

OPERATION MANUAL 01/2025-WW

ps:® 3D-RTC

OPERATION MANUAL

ps:®3D-RTC

THANK YOU VERY MUCH,

for purchasing a **ps:®3D-RTC** cartridge from the system TRUMPF, developed and produced by PASS Stanztechnik AG.

It is our utmost intention to guarantee you a long-term service with your new PASS product.

Therefore, we have prepared a detailed operation manual for you including notes on technology requirements, application area, installation, drawing and parts list as well as cleaning and care.

Please feel free to contact us in any case of questions.

Yours

PASS Stanztechnik AG

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SAFETY

ps:®3D-RTC

A. WARRANTY AND LIABILITY

Before using the tools for the first time, it is recommended to read this operation manual carefully, as PASS Stanztechnik AG does not assume any liability for damages and malfunctions resulting from non-observance of this operation manual.

Please contact us by email if you require further information: sales@pass-ag.com.

Basically, the „General Terms and Conditions of Delivery and Payment“ of PASS Stanztechnik AG are to be obtained. These will be made available to the operator at the latest when the contract is concluded. Warranty and liability claims concerning personal injury and damage to property are excluded if they are due to one or more of the following causes:

- improper use of the tool
- improper assembly, disassembly and maintenance
- non-compliance with the instructions in the operation manual
- inadequate control of tools or tool parts subject to wear and non-observance of the prescribed maintenance intervals
- improperly performed repairs
- disasters caused by foreign objects and force majeure

Furthermore, when using tools from PASS Stanztechnik AG, the standards, regulations and laws applicable in the respective country must be observed.

B. GENERAL SAFETY INSTRUCTIONS



Risk of cuts and bruises!

Working without approved protective work clothing can result in cuts and bruises.



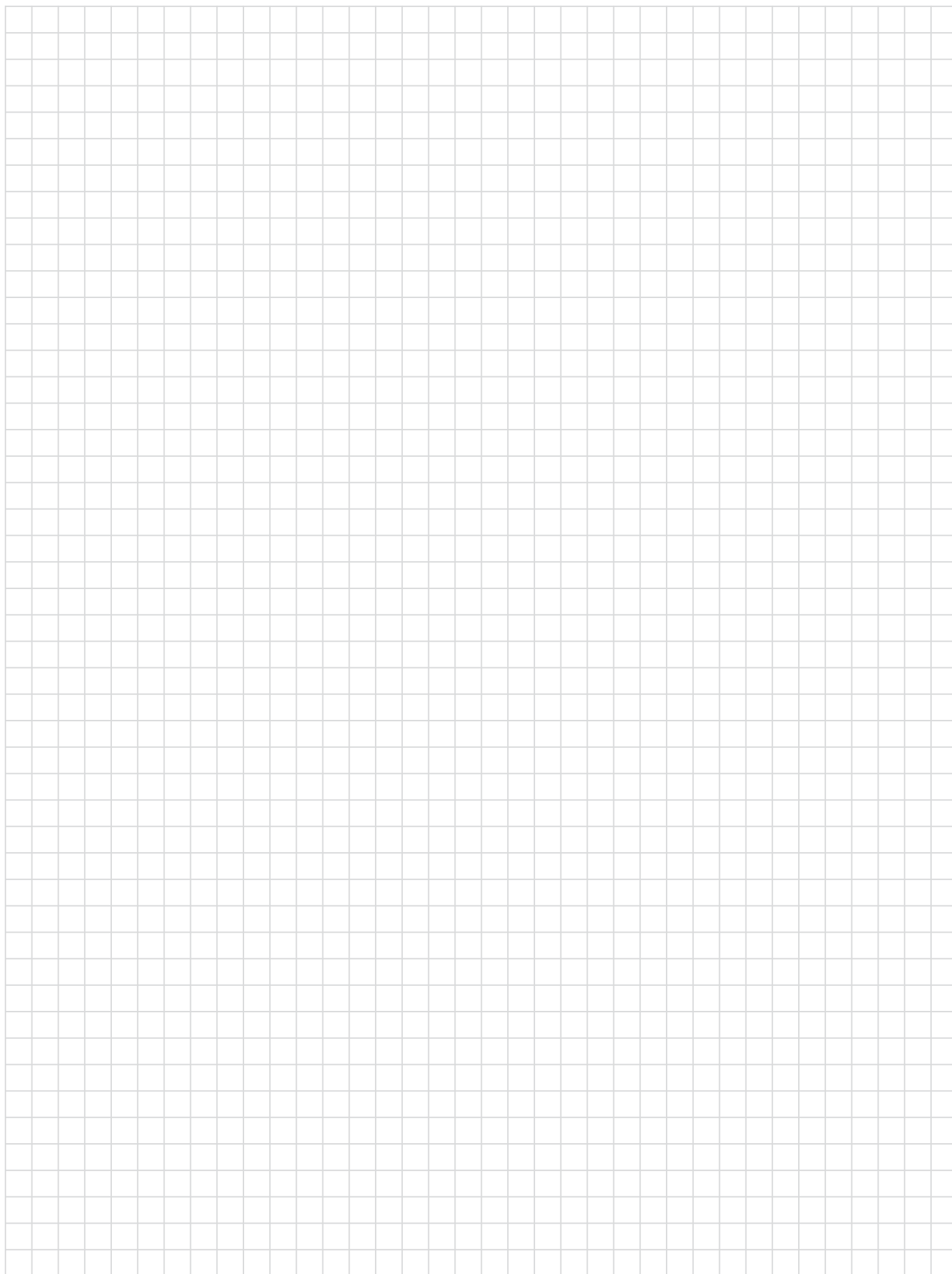
Therefore, always wear suitable protective clothing such as work shoes and work gloves to avoid injuries.



