Operator's manual

TruTool TKA 500 (2A1)

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TRUMPF

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1. Safety

1.1 General safety information

⚠ WARNING

- Read all the safety information and instructions including those in the brochure also supplied.
- Failure to comply with the safety information and instructions can cause electric shock, burns and/or serious injury.
- Retain all the safety information and instructions for future use.

⚠ 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.

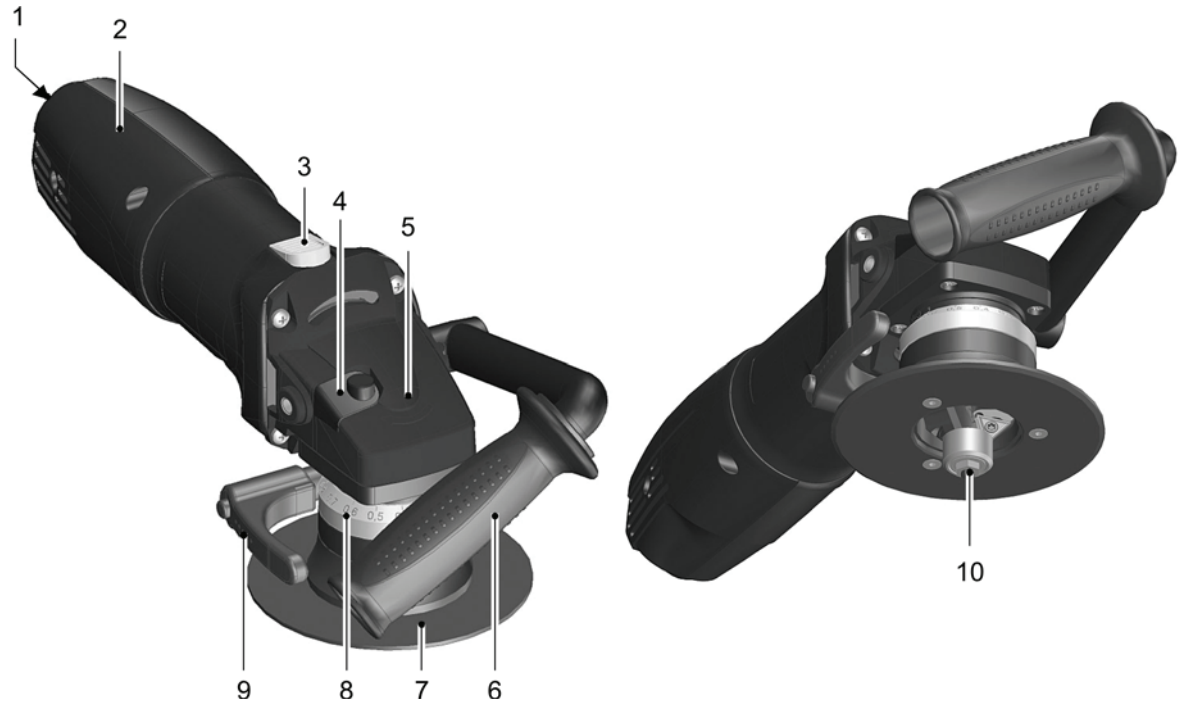
1.2 Specific safety information for lip trimmers

⚠ 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



1	Speed controller	5	Gear head	8	Dial ring
2	Motor	6	Handle	9	Clamping lever
3	On/Off switch	7	Support plate	10	Multi-edge cutter mount
4	Spindle lock				

TruTool TKA 500: Overview Fig. 33402

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 TruTool TKA 500 lip trimmer is an electrical powered hand-held device designed for the following applications:

- Processing of workpieces made of steel, chromium steel, aluminum, aluminum alloys, brass or plastic material (PA6).
- Utilization in industry and trade.
- Attachment of visible edges
- Rounding off of T-beams etc.
- Removal of cutting burrs after splitting procedures (e.g. guillotine shearing).

2.2 Technical data

	Other countries			USA
	Values			
Voltage	230 V	120 V	100 V	120 V
Frequency	50/60 Hz			50/60 Hz
Working speed	3 - 4 m/min			10 - 13 ft/min
Nominal power consumption	1400 W	1400 W	1200 W	1140 W
Idle stroke rate	8390/min	7300/min	7300/min	7300/min
Weight with guide handle	3.9 kg	3.9 kg	3.9 kg	8.6 lbs
Min. material thickness (see Fig. 36835)	Chamfer height/Radius +1.5 mm	Chamfer height/Radius +1.5 mm	Chamfer height/Radius +1.5 mm	Chamfer height/ Radius +0.059 in
Max. chamfer length (see Tab. 3)				
▪ **400 N/mm²**	5 mm/R4	5 mm/R4	5 mm/R4	0.197 in/R0.157 in
▪ **600 N/mm²**	2.5 mm/R2	2.5 mm/R2	2.5 mm/R2	0.098 in/R0.079 in
▪ **800 N/mm²**	1.5 mm	1.5 mm	1.5 mm	0.059 in
Smallest radius for interior cutouts at:				
▪ **30°, 40°**	16 mm	16 mm	16 mm	0.63 in
▪ **45°, 60°**	12 mm	12 mm	12 mm	0.47 in
▪ **R**	11 mm	11 mm	11 mm	0.433 in
Safety class	II / ⧈	II / ⧈	II / ⧈	II / ⧈

Tab. 1

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

Icon	Name	Meaning
mm	Millimeters	Dimensions e.g.: material thickness, chamfer length
in	Inch	Dimensions e.g.: material thickness, chamfer length
n_o	Idle speed	Revolution speed without load
.../min	Revolutions/strokes per minute	Revolution speed, stroke rate per minute

Tab. 2

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	4.4
Uncertainty K for vibration emission value	m/s^2	1.5

Designation of measured value	Unit	Value according to EN 60745
A-class acoustic pressure level L_{PA} typically	dB (A)	88
A-class acoustic power level L_{WA} typically	dB (A)	99
Uncertainty K for noise emission value	dB	3

