

Operator's manual



TruTool C 250 (1B1)

english

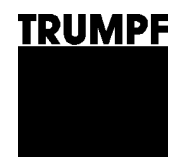


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Warranty

Spare parts list

Addresses

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 in the machining path.
-



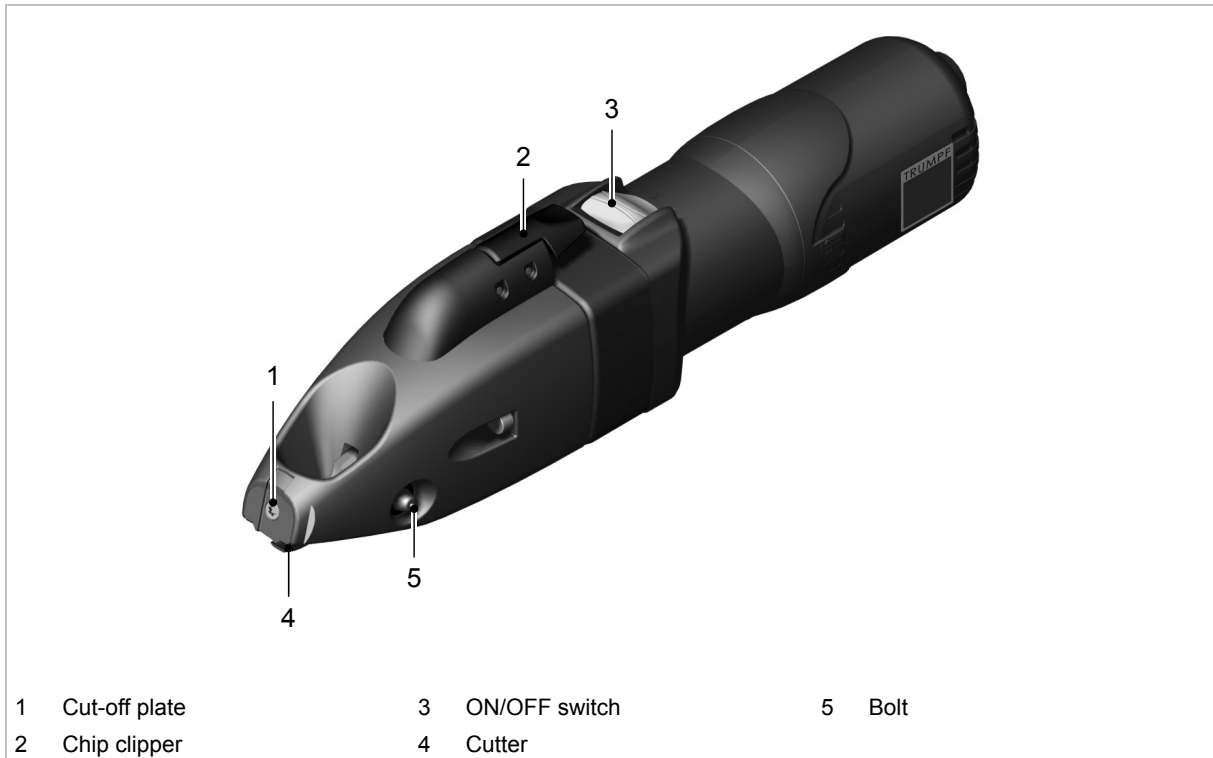
Caution

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



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/mm ²	Steel up to 600 N/mm ²	Aluminum 250 N/mm ²
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/s ²

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/mm ² 1.5 to 3.0 Steel max. 400N/mm ² 1.5 to 2.5	150	1273341
	Straight cutter - 1.5 mm	Aluminum max. 250N/mm ² 0.5 to 2.0 Steel max. 400N/mm ² 0.5 to 1.5	80	1258006
	Curved cutter - 1.5 mm	Aluminum max. 250N/mm ² 0.5 to 2.0 Steel max. 400N/mm ² 0.5 to 1.5	45 left 80 right	1260101
	CR cutter	Stainless steel max. 600N/mm ² 0.5 to 1.5	120	1278387
	SC cutter (folded spiral seam)	Steel max. 400N/mm ² 4x0.9 Stainless steel max. 600N/mm ² 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.

