Operator's manual

# TruTool C 250 (1B1)

english

TRUMPF

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# 1. Safety

**USA/CAN**

- Read the Operator's Manual and the general safety rules (Material number 1239438, red document) in their entirety before starting up the machine. The directions contained therein must be followed without fail.

**Rest of the world**

- Read the Operator's Manual and safety instructions (Material number 125699, red document) in their entirety before starting up the machine. The directions contained therein must be followed without fail.
- The safety regulations according to DIN VDE, CEE, AFNOR and other regulations which are valid in individual countries must be adhered to.

**Danger**

**Lethal danger due to electric shock!**

- Always pull the plug out of the socket before undertaking any maintenance work on the machine.
- Always check the plug, the cable and the machine for damage before starting work.
- Keep the machine dry and do not operate in damp rooms.
- When using the electric tool outside, connect the residual current (FI) circuit breaker with a maximum release current of 30 mA.

**Warning**

**Danger of injury due to improper handling!**

- When working with the machine, wear safety glasses, hearing protection, protective gloves and work shoes.
- Do not plug in the plug unless the machine has been switched off. Pull out the mains plug after use.

**Warning**

**Risk of injury to the hands!**

- Do not place your hand inn the machining path.

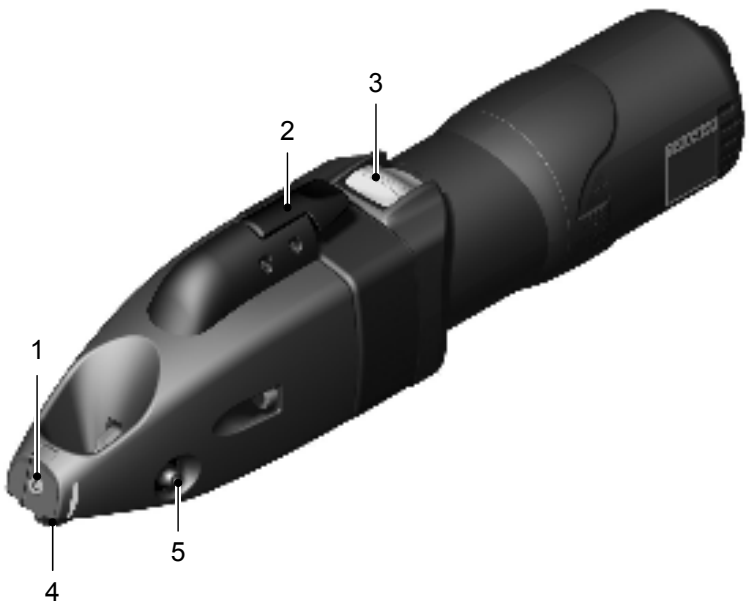
**Caution**

**Damage to property due to improper handling!**

**The machine will be damaged or destroyed.**

- Do not use the power cord to carry the machine.
- Always guide the electric cord away from the back of the machine and do not pull it across sharp edges.
- Arrange for repairs and checks on portable electric tools to be carried out by a trained specialist. Only the original accessories provided by TRUMPF may be used.

# 2. Description




| | | | | | |
|---|---|---|---|---|---|
| 1 | Cut-off plate | 3 | ON/OFF switch | 5 | Bolt |
| 2 | Chip clipper | 4 | Cutter | | |

Slitting shears TruTool C 250 Fig. 37729

## 2.1 Correct use

**Warning**

**Risk of injury!**

- Use machine only for the work and materials that are described under "Correct use".

The TRUMPF TruTool C 250 slitting shears is a portable electrical tool designed for the following applications:

- Slitting of plate-type workpieces made of steel, aluminum, plastic, etc.
- Slitting straight or curved outside edges and interior cutouts.
- Slitting along scribed lines.

The TRUMPF TruTool C 250 also offers the option of clipping off the chip that results when machining inside the workpiece as required.

