

# Operator's manual



## TruTool PN 130 (1A1)

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english

**TRUMPF**





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# 1. Safety

## 1.1 General safety information



- Read the operator's manual and safety information in their entirety before starting up the machine. Closely 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.

Tab. 1



**Danger**

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

- Keep the machine dry and do not operate it in damp rooms.
  - Check the plug, cable and machine for damage each time before using the machine.
  - Always lay the electrical cable away from the back of the machine and do not pull it over sharp edges.
  - Connect the earth leakage (EL) circuit breaker with a maximum release current of 30 mA when using the electric tool outside.
  - Pull the plug out of the socket whenever tools have to be replaced or prior to maintenance work on the machine.
-



**Warning**

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**Read all safety warnings (order no. 0125699) and all instructions!**

- Failure to follow the warnings and instructions may result in electric shock, fire and/or serious injury.
- 



**Warning**

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**Risk of injury due to improper handling.**

- Wear safety glasses, hearing protection, protective gloves and work shoes when working at the machine.
  - Have servicing and inspections of hand-held electric tools carried out by a qualified specialist. Only use original accessories provided by TRUMPF.
- 

## 1.2 Specific safety information



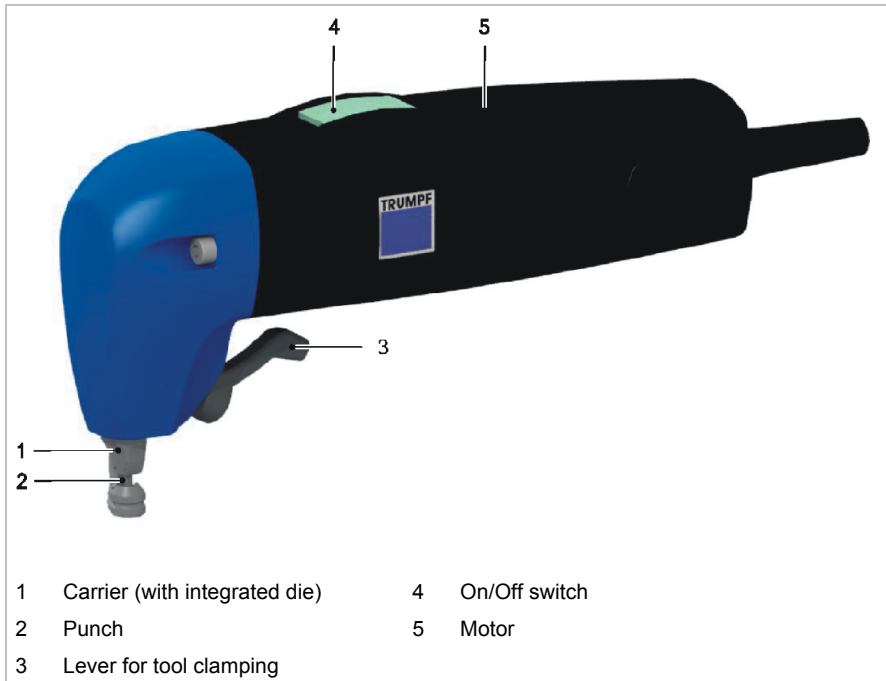
**Warning**

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**Risk of injury to hands**

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

## 2. Description



TruTool PN 130

Fig. 52866

## 2.1 Intended use



### Warning

#### Risk of injury

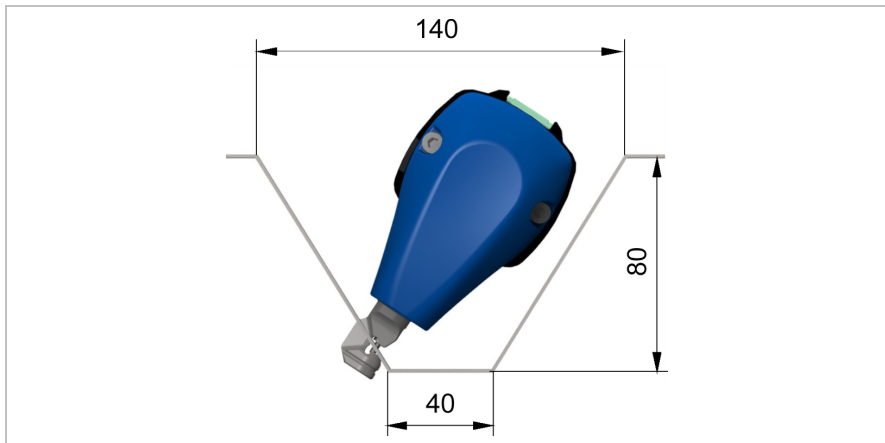
- Only use the machine for work and materials described in "Intended use."

