

Operator's manual



TruTool C 250 (2B1)

TRUMPF Werkzeugmaschinen GmbH + Co. KG, Technische Redaktion
Johann-Maus-Straße 2, D-71254 Ditzingen
Fon: +49 7156 303 - 0, Fax: +49 7156 303 - 930540
Internet: <http://www.trumpf.com>
E-Mail: docu.tw@de.trumpf.com

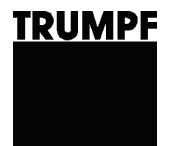


Table of contents

| | | |
|----------|--|-----------|
| 1 | Safety | 2 |
| 1.1 | General safety information | 2 |
| 1.2 | Specific information for slitting shears | 2 |
| 2 | Description | 3 |
| 2.1 | Intended use | 3 |
| 2.2 | Technical data | 4 |
| 2.3 | Icons | 4 |
| 2.4 | Noise and vibration information | 5 |
| 3 | Setting work | 7 |
| 3.1 | Select tool | 7 |
| 4 | Operation | 8 |
| 4.1 | Switching on/off TruTool C 250 (2B1) | 8 |
| 4.2 | Working with TruTool C 250 (2B1) | 8 |
| 4.3 | Separating chips | 9 |
| 5 | Maintenance | 10 |
| 5.1 | Changing tool TruTool C 250 (2B1) | 10 |
| 5.2 | Replacing cutter plate | 11 |
| 5.3 | Changing the power cable | 12 |
| 5.4 | Replacing carbon brushes | 12 |
| 6 | Accessories and consumables | 13 |
| 6.1 | Ordering consumables | 13 |
| 7 | Appendix: Declaration of conformity, guarantee, replacement parts lists | 15 |

1. Safety

1.1 General safety information

 **DANGER**

Electrical voltage! Risk of fatal injury due to electric shock!

- Remove the plug from the plug socket before undertaking any maintenance work on the machine.
 - Check the plug, cable and machine for damage each time before using the machine.
 - Keep the machine dry and do not operate it in damp rooms.
 - Connect the fault current (FI) circuit breaker with a maximum breaking current of 30 mA when using the electric tool outside.
 - Only use original TRUMPF accessories.
-

 **WARNING**

Damage to the machine due to improper handling.

- Wear safety glasses, hearing protection, breathing protection, protective gloves and working shoes when working.
 - Connect the plug only when the machine is switched off. Pull the power plug after use.
 - Do not carry the machine by the cable.
 - Have maintenance carried out by specialists.
-

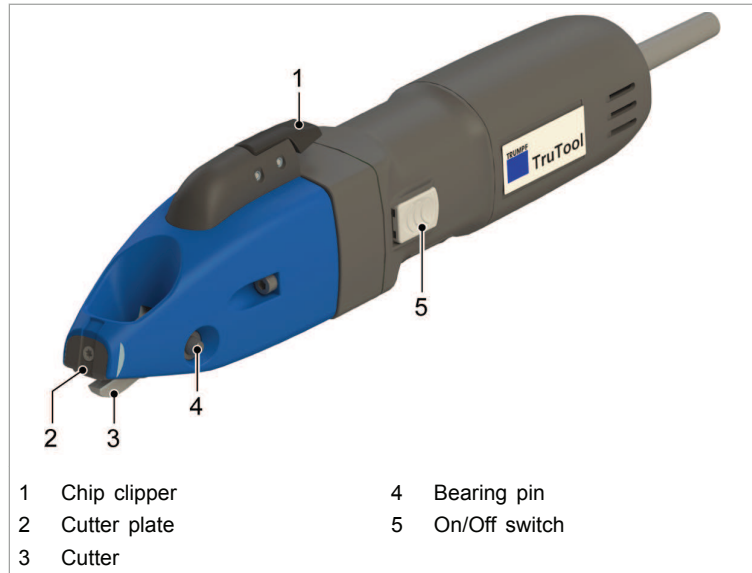
1.2 Specific information for slitting shears

 **WARNING**

Risk of injury to hands.

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

2. Description



Slitting shears TruTool C 250 (2B1)

Fig. 73698

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 (2B1) is a manually operated power 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 (2B1) 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

| TruTool C 250 (2B1) | Other countries | | | USA |
|----------------------------------|--|----------|-------|--------------|
| | 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 | | | 10-32 ft/min |
| Nominal power consumption | 550 W | 500 W | 500 W | 500 W |
| Idle stroke rate | 4000/min | | | |
| Weight | 2.1 kg | | | 4.63 lbs |
| Protective insulation | II /  | | | |

Technical data TruTool C 250 (2B1)

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. |
|  | Safety class II | Indicates a doubly insulated tool. |
|  | Alternating current | Type or property of current |
| V | Volt | Voltage |
| A | Ampere | Current, current input |
| Hz | Hertz | Frequency (oscillations per second) |
| W | Watt | Power, power input |
| mm | Millimeters | Dimensions e.g.: material thickness, chamfer length |
| in | Inch | Dimensions e.g.: material thickness, chamfer length |
| n_0 | Idle speed | Revolution speed without load |
| .../min | Revolutions/strokes per minute | Revolution speed, stroke rate per minute |

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 | 17.5 |
| Uncertainty K for vibration emission value | m/s ² | 7.3 |
| 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.

If the cutter selection is not done according to the table (see "Tab. 2", pg. 4):

The cut quality will be impaired considerably.

The feed force will increase considerably.

The cutter breaks.

4. Operation

CAUTION

Damage to property due to excessively high line voltage!

