</td>
<td>m/min</td>
<td>0.5 – 4.5</td>
</tr>
<tr>
<td>Control</td>
<td>Closed-loop</td>
<td>Closed-loop</td>
</tr>
<tr>
<td>Blower</td>
<td>Brush motor</td>
<td></td>
</tr>
<tr>
<td>Welding seam</td>
<td>mm</td>
<td>2.5 / 3.5</td>
</tr>
<tr>
<td>Size (L × W × H)</td>
<td>mm</td>
<td>310 × 225 × 245</td>
</tr>
<tr>
<td>Weight</td>
<td>kg</td>
<td>5.3</td>
</tr>
<tr>
<td>Conformity marks</td>
<td></td>
<td>CE</td>
</tr>
<tr>
<td>Protection class I</td>
<td></td>
<td>CE</td>
</tr>
</tbody>
</table>

### Accessories MINIFLOOR Drive Unit

- **TRIAC AT / TRIAC ST**
  - All models and part numbers can be found at page 10/11
  - 154.266 Storage case MINIFLOOR
  - 156.531 Carrying strap for Leister Case
  - 154.723 Rubber pads for TRIAC-bracket (old generation Ø 64 mm)
  - 100.303 Ø 5 mm, tubular nozzle, push-fit
  - 105.432 Speed weld nozzle, with small air-slide, push-fit on Ø 5 mm tubular nozzle Ø 4 mm
  - 105.433 Ø 5 mm (recommended)
  - 154.425 Replacement Guide wheel Guide wheel 0.5 mm
  - 159.436 Guide wheel 2.0 mm
  - 163.870 Additional weight, increases the directional stability. Compatible with previous models

### MINIFLOOR Drive Unit

- **Article No.:**
  - 154.330 MINIFLOOR drive unit, with EU-plug; 230V
  - 154.334 MINIFLOOR drive unit, with CH-plug; 230V
  - 154.337 MINIFLOOR drive unit, with UK-plug; 110V
  - 154.338 MINIFLOOR drive unit, with AUS-plug; 230V
  - Scope of delivery: Plastic case, Roller Holder, Rubber pad set Ø 57 - Ø 60 mm, Velcro fastener 2 pcs, Operating Manual
  - 154.335 MINIFLOOR drive unit, with US/JP-plug; 120V
  - 154.336 MINIFLOOR drive unit, without plug; 230V
  - Scope of delivery: Plastic case, Roller Holder, Rubber pad set Ø 57 - Ø 60 mm, Rubber pad set Ø 64 - Ø 65 mm, Velcro fastener 2 pcs, Operating Manual

**General accessories**
UNIFLOOR E / S: A jack of all trades.

With the UNIFLOOR E you can weld floor coverings made of PVC-P, PE, linoleum and modified thermoplastics without any reconfiguration, up to 7.5 meters per minute.

**Hot-air welder**

**UNIFLOOR E / UNIFLOOR S**

- Reproducible results thanks to permanent regulation of the NOMINAL and ACTUAL values
- Heater and drive electronically regulated
- Steplessly controlled air flow (only UNIFLOOR E)
- All floor coverings welded without reconfiguration
- Automatic start
- Integrated wall switch

---

**Technical Data**

<table>
<thead>
<tr>
<th>Parameter</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Voltage</td>
<td>120 / 230 V~</td>
</tr>
<tr>
<td>Power</td>
<td>2300 W</td>
</tr>
<tr>
<td>Temperature</td>
<td>80 – 620 °C</td>
</tr>
<tr>
<td>Speed</td>
<td>1.0 – 7.5 m/min</td>
</tr>
<tr>
<td>Air flow range</td>
<td>50 – 100 %</td>
</tr>
<tr>
<td>Size (L x W x H)</td>
<td>420 x 270 x 215 mm</td>
</tr>
<tr>
<td>Weight (without de-reeler)</td>
<td>11.5 (with 3 m cable)</td>
</tr>
<tr>
<td>Conformity marking</td>
<td>CE</td>
</tr>
<tr>
<td>Protection class</td>
<td>I</td>
</tr>
</tbody>
</table>

