

# Operator's manual



## TruTool C 200 (1A5)

Scissors

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# 1. Safety

## 1.1 General safety information

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 **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

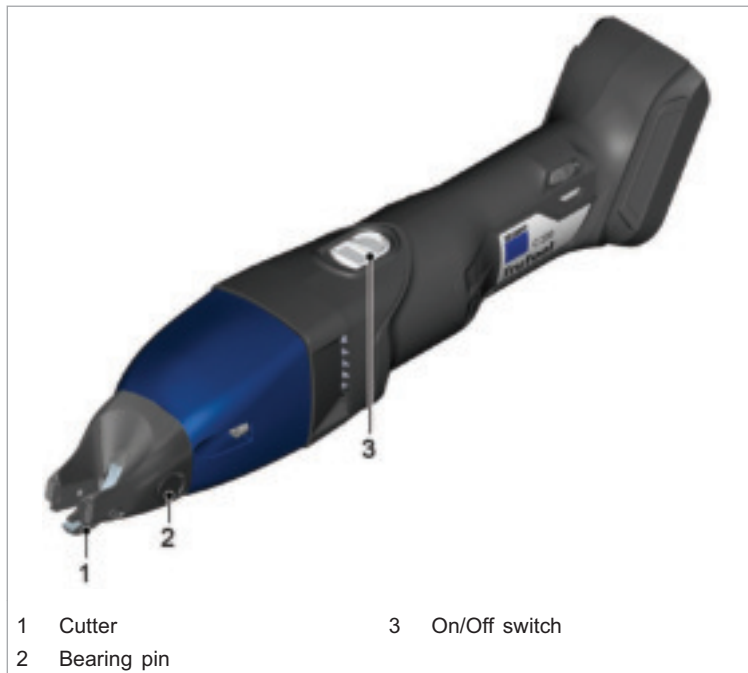
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 **WARNING**

**Risk of injury to hands.**

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

## 2. Description



Slitting shears TruTool C 200

Fig. 89222

### 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 200 (1A5) 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.

### 2.2 Technical data

	Other countries	USA
Voltage	18 V	18 V
Idle stroke rate	2400/min	

	Other countries	USA
Weight without rechargeable battery	1.9 kg	4.2 lbs

Technical data TruTool C 200

Tab. 1

Acceptable material thickness						
Set	Spiro 4 x 0.9 mm	HighQuality 1.5 - 2 mm	HighSpeed 1.5 - 2 mm	HighQuality 0.5 - 1.5 mm	CR 0.5 - 1.5 mm	Curves 0.5 - 1.5 mm
Steel up to 400 N/mm <sup>2</sup>	-	1.5 mm (0.059 in) - 2.0 mm (0.079 in)	1.5 mm (0.059 in) - 2.0 mm (0.079 in)	0.5 mm (0.02 in) - 1.5 mm (0.059 in)	-	1.5 mm (0.059 in)
Steel up to 600 N/mm <sup>2</sup>	-	-	-	1.0 mm (0.032 in)	1.5 mm (0.059 in)	0.8 mm (0.031 in)
Aluminum up to 250 N/mm <sup>2</sup>	-	3 mm (0.12 in)	3 mm (0.12 in)	2 mm (0.079 in)	-	2 mm (0.079 in)
Spiral duct, steel	4 x 0.9 mm  (4 x 0.035 in)	-	-	-	-	-
Starting hold diam- eter	8 mm (0.31 in) <sup>1</sup>	20 mm (0.8 in)	20 mm (0.8 in)	16 mm (0.63 in)	18 mm (0.7 in)	16 mm (0.63 in)
Smallest radius for curved cutouts	150 mm (5.9 in)	150 mm (5.9 in)	150 mm (5.9 in)	100 mm (3.94 in)	120 mm (4.7 in)	L 40 mm (1.57 in)  R 80 mm (3.15 in)
Working Speed	3-10 m/min  10-32 ft/min	3-10 m/min  10-32 ft/min	3-15 m/min  10-49 ft/min	3-10 m/min  10-32 ft/min	3-10 m/min  10-32 ft/min	3-10 m/min  10-32 ft/min


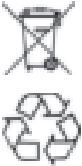



Tab. 2

## 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.

1 value for Spiro 4 x 0.6 mm, Ø 60; on flat sheet the value is 16 mm

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.
Ni Cd		The characters under the symbols stand for: Battery contains nickel 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 <sub>o</sub>	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)	$m/s^2$	13.2
Uncertainty K for vibration emission value	$m/s^2$	1.5
A-class acoustic pressure level $L_{pA}$ typically	dB (A)	81
A-class acoustic power level $L_{WA}$ typically	dB (A)	92
Uncertainty K for noise emission value	dB	3

Tab. 4

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## 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 tools are needed.

Depending on the application, corrugated or smooth cutting blades are used.

#### 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 200

- Switching on the machine**
1. Push the On/Off switch forwards until it engages.



Fig. 89223

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

Do not increase the feed force by pressing firmly on the machine.