## 2.2 Technical data

| | Rest of the world | | | USA |
|---|---|---|---|---|
| | **Values** | **Values** | **Values** | **Values** |
| **Voltage** | 230 V | 120 V | 110 V | 120 V |
| **Frequency** | 50/60 Hz | 50/60 Hz | 50 Hz | 50/60 Hz |
| **Working speed** | 3-10 m/min | 3-10 m/min | 3-10 m/min | 10-33 ft/min |
| **Power rating** | 500 W | 500 W | 500 W | 500 W |
| **No-load speed** | 4000/min | 4000/min | 4000/min | 4000/min |
| **Weight** | 2.0 kg | 2.0 kg | 2.0 kg | 4.44 lbs |
| **Start hole diameter** | 25 mm | 25 mm | 25 mm | 0.98 in |
| **Protective insulation** | Class II | Class II | Class II | Class II |

Technical data Tab. 1

| **Permitted material thicknesses** | | |
|---|---|---|
| **Steel up to 400 N/mm²** | **Steel up to 600 N/mm²** | **Aluminum 250 N/mm²** |
| 2.5 mm (0.098 in) | 1.5 mm (0.059 in) | 3.0 mm (0.118 in) |

Tab. 2

Depending on the sheet thickness or tensile strength of the material, different types of cutters are needed (see Tab. 4, Page 8)

| **Noise and vibration** | **Measured values in accordance with EN 60745** |
|---|---|
| A-weighted sound level | Typically 81 dB (A) |
| A-weighted acoustic power level | Typically 85 dB (A) |
| Hand-arm vibration | Typically 2.6 m/s² |

Measured values for noise and vibration Tab. 3

**Note**
The measured values specified above may be exceeded while working.

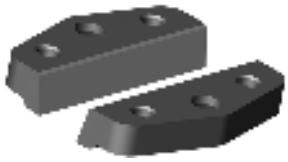
# 3. Tool assembly

## 3.1 Tool selection

**Note**
The cutters have 2 cutting edges that cannot be resharpened.

Different types of cutters are required according to the thickness or tensile strength of the workpiece. (see Tab. 4, Page 8)

**Note**
If the cutter is not selected as specified,
- the cut quality suffers greatly.
- the feed power increases significantly.
- the cutter will break.

| Tool type | Designation | Sheet thick. [mm] | Radius | Mat. No. |
|---|---|---|---|---|
|  | Straight cutter 1.5 – 2.5 mm | Aluminum max. 250N/mm² 1.5 to 3.0 Steel max. 400N/mm² 1.5 to 2.5 | 150 | 1273341 |
|  | Straight cutter - 1.5 mm | Aluminum max. 250N/mm² 0.5 to 2.0 Steel max. 400N/mm² 0.5 to 1.5 | 80 | 1258006 |
|  | Curved cutter -1.5 mm | Aluminum max. 250N/mm² 0.5 to 2.0 Steel max. 400N/mm² 0.5 to 1.5 | 45 left 80 right | 1260101 |
|  | CR cutter | Stainless steel max. 600N/mm² 0.5 to 1.5 | 120 | 1278387 |
|  | SC cutter (folded spiral seam) | Steel max. 400N/mm² 4x0.9 Stainless steel max. 600N/mm²[1] 4x0.6 | 150 | 1260102 |
|  | Cutter blades (1 set = 2 blades) | All materials | | 1275275 |
|  | Cut-off plate | All materials | | 1267770 |
|  | Screw | All materials | | 0350327 |

Cutter selection Tab. 4

[1] The chip should not be cut off on the fold as it reduces tool life.

# 4. Operation

**Caution**

**Damage to property possible if line voltage is too high!**

**Damage to the motor**

- Check the power supply. The line voltage must correspond to the specifications on the machine nameplate.

**Warning**

**Risk of injury due to improper handling!**

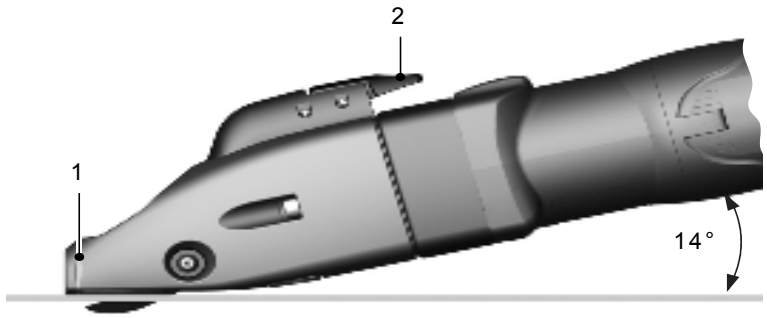
- When working with the machine, always ensure that it has a secure base.
- Never touch the tool while the machine is running.
- Always guide the machine away from your body while working.
- Do not work holding the machine above your head.

