

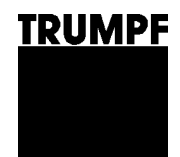
# Operating manual



## TruTool F 305 (1A1)

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english



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**Guarantee**

**Replacement parts list**

**Addresses**

# 1. Safety

- USA/CAN** ➤ Read the operating manual and the safety information (material no. 1239438, red document) completely before putting the machine into service. Follow the instructions strictly.

- Other countries** ➤ Read the operating manual and the safety information (material number 125699, red document) completely before putting the machine into service. Follow the instructions strictly.
- 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 from plug socket before undertaking any maintenance work at 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 earth leakage (EL) circuit breaker with a maximum release current of 30 mA when using the electric tool outside.
- 



**Warning**

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### Danger of injury due to improper handling!

- When working with the machine, wear safety glasses, hearing protection, protective gloves and work shoes.
  - Do not insert the plug unless the machine is switched off. After use, pull out the power plug.
- 



**Warning**

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### Risk of injury to hands!

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



**Caution**

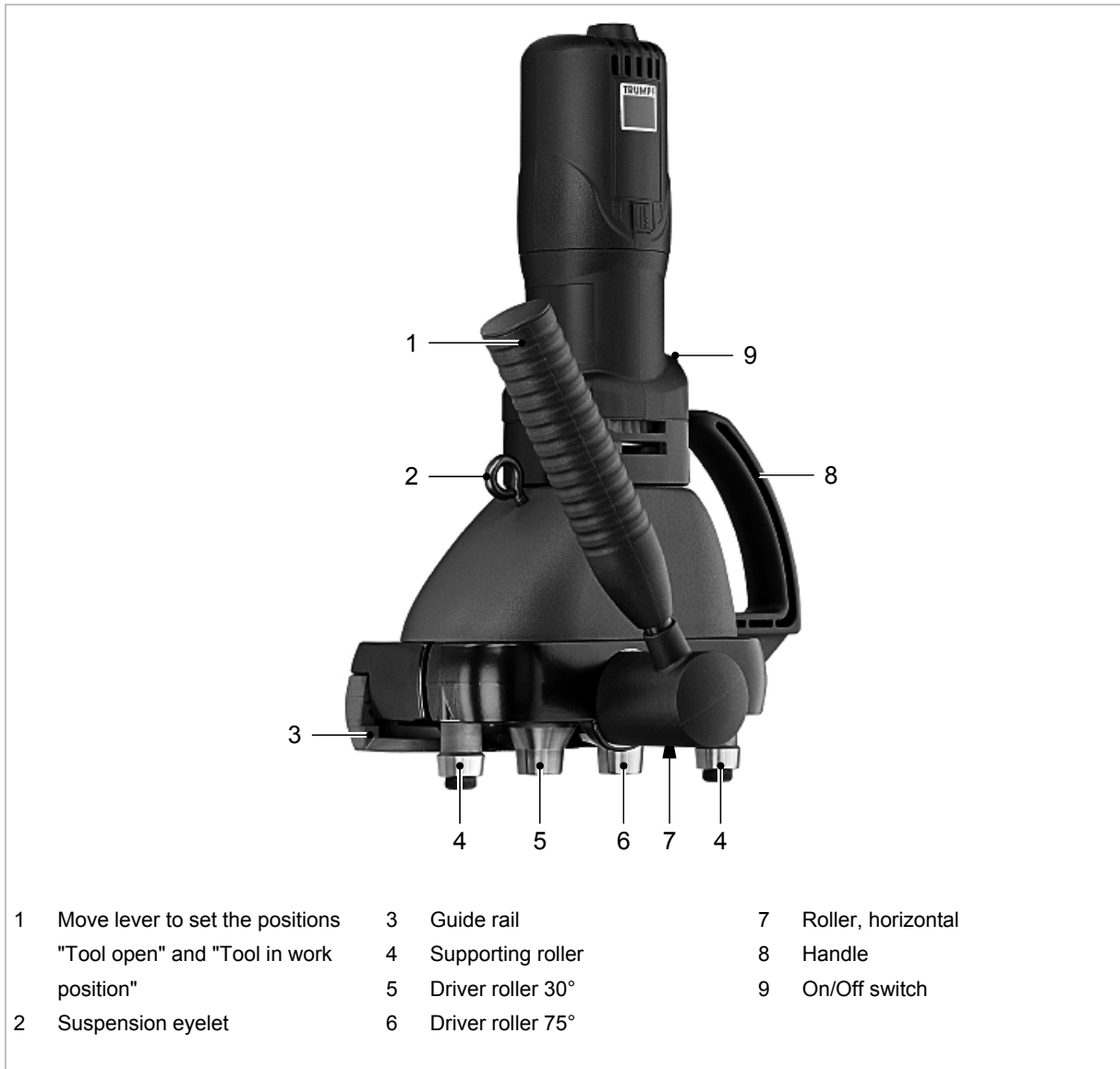
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### Damage to property due to improper handling!