Tab. 3

3. Setting work

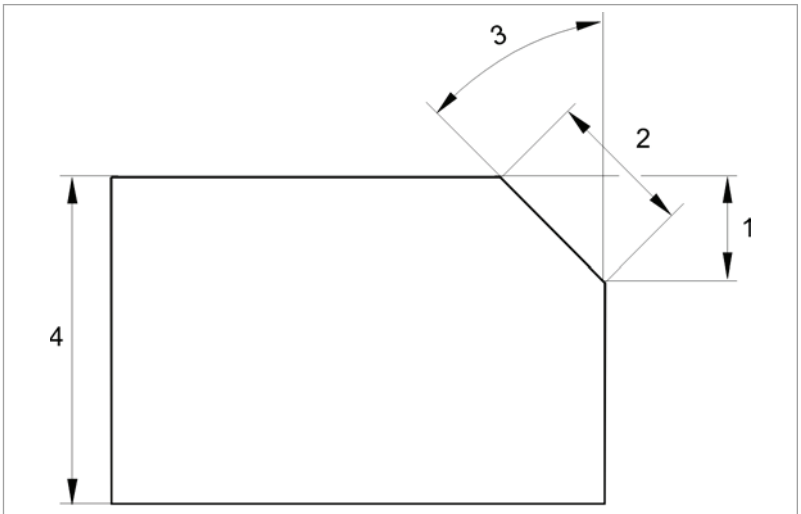
⚠ WARNING

Overheated support plate and dial ring!

Risk of burns

➢ Wear protective gloves when setting the chamfer height.

3.1 Chamfer height



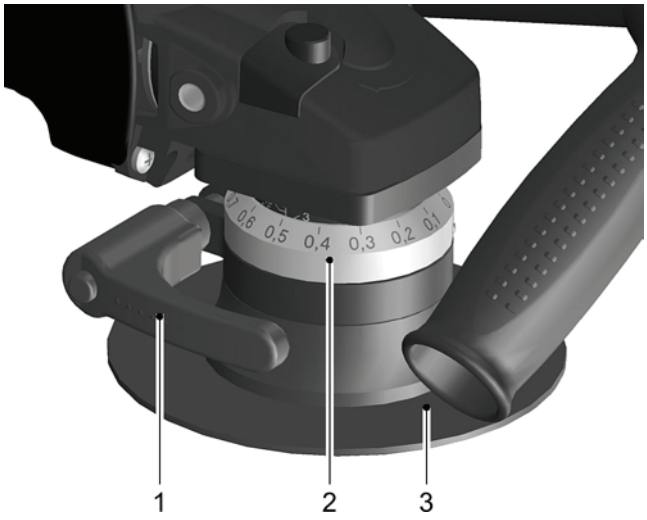
1 Chamfer height
2 Chamfer length
3 Chamfering angle
4 Material thickness

Fig. 36835

Material and tensile strength	Max. chamfer height mm/in						Max. chamfer length mm/in	
Angle	**30°**		**45°**		**60°**			
	230 V	**110/120 V**	**230 V**	**110/120 V**	**230 V**	**110/120 V**	**230 V**	**110/120 V**
400 N/mm^2	4.3	3.5/0.138	3.5	2.8/0.110	2.5	2.0/0.079	5.0	4.0/0.157
600 N/mm^2	2.2	1.9/0.079	1.8	1.6/0.061	1.3	1.1/0.043	2.5	2.2/0.087
800 N/mm^2	1.3	1.1/0.044	1.1	0.9/0.036	0.8	0.7/0.028	1.5	1.3/0.051
250 N/mm^2	6.5	6.5/0.256	6.4	6.0/0.237	5.0	4.3/0.169	10	8.5/0.335

Tab. 4

Setting the chamfer height



1 Clamping lever
2 Dial ring
3 Support plate

Fig. 33408

Note

The chamfer height is set with the aid of the support plate and read by means of the number scale on the dial ring.

1. Undo the clamping lever (1).
2. Rotate the support plate (3) until the desired chamfer height can be read off the dial ring (2). The chamfer height is calculated as follows:

   (value on the scale) + (value on the dial ring) = chamfer height.

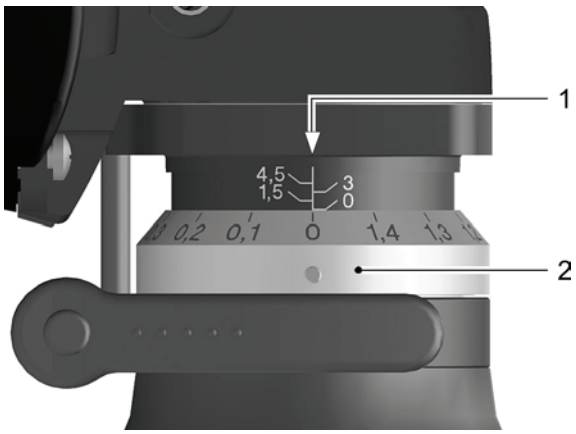
   Example: 1.5 + 0.7 = 2.2

   The values on the dial ring indicate the chamfer height (1) in mm.

   Each complete rotation (=360° rotation) corresponds to a chamfer height of 1.5 mm.
3. Fix the clamping lever (1) back into place.

   Chamfer height is adjusted.

Dial ring



1 Scale 2 Dial ring

Zero position Fig. 33409

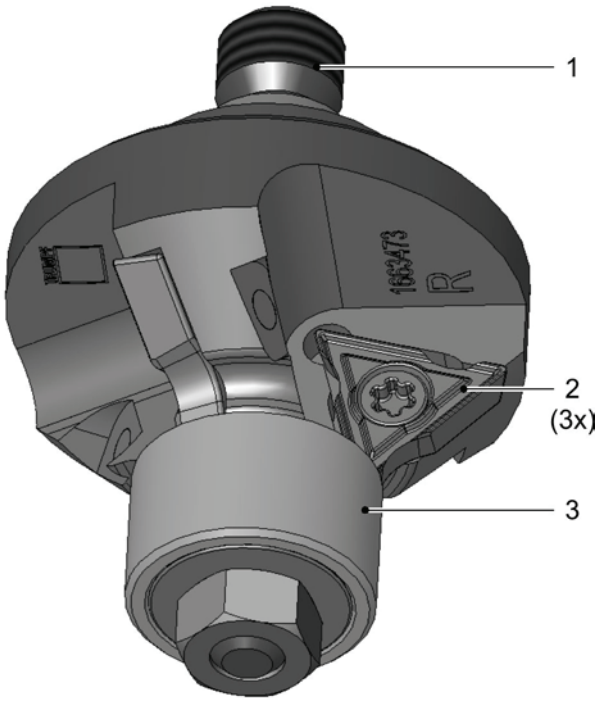
Notes

- The machine is adjusted in zero position during assembly. Zero position means chamfer height zero. The dial ring can be readjusted.
- The integrated multi-edge cutter mount consists of the 3-way multi-edge cutter mount, the 3-way multi-edge cutter and the impeller.

