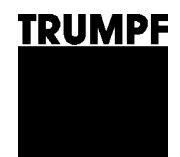


Operator's manual



TruTool F 125 (1A2)

English



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Guarantee

Replacement parts list

Addresses

1. Safety

1.1 General safety information

- Before starting-up the machine, read the operator's manual and the safety information (order no. 0373678, red document) in its entirety and carefully follow the instructions given.
- Adhere to the safety regulations in accordance with DIN VDE, CEE, AFNOR and to the specific regulations of the country of operation.



Danger

Risk of fatal injury from electric shock.

- When working with the machine do not touch any electrical lines. The machine is not insulated.
-



Warning

Risk of injury due to improper handling.

- Always remove the compressed-air hose from the machine prior to maintenance work.
 - Check the compressed-air hose, connection coupling, and machine for damage each time before using the machine.
 - Wear safety glasses, hearing protection, protective gloves and work shoes when working at the machine.
-

1.2 Specific safety information



Warning

Risk of injury due to improper handling.

- Make sure the machine is in a stable position when operating it.
 - Never touch the tool while the machine is running.
 - Always move the machine during work away from your body.
-



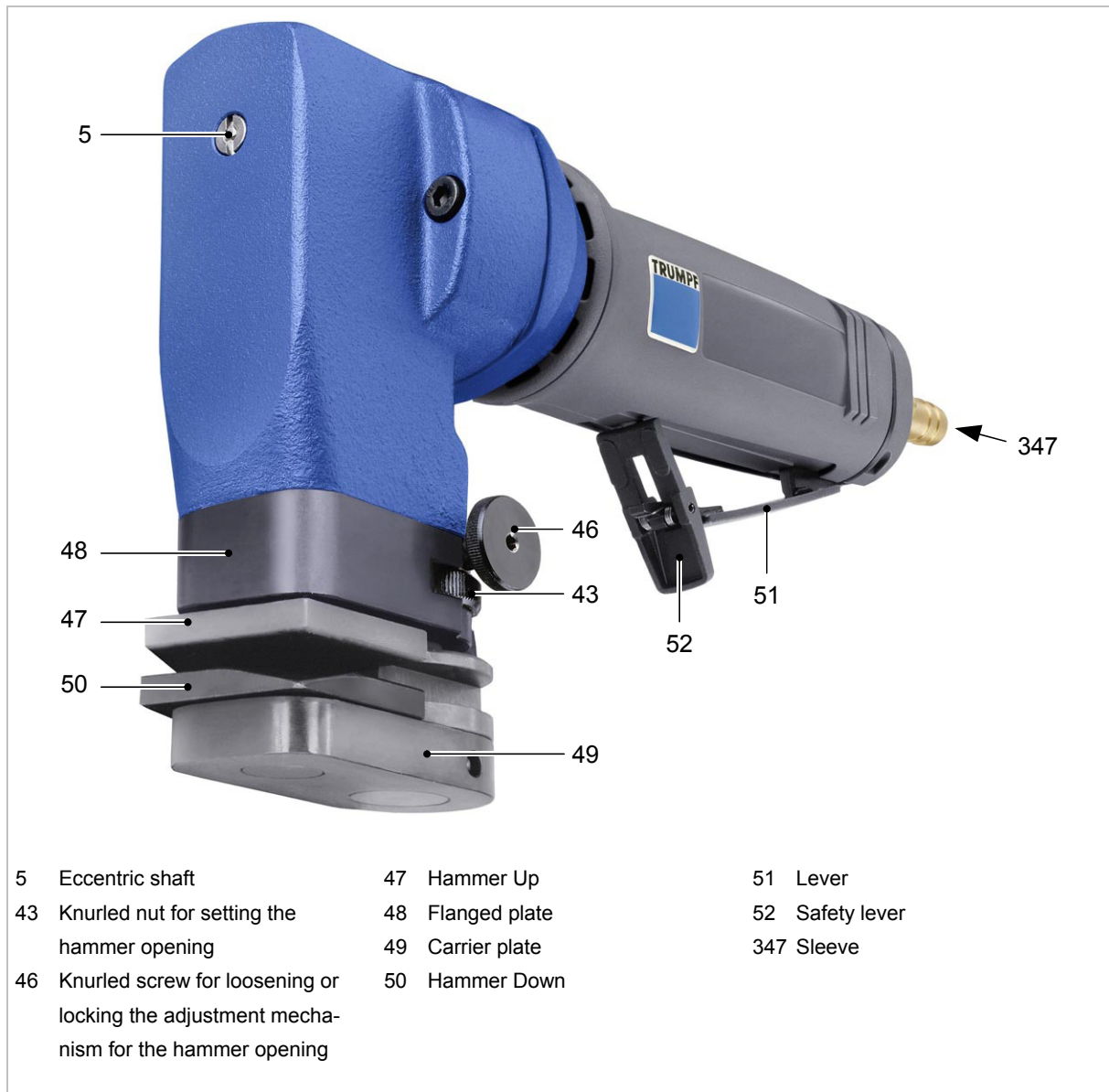
Caution

Damage to property due to improper handling.

Machine will be damaged or destroyed.

- Have servicing and inspections of hand-held compressed-air tools carried out by a qualified technician. Only use original accessories provided by TRUMPF.
-

2. Description



Seam locker TruTool F 125