## 4.1 Working with the TruTool C 250

**Switching on:**

➢ Slide the ON/OFF switch forward.

**Note**
Do not engage the machine in the workpiece until full speed has been reached.




1 Marking for cut-off position 2 Chip clipper

Fig. 37735

➢ Guide the machine to the sheet surface at an angle of approx. 14°.

**Note**
Do not burden the machine to such an extent that it comes to a standstill.
Never operate the machine without a cutter.

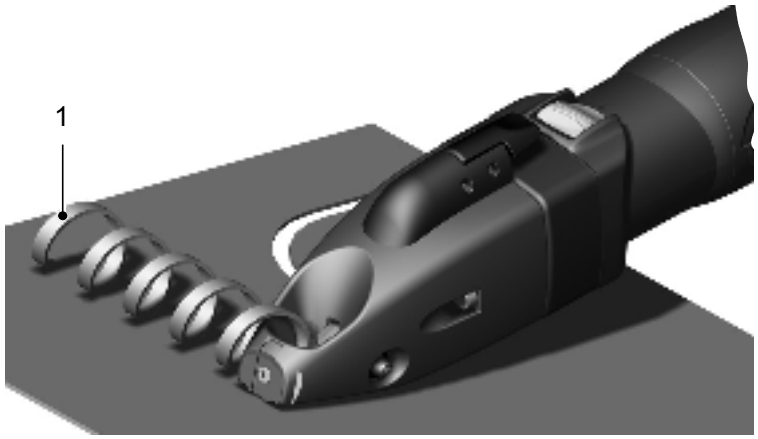
For safe operation and good cutting performance:

- Ensure that cutters are sharp.
- Turn cutter blades in due time.
- Replace cutter blades in due time.

The following specifications apply when cutting radii:

- Do not tilt the machine.
- Proceed at low speed.

## Working with the TruTool C 250




1 Chip

Fig. 37734

### Cutting the chips off

- Press the cut-off switch for about 0.5 seconds while the machine is running. The cut-off operation is terminated automatically.

**Note**
Do not cut off short chips. The minimum length of the chip must be one rotation.
Remove the chip manually.

**Note**
The cut-off position is indicated by marks at the front of the housing.

### Switching off

- Slide the On/Off switch to the rear.

# 5. Maintenance

**Warning**

**Risk of injury due to improper repairs!**

**The machine does not function properly.**

➢ Repairs may be carried out only by a trained specialist.

| Maintenance point | Procedure and time interval | Recommended lubricant | Lubricant Order number |
|---|---|---|---|
| Bolt | Lubricate when replacing cutter | "G1" lubrication grease | 0139440 |
| Cutter | Lubricate when replacing cutter | "G1" lubrication grease | 0139440 |
| Gearbox and gear head and chip clipper | After 300 operating hours, arrange for a trained specialist to lubricate or to replace the grease | "G1" lubrication grease | 0139440 |
| Cutter blades | Turn as needed | - | - |
| Cutter blades | Replace as needed | - | - |
| Cutter | Replace as needed | - | - |
| Cutting plate | Replace as needed | - | - |