Danger of ejected metal shavings!

When grinding tools, there is an increased risk of injury from flying metal chips.

Always wear safety goggles when working to prevent eye injury.



CARTRIDGE PLASTIC SIZE 2

ps:®3D-RTC

A. TECHNOLOGY REQUIREMENTS

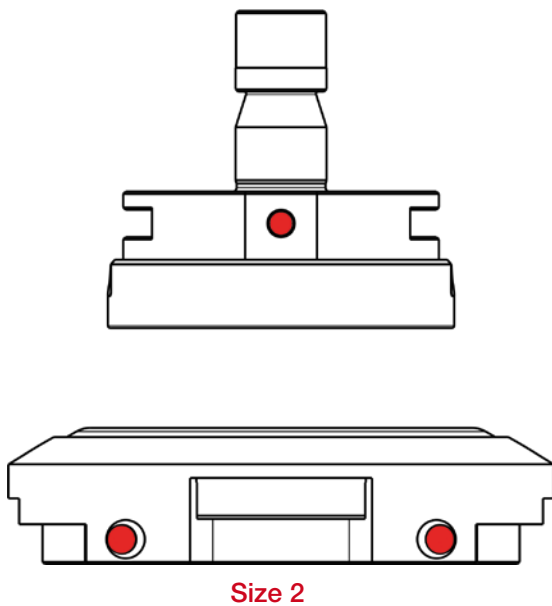
Machines

Usable for machine group I:

- TruPunch 1000/2000/2020/3000/5000
- TruMatic 1000/3000/6000/7000

B. APPLICATION AREA

- The **ps:®3D-RCT** cartridge plastic size 2 are intended exclusively for use with size 2 tools.
- The definition of whether it is a size 2 tool is determined by the locating holes on the adjusting rings and on the die plate.