4. When deburring or chamfering, insert the 45° 3-way multi-edge cutter mount completely.

3.2 Set up radius tool

3-way multi-edge cutter mount



1 3-way multi-edge cutter mount R
2 Multi-edge cutter R
3 Impeller R D20

3-way multi-edge cutter mount Fig. 33407

When deburring or chamfering with radius the multi-edge cutter mount R is inserted completely. The integrated multi-edge cutter mount consists of the multi-edge cutter mount R, the multi-edge cutters R and the impeller R D20.

The multi-edge cutters are the actual wear parts. They are:

- useable for processing steel, aluminum and aluminum alloys as well as plastic material.
- suitable for working with radii R2, R3 or R4.

3.3 Select multi-edge cutters

The multi-edge cutters are the actual wear parts. They are:

- useable for machining steel, aluminum and aluminum alloys as well as plastic material.
- suitable for machining bevels of 0, 15°...60°.

There is an appropriate multi-edge cutter for each material:

Tensile strength of the workpiece		Multi-edge chamfer cutter	Multi-edge radius cutter
Steel up to 400 N/mm^2	0 - 2.2 x 45°	St Universal St/Cr	St R2, St R3 St R4
	2.2 - 3.5 x 45°	Cr Universal St/Cr	
Steel up to 600 N/mm^2		Cr	Cr R2
Steel up to 800 N/mm^2		Cr	-
Aluminum/aluminum alloy up to 250 N/mm^2		Alu	St R2, St R3 St R4
Plastic material (PA6)		Alu	St R2, St R3 St R4

Tab. 5

Multi-edge cutters and setting value

Radius	Chamfer height (approx.) mm
R2	1.1
R3	1.7
R4	2.3

Tab. 6

Notes

- The values of the chamfer height are recommended values which could differ from the specified values in individual cases.
- Before machining chrome-steel and aluminum and/or aluminum alloys, it is advisable to oil the cutting edges with cutting oil (see "Tab. 8", pg. 22) in order to improve the machinability of the edges and to increase the service life of the tools.

4. Operation

⚠ 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.

⚠ 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.

⚠ CAUTION

Damage to property!

Wear and destruction of the multi-edge cutter and of the multi-edge cutter mount, failure of the tool.

- Avoid collisions during processing.

4.1 Overload protective device on the motor

Notes

- The appliance may switch off prematurely when affected by electromagnetic interference. The appliance will resume operation when the faults have been cleared.
- If the motor temperature is too high, the motor will switch off.

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

4.2 Working with the TruTool TKA 500

Switching on TruTool TKA 500

1 Speed controller (230 V motor only)
2 Motor
3 On/Off switch

Fig. 33404

1. Only with 230 V motor: set the speed controller (1) to the highest level (= stage G).
2. Slide the on/off switch (3) on the motor (2) forwards and push the switch downwards until it locks into place.

   The motor will start to run.

Working with the TruTool TKA 500

Note

2-hand control device

Work is performed with two-hand operation for all machine positions.

When operating the machine ensure that the machine is held with both hands in such a way that both hands are kept away from the machining point.

3. Do not move the machine towards the workpiece until full speed has been reached.

Note

When deburring or chamfering, the machine must always be guided from left to right **(conventional milling**).

2-hand control device Fig. 61420

4. Edit material.

Switching off TruTool TKA 500

5. Remove the machine from the material.
6. Firstly push the on/off switch (see "Fig. 33404", pg. 13) on the motor downwards, then slide the switch backwards.

   The motor is stopped.

5. Maintenance

⚠ 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.

⚠ CAUTION

Overheated tool and multi-edge cutter mount!

Risk of burns

- ➢ Wear protective gloves during tool change.

⚠ CAUTION

Damage to property caused by blunt tools.

Machine overload.

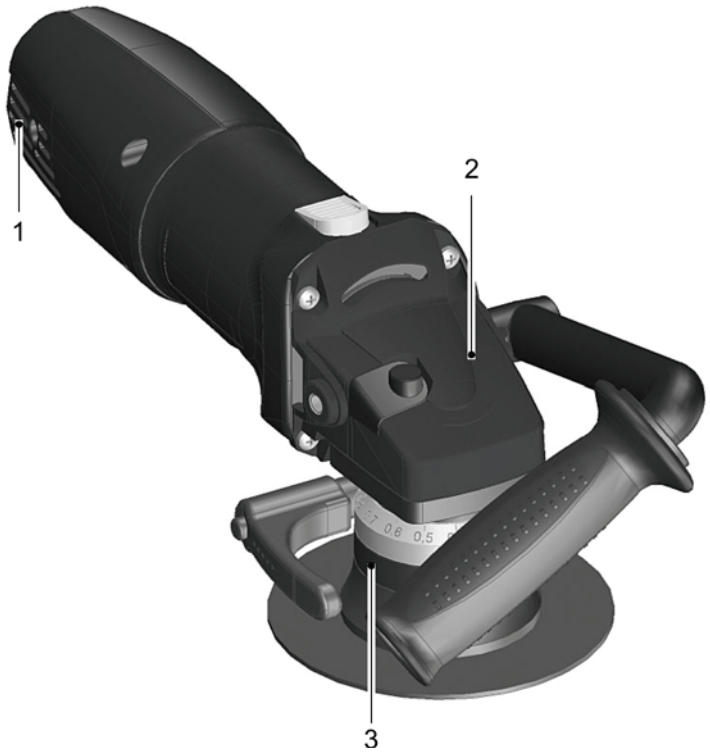
- ➢ Check tools regularly for wear. Sharp multi-edge cutters provide good cutting performance and prevent machine damage. Rotate or replace multi-edge cutters in good time.

