# Operator's manual

# TruTool C 250 (2B5)

## Shears

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# Table of contents

# 1. Safety

## 1.1 General safety information

**WARNING**

**Read all warnings and instructions.**

- Failure to follow the warnings and instructions may result in electric shock, fire, and/or serious injuries.
- Keep all warnings and instructions for future reference.

**DANGER**

**Risk of fatal injury due to electric shock!**

- Check recharger and rechargeable battery for damage before each use.
- Do not insert damaged battery casing into the recharger.
- Do not touch electric contacts of the recharger and battery.
- Store recharger and battery in dry places and do not operate them in damp rooms.
- Clean recharger regularly.
- Maintenance may be carried out by trained specialist technicians only.
- Use original accessories of TRUMPF only.

**WARNING**

**Risk of injury from rechargeable battery!**

- Remove the rechargeable battery from the machine before all maintenance work.
- Only operate the machine with the listed rechargeable batteries, see table at end of document with consumables and accessories.
- Only charge the machine using the listed rechargers, see table at end of document with consumables and accessories.
- Do not open rechargeable batteries or rechargers.
- Do not throw rechargeable batteries into fire or domestic waste.
- Protect rechargeable batteries against heat, for example, constant exposure to sunlight or fire.

**CAUTION**

**Respiratory irritation due to vapors leaking from damaged rechargeable batteries!**

- Make sure there is a supply of fresh air.
- If symptoms develop, consult a doctor.

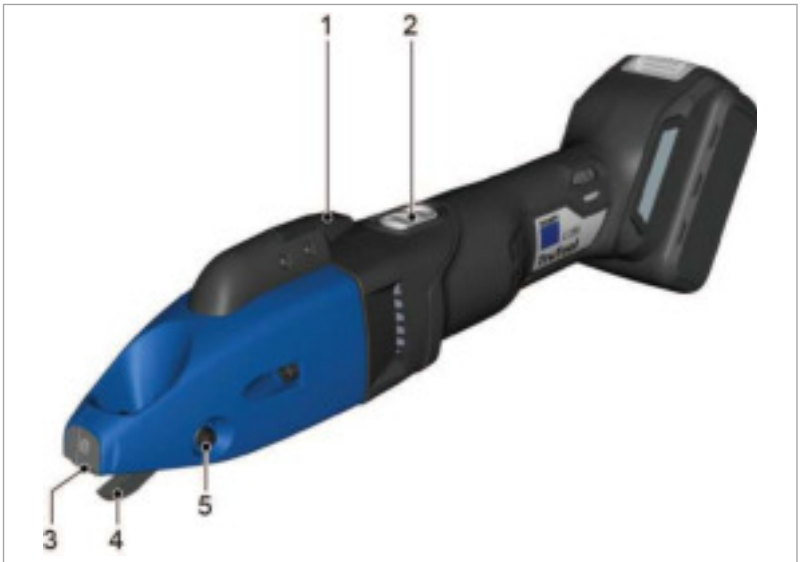
## 1.2 Specific information for slitting shears

**⚠ WARNING**

**Risk of injury to hands.**

➢ Do not reach into the processing line with your hands.

# 2. Description




| | | | |
|---|---|---|---|
| 1 | Chip clipper | 4 | Cutter |
| 2 | On/Off switch | 5 | Bearing pin |
| 3 | Cutter plate | | |

Slitting shears TruTool C 250 Fig. 94701

## 2.1 Intended use

**⚠ WARNING**

**Damage to the machine due to improper handling.**

➢ Only use the machine for work and materials as described under "Intended use."

The TRUMPF Slitting Shears TruTool C 250 (2B5) is a manually operated battery-powered tool for the following applications:

- Slitting plate-shaped workpieces made of steel, aluminum, plastic, etc.
- Slitting straight or curved exterior and interior cutouts.
- Slitting from scribed lines.

The TRUMPF slitting shears TruTool C 250 (2B5) also offers the option of cutting off the chips which come about when processing within the workpiece any way you like.