#### Machine will be damaged or destroyed.

- Do not use the power cable to carry the machine.
  - Always lead the cable backwards, away from the machine and do not pull it over sharp edges.
  - Have servicing and inspections of hand-held electric tools carried out by a qualified specialist. Only use original accessories provided by TRUMPF.
-

## 2. Description



Folding closer TruTool F 305

Fig. 46684



## 2.1 Intended use



### Warning

#### Danger of injury!

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

The TRUMPF TruTool F 305 lock seam closer is an electrical hand-held device used for the following applications:

- Closing of Pittsburgh lock joints on correspondingly pre-machined workpieces, e.g. ventilation ducts, housings, containers, etc.
- Machining of all lock seam elevations.
- Closing of the lock seams on straight or curved contours.
- Automatic adjustment to the sheet thickness.

## 2.2 Technical data of the TruTool F 305

	Other countries			USA
	Values	Values	Values	Values
<b>Voltage</b>	230 V	120 V	110 V	120 V
<b>Frequency</b>	50/60 Hz	50/60 Hz	50 Hz	50/60 Hz
<b>Material tensile strength 400 N/mm<sup>2</sup></b>	0.45-0.75 mm	0.45-0.75 mm	0.45-0.75 mm	26-22 GA 0.018-0.029 in
<b>Working speed</b>	4-7 m/min	4-7 m/min	4-7 m/min	13-23 ft/min
<b>Nominal power consumption</b>	500 W	500 W	500 W	500 W
<b>Idle speed n<sub>0</sub></b>	160/min	160/min	160/min	160/min
<b>Weight</b>	5.2 kg	5.2 kg	5.2 kg	11.5 lbs
<b>Protective insulation</b>	Class II	Class II	Class II	Class II

Technical data

Table 1

Noise and vibration	Measured values according to EN 60745
A-class sound pressure level	Typically 81 dB (A)
A-class acoustic power level	Typically 85 dB (A)
Hand-arm vibration	Typically less than or equal to 2.5 m/s <sup>2</sup>

Measured noise and vibration values

Table 2



**Note**

The measured values specified above may be exceeded while working.

**"Pittsburgh lock seam" geometry**

Sheet thickness range		Height of flange
[mm]	[Gauge]	
0.45 - 0.75	26-22	 <p>B    Height of flange 5 mm/0.197 in</p>

