

Operator's manual



TruTool F 125 (2A1)

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Table of contents

1	Safety	2
1.1	General safety information	2
1.2	Specific safety information for shears	2
2	Description	4
2.1	Intended use	4
2.2	Technical data	5
2.3	Icons	5
2.4	Noise and vibration information	6
3	Setting work	8
3.1	Setting the hammer - standing seam	8
3.2	Setting the hammer - angled standing seam	9
4	Operation	11
4.1	Working with TruTool F 125 (2A1)	11
	Switching on	11
	Process	11
	Switching off	11
4.2	Overload protective device on the motor	12
5	Maintenance	13
5.1	Replacing the plastic buffer	13
5.2	Replacing carbon brushes	13
5.3	Changing the power cable	14
6	Accessories and consumables	15
6.1	Ordering consumables	15
7	Appendix: Declaration of conformity, guarantee, replacement parts lists	16

1. Safety

1.1 General safety information

WARNING

Read all safety warnings and all instructions.

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

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 safety information for shears

DANGER

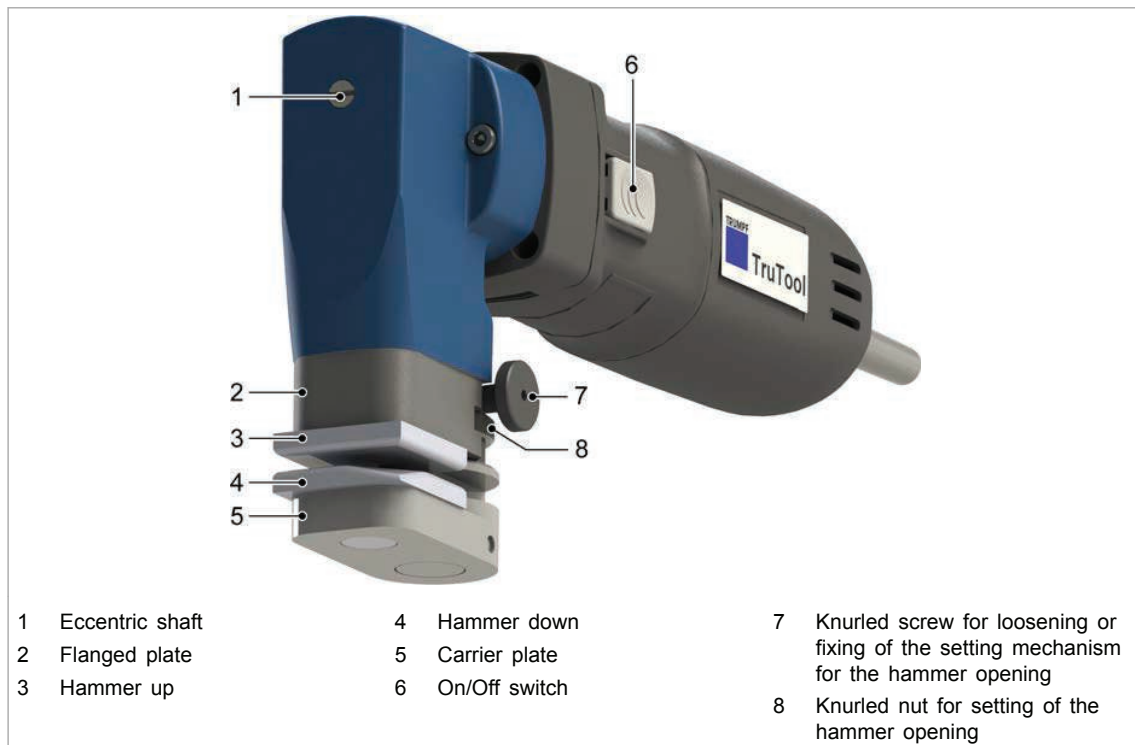
Electrical voltage! Risk of fatal injury due to electric shock!

- Always keep the power cable behind the device and do not pull it over sharp edges.
- Do not perform any work that may cause the machine to come into contact with hidden power lines or its own cable. Contact with a live conductor can cause metallic machine parts to become live and can lead to an electric shock.

 **WARNING****Risk of injury to hands.**

- Do not reach into the processing line with your hands.
- Use both hands to hold the machine.