C. INSTALLATION

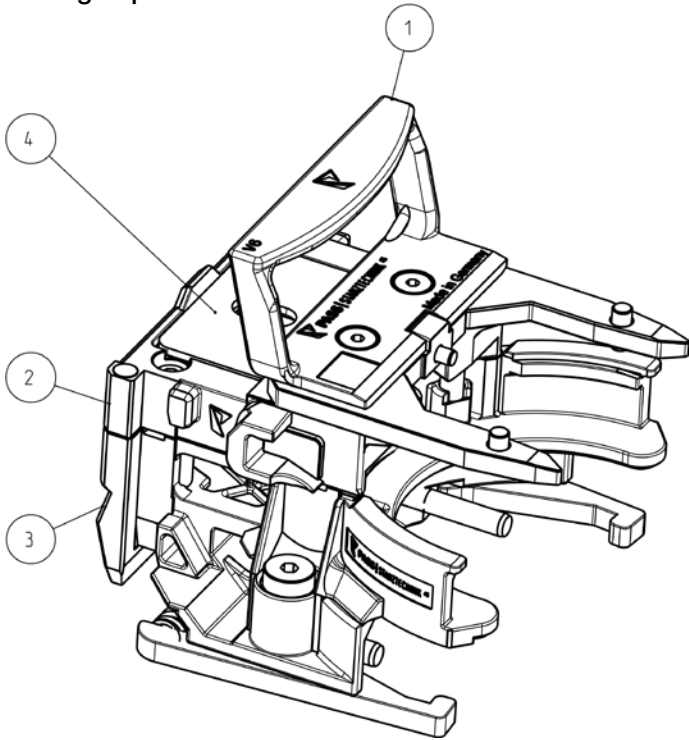
- Tools can be installed in the cartridge by hand.
- However, for mounting the tools we recommend using the QuickLoad (easyload) from year of construction 2017 available by Trumpf.

CARTRIDGE PLASTIC SIZE 2

ps:®3D-RTC

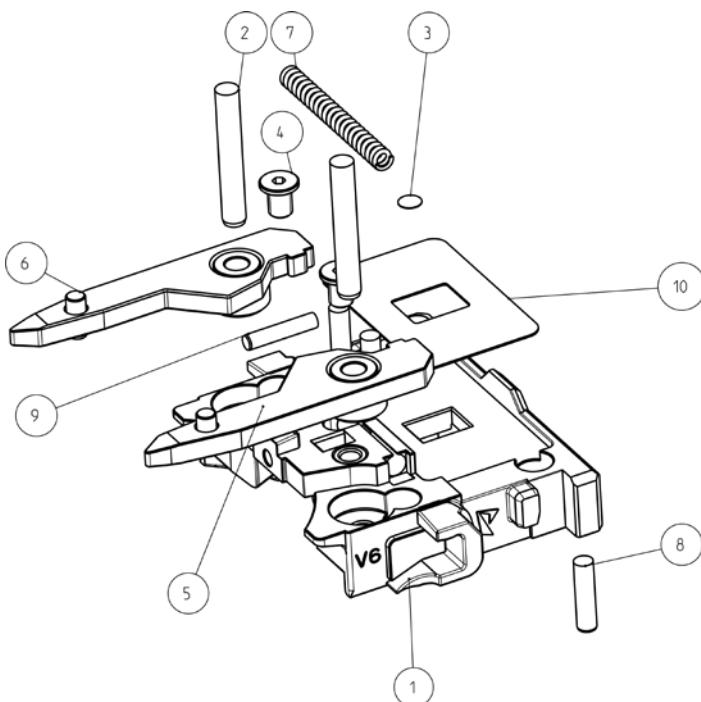
D. DRAWING AND PARTS LIST

Cartridge plastic



POSITION	DESCRIPTION	INSTALLED PIECES	PART-NO. (PER PIECE)
1 - 4	Cartridge plastic	1	15201R1
1	Handle	1	15201R1-G
2	Upper cartridge unit	1	15201R1-U
3	Lower cartridge unit	1	15201R1-L
4	Information plate	1	960100011