⚠ 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.



1 Ventilation slots
2 Gear head
3 Thread gear housing and thread support plate

Maintenance positions on TruTool TKA 500 Fig. 33405

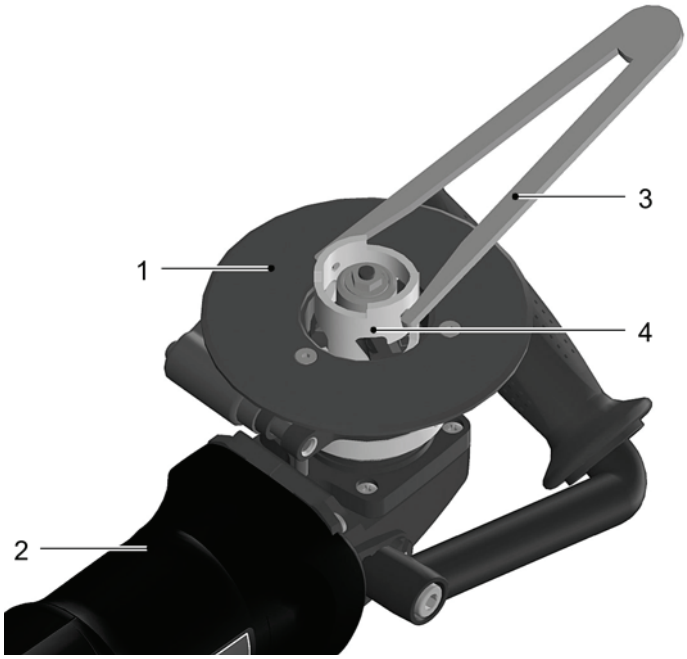
Maintenance point	Procedure and interval	Recommended lubricants	Lubricant order no.
Gearbox and gear head (2)	After 100 operating hours, arrange for a trained specialist to relubricate or to replace the lubricating grease.	Lubricating grease "G1"	0139440
Thread gear housing complete and thread support plate complete (3)	Clean and lubricate as needed.	Lubricating grease "G3"	0353969
Multi-edge cutter mount: all threads and mounting surfaces	During changeover	Lubricating grease "G3"	0353969
Multi-edge cutters	Rotate or replace as needed.	-	-
Impeller	Replace if required.	-	-

Maintenance point	Procedure and interval	Recommended lubricants	Lubricant order no.
Ventilation slots (1)	Clean as needed.	-	-

Maintenance positions and intervals Tab. 7

5.1 Replacing the tool

Removing the multi-edge cutter mount

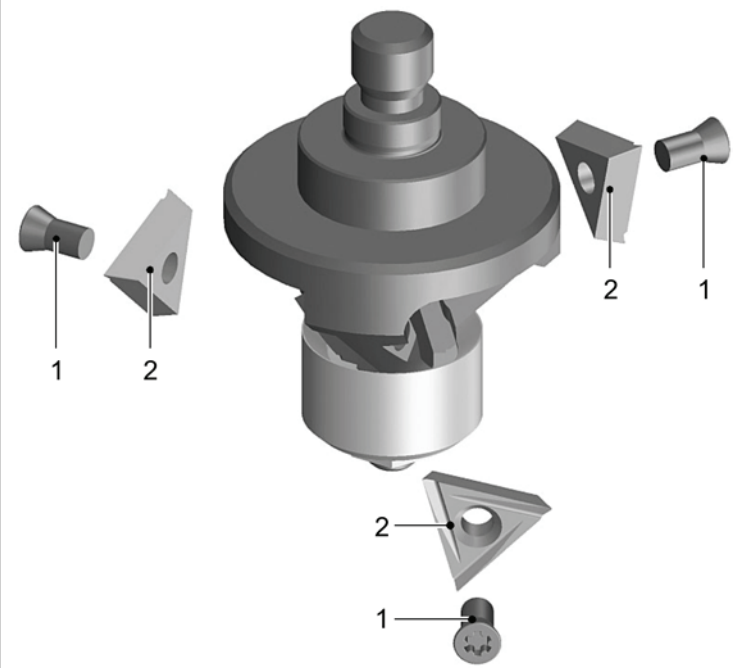


1	Support plate	3	Face wrench
2	Motor	4	Socket wrench

Fig. 33534

1. Set the socket wrench (4) to milling cutter.
2. Plug the face wrench (3) into the corresponding bore holes on the socket wrench.
3. Press the spindle lock (see "Fig. 33534", pg. 17) while simultaneously rotating the face wrench (3) counter-clockwise.
4. Remove the integrated multi-edge cutter mount completely.
5. Lubricate threads and support areas with "G3" lubricant before installation.

5.2 Replacing multi-edge cutters



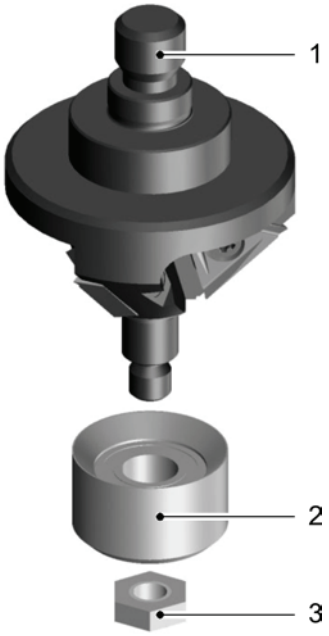
1 Fixing screws 2 3-way multi-edge cutters

Fig. 33406

1. Undo mounting screw (1) and remove multi-edge cutters (2).
2. Rotate multi-edge cutters or insert new multi-edge cutters.
3. Fasten the multi-edge cutters once again with fixing screws.
4. Lubricate threads and support areas with "G3" lubricant before installation.

5.3 Changing the impeller

The impeller must be replaced when there is wear, because otherwise the chamfer surfaces will not receive even machining.



