

TRUMPF deburrers:

Save time –
in a
single step.

In the construction of machines, rail cars and ships, TRUMPF deburrers are just as established as in steel working, job shops for sheet metalworking or in other metalworking shops. The TruTool TKA let you produce either straight bevelled or radius edges. You can also break or round sharp edges or make flawless bevels at a variety of angles. And you can do all that without any refinishing, burr- and oxide-free, with precision and high quality you can easily see. For radii and interior contours, cut ends or for welding preparation.



The right tool for every angle.

We offer a large variety of standard cutter mounts that enable you to produce angles from 15° up to 60°. Our standard cutter mount product line also includes a 0° cutter mount that can be used for cutting short edges and a plasma cutter mount for rounding off plasma-cut edges.

And when you want to make rounded edges with 2, 3 or 4 mm radii, the R cutter mount is the perfect accessory.

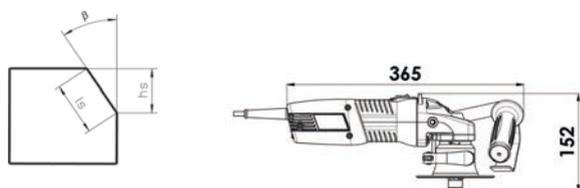
Particular strengths:

- Fast, emission-free process
- Clean, oxide-free edge surfaces
- Accurate, constant edge quality in one step
- Ideal for complex workpieces as well as for interior contours, bores and tubes
- Tool-free adjustment of the bevel height
- No sparks
- Can handle small parts (with workstation)



Bevelling Deburrers (power tools)

TruTool TKA 500



- 3-cutter tool system
- 30°, 45° and 60° as well radius edges
- Optional cutter mounts for 15° – 55° available

Accessories TruTool TKA 500

Included accessories

| | | |
|--|------|------------|
| 3 cutters CR | | integrated |
| Cutter mount 45° with integrated blade wheel | | integrated |
| Head key wrench | | 0353531 |
| TORX – screwdriver | TX15 | 0353793 |
| Single head wrench | | 0068012 |
| Socket wrench | | 1241272 |
| Protective eyewear | | 0944950 |
| TRUMPF Box | | included |

Available accessories

| | | |
|---|---------------------|----------------------|
| Cutter mount 45° with integrated blade wheel Ø 22 mm for 3 cutters | | 1227954 |
| Cutter mount 30° with integrated blade wheel Ø 29.6 mm for 3 cutters | | 1237683 |
| Cutter mount 60° with integrated blade wheel Ø 22 mm for 3 cutters | | 1257861 |
| Cutters ST | (set of 3, 1241780) | (set of 10, 1232627) |
| Cutters ST Radius 2 | (set of 3, 1693743) | (set of 10, 1232676) |
| Cutters ST Radius 3 | (set of 3, 1693742) | (set of 10, 1232671) |
| Cutters CR | (set of 3, 1241851) | (set of 10, 1232628) |
| Cutters CR Radius 2 | (set of 3, 1693744) | (set of 10, 1232691) |
| Cutters Aluminium | (set of 3, 1241852) | (set of 10, 1232629) |
| Cutters R2 PLUS ST | (set of 3, 1266783) | (set of 10, 1266784) |
| Cutter ST Radius 4 | (set of 3, 1693629) | (set of 10, 1630310) |
| Cutter R3 coated (for plasma application and ST) | (set of 2, 1320642) | |

Technical Data TruTool TKA 500

(for 15°, 20°, 25°, 35°, 40°, 50° and 55° please check sales manual)

