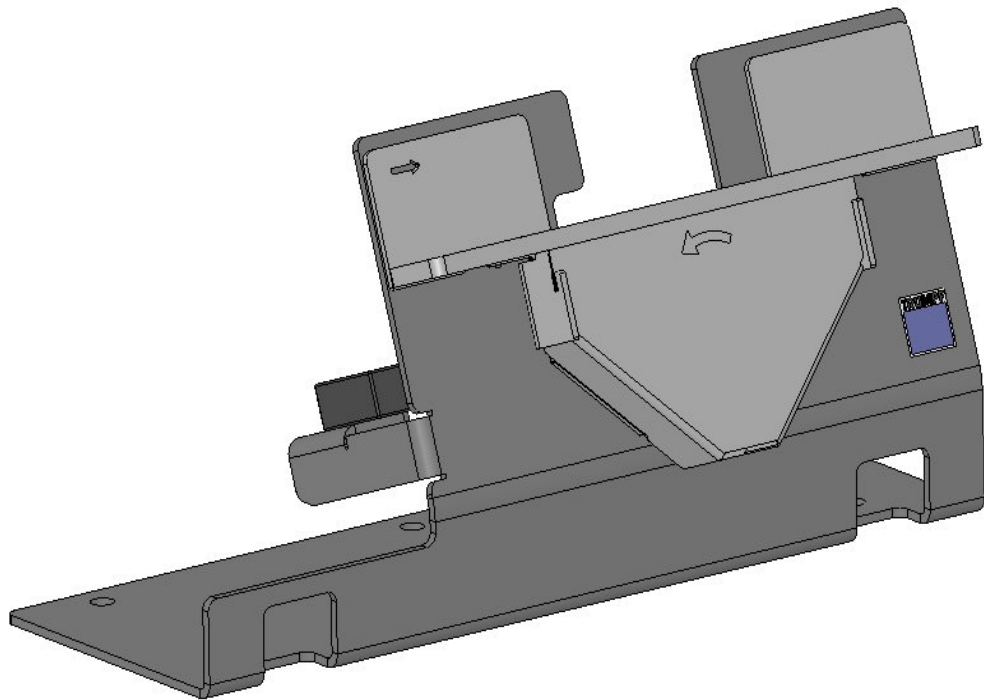


# Operating manual



## **STAND TruTool TKA 500 (1A1)**

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English

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## 1. Safety

- Read the operating manual for the machine as well as that of the station, in addition to the safety information (Order number 0125699), in their entirety and follow precisely the instructions contained therein before starting up the machine.
- Comply with the safety regulations in accordance with DIN VDE, CEE, AFNOR as well as any other regulations that apply in the individual countries.



**Danger**

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### **Risk of fatal injury from electric shock!**

- Pull the plug out of the socket prior to setting and maintenance work on the machine.
- 



**Warning**

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### **Risk of injury if the workstation tips over!**

- Securely fasten the workstation on the base plate or pedestal (Order no. 0003677).
- 



**Warning**

---

### **Danger of injury due to improper handling**

- Wear safety glasses, hearing protection, protective gloves and work shoes when working at the machine.
- 



**Warning**

---

### **Risk of injury through crushing of the hand!**

- Hold workpiece with both hands.
  - Do not reach in between tool parts with your hands.
- 



**Warning**

---

### **Risk of injury from sharp blades!**

- Pull the plug out of the socket prior to setting and maintenance work on the machine.
- 



**Warning**

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### **Risk of injury due to backkick!**