**Accessories UNIFLOOR E / UNIFLOOR S**

- **115.054** Welding rod de-reeler
- **115.057** Trolley attachment
- **114.224** Floor welding nozzle, optimized for PVC material
- **115.342** Floor welding squeezed nozzle, for PVC + PUR material
- **103.394** Floor welding nozzle air-knife, optimized for PUR material
- **115.216** 3/3 air flap for Linoleum welding rod
- **117.235** 2/3 air flap, optimized for PUR material and linoleum welding rod
- **126.448** Storage case 605 x 486 x 312 mm plastic, green (included with purchase)
- **103.604** Heating element, 230 V / 2100 W
- **103.602** Heating element, 120 V / 1800 W

**Article No.:**

- 138.493 UNIFLOOR E, 230 V, including rod de-reeler, squeezed nozzle (PVC and PUR), with Euro plug, storage case
- 115.345 UNIFLOOR E, 230 V, squeezed nozzle (PVC and PUR), with Euro plug, storage case
- 138.494 UNIFLOOR S, 230 V, including rod de-reeler, squeezed nozzle (PVC and PUR), with Euro plug, storage case
- 115.032 UNIFLOOR S, 230 V, squeezed nozzle (PVC and PUR), with Euro plug, storage case
- 139.217 UNIFLOOR E, 230 V, including rod de-reeler, Air-Knife nozzle, 2/3 air flap (PUR), with Euro plug, storage case
- 115.024 UNIFLOOR E, 120 V, squeezed nozzle (PVC and PUR), without plug, storage case
**GROOVER: Dust-free milling.**

The GROOVER grooving machine cuts welding grooves into thick, tough floor coverings made of PVC-P, PE and linoleum. The tool glides on three rollers and cuts a uniform groove depth, even at high speeds.

---

**Grooving machine**

**GROOVER**

- Cuts grooves into all types of floor coverings
- Extremely high, two stage cutting speeds
- Adjustable guide roller for tracking accuracy
- Reduced dust particles when used with dust bag
- Cutting close to the edge possible

---

**Accessories GROOVER**

<table>
<thead>
<tr>
<th>Article No.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>102.401</td>
<td>Ø 110 × 3.5 mm, tungsten carbide-tipped blade, trapezium profile</td>
</tr>
<tr>
<td>102.402</td>
<td>Ø 110 × 4 mm, tungsten carbide-tipped blade, round profile</td>
</tr>
<tr>
<td>102.404</td>
<td>Ø 110 × 2.5 mm, tungsten carbide-tipped blade, round profile</td>
</tr>
<tr>
<td>102.403</td>
<td>Ø 110 × 2.8 mm, tungsten carbide-tipped blade, round profile</td>
</tr>
<tr>
<td>102.405</td>
<td>Ø 110 × 3.5 mm, tungsten carbide-tipped blade, round profile</td>
</tr>
<tr>
<td>102.406</td>
<td>Ø 110 × 3.5 mm, diamond cutting blade, semi-round profile</td>
</tr>
<tr>
<td>126.448</td>
<td>Storage case (included with purchase)</td>
</tr>
</tbody>
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**Technical Data**

<table>
<thead>
<tr>
<th>Feature</th>
<th>Value</th>
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</thead>
<tbody>
<tr>
<td>Voltage V~</td>
<td>120 / 230</td>
</tr>
<tr>
<td>Power W</td>
<td>350 / 700 (2 levels)</td>
</tr>
<tr>
<td>Cutting speeds rpm Level 1</td>
<td>14 500 (350 W)</td>
</tr>
<tr>
<td></td>
<td>Level 2: 18 500 (700 W)</td>
</tr>
<tr>
<td>Groove depth adjustment mm</td>
<td>0 – 4</td>
</tr>
<tr>
<td>Size (L × W × H) mm</td>
<td>240 × 205 × 255</td>
</tr>
<tr>
<td>Weight kg</td>
<td>6.7 (with 3 m cable)</td>
</tr>
</tbody>
</table>

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**Conformity marking**

CE

---

**Article No.:**

<table>
<thead>
<tr>
<th>Article No.</th>
<th>Description</th>
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</thead>
<tbody>
<tr>
<td>108.393</td>
<td>GROOVER 230 V, tungsten carbide tipped blade Ø 110 x 3.5 mm, trapezium profile, with Euro plug, storage case</td>
</tr>
<tr>
<td>111.032</td>
<td>GROOVER 230 V, tungsten carbide tipped blade Ø 110 x 3.5 mm, round profile, with Euro plug, storage case</td>
</tr>
<tr>
<td>108.397</td>
<td>GROOVER 120 V, tungsten carbide tipped blade Ø 110 x 3.5 mm, trapezium profile, with UK plug yellow, storage case</td>
</tr>
<tr>
<td>108.395</td>
<td>GROOVER 120 V, tungsten carbide tipped blade Ø 110 x 3.5 mm, trapezium profile, with US plug polarized, storage case</td>
</tr>
<tr>
<td>108.396</td>
<td>GROOVER 120 V, tungsten carbide tipped blade Ø 110 x 2.5 mm, round profile, with US plug nonpolarized, storage case</td>
</tr>
</tbody>
</table>

---

Strong drive suitable for PVC, PUR and linoleum materials.
GROOVY: Lightweight and handy.