1 Multi-edge cutter mount
2 Impeller
3 Hexagonal nut

Fig. 33410

1. Undo hexagonal nut (3) with single-head wrench (see "Tab. 8", pg. 22).
2. Pull away impeller (2) and replace it.
3. Fasten new impeller back on with hexagonal nut.

5.4 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.

5.5 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.

6. Accessories and consumables

	Scope of delivery	Consumables	Accessories	Order number
Pin-type face spanner	X	-	-	0353531
Socket wrench	X	-	-	1241272
Torx screwdriver TX 15x60	X	-	-	0353793
Open-end wrench	X	-	-	0068012
Safety glasses	X	-	-	0944950
Case	X	-	-	1209342
Operator's manual, TruTool TKA 500	X	-	-	1893448
Safety information, other countries	X	-	-	0125699
Safety information, USA	X	-	-	1239438
Cutting oil for steel (0.5 l)	-	X	-	103387
Cutting oil for aluminum (1 l)	-	X	-	125874
Spacer plate	-	-	X	1236998
Protective foil (5 pieces)	-	X	-	1234851
Waste metal box	-	-	X	1236997
Impeller 45° - 60° for thin sheet metal D22x14.5	-	-	X	1237451
Support plate (small)	-	-	X	1315258
Lubricating grease "G1"	-	X	-	0139440
Lubricating grease "G3"	-	X	-	0353969
Multi-edge cutter mount 15° triple with impeller	-	-	X	1412639
Multi-edge cutter mount 20° triple with impeller	-	-	X	1619933
Multi-edge cutter mount 25° triple with impeller	-	-	X	1419177
Impeller 15° - 25° D29.6x11.6	-	X	-	1414170
Multi-edge cutter mount 30° triple with impeller	-	-	X	1237683
Multi-edge cutter mount 35° triple with impeller	-	-	X	1256510
Multi-edge cutter mount 40° triple with impeller	-	-	X	1620265
Impeller 30° - 40° D29.6x12.3	-	X	-	1237495
Multi-edge cutter mount 45° triple with impeller	X	-	-	1227954
Multi-edge cutter mount 50° triple with impeller	-	-	X	1429605
Multi-edge cutter mount 55° triple with impeller	-	-	X	1251684
Multi-edge cutter mount 60° triple with impeller	-	-	X	1257861
Impeller 45° - 60° D22x12.5	X	-	-	1214439
Multi-edge cutter mount R 3-way with impeller	-	-	X	1663473
Impeller R D20	-	X	-	1227953
Multi-edge cutter mount R 2-way plasma with impeller (conic)	-	-	X	1484142
Impeller plasma D20 conic D15	-	X	-	1484526
Multi-edge cutter mount R2-PLUS with impeller (crowned)	-	-	X	1265985
Impeller R2-PLUS D29 crowned D27	-	X	-	1266024
Multi-edge cutter mount R4-PLUS with impeller (crowned)	-	-	X	1264547
Impeller R4-PLUS D27 crowned D24	-	X	-	1264586

	Scope of delivery	Consumables	Accessories	Order number
RPLUS spacer plate and guard plate	-	-	X	1265501
Tool face edge	-	-	X	1645165
Work station for small parts	-	-	X	1404742
3 Multi-edge cutters ST (replacement part set)	-	X	-	1241780
3 Multi-edge cutters CR (replacement part set)	X	-	-	1241851
3 Multi-edge cutters ALU (replacement part set)	-	X	-	1241852
3 Multi-edge cutters ST R4 (replacement part set)	-	X	-	1693629
3 Multi-edge cutters ST R3 (replacement part set)	-	X	-	1693742
3 Multi-edge cutters ST R2 (replacement part set)	-	X	-	1693743
3 Multi-edge cutters CR R2 (replacement part set)	-	X	-	1693744
3 Multi-edge cutters R3 coated (replacement part set)	-	X	-	1693745
3 Multi-edge cutters R PLUS ST (R2 and R4)	-	X	-	1266783
TKA selection card	X	-	-	1673948
Fixing screw for multi-edge cutter	X	-	-	0353387

Accessories and consumables Tab. 8

6.1 Ordering consumables

Note

The following data must be specified in order to ensure that parts are delivered correctly and without delay.

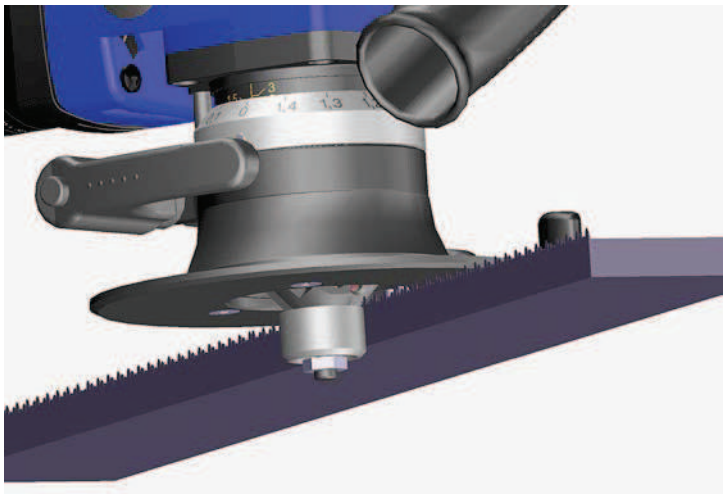
1. Specify the order number.
2. Enter further order data:
   - Voltage data
   - Quantity
   - Machine type
3. Specify the complete shipping information:
   - Correct address.
   - Desired delivery type (e.g. air mail, courier, express mail, ordinary freight, parcel post).

   Note

   For TRUMPF service addresses, see www.trumpf-powertools.com.
4. Send the order to the TRUMPF representative office.