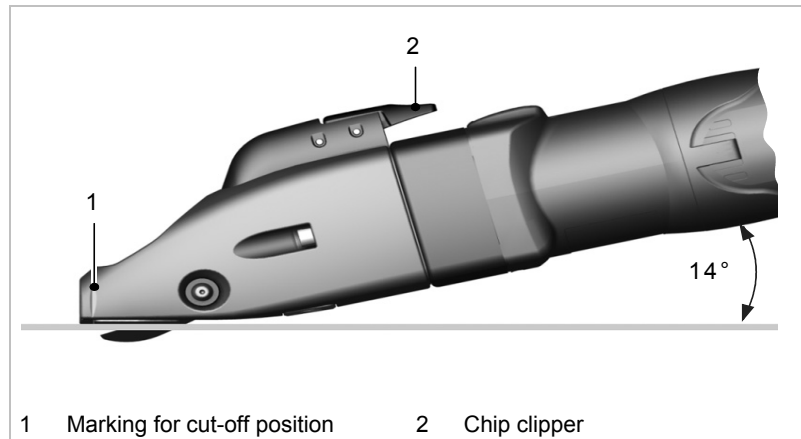


Fig. 37735

➤ 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

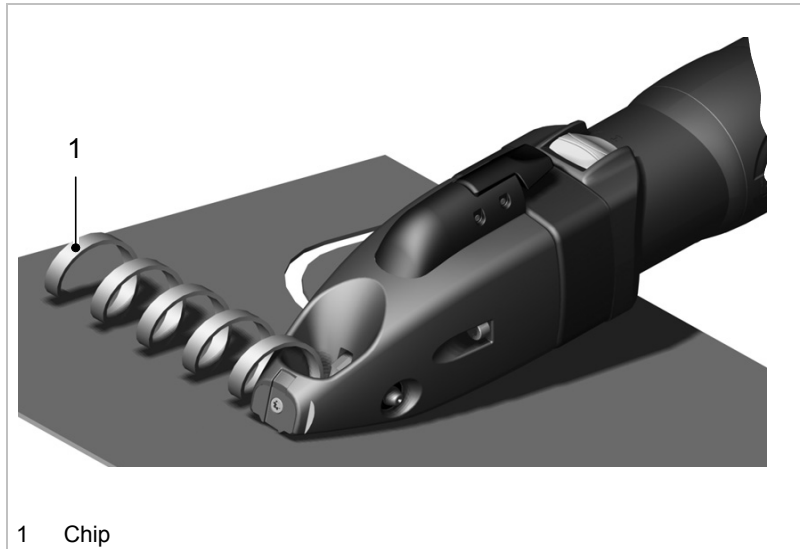


Fig. 37734

- 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

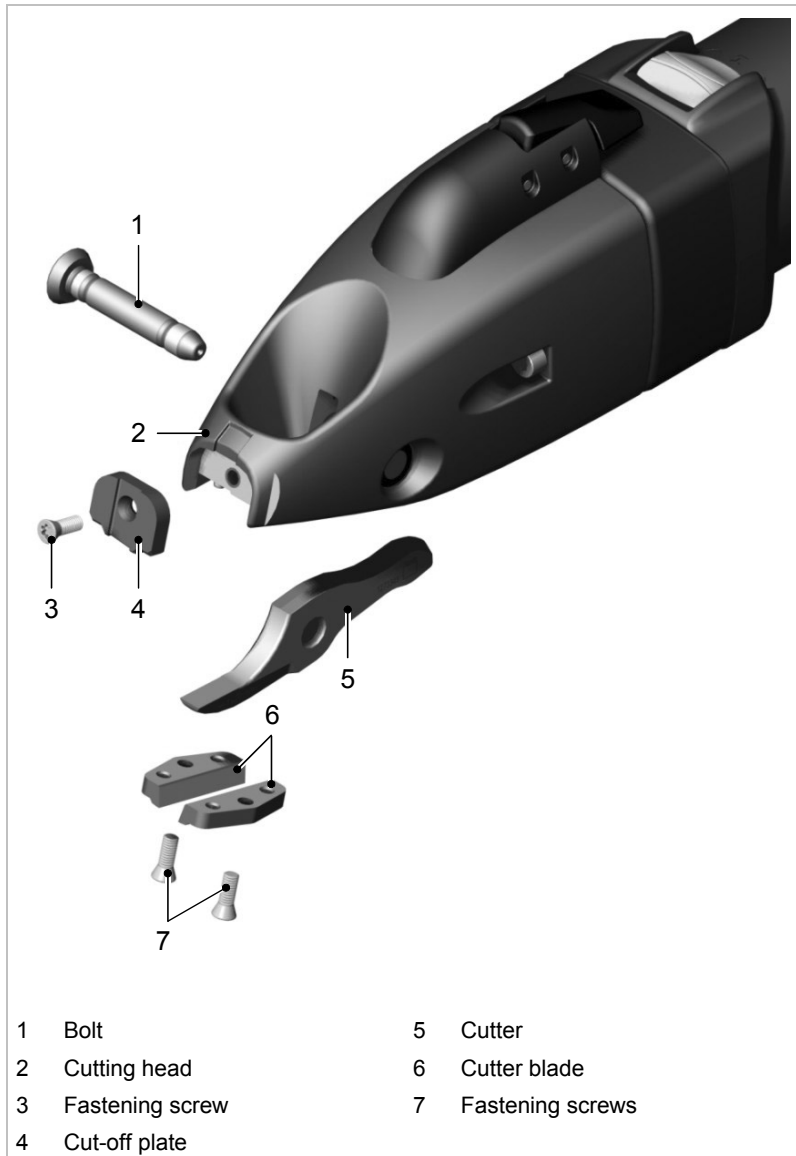
5.1 Replacing the TruTool C 250 tool



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.



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 (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.