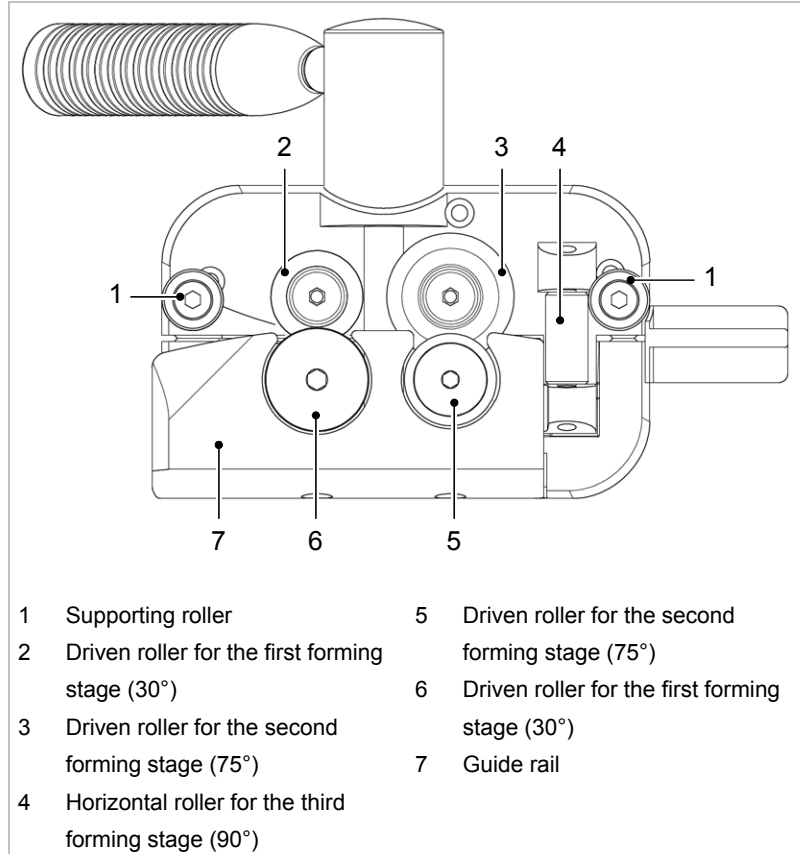
Table 3

**Note**

The lock seam quality depends essentially on the height of the flange B. If B is too small, then the lock seam cannot be properly closed.



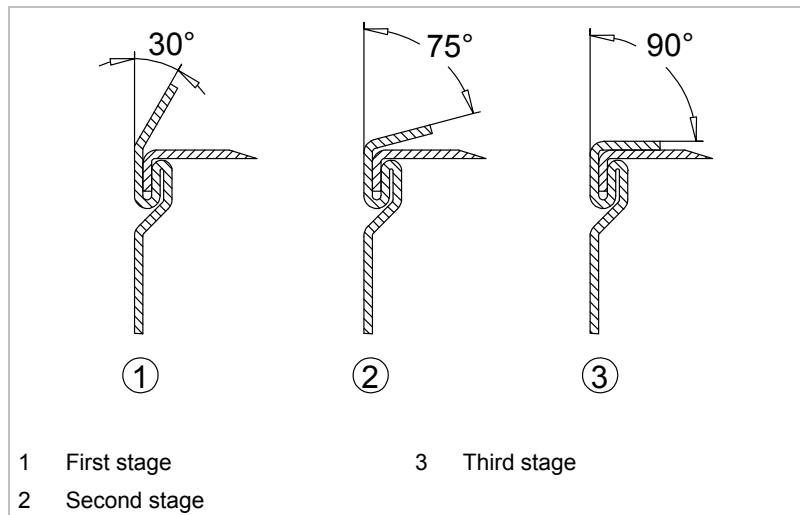
**Roller arrangement**



View of the machine from below: roller arrangement

Fig. 46685

**Folding process sequence**



Folding process

Fig. 13416

**Note**

The reforming of the of the takes place in three stages.

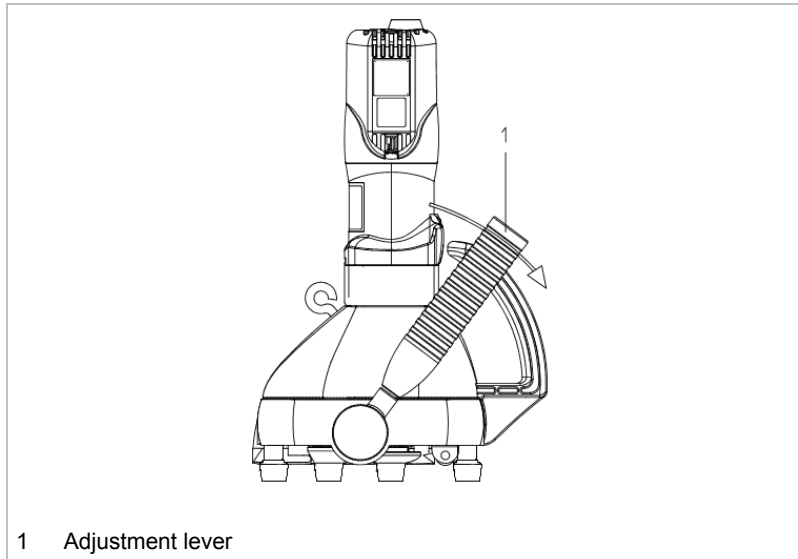
### 3. Setting work

#### 3.1 Setting the tool

The clearance between the rollers and the guide rails can be locked into place in two positions in order to be able to place the machine at the desired position of the channel (and) to be able to remove it from the machining position at the end of the channel:

- Lever (1) in position against the direction of feed: Tool open.
- Move lever (1) in direction of feed in end position: Tool in work position.