Fig. 52430



2.1 Intended use



Warning

Risk of injury.

- Only use the machine for work and materials described in "Intended use."

The TRUMPF seam locker TruTool F 125 is a compressed air hand-held device used for the following applications:

- Closing pre-bent standing seams and angular seam on correspondingly pre-machined workpieces, e.g. ventilation ducts, housings, containers, etc.
- Hammering together or metal inserts for workpieces made of rubber, textile or plastic.

Note

The lock seam can be closed on straight or curved contours.

2.2 Technical data of the TruTool F 125

	Other countries	USA
	Values	Values
Max. material thickness of steel 400 N/mm ²	1.25 mm	0.049 in
Max. folding thickness	5 mm	0.2 in
Max. lock seam elevation	40 mm	1.5 in
Working speed	5-6 m/min	16-19 ft/min
Nominal power consumption	600 W	600 W
Idle stroke rate	1630/min	1630 per min
Stroke rate with nominal load	1430/min	1430/min
Weight	2.6 kg	5.7 lbs
Max. operating pressure (flow pressure)	6.2 bar	90 psi
Air consumption at 6 bar	0.8 m ³ /min	28.3 cubic ft/min
Connecting thread	1/4"	1/4"
Inside diameter of the compressed- air hose	10 mm	0.4 in (3/8")

Technical data

Tab. 1

Vibration	Specifications in accordance with EN 12096 Measured values in accordance with EN ISO 8662-10
Vibration value at the handle a	24.1 m/s ²
Uncertainty K	10.3 m/s ²

Tab. 2

Measured values were measured while cutting sheet steel 400 N/mm² with max. material thickness.

Noise emissions	Designations in accordance with EN ISO 4871 Measured values in accordance with EN ISO 15744
A-rated sound level L _{WA}	92 dB
A-rated acoustic power level at the work place L _{PA}	81 dB