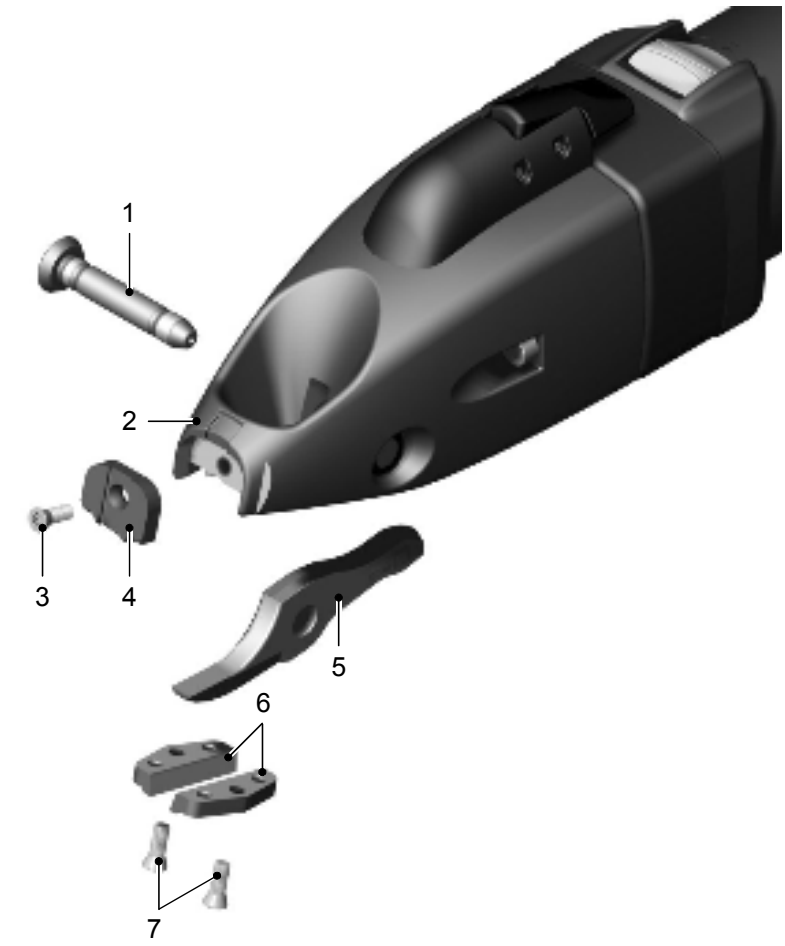
Maintenance table Tab. 5

## 5.1 Replacing the TruTool C 250 tool

**Danger**

**Lethal danger due to electric shock!**

- Always pull the plug out of the socket before changing tools and before performing any maintenance work on the machine.




| | | | |
|---|---|---|---|
| 1 | Bolt | 5 | Cutter |
| 2 | Cutting head | 6 | Cutter blade |
| 3 | Fastening screw | 7 | Fastening screws |
| 4 | Cut-off plate | | |

Changing the tool Fig. 37728

## Replacing the cutter

**Caution**

**Damage to property possible due to blunt tools!**

**Machine overload.**

- Check the cutting edge of the cutter hourly for wear. Sharp cutters provide good cutting performance and are easier on the machine. Replace cutters promptly.

Replace the cutter if the cutting edges are blunt.

1. Press out the bolt that was locked into place (1st position).
2. Pull the cutter out of the cutting head.
3. Lightly grease the new cutter and the bolt.
4. Insert the new cutter.
5. Push the bolt into the bore hole until it locks into place.

## Turning or replacing the cutter blades

1. Unscrew the fastening screws.
2. Check the cutter blades:
   - If a cutting edge is blunt, turn the cutter blades 180° (change the left cutter blade to the right side and the right cutter blade to the left side).

   **or**

   - If both cutting edges of a cutter blade are blunt, replace cutter blades.
3. Tighten the fastening screw.

## 5.2 Replacing the cut-off plate

1. Loosen the fastening screws.
2. Replace the cut-off plate.
3. Tighten the fastening screws.

## 5.3 Replacing carbon brushes

The motor will stop if the carbon brushes are worn out.

- Have the carbon brushes checked and replaced as needed by a trained technician.

**Note**
Use only original replacement parts and note the information on the rating plate.

# 6. Original accessories and wearing parts

| Designation | Original accessories supplied | Wearing parts | Options | Material number |
|---|---|---|---|---|
| Cutter blades (2 pieces) | + | + | | 1275275 |
| Straight cutter 1.5-2.5 mm | + | + | | 1273341 |
| Straight cutter 0.5-1.5 mm | | + | | 1258006 |
| Curved cutter | | + | | 1260101 |
| CR cutter<br>(for working high-tensile sheets) | | + | | 1278387 |
| SC cutter (folded spiral seam) | | + | | 1260102 |
| Cut-off plate | + | + | | 1267770 |
| Operator's manual | + | | | 1266061 |
| Safety information (red document), all countries except USA | + | | | 0125699 |
| Safety information (red document), USA | + | | | 1239438 |
| Torx screwdriver TX 20x 60 | + | | | 0359907 |

Original accessories, wearing parts and options Tab. 6

**Ordering wearing parts**

To ensure fast and correct delivery of original and wearing parts:

1. State the order number.
2. Enter further ordering information:
   - Voltage data
   - Quantity
   - Machine model.
3. Specify complete shipping information:
   - Correct address.
   - Required delivery method (e.g. airmail, courier, express mail, ordinary freight, parcel post).
4. Send the order to the TRUMPF representative's office. For TRUMPF service addresses, see the address list at the end of the document.