Upper cartridge unit

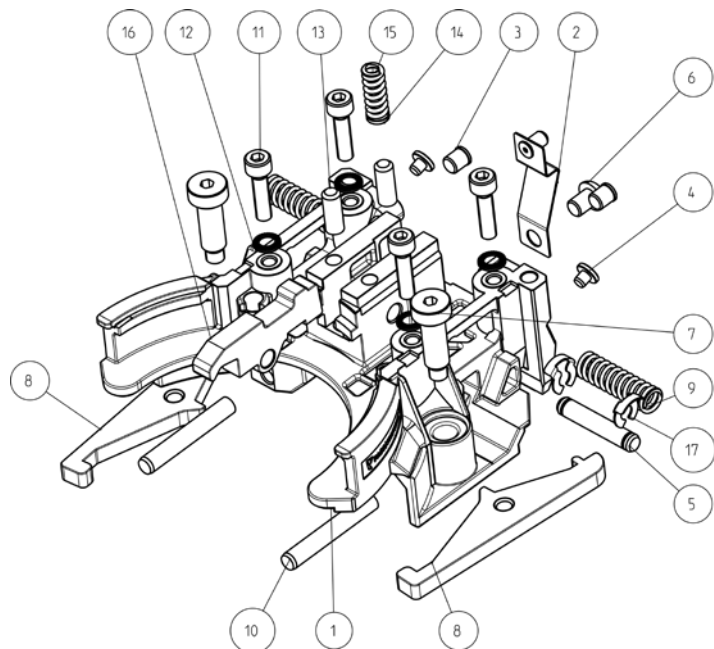


POSITION	DESCRIPTION	INSTALLED PIECES	PART-NO. (PER PIECE)
1 - 10	Upper cartridge unit	1	15201R1-U
4	Screw	2	15201R1-U4
5	Upper gripper arm left	1	15201R1-U5
6	Upper gripper arm right	1	15201R1-U6
7	Spring	1	15201R1-U7
9	Pin	1	15201R1-U9

CARTRIDGE PLASTIC SIZE 2

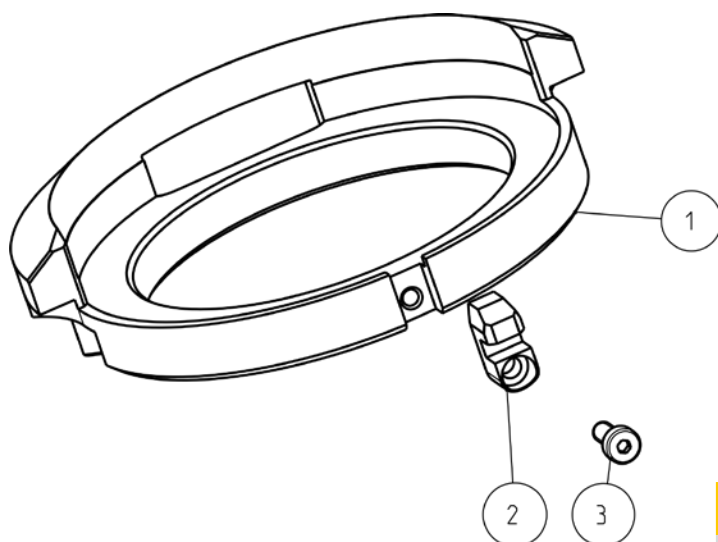
ps:®3D-RTC

Lower cartridge unit



POSITION	DESCRIPTION	INSTALLED PIECES	PART-NO. (PER PIECE)
1 - 17	Lower cartridge unit	1	15201R1-L
2	Toolmaster spring	1	15201R1-L2
7	Screw	2	15201R1-L7
8	Lower gripper arm left	1	15201R1-L8L
8	Lower gripper arm right	1	15201R1-L8R

Die plate



POSITION	DESCRIPTION	INSTALLED PIECES	PART-NO. (PER PIECE)
1 - 3	Die plate	1	960100020

CARTRIDGE PLASTIC SIZE 2

ps:[®]3D-RTC

E. CLEANING & CARE

We recommend to check and if necessary to clean the cartridge daily. Especially when you work with galvanised steel, periodic visual inspections should be made more frequently.

**Hinweis**

NOTE

Carry out periodic (daily) visual inspections and clean the tool if necessary!

Especially when soft and galvanised or foil-coated sheets are processed, abrasion of material, zinc or foils can get into the cartridge and can lead to a damage of the cartridge!

-
- Contamination can be removed using cleaning agents (e.g. cold cleaning agent from Kluthe, Heidelberg - type HAKU 1025-810-1).
 - It is also permitted to clean the **ps:[®]3D-RTC** cartridge plastic in an ultrasonic bath.