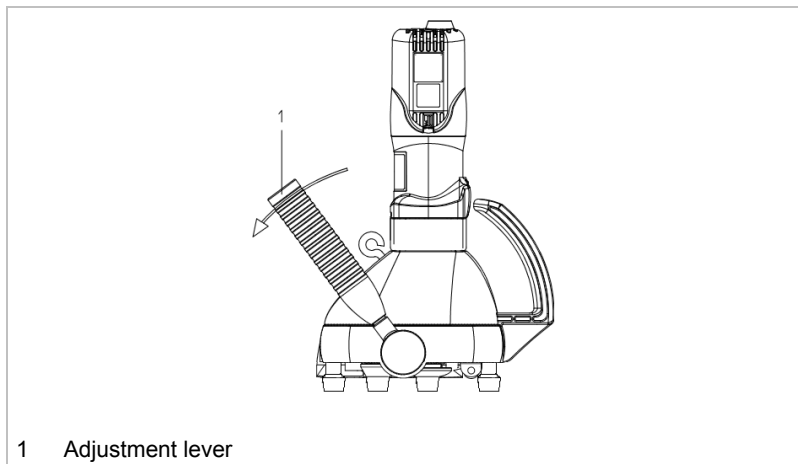
##### Tool open



Tool open

Fig. 46686

##### Tool in work position



Tool in work position

Fig. 46687

##### Note

No adjustment for sheet thickness is required because the machine automatically adjusts itself to the sheet thickness.

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## 4. Operation



**Caution**

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### **Damage to property due to high power-supply voltage!**

#### **Motor damage**

- Check the power supply voltage. The power supply voltage must correspond to the information on the type plate of the machine.
- 



**Warning**

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### **Danger 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 operate the machine away from your body.
  - Do not operate the machine above your head.
- 

### 4.1 Working with the TruTool F 305

#### **Switching on the TruTool F 305**

- Move the On/Off switch downwards.

#### **Operating the TruTool F 305**

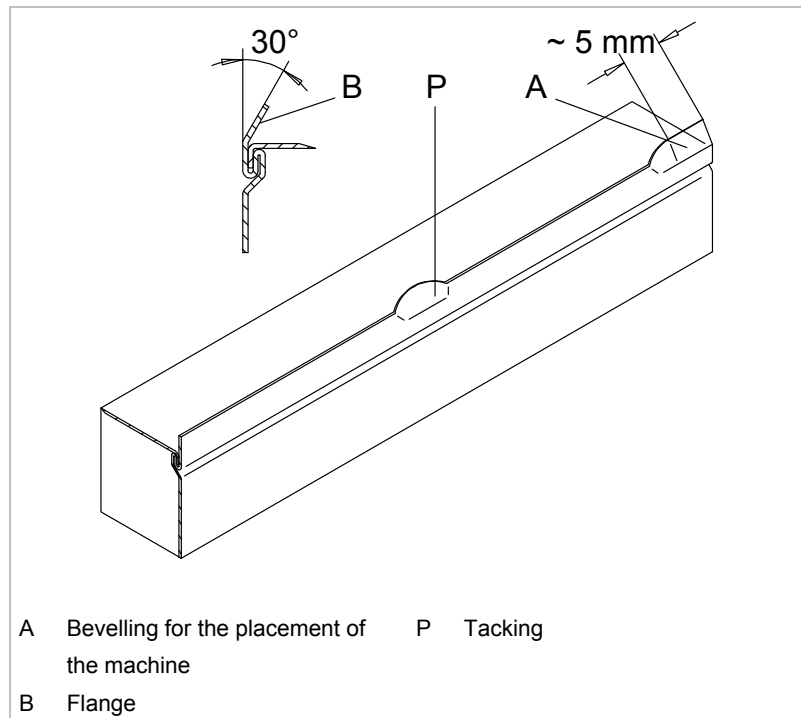
In order to improve work results, lightly oil the rollers or the tool with universal oil (Order No.138648).

Depending on the construction type of the channel to be machined, a distinction is made between two possible ways of commencing work:

- Channel open.
- Flange at the beginning of the channel.