The TRUMPF Nibbler TruTool PN 130 is a handheld electric tool used for the following applications:

- For slitting sectional sheets such as trapezoidal sheet, corrugated sheet, boxed sheet, offset profiled strips.
- Slitting plate-shaped workpieces made of a punchable material such as steel, aluminum, non-ferrous heavy metals, and plastic.
- Nibbling straight or curved exterior and interior cutouts.
- For nibbling from scribed lines.

#### Note

The nibbling process produces cutting edges free of deformations.



TruTool PN 130 in sectional sheets

Fig. 52873

## 2.2 Noise and vibration information



**WARNING**

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### **Vibration emission value may be exceeded.**

- Select tools correctly and replace them promptly when they show wear.
  - Have maintenance and repair work performed by trained specialist technicians.
  - Establish additional safety precautions for the protection of the operator against the effects of vibrations (e.g. keeping hands warm and organizing the work sequences).
- 



**WARNING**

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### **Noise emission value may be exceeded.**

- Wear hearing protection.
- 

### **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 the device is switched off or running but not actually in use can considerably reduce the vibration load during the entire working period.



Designation of measured value	Unit	Value in accordance with EN 60745
Vibration emission value $a_h$ (vector sum of three directions)	$m/s^2$	8.7
Uncertainty K for vibration emission value	$m/s^2$	1.5
A-class acoustic pressure level $L_{PA}$ typically	dB (A)	80
A-class acoustic power level $L_{WA}$ typically	dB (A)	91
Uncertainty K for noise emission value	DB	3

Tab. 3

## 2.3 Technical data of the TruTool PN 130

	Other countries			USA
	Value	Value	Value	Value
<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>Maximum thickness of the material</b>				
<b>Steel 400 N/mm<sup>2</sup></b>	1.3 mm			0.051 in
<b>Steel 600 N/mm<sup>2</sup></b>	0.8 mm			0.031 in
<b>Aluminum 250 N/mm<sup>2</sup></b>	2.0 mm			0.078 in
<b>Working speed</b>	3.2 m/min			10.5 ft/min
<b>Starting hole diameter</b>	15 mm			0.591 in
<b>Radius (hole)</b>	25 mm			0.98 in
<b>Nominal power consumption</b>	350 W			350 W
<b>Idle stroke rate</b>	3650 1/min			3650 1/min
<b>Weight</b>	1.4 kg			3.1 lbs
<b>Cutting track width</b>	5 mm			0.197 in
<b>Protective insulation</b>	Class II			Class II

Table 2

### 3. Setting work

#### 3.1 Select tool

Two tool configurations are available for machining work:




	Standard tool	Tool S
<b>Application</b>	Tool for all applications.	Tool for exact and clean cuts (slow feed).
<b>Identification</b>	-	Yellow-coated. With recognition groove under the punch head.
<b>Punch</b>		
<b>Carrier</b>		

Table 3

**Note**

Before processing the workpiece, coat the cutting track with oil. In this way:

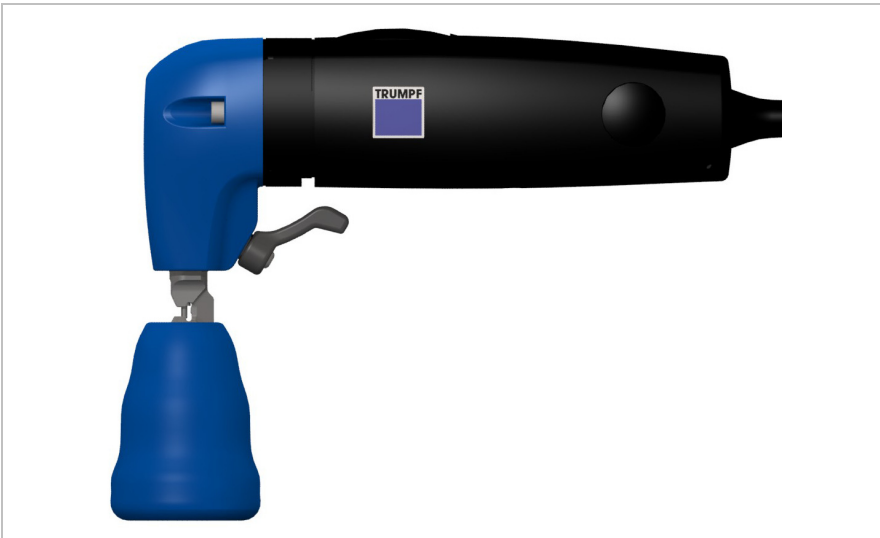
- The cutting result is improved.
- The service life of the tools is increased.