- Firmly press the workpiece onto the workstation.
- 



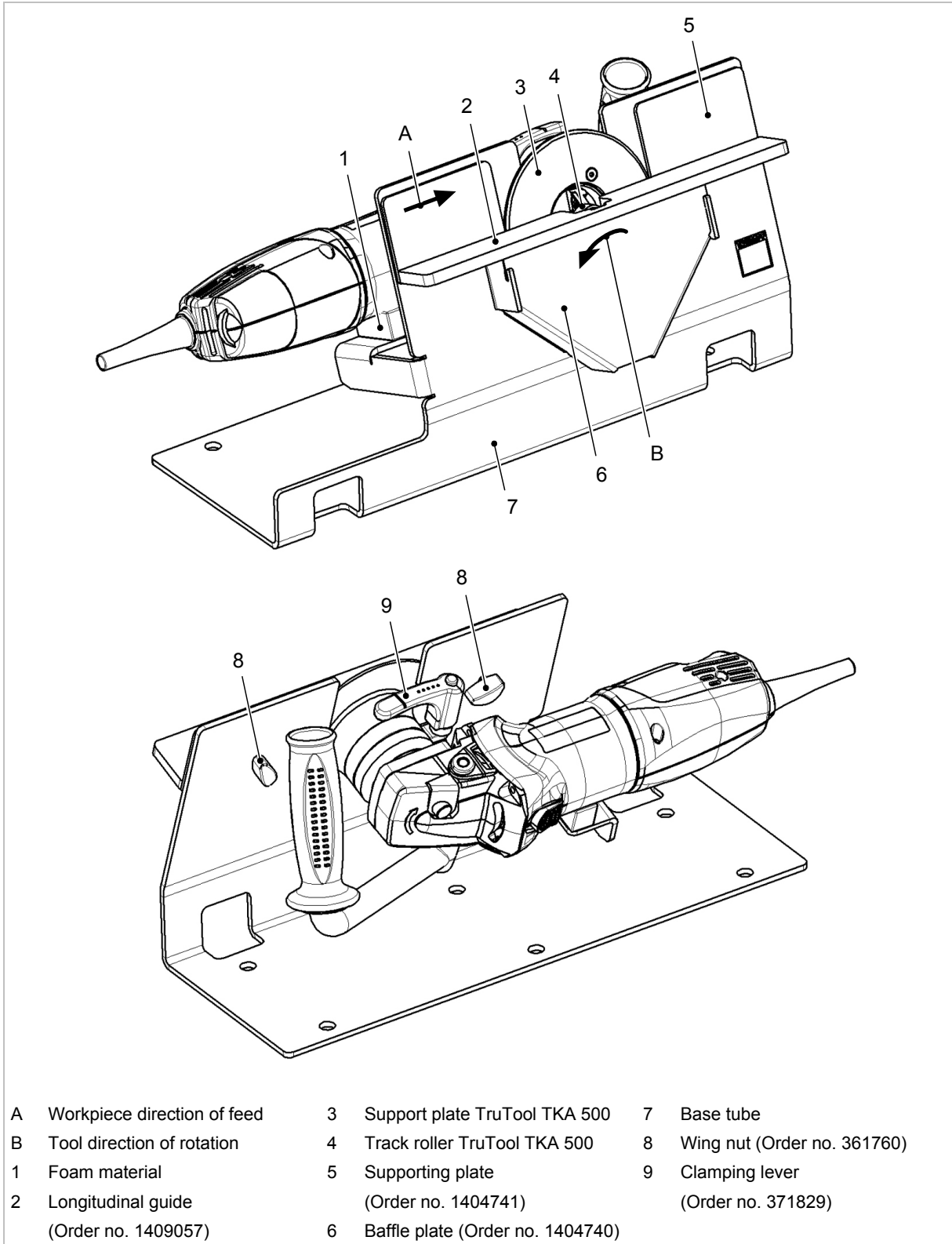
**Warning**

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### **Risk of injury due to forward throw!**

- Feed the workpiece through the machine only in the direction of processing.
-

## 2. Description



Replacement parts list

Fig. 48499

## 2.1 Intended use

The workstation is used for the stationary operation of the TRUMPF TruTool TKA 500 chamfering and deburring machine.

Guide small workpieces to the machine.

- Min. part size: 50 x 50 mm.
- Max. part size: 300 x 300 mm.
- Max. workpiece weight: 3 kg.
- Min. sheet thickness: 1 mm.

The use of the TruTool TKA 500 machine is described in the operating manual.