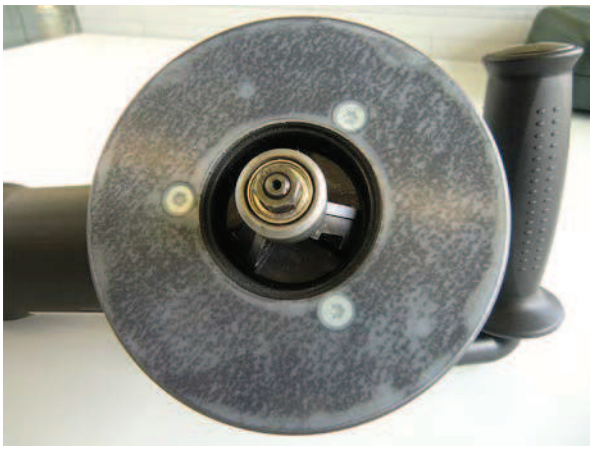
6.2 Accessories

Spacer plate for deburring

Order No.	1236998
Intended use	 ▪ Support plate for the removal of a cutting burr of up to approx. 3 mm. ▪ The spacer plate ensures workpiece support when burrs present. It can be clamped according to the chamfer direction. ▪ Combinable with multi-edge cutter mount plasma.
Assembly	 1. Undo butterfly screw. 2. Guide spacer plate into support plate. 3. Tighten butterfly screw. Spacer plate is parallel to support plate.
Technical data	▪ Height h = 3 mm ▪ Length L = 122 mm ▪ Depth t = 52 mm

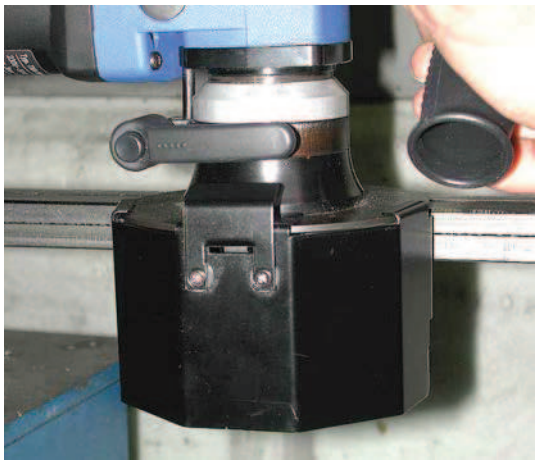
Tab. 9

5 Protective foil for low-scratch machining (Set)

Order No.	1234851
Intended use	 ▪ Low-scratch guidance to the support plate using an affixed sheet of plastic. ▪ For soft work pieces.
Assembly	 1. Clean support plate. 2. Stick on foil.
Technical data	Self-sticking foil ▪ Diameter ∅ = 116 mm ▪ Thickness d = 0.3 mm

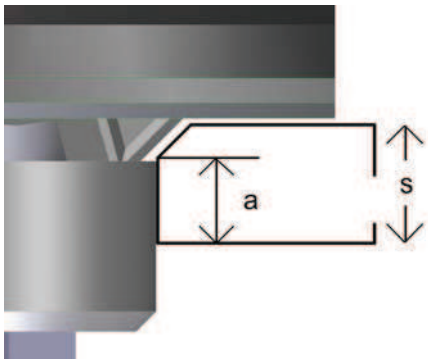
Tab. 10

Chip box

Order No.	1236997
Intended use	 ■ Storage bin for chips for applications with straight edges. ■ Rotatable 360°. ■ Tool not necessary for mounting.
Assembly	 1. Push support plate between the middle hook and the edge of the chip box and clamp. 2. Turn chip box parallel to the direction of machining. 3. Press middle flange (middle hook is lifted out of the plate gutter edge). Release chip box.
Technical data	■ Height approx. 100 mm ■ Width approx. 130 mm ■ Depth approx. 80 mm

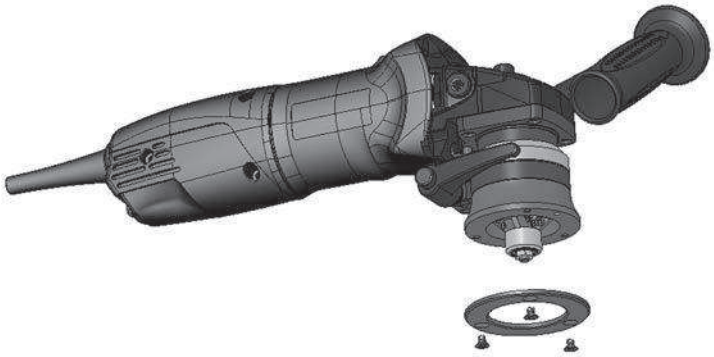
Tab. 11

Impeller for thin sheet metal

Order No.	1237451
Intended use	 a "Rest" material thickness s Material thickness ▪ For applications with small "rest" material thickness a. **Note :** ▪ Good workpiece support. ▪ Support plate parallel to the workpiece.
Assembly	 1. Align disc springs. 2. Tighten nut, until impeller is touching multi-edge cutter. 3. Undo nut approx 10°. It should now be possible to turn the impeller easily.
Technical data	▪ Minimum "residual" material thickness a = 0.7 mm ▪ Impeller dimensions – ∅ = 22 mm – Height h = 14.5 mm ▪ Multi-edge cutter mount 45° - 60°

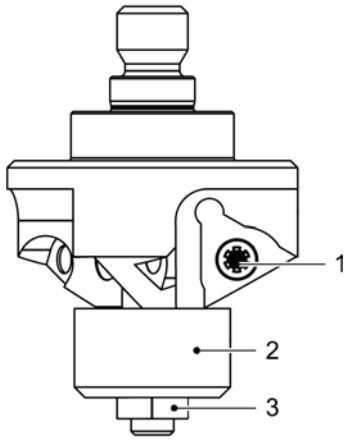
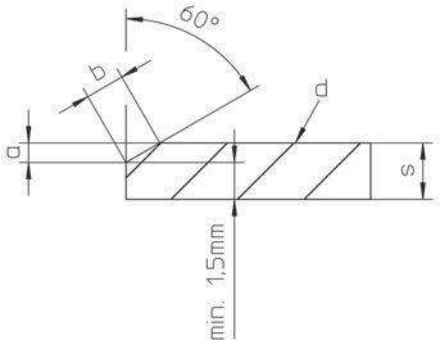
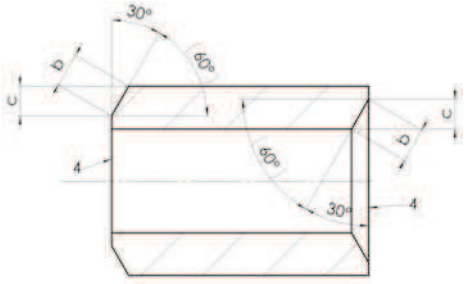
Tab. 12