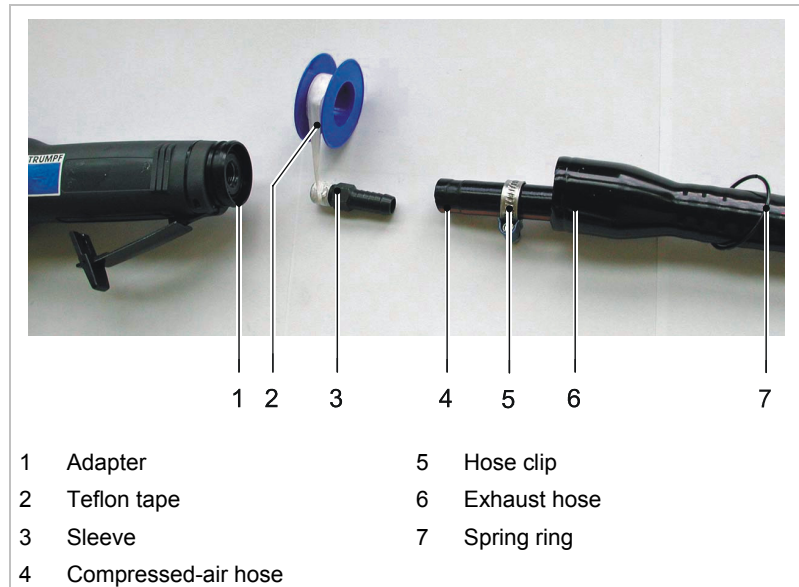
Tab. 3

The noise emission values given are the sum of the measured values and the corresponding uncertainties. They represent an upper value limit which can emerge during measurements.

3. Setting work

3.1 Installing the exhaust hose

The exhaust hose reduces noise emissions and guides the exhaust air away from the operator.



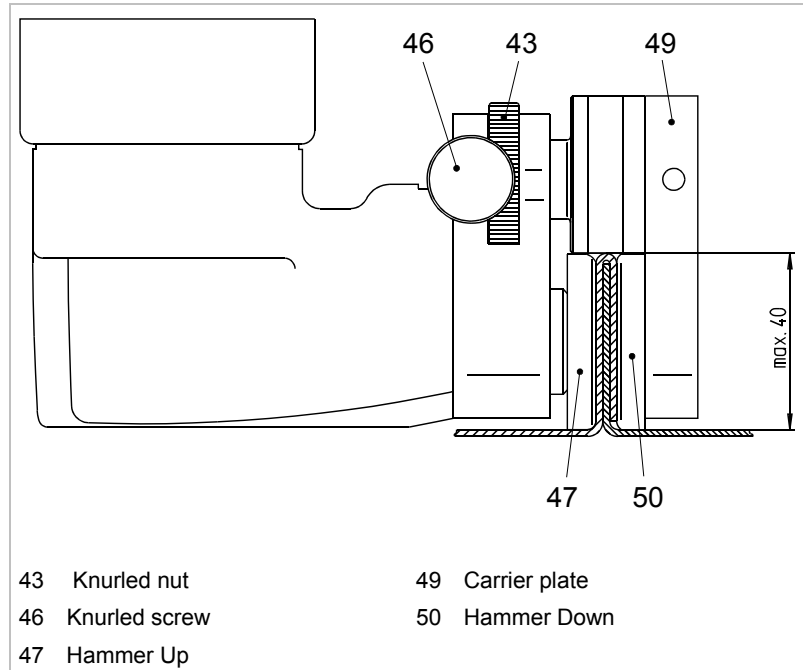
Exhaust hose

Fig. 52422

1. Put the exhaust hose (6) and the hose clip (5) over the compressed-air hose (4).
2. Undo the spring ring (7) and screw the adapter (1) onto the motor.
3. Wind Teflon tape (2) around the sleeve (3).
4. Firmly screw in the sleeve (3) in the motor.
5. Push the compressed-air hose (4) on to the sleeve (3).
6. Position the hose clip (5) and tighten.
7. Push the exhaust hose (6) on to the adapter (1).
8. Secure the exhaust hose (6) using the spring ring (7).

3.2 Adjusting the hammer

The clearance between the upper and lower hammer must be adjusted depending on the material thickness and/or seam thickness.