CARTRIDGE PLASTIC SIZE 5

ps:®3D-RTC

A. TECHNOLOGY REQUIREMENTS

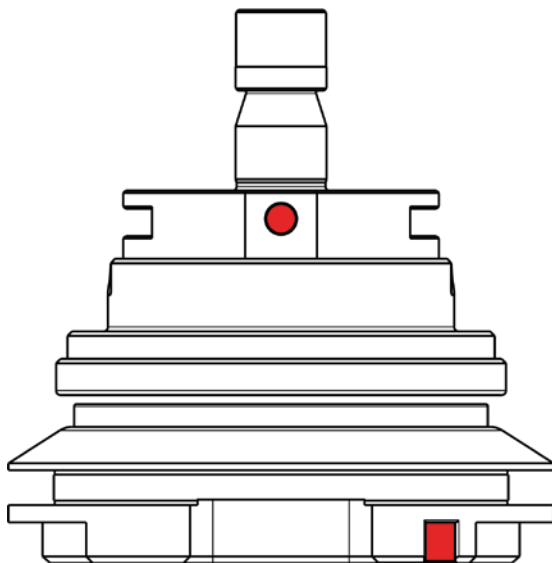
Machines

Usable for machine group I:

- TruPunch 1000/2000/2020/3000/5000
- TruMatic 1000/3000/6000/7000

B. APPLICATION AREA

- The **ps:®3D-RCT** cartridge plastic size 5 are intended exclusively for use with size 5 tools.
- The definition of whether it is a size 5 tool is determined by the locating holes on the adjusting rings and on the die plate.



Size 5

C. INSTALLATION

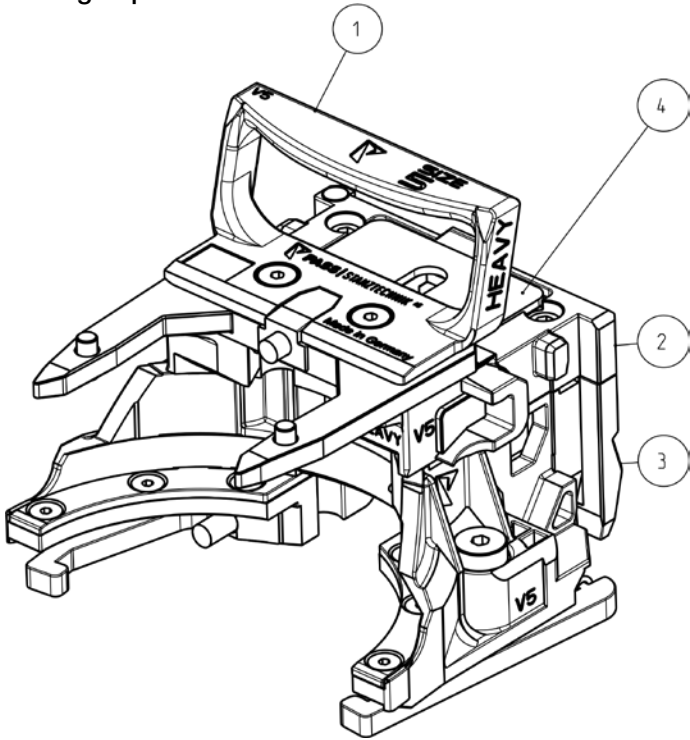
- Tools can be installed in the cartridge by hand.
- However, for mounting the tools we recommend using the QuickLoad (easyload) from year of construction 2017 available by Trumpf.