Material	Oil
Steel	Punching and nibbling oil (0.5 l, order no. 103387)
Aluminum	Wisura oil (1 l, order no. 125874)

Table 4

## 3.2 Chip bag (optional)

A chip sack can be used to intercept the chips.



TruTool PN 130 with chip bag

Fig. 52868

## 4. Operation



### Warning

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#### Risk of injury 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 move the machine during work away from your body.
  - Do not operate the machine above your head.
- 

### Switch on

- Shift the On/Off switch forwards.

### Working with TruTool PN 130

1. Do not move the machine towards the workpiece until full speed has been reached.
2. Machine the material.  
Machine the desired cutting line
3. In the event that the cutting track ends in the sheet, pull the machine (still running) a few millimeters back towards where the cutting track has already been cut open.
4. Switch the machine off.

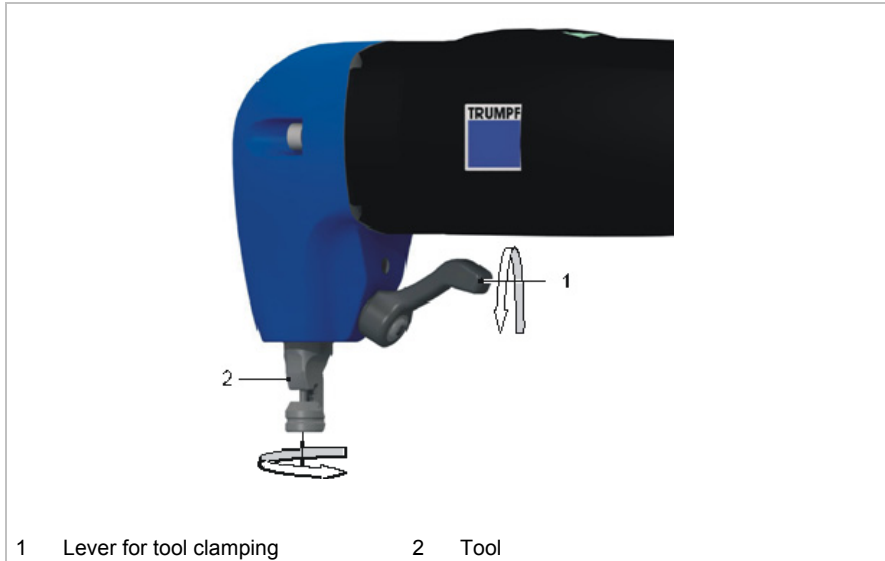
### Switching off

- Shift the On/Off switch to the rear.

## 4.1 Changing the cutting direction

If necessary, the direction of cutting can be turned to the right or left in 8 indexed positions (every 45°) or freely.

- Adjust for right-handed/left-handed operation.
- Machining sectional sheets.



1 Lever for tool clamping

2 Tool

Changing the cutting direction

Fig. 52867

1. Release the lever (1) for tool clamping (½ turn).
2. Turn the tool (2) to the desired direction.
3. Retighten the lever (1) (parallel to the motor).

## 4.2 Making inner cutouts

- Make a start hole at least 15 mm in diameter.

## 5. Maintenance



**Danger**

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### Risk of fatal injury from electric shock

- Pull the plug out of the socket whenever tools have to be replaced or prior to maintenance work on the machine.
- 



**Warning**

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### 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.
- 



**Caution**

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### Damage to property caused by blunt tools!