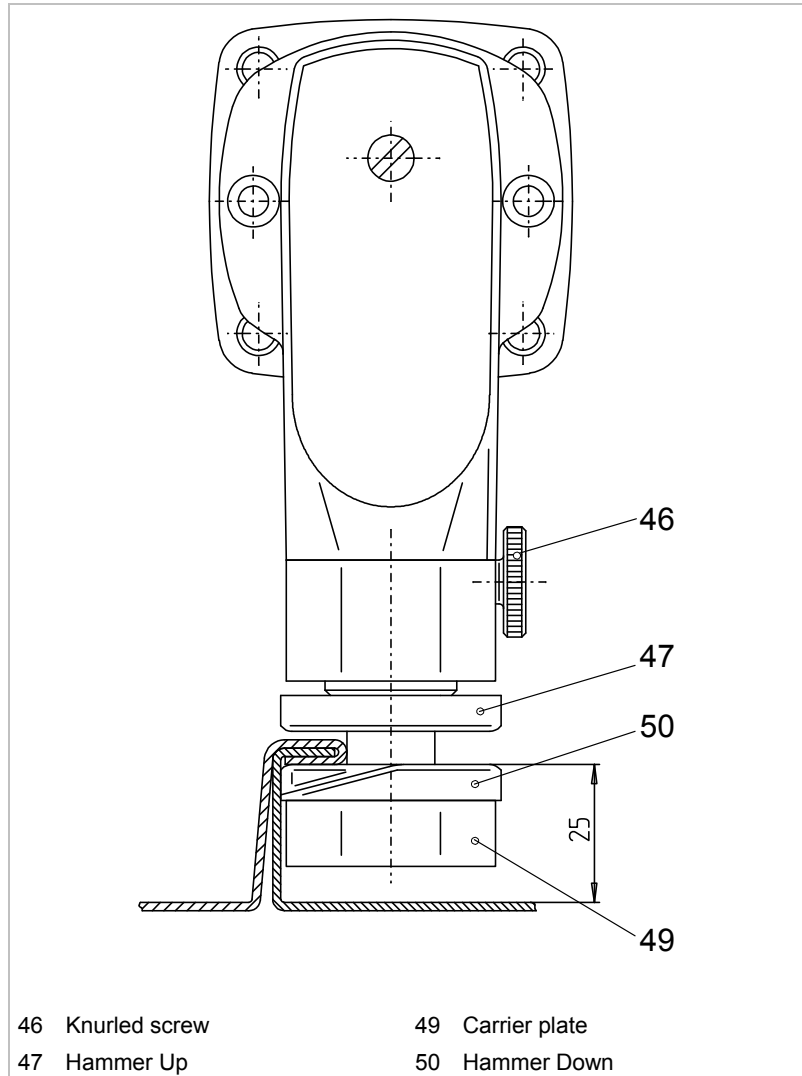


Standing seam

Fig. 11400

Setting the hammer for standing seam

1. Loosen small knurled screw (46).
2. With the motor running, set the hammer opening to the desired seam thickness using the large knurled nut (43).
3. Lock small knurled screw (46) into place.
4. Close the lock seam.



Angled standing seam

Fig. 11401

Setting the hammer for angle seam

1. Loosen small knurled screw (46).
2. Set maximum hammer opening with the large knurled nut (43).
3. Lock small knurled screw (46) into place.
4. Pre-seam the lock seam.
5. Loosen small knurled screw (46) again.
6. With the motor running, set the hammer opening to the desired seam thickness using the large knurled nut (43).
7. Lock small knurled screw (46) into place.
8. Close the lock seam.

Plastic buffer

- Minor differences in seam thickness are balanced out through the use of a plastic buffer.

4. Operation



Warning

Risk of injury due to improper handling.

- Make sure the machine is in a stable position when operating it.
 - Never touch the tool while the machine is running.
 - Always move the machine during work away from your body.
-

4.1 Operating the TruTool F 125

- Switching on**
1. Swivel the safety lever.
 2. Press the lever against the motor housing.

- Operating the TruTool F 125**
1. Guide the machine to the workpiece with the flattened edge foremost once the full rpm has been achieved.
 2. Guide the machine along the lock seam.
 3. Remove the machine from the workpiece at the end of the lock seam.

- Switching off**
- Release the lever.
- The lever springs back to initial position, the compressed air is interrupted.