**Channel open** Bevel the web at the beginning of the channel approximately 30° for a length of approximately 5 mm.

**Lock seam preparation**



Lock seam preparation

Fig. 13411

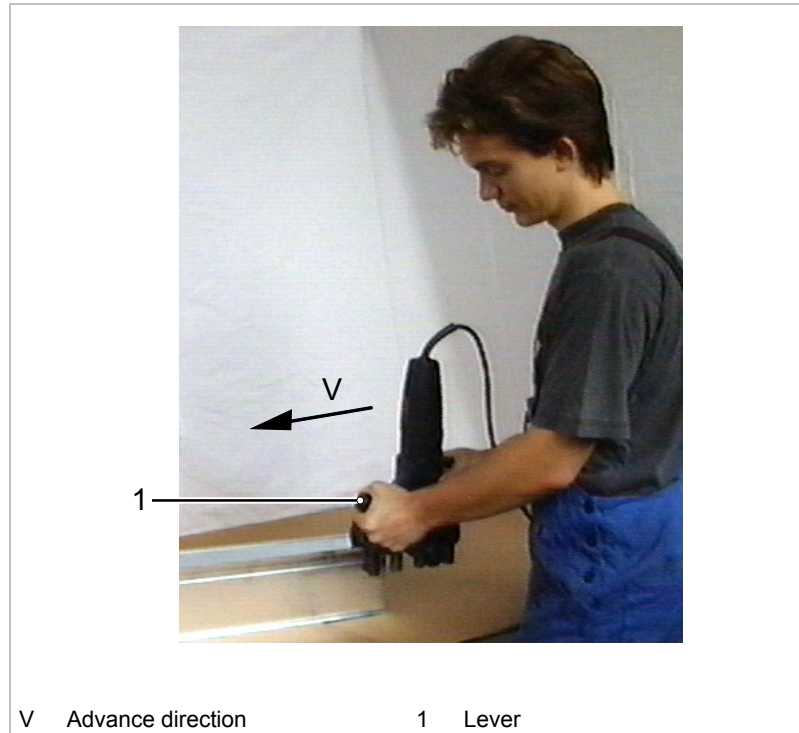


Fig. 13415

1. Move lever (1) in end position in direction of feed (tool in work position).
2. Switch on machine and place against the beginning of the channel.  
The curved guide rail ensures a simple placement of the machine at the beginning of the machining process.
3. The machine is drawn through the driving rollers in the feed direction, meaning that lock seam closure takes place.

### Flange at the beginning of the channel

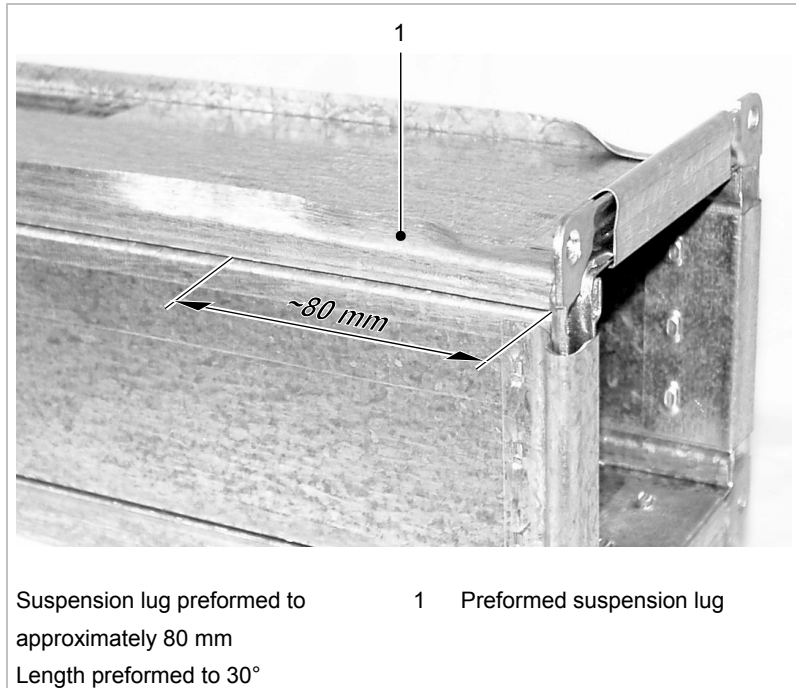


Fig. 18183

The machine cannot be placed up against the beginning of the channel.

Preparation of the channel so that the machine can be brought into position.

1. Move lever (1) into position against the direction of feed (Tool open).
2. Set machine up against desired (prepared) position on the channel.
3. Position lever (1) in direction of feed. (Tool in work position).  
The working direction (direction of feed) of the machine is determined by its design.
4. Switch on the machine.
5. Close the lock seam.
6. Move lever (1) into "tool open" position.
7. Switch off machine and remove from the machining position.