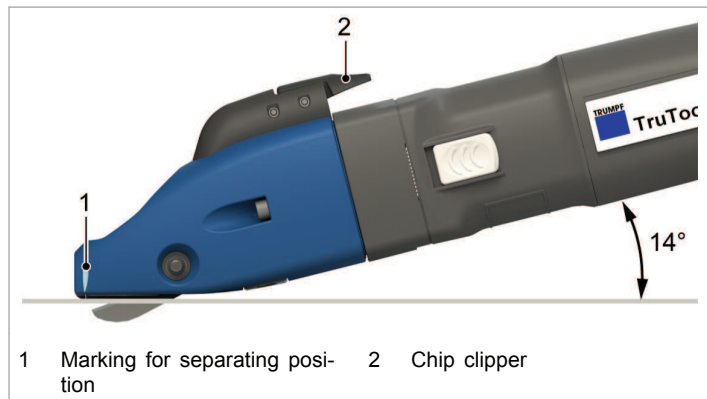
Motor damage.

- Check the power supply voltage. The power supply voltage must correspond to the information on the nameplate of the machine.

4.1 Switching on/off TruTool C 250 (2B1)

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 (2B1)

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:

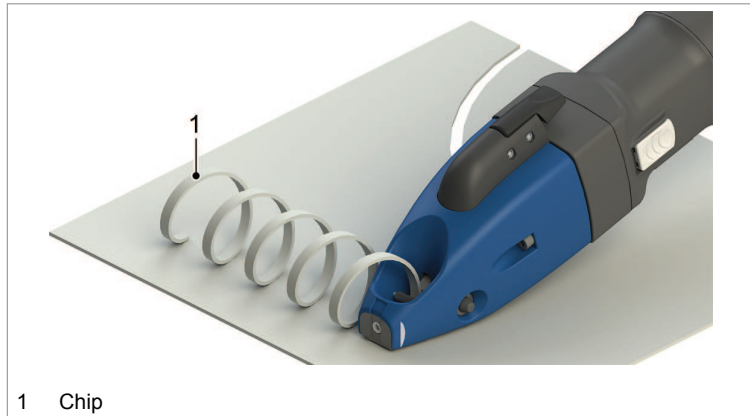
- Do not tilt the machine.
- Work only with low feed.

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

⚠ DANGER

Risk of fatal injury due to electric shock!

- Remove the plug from the plug socket 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 punch hourly for wear. A sharp punch provides good cutting performance and is easier on the machine.
- Change the punch in a timely manner.

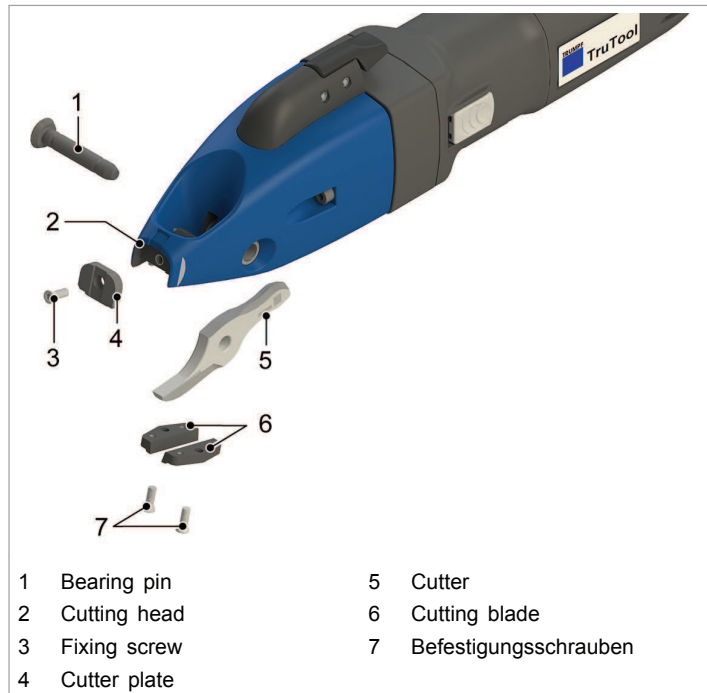
| Maintenance point | Procedure and interval | Recommended lubricants | Lubricant Order No. |
|--------------------------------|---|-------------------------|---------------------|
| Cutter | Lubricate when replacing the blade | Lubricating grease "G1" | 0139440 |
| Cutter | Change as needed | - | - |
| Bearing pin | Lubricate when replacing the blade | Lubricating grease "G1" | 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 "G1" | 0139440 |
| Cutter plate | Change as needed | - | - |

Maintenance positions and maintenance intervals

Tab. 5

5.1 Changing tool TruTool C 250 (2B1)

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



Replacing the tool

Fig. 73700

Turn/Replace cutting blades

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.
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 Changing the power cable

If the power cable is to be replaced, it should be procured from the manufacturer or an authorized dealer to avoid safety hazards.

Note

For TRUMPF service addresses, see www.trumpf-power-tools.com.

5.4 Replacing carbon brushes

The motor comes to a standstill whenever the carbon brushes are worn out.

Notes

- Use only original spare parts from TRUMPF.
 - Observe the information on the rating plate.
- Have the carbon brushes checked and replaced as required by a qualified technician.

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 (2B1)

Tab. 6

| 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, Tru-Tool C 250 (2B1) | 1 piece | 1942455 | X |
| Selection card, cutter | 1 piece | 1295699 | X |
| Lubricating grease "G1" (25 g) | 1 piece | 0344969 | - |

TruTool C 250 (2B1)

Tab. 7

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