- Switching off the machine**
3. Press the rear part of the On/Off switch.

### 4.2 Working with TruTool C 200

For conservative work and good cutting performance:

- Look out for sharp cutters.
- Turn smooth cutting blades in a timely manner.
- Change smooth and/or corrugated 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.

## 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.

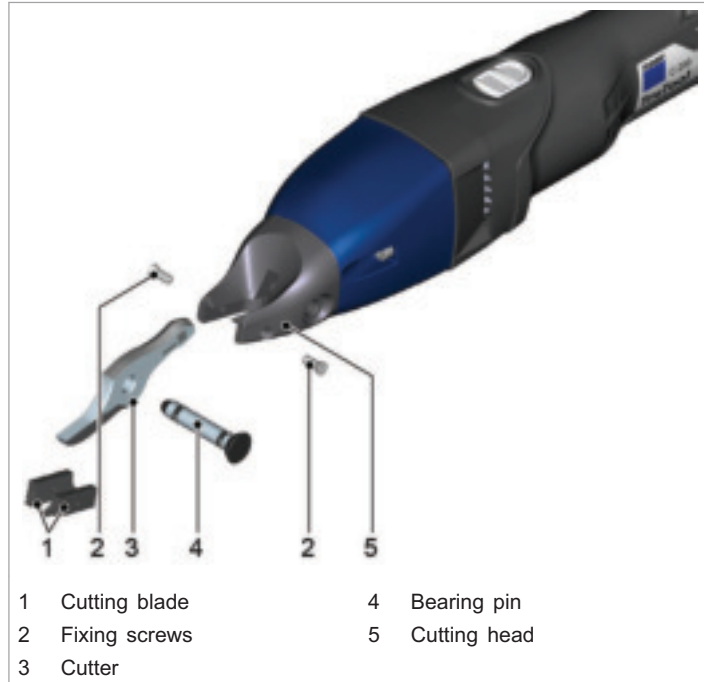
Maintenance point	Procedure and interval	Recommended lubricants	Lubricant Order No.
Cutter	Lubricate when replacing the blade	Lubricating grease "G5"	0139440
Cutter	Change as needed	-	-
Bearing pin	Lubricate when replacing the blade	Lubricating grease "G5"	0139440
Smooth cutting blades	Turn if necessary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

Maintenance positions and maintenance intervals

Tab. 5

### 5.1 Changing tool TruTool C 200

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



Replacing the tool

Fig. 89224

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:
  - Smooth cutting blades: If a cutting edge is blunt, turn cutting blades 180°.

**or**

  - Smooth and corrugated cutting blades: Replace both cutting blades if both sides of the cutting edges of a cutting blade are blunt.
8. Tighten the fixing screws.

## 5.2 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.

### 5.3 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
Spiro set	1-pack	2328882	x <sup>2</sup>
Thick sheet set	1-pack	2328883	x <sup>2</sup>
Thick sheet set, automatic feed	1-pack	2328884	x <sup>2</sup>
Thin sheet set	1-pack	2328885	x <sup>2</sup>
Chromium steel set	1-pack	2328886	x <sup>2</sup>
Curves set	1-pack	2328887	x <sup>2</sup>
Corrugated cutting blades	1-pack	2332027	x <sup>3</sup>
Smooth cutting blades	1-pack	2332028	-
Cutting blades Cr	1-pack	2361121	-
Straight cutter > 1.5 mm	2-pack	2365673	-
	5-pack	2365674	-
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	1 piece	-	x <sup>3</sup>
	2-pack	1279109	-
	5-pack	1279110	-

TruTool C 200

Tab. 7

Accessories	Quantity	Order number	Scope of delivery
TRUMPF Box S1	1 piece	1763681	x
Cover, TRUMPF Box lining	1 piece	2357136	x
Seal cap	4 piece	1890095	x
TRUMPF Box S102 C 200 lining	1 piece	2328396	x
Screwdriver Torx PB 410	1 piece	1775531	x
Safety information EW	1 piece	0125699	x
Operator's manual, TruTool C 200	1 piece	2337112	x
Selection card, cutter C 200	1 piece	2328391	x
Lubricating grease "G5" (900 g)	1 piece	1954202	-

TruTool C 200

Tab. 8

- 2 Depending on the set bought  
 3 SC machine



Consumables rechargeable battery	Order number	Scope of delivery
TRUMPF 10.8 V 2.0 Ah	2272664	x <sup>4</sup>
TRUMPF 10.8 V 4.0 Ah	2272665	-
Recharger 100 - 240 V, 50/60 Hz (D)	2272666	x <sup>4</sup>
Recharger 100 - 240 V, 50/60 Hz (GB)	2275871	x <sup>4</sup>
Recharger 100 - 240 V, 50/60 Hz (USA)	2275872	x <sup>4</sup>

Tab. 9

## 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](http://www.trumpf-powertools.com).

4. Send the order to the TRUMPF representative office.

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4 Depending on the type of machine ordered



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