## 2.2 Technical data

| | Other countries | USA |
|---|---|---|
| **Voltage** | 18 V | 18 V |
| **Working Speed** | 3-10 m/min | 10-32 ft/min |
| **Idle stroke rate** | 2400/min | |
| **Weight without rechargeable battery** | 2 kg | 4.4 lbs |

Technical data TruTool C 250 Tab. 1

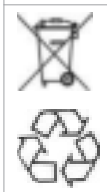
| **Acceptable material thickness** | | | | | |
|---|---|---|---|---|---|
| | **Straight cutter 1.5 - 2.5 mm** | **Straight cutter 1.0 - 1.5 mm** | **Curve cutter 0.5 - 1.5 mm** | **Blade CR 0.5 - 1.5 mm** | **SC cutter** |
| **Steel up to 400 N/mm²** | 2.5 mm (0.098 in) | 1.5 mm (0.059 in) | 1.5 mm (0.059 in) | - | - |
| **Steel up to 600 N/mm²** | - | 1.0 mm (0.032 in) | 0.8 mm (0.031 in) | 1.5 mm (0.059 in) | - |
| **Aluminum up to 250 N/mm²** | 3 mm (0.118 in) | 2 mm (0.079 in) | 2 mm (0.079 in) | - | - |
| **Spiral duct steel up to 400 N/mm²** | - | - | - | - | 4 x 0.9 mm (4 x 0.035 in) |
| **Spiral duct steel up to 600 N/mm²** | - | - | - | - | 4 x 0.6 mm (4 x 0.024 in) |
| **Starting hold diameter** | 22 mm (0.9 in) | 17 mm (0.7 in) | 15 mm (0.6 in) | 20 mm (0.8 in) | 18 mm (0.7 in) |
| **Smallest radius for curved cutouts** | 150 mm (5.9 in) | 80 mm (3.15 in) | L 45 mm (2 in) R 80 mm (3.15 in) | 120 mm (4.7 in) | 150 mm (5.9 in) |

Tab. 2

## 2.3 Icons

**Note**

The following symbols are important for reading and understanding the operator's manual. The correct interpretation of the symbols will help you operate the machine better and safer.

| Icon | Name | Description |
|---|---|---|
|  | Read operator's manual | Read the operator's manual and safety information in their entirety before starting up the machine. Closely follow the instructions given. |
|  | Disposal | Batteries may not be disposed of in domestic waste! They contain harmful substances which are damaging to health and the environment. All dealers of TRUMPF machines in the EU and the USA accept empty batteries without charge. |

| Icon | Name | Description |
|---|---|---|
| Ni<br>Cd | | The characters under the symbols stand for:<br>Battery contains nickel<br>Battery contains cadmium |
|  | Information symbol | Do not throw batteries into fire. |
|  | Information symbol | Do not charge a damaged battery, but replace it immediately. |
|  | Direct current | Type or property of current |
| V | Volt | Voltage |
| Ah | Ampere hours | Electrical load |
| Wh | Watt hours | Electrical work |
| mm | Millimeters | Dimensions e.g.: material thickness, chamfer length |
| in | Inch | Dimensions e.g.: material thickness, chamfer length |
| $n_o$ | Idle speed | Revolution speed without load |

Tab. 3

## 2.4 Noise and vibration information

**⚠ WARNING**

**Noise emission value may be exceeded.**

- ➢ Wear hearing protection.

**⚠ WARNING**

**The vibration emission value can be exceeded!**

- ➢ Select the right tools and exchange them in time in the event of wear.
- ➢ Have maintenance carried out by trained specialized technicians.
- ➢ Define additional safety measures for protecting the operator from the effect of vibrations (e. g. keep hands warm, organization of working procedures, machining at normal feed force).
- ➢ Depending on the operating conditions and state of the electric tool, the actual load might be higher or lower than the specified measured value.

**Notes**

- The specified vibration emission value was measured in accordance with a standardized testing procedure and can be used to compare one electric tool with another.