The new “GROOVY” gouging tool is the lightweight, handy tool for the experienced layer of plastic floor coverings made of PVC or linoleum. Its ergonomic shape makes it possible to achieve the desired groove width and depth up to the connecting walls, defined and clean-cut, with little pressure.

Gouging tool

GROOVY

• Lightweight and handy
• Groove preparation without milling
• Clean transition from machine-milled groove to the closure
• Ideal for surfaces that are small and difficult to access
• Precise work thanks to roller guide
• Groove gouging up to connecting walls
• Adjustable groove depth

Technical Data

<table>
<thead>
<tr>
<th></th>
<th>mm</th>
<th>3.5</th>
</tr>
</thead>
<tbody>
<tr>
<td>Groove width</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Groove depth</td>
<td></td>
<td>0.5 – 2.5</td>
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<tr>
<td>Size (L × W × H)</td>
<td>mm</td>
<td>180 × 42 × 92</td>
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<tr>
<td>Weight</td>
<td>kg</td>
<td>0.290</td>
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Article number: 150.809  Gouging tool “GROOVY” 3.5 mm for elastic floor coverings

Accessories GROOVY

<table>
<thead>
<tr>
<th>Article number</th>
<th>Item</th>
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<tbody>
<tr>
<td>151.394</td>
<td>Protective plug</td>
</tr>
<tr>
<td>150.815 / 154.717</td>
<td>Blade Ø 3.5 mm / Blade Ø 2.5 mm</td>
</tr>
<tr>
<td>154.279 / 151.453</td>
<td>Replacement Guide wheel / Guide wheel pointed</td>
</tr>
</tbody>
</table>

Ideal for surfaces that are small and difficult of access

Executing clean grooves up to connecting walls

Precise and simple guidance thanks to integrated guide rollers
### General accessories