2. Description



TruTool F 125 (2A1)

Fig. 73134

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 seam locker TruTool 125 (2A1) is an electrically powered hand-held device designed for the following applications:

- The closing (locking) of hidden standing and angle seams on correspondingly pre-machined workpieces such as ventilation channels, housings, containers etc.
- Closing of foldings at straight or bend contours as well as in corners and angles.
- Pressing metal borders together for workpieces made of rubber, textile or plastic.

2.2 Technical data

	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	5 - 6 m/min			16 - 20 ft/min
Nominal power consumption	550 W	500 W		
Idle stroke rate	2100/min			
Weight	2.8 kg			6.17 lbs
Safety class	II / 			

Tab. 1




Acceptable material thickness	
	Hammer (up / down)
Steel up to 400 N/mm²	1.25 mm 0.049 in
Max. lock seam thickness	5 mm 0.2 in
Max. lock seam elevation	40 mm 1.6 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	Meaning
	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

Icon	Name	Meaning
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	3.8
Uncertainty K for vibration emission value	m/s^2	1.4
A-class acoustic pressure level L_{pA} typically	dB (A)	80

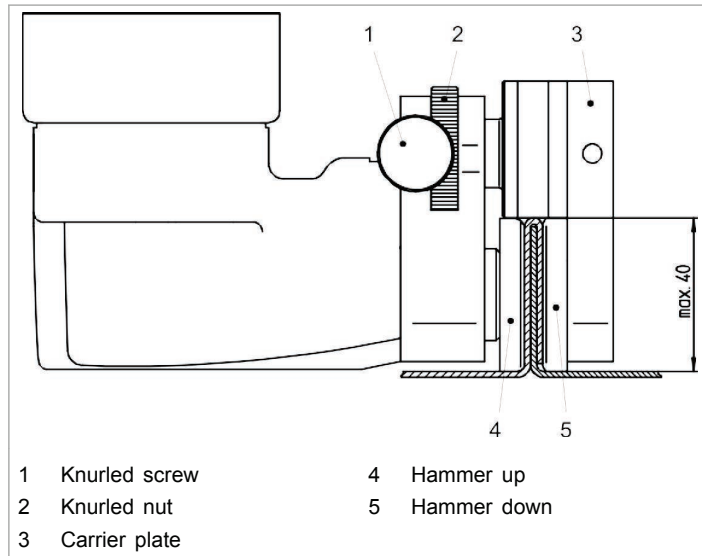


Designation of measured value	Unit	Value according to EN 60745
A-class acoustic power level L_{WA} typically	dB (A)	91
Uncertainty K for noise emission value	dB	3