#### Note

A minor refinishing operation (length approximately 130 mm) must be carried out manually at the end of the channel following the use of the lock seam closer.

### Switching off the TruTool F 305

- Move the On/Off switch upwards.

## 5. Maintenance



**Warning**

**Danger of injury due to the improper conduction of repair work!**

**Machine does not work properly.**

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

Maintenance point	Procedure and interval	Recommended lubricant	Lubricant order no.
Guide rail and driving pinion	Clean with a steel brush and apply a light coating of oil every 10 operating hours	Universal oil	0138648
Gearbox and gear head (2)	After 300 operating hours, arrange for a trained specialist to relubricate or to replace the lubricating grease.	Lubricating grease "G1"	0139440
Ventilation slots	Clean as needed	-	-

Maintenance points and maintenance intervals

Table 4

### 5.1 Replacing carbon brushes

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

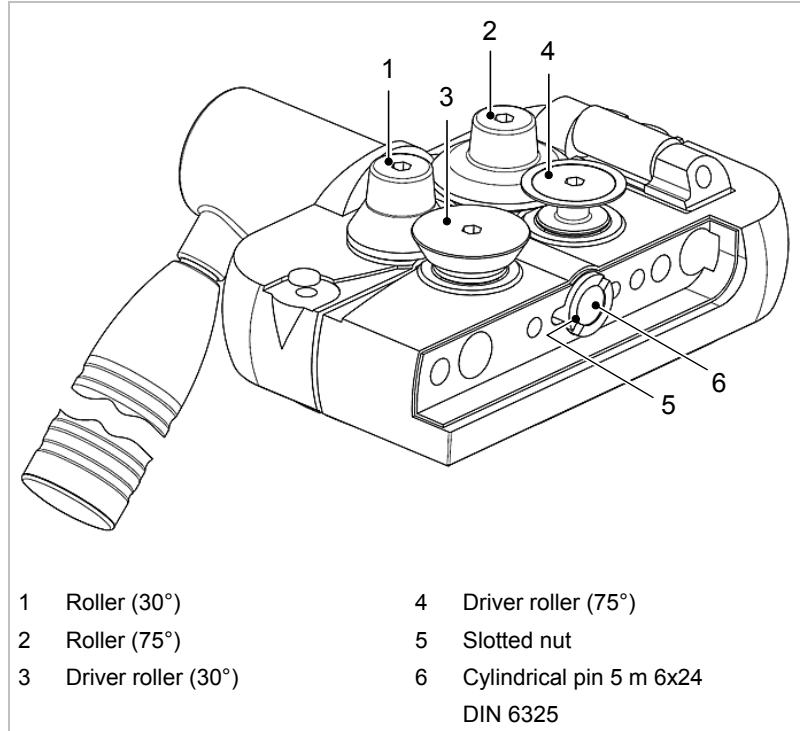
- Have the carbon brushes checked and replaced as required by a qualified specialist.

**Note**

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

## 5.2 Tightening screws with turning moment

If parts of the machine are disassembled, be sure that the screws and nuts are tightened with the right torque when the machine is reassembled.



View of the seam locker TruTool F 305 from below; the guide rail and the supporting rollers have been disassembled.

Fig. 46688

No.	Components	Torque	Threaded nut retention
1	Roller (30°)	24 Nm	Loctite 262
2	Roller (75°)	24 Nm	Loctite 262
3	Driver roller (30°)	24 Nm	-
4	Driver roller (75°)	24 Nm	-
5	Slotted nut	6 Nm <sup>1</sup>	Loctite 262
6	Cylindrical pin 5 m 6x24 DIN 6325	-	-

Table 5

<sup>1</sup> Locking mechanism must be closed.

## 6. Original accessories and wearing parts

Designation	Supplied original accessories	Wearing parts	Options	Order no.
Guide rail	+	+		920881
Driver roller 30°	+	+		145769
Driver roller 75°	+	+		135478
Roller (horizontal)	+	+		135791
Suspension eyelet	+			107666
Allen key DIN 911-4	+			067849
Universal oil (0.1 liter)	+			138648
Case	+			982582
Operating manual	+			1369682
Safety information (red document), other countries	+			125699
Safety information (red document), USA	+			1239438

Original accessories, wearing parts and optional items

Table 6

### 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.