- The specified vibration emission value can also be applied for a provisional estimate of the vibration load.
- Times during which either the machine is switched off or running but not actually in use can considerably reduce the vibration load during the entire working period.
- Times during which the machine works independently and self-propelled do not have to be calculated.

| Designation of measured value | Unit | Value according to EN 60745 |
|---|---|---|
| Vibration emission value $a_h$ (vector sum of three directions) | $m/s^2$ | 7.2 |
| Uncertainty K for vibration emission value | $m/s^2$ | 1.5 |
| A-class acoustic pressure level $L_{PA}$ typically | dB (A) | 80 |
| A-class acoustic power level $L_{WA}$ typically | dB (A) | 91 |
| Uncertainty K for noise emission value | dB | 3 |

Tab. 4

# 3. Setting work

## 3.1 Select tool

**Note**

The cutters have two blades. These cannot be regrinded.

➢ Depending on the thickness or strength of the material, different types of cutters are needed.

**Tip**

Select the blades according to the table for the permissible material thicknesses, as otherwise the cut quality is impaired and the feed force can increase until the blade breaks.

## 3.2 Setting the speed

➢ Use the setting wheel to set the revolution speed depending on the application.

# 4. Operation

## 4.1 Switching on/off TruTool C 250

**Switching on the machine**

1. Push the On/Off switch forwards until it engages.


1 Marking for separating position
2 Chip clipper

Fig. 73701

2. Bring machine to the sheet surface at an angle of approx. 14°.

**Switching off the machine**

3. Press the rear part of the On/Off switch.

## 4.2 Working with TruTool C 250

For conservative work and good cutting performance:

- Look out for sharp cutters.
- Turn cutting blades in a timely manner.
- Change cutting blades in a timely manner.

The following requirements must be met when cutting radii:

- Do not tilt the machine.
- Work only with low feed.

## 4.3 Separating chips

**⚠ CAUTION**

**Property damage resulting from broken off chip brake!**

**Do not continue to work with the machine.**

➢ Replace chip clipper.


1 Chip

Fig. 73699

**Notes**

- Do not cut off short chips. The minimum chip length must be one turn.

  Remove chip manually.

- At the front housing part there are markings that indicate the cutting-off position.

1. Press the chip clipper for about 0.5 s with the machine running. The cutting-off process is terminated automatically.
2. Slide the On/Off switch to the rear.

# 5. Maintenance

**⚠ WARNING**

**Risk of injury from rechargeable battery!**

➢ Remove the rechargeable battery before changing the tool or undertaking any maintenance work on the machine.

**⚠ WARNING**

**Risk of injury due to incorrect repair work**

**Machine does not work properly.**

➢ Maintenance may be carried out by trained specialist technicians only.

**⚠ CAUTION**

**Damage to property caused by blunt tools!**

**Machine overload.**

➢ Check the cutting edge of the tool hourly for wear. A sharp tool provides good cutting performance and is easier on the machine.

➢ Change blades in a timely manner.

| Maintenance point | Procedure and interval | Recommended lubricants | Lubricant Order No. |
|---|---|---|---|
| Cutter | Lubricate when replacing the blade | Lubricating grease "G5" | 0139440 |
| Cutter | Change as needed | - | - |
| Bearing pin | Lubricate when replacing the blade | Lubricating grease "G5" | 0139440 |
| Cutting blades | Turn if necessary | - | - |
| Cutting blades | Change as needed | - | - |
| Gearbox, gear head, and cutter | Every 300 operating hours, have a trained specialist relubricate or replace the lubricating grease. | Lubricating grease "G5" | 19542020139440 |
| Cutter plate | Change as needed | - | - |

Maintenance positions and maintenance intervals Tab. 5

## 5.1 Changing tool TruTool C 250

**Replacing cutter**

The cutter is to be replaced when both cutting edges of a cutting blade are blunt.


| | | | |
|---|---|---|---|
| 1 | Bearing pin | 5 | Cutter |
| 2 | Cutting head | 6 | Cutting blade |
| 3 | Fixing screw | 7 | Befestigungsschrauben |
| 4 | Cutter plate | | |

Replacing the tool Fig. 73700

1. Push out snapped in bearing pin.
2. Remove cutter from the cutting head.
3. Lightly lubricate the new cutter and the bearing pin.
4. Insert the new cutter.
5. Insert the bearing pin through the bore hole until it snaps in.