#### Machine overload.

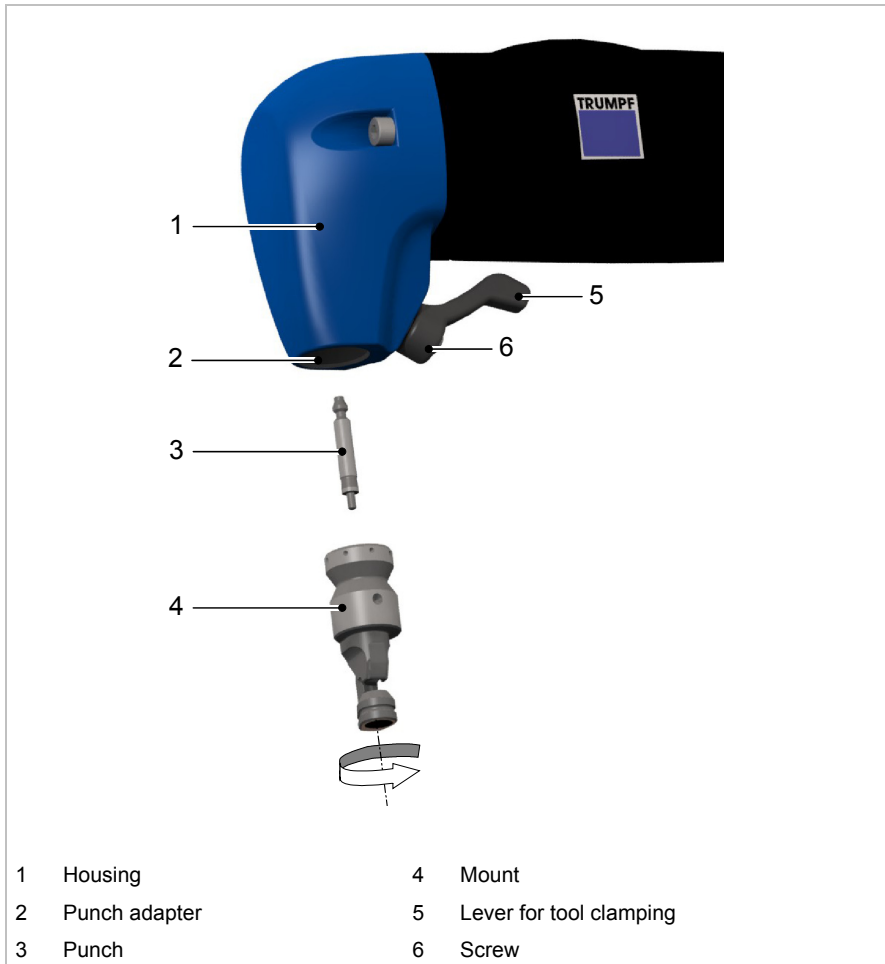
- Check the cutting edge of the cutting tool hourly for wear. Sharp cutting tools provide good cutting performance and are easier on the carrier and the machine. Replace punches promptly.
- 

Maintenance point	Procedure and interval	Lubricant
Carrier (punch guide)	Replace as necessary. Lubricate upon tool change.	Lubricating grease "G1" (order no. 0344969)
Punch	Replace as necessary.	-
Ventilation slots	Clean as needed.	-
Gearbox and gear head	After 300 operating hours, have a trained specialist relubricate or replace the lubricating grease.	Lubricating grease "G1" (order no. 0344969)

Maintenance table

Table 5

## 5.1 Replacing the tool



Replacing the tool

Fig. 52864

➤ Change dull punches and/or carriers.

### Note

Dull punches cause the carrier to break.



### Disassembling the punch

1. Release the lever (5) by at least three revolutions.
2. Pull carrier (4) out of the housing (1).
3. Remove punch (3).

### Installing the punch

1. Lubricate the punch (3) and carrier (4) with lubricating grease "G1".
2. Hang the punch (3) in the groove of the punch holder (2).
3. Insert the carrier (4) into the housing (1).
4. Tighten the lever (5).

### Changing carrier

1. Release the lever (5) by at least three revolutions.
2. Pull out carrier (4).
3. Insert the new carrier (4) into the housing (1).
4. Tighten the lever (5).

## 5.2 Readjusting the lever

The position of the lever can be readjusted as needed.

1. Tighten the lever (5).
2. Release the screw (6) on the lever.
3. Pull off the lever (5) and clean it.
4. Align the lever (5) parallel to the motor and retighten the screw (6).

### 5.3 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 specifications on the type plate.

## 6. Original accessories and wearing parts

Designation	Original accessories	Wearing parts	Options	Order no.
Punch	+	+		1439361
PunchS		+	+	1443568
Carrier	+	+		1439360
Case	+			1452926
Operator's manual	+			1444881
Safety information	+			0125699
Punching and nibbling oil for aluminum (1 l)			+	0125874
Punching and nibbling oil for steel (0.5 l)			+	0103387
Chip bag			+	1460314
Lubricating grease "G1"			+	0344969

Table 6

**Ordering wearing parts**

1. Specify the order number.
2. Enter further order information:
  - 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.  
For TRUMPF service addresses, see [www.trumpf-powertools.com](http://www.trumpf-powertools.com).