## 2.2 Technical data

	Value
<b>Weight (without machine)</b>	Approx. 5.3 kg
<b>Working height</b>	approx. 160 mm
<b>Total height with machine</b>	approx. 210 mm

Technical data

Table 1

Material tensile strength [N/mm <sup>2</sup> ]	Max. chamfer length; radius [mm]
up to 250	5; R4 PLUS
up to 400	3; R3
up to 600	2; R2
up to 800	1

Chamfer lengths

Tab. 2

### 3. Setting work

#### 3.1 Installing the workstation



**Danger**

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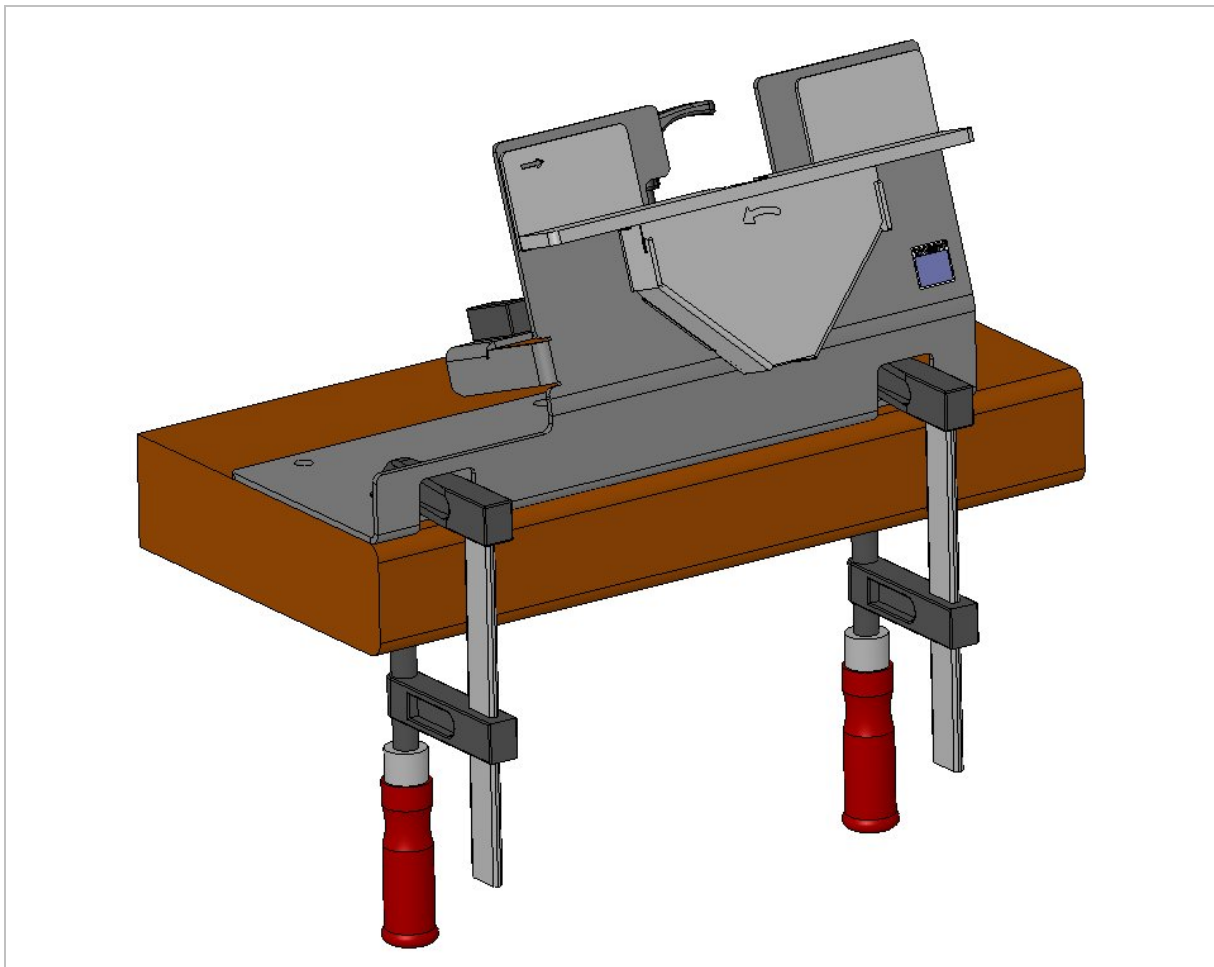
**Risk of fatal injury from electric shock!**

- Install the machine after assembly of the workstation.
  - Pull the plug from plug socket before cleaning the guides.
- 