5. Maintenance



Warning

Risk of injury due to uncontrolled machine movements.

- Remove the compressed-air hose from the machine when changing tools and before performing any maintenance work on the machine.



Warning

Risk of injury due to repair work not being carried out properly.

Machine does not work properly.

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

Maintenance point	Procedure and interval	Recommended lubricant	Lubricant order no.
Gearbox and gear head	After 300 operating hours, arrange for a qualified technician to relubricate or to replace the lubricating grease.	Lubricating grease "G1"	139440
Changing plastic buffers	Change as needed (see "Changing plastic buffers", p. 13).		
Filter, oil mist lubrication device	Maintain daily in accordance with the manufacturer's specifications (see "Supplying with power and guaranteeing lubrication", p. 14).	-	-
Strainer	Clean every 10 operating hours and when there has been a decline in performance (see "Cleaning the strainer", p. 16).	-	-

Maintenance table

Tab. 4

5.1 Changing plastic buffers

The plastic buffer is for damping the hammer. The plastic buffer can wear with time and the lock seam is then not closed properly. (see Fig. 11400, p. 9)

1. Loosen small knurled screw (46).
2. Loosen knurled nut (43).
3. Remove lower hammer.
4. Pull out upper hammer.
5. Remove plastic buffer with a screwdriver.
6. Push in new plastic buffer.
7. Put upper hammer in place.
8. Insert lower hammer.
9. Lock knurled nut (43).
10. Tighten knurled screw (46).

5.2 Supplying with power and guaranteeing lubrication



Caution

Damage to property due to improper handling.

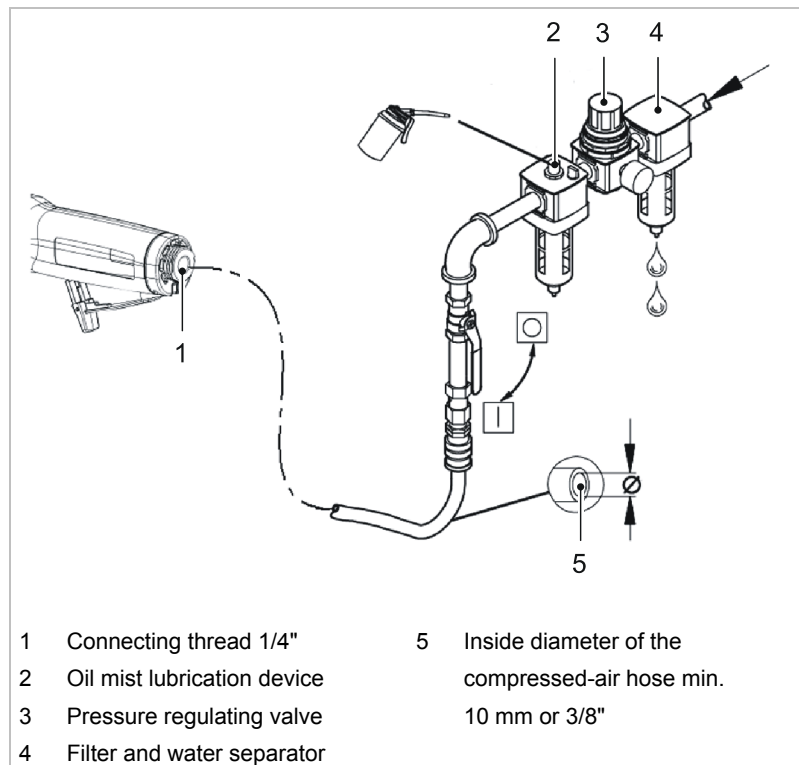
Failure of the compressed-air motor.

- Do not exceed the maximum operating pressure.
- Regularly lubricate the compressed-air motor. Install an oil mist lubrication device into the compressed-air line.

Supplying compressed air

Prerequisite

- The pressure regulating valve and the connecting threads are laid out correctly (see "Technical data", section 2.2, p. 7).