CARTRIDGE PLASTIC SIZE 5

ps:®3D-RTC

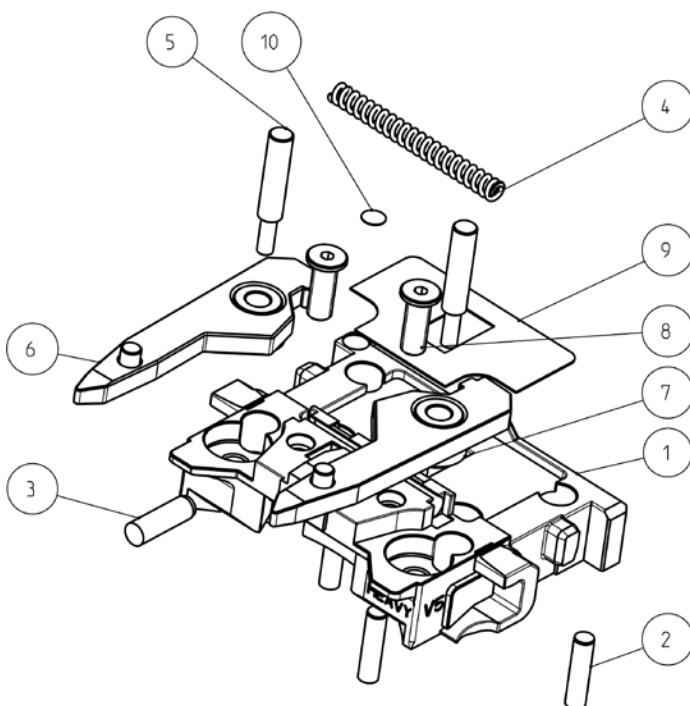
D. DRAWING AND PARTS LIST

Cartridge plastic



POSITION	DESCRIPTION	INSTALLED PIECES	PART-NO. (PER PIECE)
1 - 4	Cartridge plastic	1	155R311
1	Handle	1	155R311-G
2	Upper cartridge unit	1	155R311-U
3	Lower cartridge unit	1	155R311-L
4	Information plate	1	960100011

Upper cartridge unit

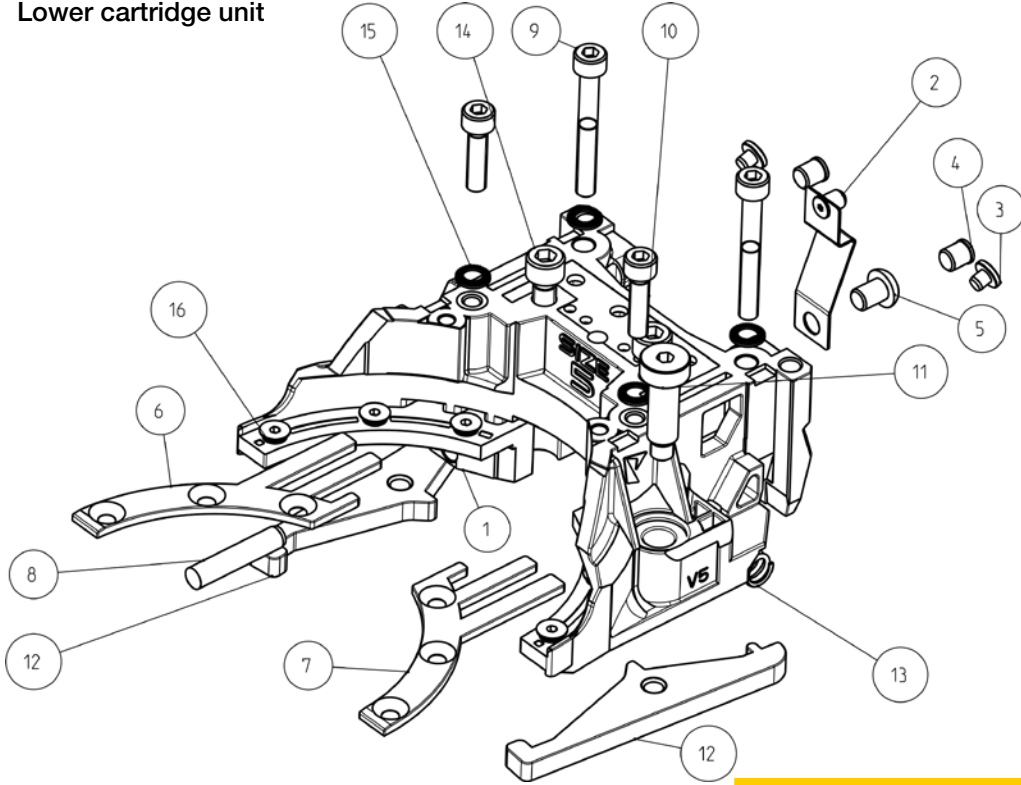


POSITION	DESCRIPTION	INSTALLED PIECES	PART-NO. (PER PIECE)
1 - 10	Upper cartridge unit	1	155R311-U
3	Pin	1	155R311-U3
4	Spring	1	155R311-U4
6	Upper gripper arm right	1	155R311-U6
7	Upper gripper arm left	1	155R311-U7
8	Screw	2	155R311-U8

CARTRIDGE PLASTIC SIZE 5

ps:®3D-RTC

Lower cartridge unit



POSITION	DESCRIPTION	INSTALLED PIECES	PART-NO. (PER PIECE)
1 - 16	Lower cartridge unit	1	155R311-L
2	Toolmaster spring	1	155R311-L2
11	Screw	2	155R311-L11
12	Lower gripper arm left	1	155R311-L12L
12	Lower gripper arm right	1	155R311-L12R

E. CLEANING & CARE

We recommend to check and if necessary to clean the cartridge daily. Especially when you work with galvanised steel, periodic visual inspections should be made more frequently.