**Note**

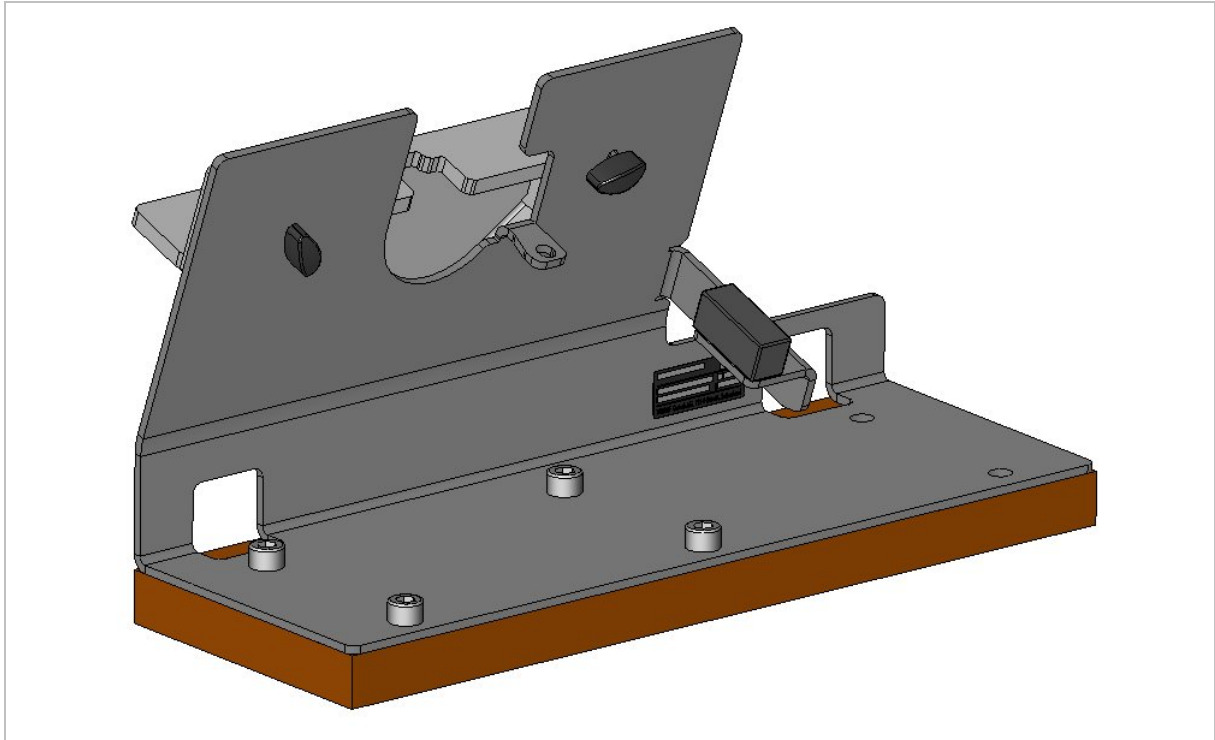
Install the workstation only in a horizontal position.

- Fix the workstation on to the table or pedestal (Order no. 0003677) with 4 screws or clamping screws.