| | | 230 V | | | 110 V | | |
|----------------------------------|-------|-------|-------|-------|-------|-------|-------|
| | | 30° | 45° | 60° | 30° | 45° | 60° |
| Bevel angles | | | | | | | |
| Max. bevel height | | | | | | | |
| Steel 400 N/mm ² | mm | 4.3 | 3.5 | 2.5 | 3.5 | 2.8 | 2.0 |
| = bevel length | mm | 5.0 | 5.0 | 5.0 | 4.0 | 4.0 | 4.0 |
| Steel 600 N/mm ² | mm | 2.2 | 1.8 | 1.3 | 1.9 | 1.6 | 1.1 |
| = bevel length | mm | 2.5 | 2.5 | 2.5 | 2.2 | 2.2 | 2.2 |
| Steel 800 N/mm ² | mm | 1.3 | 1.0 | 0.8 | 1.1 | 0.9 | 0.7 |
| = bevel length | mm | 1.5 | 1.5 | 1.5 | 1.3 | 1.3 | 1.3 |
| Aluminium 250 N/mm ² | mm | 6.5 | 6.4 | 5.0 | 6.5 | 6.0 | 4.3 |
| = bevel length | mm | 7.5 | 9 | 10 | 7.5 | 8.5 | 8.5 |
| Min. sheet thickness | mm | 0.7 | 0.7 | 0.7 | 0.7 | 0.7 | 0.5 |
| Smallest inner radius | mm | 16 | 12 | 12 | 16 | 12 | 12 |
| Working speed | m/min | 3 – 4 | 3 – 4 | 3 – 4 | 3 – 4 | 3 – 4 | 3 – 4 |
| Rotational speed at idling 1/min | | 8390 | 8390 | 8390 | 7300 | 7300 | 7300 |
| Rated input power | W | 1400 | 1400 | 1400 | 1140 | 1140 | 1140 |
| Weight without cable | kg | 3.5 | 3.5 | 3.5 | 3.5 | 3.5 | 3.5 |

Accessories TruTool TKA 500

Further options

| | |
|---|---------|
| Cutter mount R with integrated blade wheel Ø 20 mm for 3 cutters | 1663473 |
| Cutter mount R2 PLUS*1 with blade wheel | 1265985 |
| Cutter mount R4 PLUS*2 with blade wheel | 1264547 |
| Cutter mount 15° with integrated blade wheel Ø 29.6 x 11.6 mm (h) for 3 cutters | 1412639 |
| Cutter mount 20° with integrated blade wheel Ø 29.6 x 11.6 mm (h) for 3 cutters | 1619933 |
| Cutter mount 25° with integrated blade wheel Ø 29.6 x 11.6 mm (h) for 3 cutters | 1419177 |
| Cutter mount 35° with integrated blade wheel Ø 29.6 x 12.3 mm (h) for 3 cutters | 1256570 |
| Cutter mount 40° with integrated blade wheel Ø 29.6 x 12.3 mm (h) for 3 cutters | 1620265 |
| Cutter mount 50° with integrated blade wheel Ø 22 x 12.5 mm (h) for 3 cutters | 1429605 |
| Cutter mount 55° with integrated blade wheel Ø 22 x 12.5 mm (h) for 3 cutters | 1251684 |
| Cutter mount R 2-sided plasma with integrated blade wheel | 1484142 |
| Special wheel for cutter mount R2 Plus | 1294750 |
| Special wheel for cutter mount R4 Plus | 1294749 |
| Blade wheel for thin sheet metal, 45° – 60° Ø 22 x 14.5 mm | 1237451 |
| Supporting plate small Ø cpl. | 1315258 |
| Front edge cutter mount | 1645165 |
| Deburring plate | 1236998 |
| Chip box | 1236997 |
| Punch and nibble oil for steel 500 ml bottle | 0103387 |
| Punch and nibble oil for aluminium 1000 ml bottle | 0125874 |
| Grease «G3». Tube 100 g | 0353969 |
| Distance plate and safety plate | 1265501 |
| Work station, for the treatment of small pieces | 1404742 |

*1 For welded edge radius 2 mm, sheet thickness ca. 1.5 mm to 2.5 mm

*2 For welded edge radius 4 mm, sheet thickness ca. 2.5 mm to 5.0 mm

Bevelling Deburrers (power tools)



Cutter mount with integrated blade wheel

Cutter mount of 15° - 60° (in 5 steps) available
Cutter mount for plasma application R2 LUS and R4 PLUS for welded edge



Cutters

Can be used for processing steel, aluminium and plastic, suitable for processing edges 0°, 15° to 60°



Anti-scratch sheets

For non-scratch processing



Blade wheel for thin metal sheet

Up to min. 0.7 mm sheet thickness



Chip box

For processing on straight edges



Distance plate and safety plate



Deburring plate complete



Tool front edge



Supporting plate (small)