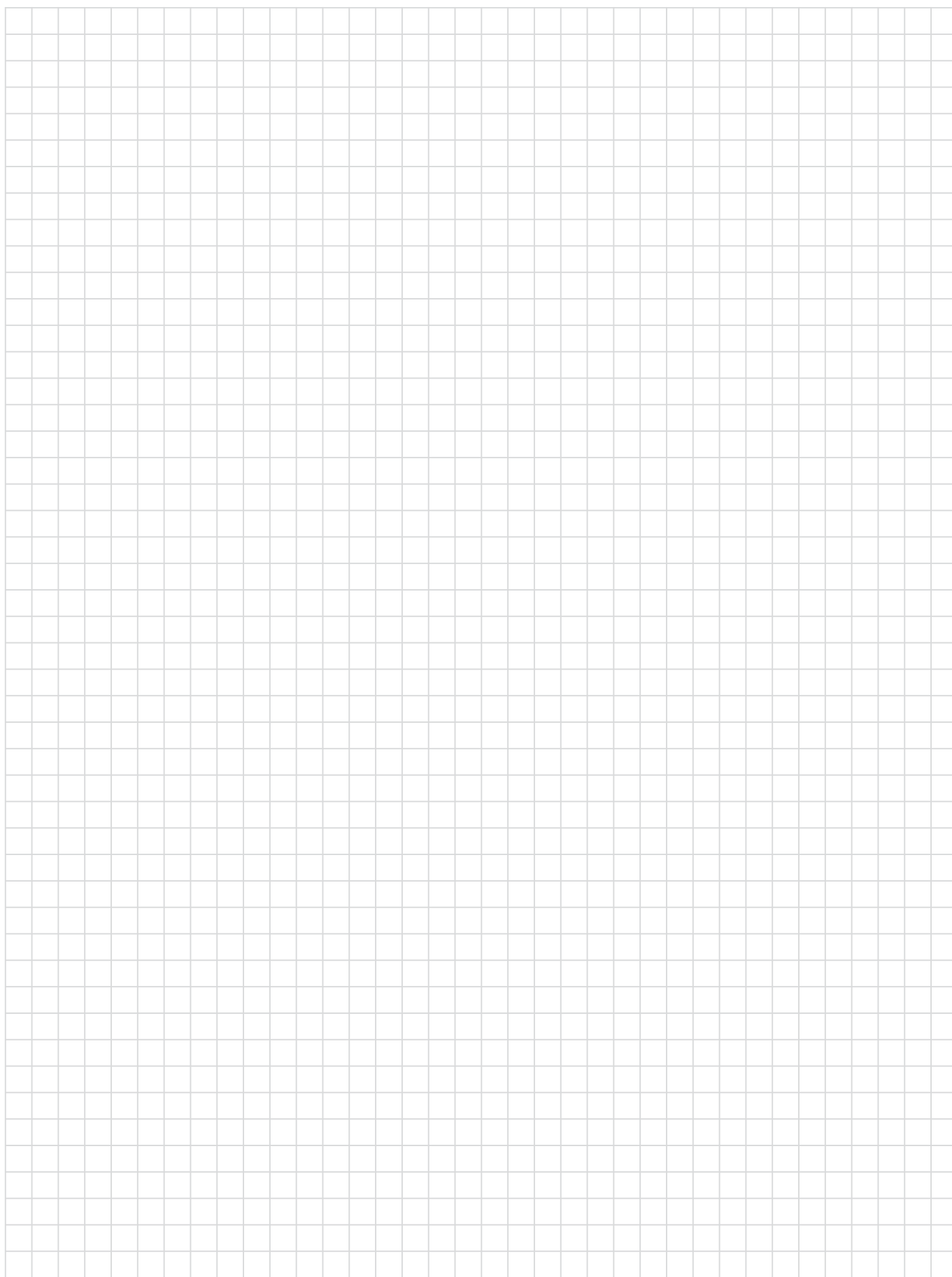


NOTE

Carry out periodic (daily) visual inspections and clean the tool if necessary!