Compressed air supply.

Fig. 52385

1. Install the filter and water separator (4).
2. Drain/check the water separator daily.

Note

To ensure a supply of compressed air the tube cross-sections in the entire line system must be twice to three times the size of the inside diameter of the compressed-air hose.



Checking the oil supply

- Hold a piece of paper in front of the exhaust air vent in the motor housing when the machine is running.

The oil supply is sufficient when oil spots appear.

When there is no oil mist lubrication device available:

- Fill the air inlet bore hole with 0.5-1 ccm of oil every two hours.

Recommended lubricant:

- BP Energol RD 80 (-15° to +10 °C / +5° to +50°F).
- BP Energol RD-E80 (+10° to +30 °C/+50° to +86°F).
- Shell Tellus Oil 15 (-15° to +10 °C / +5° to +50°F).
- Torculla 33 (+10° to +30 °C / +50° to +86°F).

Note

Secure the compressed-air hose against undesired movements using a compressed-air safety device.

5.3 Replacing fins

Worn fins decrease machine performance.

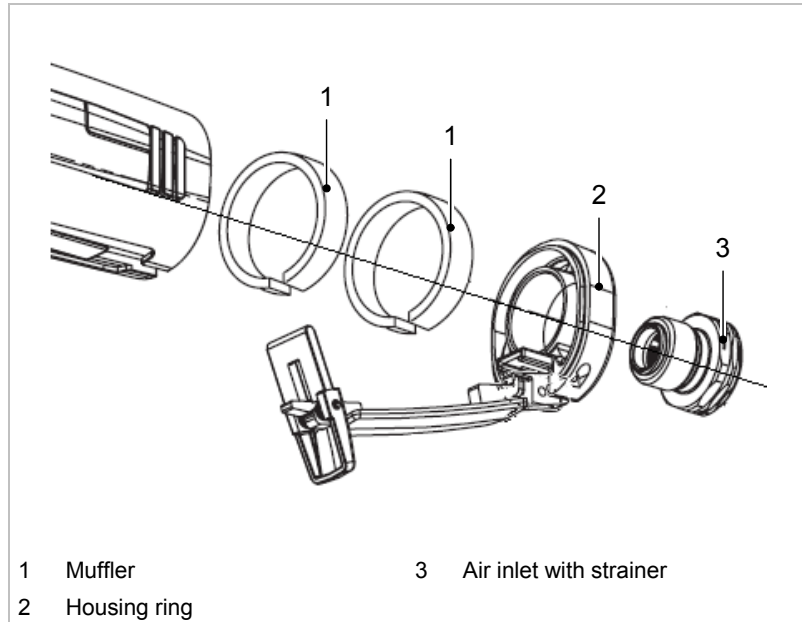
- Have the fin set checked and replaced as needed by a qualified technician.

Note

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

5.4 Cleaning the strainer

Dirty strainers decrease machine performance.



Air inlet

Fig. 52402

1. Remove the air inlet with strainer.
2. Clean the strainer or replace the complete air inlet.
3. Reinstall the air inlet.

5.5 Changing mufflers

Change the muffler pads as needed (see Fig. 52402, p. 16).

1. Remove the air inlet (3).
2. Pull off the housing ring (2).
3. Replace the muffler (1).
4. Reinstall the housing ring and the air inlet.



6. Original accessories and wearing parts

	Supplied original accessories	Wearing parts	Options	Order no.
Hammer up	+	+		102964
Hammer down	+	+		105448
Plastic buffer	+	+		105449
Sleeve	+			0376078
Case	+			1408552
Fin set (x 4)		+		1440002
Operator's manual	+			1440915
Safety information (red document)	+			0373678
Lubricating grease "G1" (900 g/1.98 lbs)			+	139440

Tab. 5

Ordering wearing 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.

7. Disposal

To dispose of the machine, completely disassemble it, degrease it and send it, according to the different types of material, for recycling.