Support plate (small)

Order No.	1315258
Intended use	 ▪ For restricted spaces. ▪ For all multi-edge cutter mounts. **Note :** ▪ Small diameter makes guidance of the TKA difficult.
Assembly	 Countersunk screws M4x6 (1646214) 1. Remove support plate. 2. Install small support plate with new M4x6 screws.
Technical data	▪ d = 76 mm

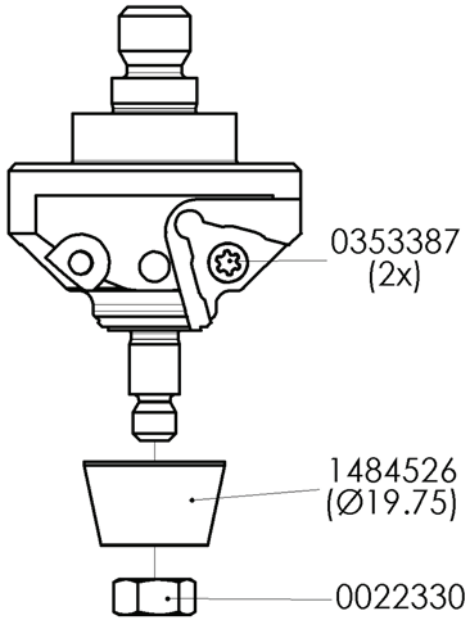
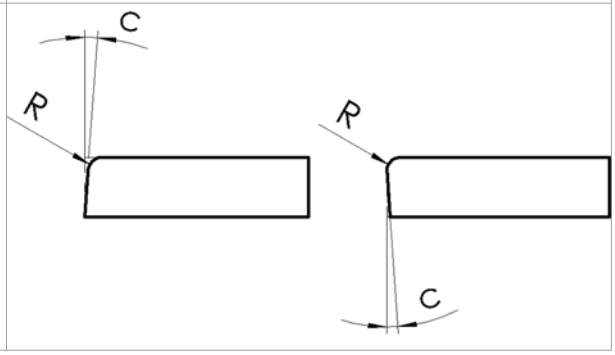
Tab. 13

Pipe and tube processing with all multi-edge cutter mounts 15° - 60° R

Order No.	(see "Tab. 8", pg. 22)	
Intended use	▪ Process on the face-side to chamfer the contrary angle.	
Assembly	1 Screw 0353387 (3x) 2 Impeller 3 Nut M6 1. Select and install multi-edge cutter and multi-edge cutter mount. Desired chamfer = 30° → Selection: multi-edge cutter mount 60°. 2. Install multi-edge cutter mount. 3. Set chamfer size as per the data sheet. 4. Lock multi-edge cutter mount into place with bracket. 5. Bevel pipe or tube on the face-side.	
Technical data	 See data sheet a Chamfer height b Chamfer length d Support plate position s Material thickness	 b Chamfer length c Pipe or tube chamfer height d Support plate position s Material thickness

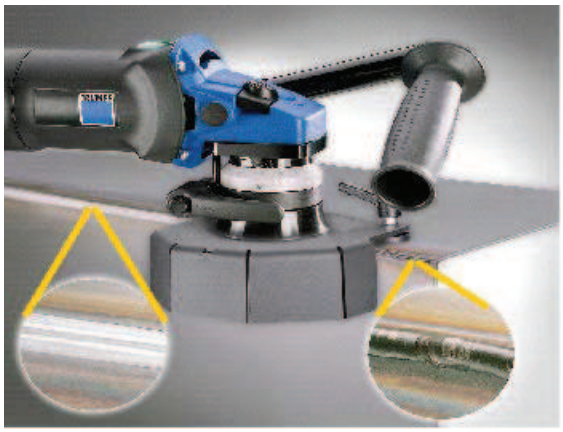
Tab. 14

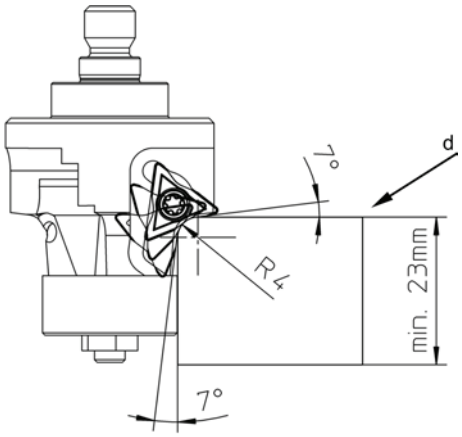
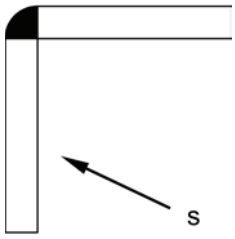
Multi-edge cutter mount plasma

Order No.	1484142	
Intended use	▪ Round off from plasma cut edges. ▪ Can also be used with spacer plate (1236998).	
Assembly	1. Select and install multi-edge cutter. Most suitable: R3 coated (1320639). 2. Fastened with screws 0353387. 3. Install multi-edge cutter mount. 4. Setting the chamfer size. 5. Lock into place with bracket. Usage: chamfer, radius, pipe and tube processing.	
Technical data	R radius R2, R3 c Max. angle 12° ▪ Impeller diameter approx. d = 15 / d = 20 mm **Note :** ▪ The impeller can not be used with other multi-edge cutter mounts because of its small inside diameter.	