Assembly with clamping screws

Fig. 48500



Assembly with screws

Fig. 48634

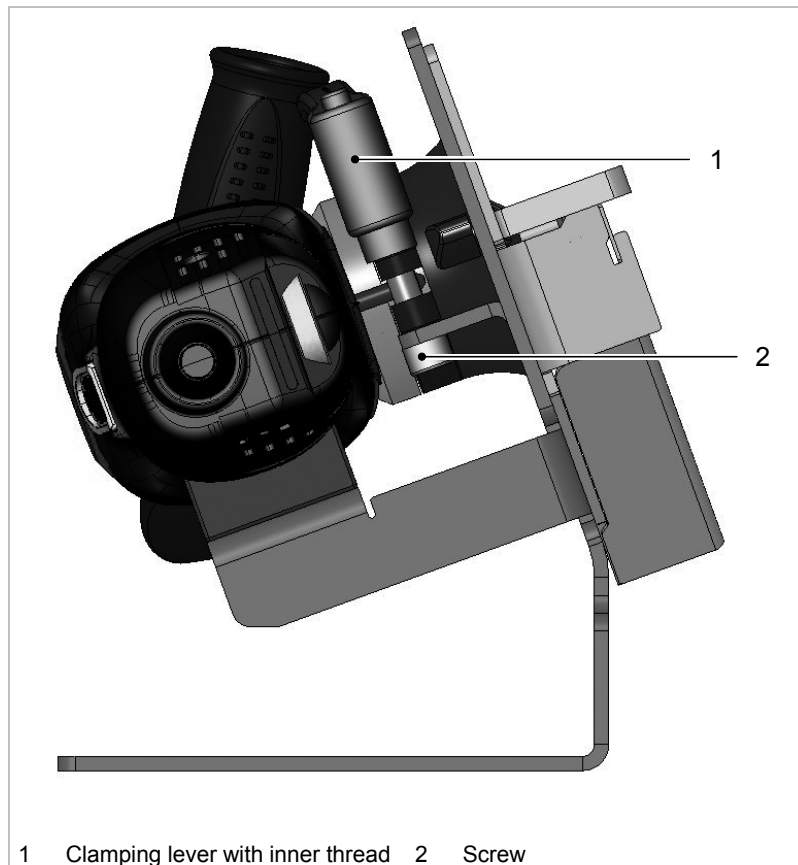
## 3.2 Mounting and aligning the machine in the workstation



Warning

### Risk of possible injury from sharp blades!

- Pull the plug out of the socket prior to setting work on the machine.



1 Clamping lever with inner thread 2 Screw

Installing the machine

Fig. 48502

### Installing the machine in the work station

1. Undo the clamping lever and remove.
2. Push the machine into the workstation.
3. Tighten the screw from below.
4. Screw in the clamping levers from above.



## Adjusting the longitudinal guides

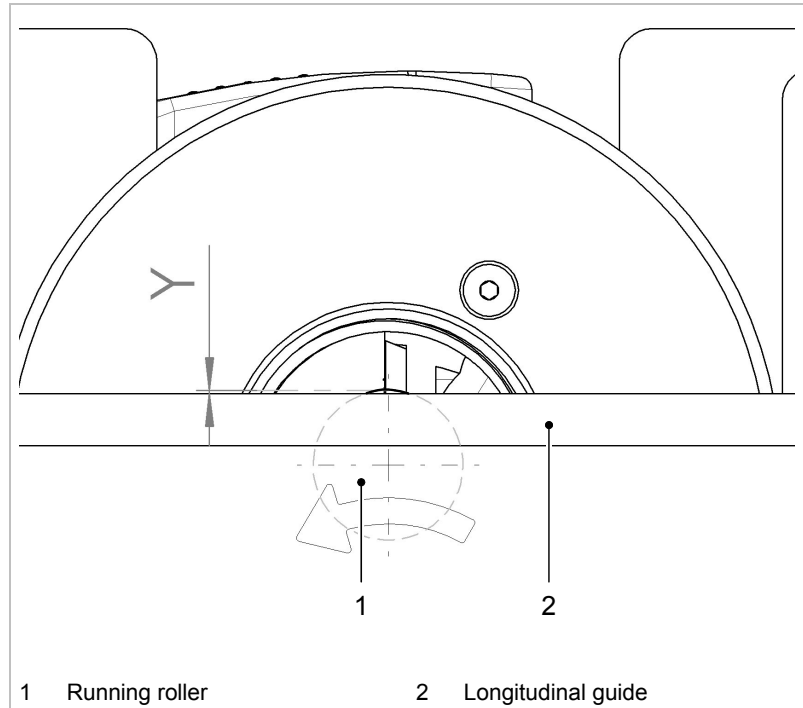


Fig. 48503

1. Undo the wing nuts.
2. Position the longitudinal guide about 0.5 mm lower than the track roller (dimension Y).
3. Tighten up the wing nuts.
4. Check if the workpiece rolls off the track roller.