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
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</thead>
<tbody>
<tr>
<td>100.303</td>
<td>Tubular nozzle, Ø 5 mm, 15° angled, push-fit (TRIAC)</td>
</tr>
<tr>
<td>107.144</td>
<td>Tubular nozzle, Ø 5 mm, 15° angled, push-fit (HOTJET)</td>
</tr>
<tr>
<td>105.576</td>
<td>Tubular nozzle, Ø 5 mm, 90° angled, push-fit (TRIAC)</td>
</tr>
<tr>
<td>131.867</td>
<td>Tubular nozzle, Ø 5 mm, 90° angled, push-fit (HOTJET)</td>
</tr>
<tr>
<td>105.567</td>
<td>Tubular nozzle, Ø 5 mm, 150 mm, straight (HOTJET)</td>
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<tr>
<td>105.575</td>
<td>Tubular nozzle, Ø 5 mm, 100 mm, straight (TRIAC)</td>
</tr>
<tr>
<td>105.431</td>
<td>Speed weld nozzle, 3 mm, with small air-slide, push-fit on Ø 5 mm tubular nozzle</td>
</tr>
<tr>
<td>105.432</td>
<td>Speed weld nozzle, 4 mm, with small air-slide, push-fit on Ø 5 mm tubular nozzle</td>
</tr>
<tr>
<td>105.433</td>
<td>Speed weld nozzle, 5 mm, with small air-slide, push-fit on Ø 5 mm tubular nozzle</td>
</tr>
<tr>
<td>107.139</td>
<td>Speed weld nozzle, 4.5 x 12 mm for fillet weld, push-fit on Ø 5 mm tubular nozzle</td>
</tr>
<tr>
<td>107.137</td>
<td>Speed weld nozzle, 8 mm welding, push-fit on Ø 5 mm tubular nozzle</td>
</tr>
<tr>
<td>159.848</td>
<td>Speed weld nozzle, 5 mm, with small air-slide, curved, push-fit on Ø 5 mm tubular nozzle</td>
</tr>
<tr>
<td>160.550</td>
<td>Speed weld nozzle, 3 mm, with small air-slide, curved, push-fit on Ø 5 mm tubular nozzle</td>
</tr>
<tr>
<td>106.992</td>
<td>Speed welding nozzle, push-fit on Ø 5 mm tubular nozzle, 5.7 mm, profile A</td>
</tr>
<tr>
<td>106.993</td>
<td>Speed welding nozzle, push-fit on Ø 5 mm tubular nozzle, 7 mm, profile B</td>
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<tr>
<td>165.937</td>
<td>Smoothing nozzle, push-fit on Ø 5 mm tubular nozzle</td>
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<tr>
<td>107.270</td>
<td>Wide slot nozzle, 150 x 12 mm, push-fit (ELECTRON ST)</td>
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<tr>
<td>142.281</td>
<td>Scraper nozzle (ELECTRON ST)</td>
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<tr>
<td>148.933</td>
<td>Protective tube (ELECTRON ST)</td>
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<tr>
<td>151.068</td>
<td>Tool stand (ELECTRON ST) (recommended)</td>
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<tr>
<td>106.970</td>
<td>Pressure roller for welding rods Ø 4 – 5 mm</td>
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<tr>
<td>106.971</td>
<td>Pressure roller for welding rods Ø 2 – 4 mm</td>
</tr>
<tr>
<td>106.966</td>
<td>Hand grooving tool</td>
</tr>
<tr>
<td>106.968</td>
<td>Spare blades for hand grooving tool</td>
</tr>
<tr>
<td>150.809</td>
<td>Gouging tool “GROOVY” 3.5 mm for elastic floor coverings</td>
</tr>
<tr>
<td>150.815</td>
<td>Blade Ø 3.5 mm</td>
</tr>
<tr>
<td>154.717</td>
<td>Blade Ø 2.5 mm</td>
</tr>
<tr>
<td>157.544</td>
<td>Leister Universal scissors 260 mm with special shaft grinding</td>
</tr>
<tr>
<td>117.000</td>
<td>Trimming knife with 0.6 mm spacer for vinyl and linoleum with 5 spare blades included</td>
</tr>
<tr>
<td>117.005</td>
<td>5 spare blades</td>
</tr>
<tr>
<td>117.007</td>
<td>1 universal spacer 0.6 mm</td>
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<tr>
<td>106.969</td>
<td>Quarter Moon Knife including leather case, 100 mm stainless steel blade</td>
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<tr>
<td>122.541</td>
<td>Trimming guide, to use with spatula (106.969)</td>
</tr>
<tr>
<td>137.855</td>
<td>Leister cutter with four spare blades</td>
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<tr>
<td>138.902</td>
<td>Hooked blade for LEISTER-cutter (10 dispenser with 10 pcs = 100 pcs)</td>
</tr>
<tr>
<td>138.539</td>
<td>Straight-edge blade for LEISTER-cutter (10 dispenser with 10 pcs = 100 pcs)</td>
</tr>
<tr>
<td>116.798</td>
<td>Brass brush</td>
</tr>
<tr>
<td>142.647</td>
<td>Brass brush Ø 3 mm</td>
</tr>
<tr>
<td>160.353</td>
<td>Cable cord roller 25 m PUR 5 × 2.5 mm², with 1 × CEE 400 V and 2 × EU socket 230 V</td>
</tr>
<tr>
<td>161.152</td>
<td>Cable cord roller 25 m PUR 5 × 2.5 mm², with 1 × CEE 400 V and 2x T23 CH socket 230 V</td>
</tr>
<tr>
<td>161.207</td>
<td>Cable cord roller 25 m PUR 5 × 2.5 mm², with 1 × CEE 400 V and 2 × Typ E with ground pin socket 230 V</td>
</tr>
<tr>
<td>164.048</td>
<td>Cable cord roller 45 m, 4 × 230 V, EU socket</td>
</tr>
<tr>
<td>160.015</td>
<td>Cable extension cord 15 m PUR 5 × 2.5 mm², with CEE 400 V plug</td>
</tr>
<tr>
<td>159.239</td>
<td>Cable extension cord 15 m PUR 3 × 2.5 mm², with EU plug 230 V</td>
</tr>
</tbody>
</table>

More at the new accessories catalog at [www.leister.com/accessories](http://www.leister.com/accessories)
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