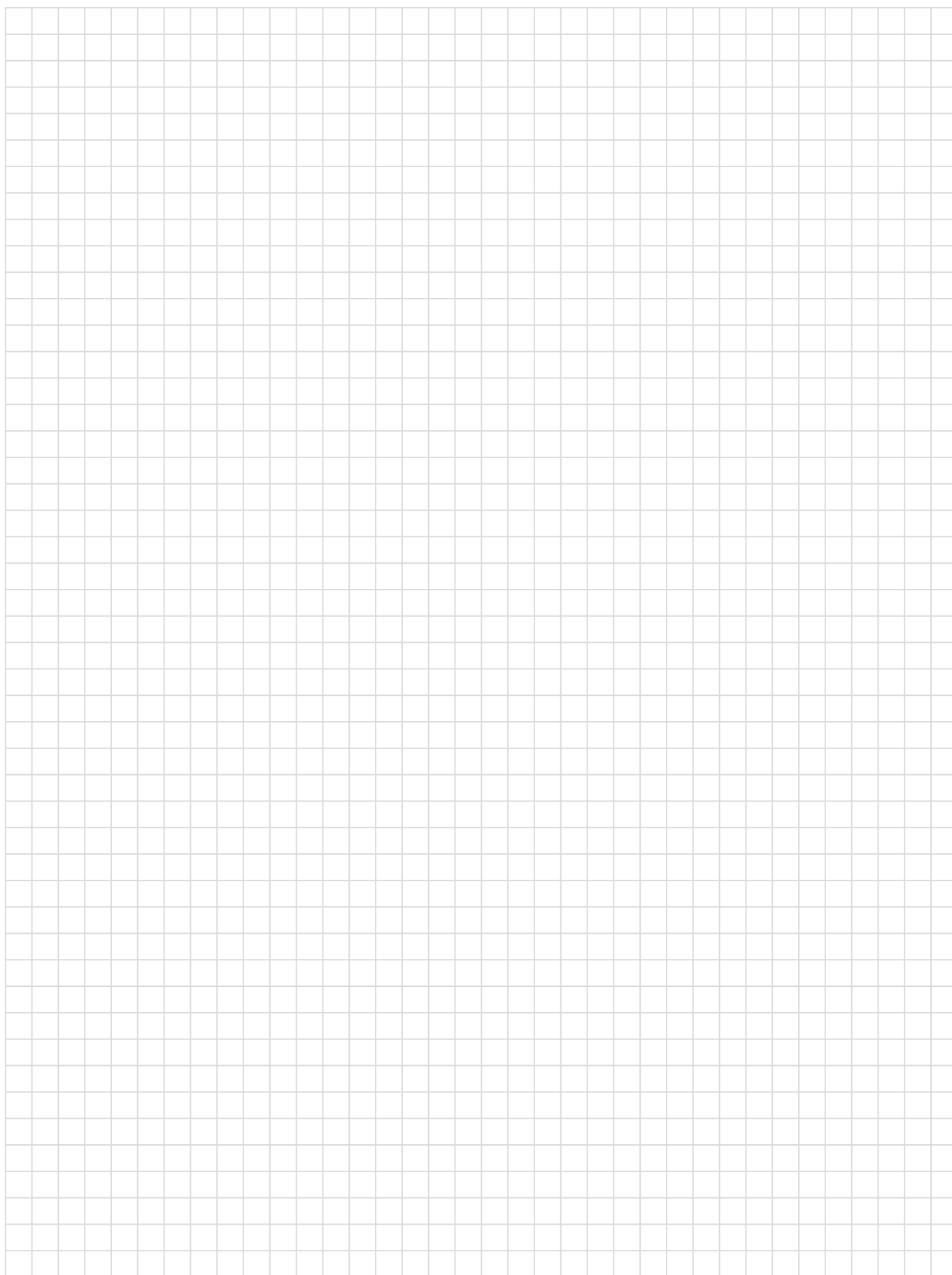
Especially when soft and galvanised or foil-coated sheets are processed, abrasion of material, zinc or foils can get into the cartridge and can lead to a damage of the cartridge!

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NOTES

A large grid area for writing notes, consisting of 20 columns and 40 rows of small squares.



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