**Turn/Replace cutting blades**

6. Unscrew the fastening screws.
7. Check cutting blades:
   - ➢ If a cutting edge is blunt: Turn cutting blades 180°.

   **or**

   - ➢ Replace both cutting blades if both sides of the cutting edges of a cutting blade are blunt.
8. Tighten the fixing screws.

## 5.2 Replacing cutter plate

1. Loosen the fixing screw.
2. Replace the cutter plate.
3. Tighten the fixing screw.

## 5.3 Checking loading status

| Color of the lamp | Loading status |
|---|---|
| Green | Full |
| Orange | Half-full |
| Red | Load soon. |

Tab. 6

➢ Switch on the machine.

The lamp which shows the loading status illuminates for 5 seconds.

## 5.4 Changing rechargeable battery

**Condition**

- Machine is switched off.

**Taking out exchangeable battery**

Changing rechargeable battery Fig. 73106

1. Trigger locking mechanism and pull out exchangeable battery in arrow direction.

**Inserting exchangeable battery**

2. Insert rechargeable battery into the mounting device from above until the battery snaps into place.

# 6. Accessories and consumables

| Consumables | Quantity | Order number | Scope of delivery |
|---|---|---|---|
| Straight cutter 1.5 - 2.5 mm | 1 piece | - | x |
| | 2-pack | 1279105 | - |
| | 5-pack | 1279106 | - |
| Straight cutter 0.5 - 1.5 mm | 2-pack | 1279107 | - |
| | 5-pack | 1279108 | - |
| Curve cutter 1.5 mm | 2-pack | 1279145 | - |
| | 5-pack | 1279146 | - |
| Blade CR | 2-pack | 1279142 | - |
| | 5-pack | 1279143 | - |
| SC cutter | 2-pack | 1279109 | - |
| | 5-pack | 1279110 | - |
| Cutting blades | 2 pieces | 1275275 | x |
| Cutter plate | 1 piece | 1267770 | x |

TruTool C 250 Tab. 7

| Accessories | Quantity | Order number | Scope of delivery |
|---|---|---|---|
| TRUMPF Box S1 | 1 piece | 1763681 | x |
| Cover, TRUMPF Box lining | 1 piece | 1889485 | x |
| Seal cap | 4 piece | 1890095 | x |
| TRUMPF Box S102 lining | 1 piece | 1771093 | x |
| Screwdriver Torx PB 410 | 1 piece | 1775531 | x |
| Safety information EW | 1 piece | 0125699 | x |
| Operator's manual, TruTool C 250 | 1 piece | 2082097 | x |
| Selection card, cutter | 1 piece | 1295699 | x |
| Lubricating grease "G5" (900 g) | 1 piece | 1954202 | - |

TruTool C 250 Tab. 8

| Consumables rechargeable battery | Order number | Scope of delivery |
|---|---|---|
| TRUMPF 10.8 V 2.0 Ah | 2272664 | x[1] |
| TRUMPF 10.8 V 4.0 Ah | 2272665 | - |
| Recharger 100 - 240 V, 50/60 Hz (D) | 2272666 | X[1] |
| Recharger 100 - 240 V, 50/60 Hz (GB) | 2275871 | X[1] |
| Recharger 100 - 240 V, 50/60 Hz (USA) | 2275872 | X[1] |

Tab. 9

1 Depending on the type of machine ordered

## 6.1 Ordering consumables

**Note**

The following data must be specified in order to ensure that parts are delivered correctly and without delay.

1. Specify the order number.
2. Enter further order data:
   - Voltage data
   - Quantity
   - Machine type
3. Specify the complete shipping information:
   - Correct address.
   - Desired delivery type (e.g. air mail, courier, express mail, ordinary freight, parcel post).

   **Note**

   For TRUMPF service addresses, see www.trumpf-powertools.com.
4. Send the order to the TRUMPF representative office.

# 7. Appendix: Declaration of conformity, guarantee, replacement parts lists