Tab. 4

3. Setting work

3.1 Setting the hammer - standing seam

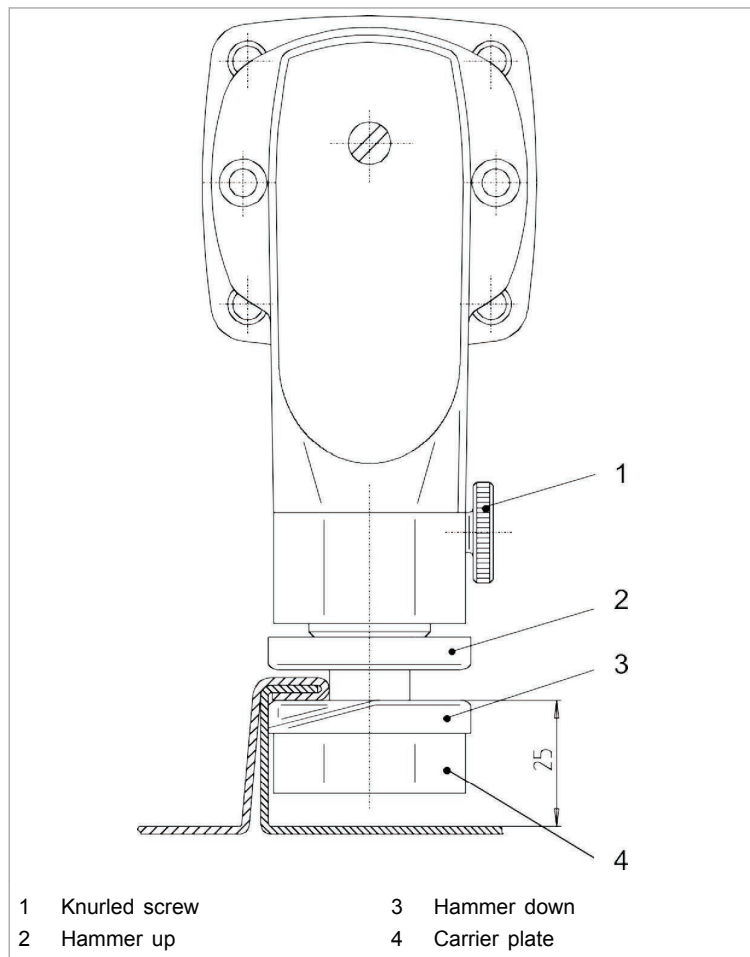


Standing seam

Fig. 11400

1. Loosen the small knurled screw (1).
2. Set the hammer opening with the large knurled nut (2) to the desired folding thickness while the motor is running.
3. Lock the small knurled screw (1) into place.
4. Close the seam.

3.2 Setting the hammer - angled standing seam



Angled standing seam

Fig. 11401

Depending on the thickness of the sheet or fold, the clearance between the upper and lower hammers must be set.

Note

Slight differences in the fold thicknesses are compensated for by a plastic buffer.

1. Loosen the small knurled screw (1).
2. Set the maximum hammer opening with the large knurled nut (2, Fig. 11400).
3. Lock the small knurled screw (1) into place.
4. Pre-fold the fold.
5. Loosen the small knurled screw (1) again.

-
6. Set the hammer opening with the large knurled nut (2, Fig. 11400) to the desired folding thickness while the motor is running.
 7. Lock the small knurled screw (1) into place.
 8. Close the seam.

4. Operation

**CAUTION**

Damage to property due to excessively high line voltage

Motor damage

- Check the line voltage. The power supply voltage must correspond to the information on the nameplate of the machine.
 - When using an extension cord that is longer than 5 m, the cord must have a line diameter of at least 2.5 mm².
-

**WARNING**

Damage to the machine due to improper handling.

- Make sure the machine is always in a stable position when operating it.
 - Never touch the tool while the machine is running.
 - Always operate the machine away from your body.
 - Do not operate the machine above your head.
-

4.1 Working with TruTool F 125 (2A1)

Switching on

- Slide the On/Off switch forwards.

Process

1. Once the full speed has been reached: move the machine with the flattened edge first toward the workpiece.
2. Guide the machine along the fold.
3. Take the machine away from the workpiece at the end of the fold.

Switching off

- Slide the On/Off switch to the rear.

4.2 Overload protective device on the motor

Note

1. Allow the machine to run in idle until it has cooled down.
2. Operate the machine normally after it has cooled down.

5. Maintenance

 **WARNING**

Risk of injury due to incorrect repair work

Machine does not work properly.

- Maintenance may be carried out by trained specialist technicians only.
 - Only use original TRUMPF accessories.
-

Is the fold no longer being correctly closed?

A worn plastic buffer is the cause. A new buffer must be installed.

5.1 Replacing the plastic buffer

The plastic buffer is used for damping of the hammer. This can become worn over time (see "Fig. 11400", pg. 8).

1. Loosen the small knurled screw (1).
2. Loosen knurled nut (2).
3. Remove lower hammer.
4. Pull off the upper hammer.
5. Remove the plastic buffer with a screwdriver.
6. Press in the new plastic buffer.
7. Put on the upper hammer.
8. Insert the lower hammer.
9. Close the close (2).
10. Tighten the knurled screw (1).

5.2 Replacing carbon brushes

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

Note

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

- Change the carbon brushes.

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.

6. Accessories and consumables

Consumables	Quantity	Order number	Scope of delivery
Hammer up	1 piece	0102964	X
Hammer down	1 piece	0105448	X
Plastic buffer	1 piece	0105449	X

TruTool F 125 (2A1)

Tab. 5

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
Safety information EW	1 piece	0125699	X
Operator's manual, Tru-Tool F 125 (2A1)	1 piece	1942457	X

TruTool F 125 (2A1)

Tab. 6

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**