## Setting the chamfer height

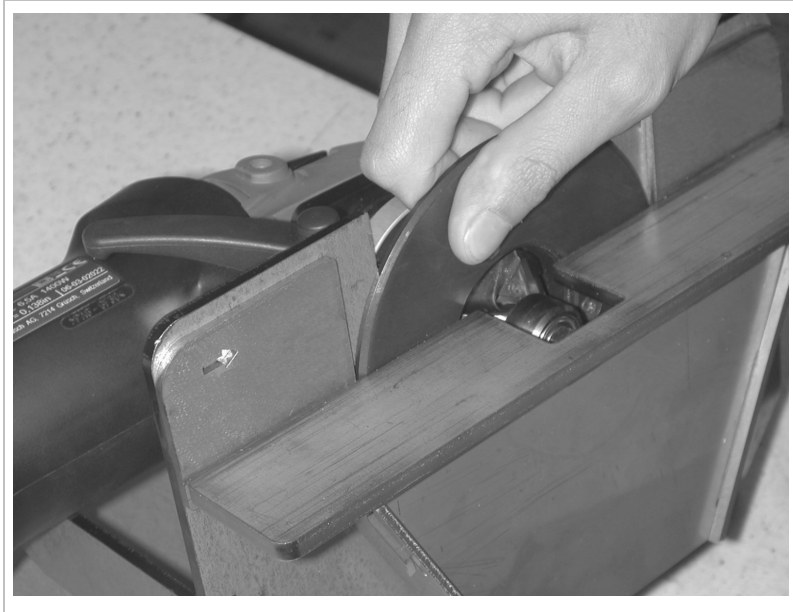


Fig. 48504

1. Undo the clamping lever.
2. Rotate the support plate until the desired chamfer height can be read off the dial ring.
3. Tighten up the clamping lever.

### Tip

In order to check the accuracy, carry out a test cut.

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## 4. Operation



**Warning**

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### **Risk of possible injury from sharp blades!**

- Do not reach into the machining area.
  - Do not reach into the space between the workpiece and the plate.
  - Do not reach into the chip chute.
- 



**Warning**

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### **Risk of injury from high-temperature chips!**

#### **High-temperature chips are produced at high speeds.**

- When working with the machine, wear safety glasses, protective gloves and work shoes.
- 



**Warning**

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### **Risk of injury due to noise emissions!**

- Wear hearing protection while working.
- 



**Warning**

---

### **Risk of injury due to backkick!**

- Firmly press the workpiece onto the workstation.
- 



**Warning**

---

### **Risk of injury due to forward throw!**

- Feed the workpiece through the machine only in the direction of processing.
-

**Switching on the TruTool TKA 500**

1. Set the speed controller to the highest level (= level 6).
2. Slide the on/off switch on the motor forwards and push the switch downwards until it locks into place.

The motor will start to run.

**Working with the TruTool TKA 500**

Fig. 48505

1. Check that all screws are securely fastened.
2. Check the position of the longitudinal guide.
3. Switch on the machine.
4. Place the workpiece on the longitudinal guide.
5. Push the workpiece backwards on to the support plate.
6. Slowly guide the workpiece through the machine from left to right.

**Switching off the TruTool TKA 500**

1. Remove the machine from the material.
2. Firstly push the on/off switch on the motor downwards, then slide the switch backwards.

The motor is stopped.

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## 5. Maintenance



**Danger**

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**Risk of fatal injury from electric shock!**

- Pull the plug from plug socket before cleaning the guides.
- 



**Warning**

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**Danger of injury due to repair work not being carried out properly**

**The device will then not function properly.**

- Repair work may only be carried out by a qualified specialist.
- 

**Note**

Only use original replacement parts and observe the information on the rating plate.

## 6. Original accessories and wearing parts

STAND TruTool TKA 500	Supplied original accessories	Wearing parts	Order no.
Operating manual	+		1404774
Safety information (red document), other countries	+		0125699
Safety information (red document), USA	+		1239438
Clamping lever	+		0371829
Screw M8x35 ISO4762	+		0014990
Allen key DIN 911-6	+		0067865
Wing nuts	+		0361760
Supporting plate	+	+	1404741
Baffle plate	+	+	1404740
Longitudinal guide	+	+	1409057

Tab. 3

### Ordering replacement parts

To ensure the correct and fast delivery of original parts and wearing parts:

1. Specify the order number.
2. Enter further order data:
  - Voltage data
  - Quantity
  - Machine type
3. Provide complete shipping information:
  - Correct address.
  - Desired delivery type (e.g. air mail, courier, express mail, ordinary freight, parcel post).
4. Send the order to your TRUMPF representative. Refer to the address list at the end of the document for TRUMPF service addresses.