Tab. 15

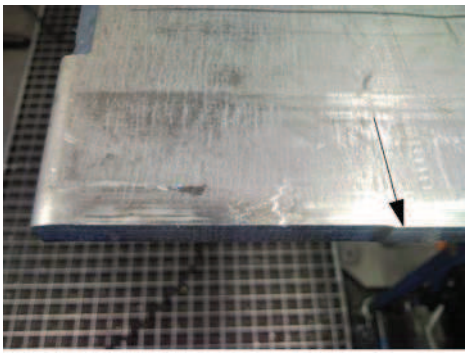
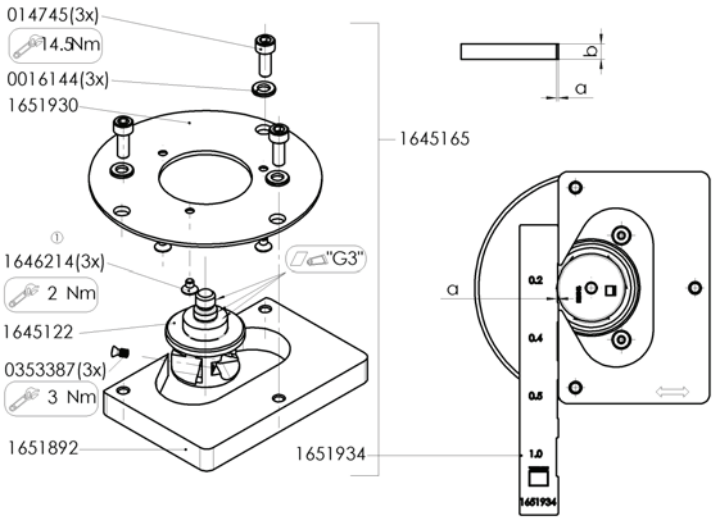
Multi-edge cutter mount R2 and R4 PLUS for corner weld processing

Order No.	R2 PLUS: 1265985 R4 PLUS: 1264577
Intended use	 ▪ Round off from weld seam R2 or R4. ▪ The spacer plate ensures workpiece support when burrs present. It can be clamped depending on the chamfer direction. ▪ Usage of a special impeller with larger diameter to eliminate angle errors is possible.
Assembly	 1 spacer plate (3 mm), 2 guard plate, 3 multi-edge cutter mount R2 and R4 PLUS 1. Release the spacer plate from the guard plate. 2. Clamp support plate between spacer plate/guard plate (set 1265501) and tighten (distance plate is parallel to the support plate). 3. Select multi-edge cutter mount. 4. Install the 3 multi-edge cutter R PLUS (1266783) with 3 screws (0353387). 5. Install multi-edge cutter mount in TKA 500. 6. Set the height of the reference multi-edge cutter. 7. Lock in place with bracket. 8. Round off corner weld.

Technical data	 d Support plate position	 Material thickness: 1.5 - 3 mm (R2 PLUS). Material thickness: 3.0 - 5 mm (R4 PLUS).
	 Multi-edge cutter mount including special impeller	
	▪ Spacer plate h = 3 mm ▪ Guard plate h = 40 mm ▪ Impeller for R2 PLUS d = 29.5 mm (1266024) ▪ Impeller for R4 PLUS d = 26.9 mm (1264586) ▪ Impeller especially for R2 PLUS d = 30 mm (1294750) ▪ Impeller especially for R4 PLUS d = 27.5 mm (1294749)	

Tab. 16

Tool face edge

Order No.	1645165
Intended use	  ▪ Level face edge (see photo 2). ▪ Rotatable 360°.
Assembly	 1. Change support plate (1651930). 2. Attach support plate with 3 screws (1646214). 3. Select and install multi-edge cutter according to the material (3 screws 0353387). 4. Install multi-edge cutter mount in TKA 500. 5. Screw the support plate in deep enough and lock into place with a suitable bracket. 6. Set abrasion depth a with gauge (1651934) towards the cutting edge. 7. Tighten screws (014745).

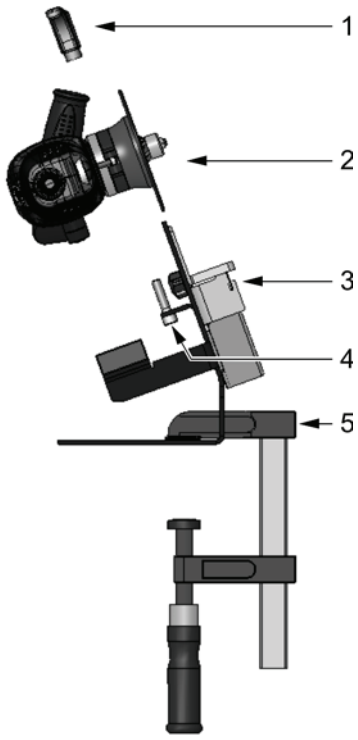
Technical data	▪ Back stop dimensions: 120 x 80 x 14 mm ▪ Adjustment gauge for 0.2, 0.4, 0.5 and 1 mm

Tab. 17

Abrasion	**TKA 500-0 / TKA 500 (1A1)**			
	230 V		110 V / 120 V	
Material **Material**	**a Cutting depth** **milling deepth** **max. mm**	**b Material thick-ness** **sheet thickness** **max. mm**	**a Cutting depth** **milling deepth** **max. mm**	**b Material thick-ness** **sheet thickness** **max. mm**
Steel 400 N/mm^2	0.5	8.0	0.5	8.0
Steel 600 N/mm^2	0.4	6.0	0.4	6.0
Steel 800 N/mm^2	0.2	4.0	0.2	4.0
Aluminum 250 N/mm^2	1.0	8.0	1.0	8.0

Tab. 18

Workstation for small parts

Order No.	1404742	
Intended use	▪ Bevel or round off small parts, on fixed TKA 500. ▪ Defined chip removal. **Note :** ▪ Use only with TKA 500 (restart protection).	
Assembly	1 Clamping lever for internal thread screw 2 TKA 500 3 Workstation 4 Screw 5. Screw clamps or pedestal 1. Pull out the mains plug. 2. Change clamping lever. 3. Push TKA 500 into the workstation. 4. Tighten screw. 5. Bevel/round off as per the operator's manual.	
Technical data	Minimum material thickness = 1 mm Workpiece dimensions: 50 x 50 mm (min.) - 300 x 300 mm (max.)	

Tab. 19

Strength	Maximum chamfer length without workstation in mm	Maximum chamfer length with workstation in mm
Steel 400 N/mm^2	5.0	3.0
Steel 600 N/mm^2	2.5	2.0
Steel 800 N/mm^2	1.5	1.0
Aluminum 250 N/mm^2	10	5.0

Tab. 20

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