For narrow spaces, can be used for all cutter mounts



Work station

For small working pieces

TruTool TKA 500

TRUMPF



| | Cutter Steel 400 N/mm ² | Cutter Alu 250 N/mm ² | Cutter CR 800 N/mm ² | Cutter mount with integrated blade wheel | Blade wheel | | | |
|-------------------------------|---------------------------------------|-------------------------------------|------------------------------------|---|-------------------------------|-------------------------------|----------|--|
| | | | | | | | | |
| Bevel 15° | 1241780 (3x) 1232627 (10x) | 1241852 (3x) 1232629 (10x) | 1241851 (3x) 1232628 (10x) | 1412639 | ø 29.6 x 11.6 mm: 1414170 | | | |
| Bevel 20° | | | | 1619933 | | | | |
| Bevel 25° | | | | 1419177 | | | | |
| Bevel 30° | | | | | | | 1237683 | ø 29.6 x 12.3 mm: 1237495 |
| Bevel 35° | | | | | | | 1256570 | |
| Bevel 40° | | | | | | | 1620265 | |
| Bevel 45° | | | | | | | 1227954 | ø 22 x 12.5 mm: 1214439 Thin sheet metal ø 22 x 14.5 mm: 1237451 |
| Bevel 50° | | | | | | | 1429605 | |
| Bevel 55° | | | | | | | 1251684 | |
| Bevel 60° | | | | | | | 1257861 | |
| Bevel 0° | | | | | | | 1645122* | |
| Radius 2 | | | | | 1693743 (3x) 1232676 (10x) | 1693744 (3x) 1232691 (10x) | | ø 20 mm: 1227953 |
| Radius 3 | | 1693742 (3x) 1232671 (10x) | – | 1663473 | | | | |
| Radius 4 | | 1693629 (3x) 1630310 (10x) | – | | | | | |
| Radius 3 Plasma | 1320642 (2x) | – | – | 1484142 | ø 20/15 mm conical 1484526 | | | |
| Welded edge radius R2 PLUS | 1266783 (3x) 1266784 (10x) | – | – | 1265985 | ø 29/27 mm raised 1266024 | | | |
| Welded edge radius R4 PLUS | | – | – | 1264547 | ø 27/24 mm raised 1264586 | | | |

* Cutter mount without blade wheel

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(for 15°, 20°, 25°, 35°, 40°, 50° and 55° please check sales manual)

| | | 230 V | | | 110 V | | |
|---------------------------------|-------|-------|------|------|-------|------|------|
| | | 30° | 45° | 60° | 30° | 45° | 60° |
| Bevel angles | | | | | | | |
| Max. bevel height | | | | | | | |
| Steel 400 N/mm ² | mm | 4.3 | 3.5 | 2.5 | 3.5 | 2.8 | 2 |
| = bevel length | mm | 5 | 5 | 5 | 4 | 4 | 4 |
| Steel 600 N/mm ² | mm | 2.2 | 1.8 | 1.3 | 1.9 | 1.6 | 1.1 |
| = bevel length | mm | 2.5 | 2.5 | 2.5 | 2.2 | 2.2 | 2.2 |
| Steel 800 N/mm ² | mm | 1.3 | 1 | 0.8 | 1.1 | 0.9 | 0.7 |
| = bevel length | mm | 1.5 | 1.5 | 1.5 | 1.3 | 1.3 | 1.3 |
| Aluminium 250 N/mm ² | mm | 6.5 | 6.4 | 5 | 6.5 | 6 | 4.3 |
| = bevel length | mm | 7.5 | 9 | 10 | 7.5 | 8.5 | 8.5 |
| Min. sheet thickness | mm | 0.7 | 0.7 | 0.7 | 0.7 | 0.7 | 0.7 |
| Smallest inner radius | mm | 16 | 12 | 12 | 16 | 12 | 12 |
| Working speed | m/min | 3-4 | 3-4 | 3-4 | 3-4 | 3-4 | 3-4 |
| Rotational speed at idling | 1/min | 8390 | 8390 | 8390 | 7300 | 7300 | 7300 |
| Rated input power | W | 1400 | 1400 | 1400 | 1140 | 1140 | 1140 |
| Weight without cable | kg | 3.5 | 3.5 | 3.5 | 3.5 | 3.5 | 3.5 |