

TWISTER

STAINLESS STEEL CONVEYORS



USER MANUAL

PN: 21-10150A_REV00



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IMPORTANT SAFETY INFORMATION

This manual is for the Twister Stainless Steel Conveyors. In this manual, the Stainless Steel Conveyors will be referred to as the conveyors, Feed Conveyor, or QC Conveyor.

The conveyors are high powered machines requiring special safety precautions to be practiced during assembly, operation, cleaning, and maintenance to reduce the risk of personal injury. Read this manual, including all important safety information, danger, warning, and caution signs before using the conveyors.

Keirton is continually improving all its products. As a result, engineering changes are sometimes made. If operation or appearances differ from this manual, please contact Keirton technical support for assistance (see **Contact Us** on page 39).

Do not allow anyone to use the conveyors without this manual. A first time user of the conveyors should obtain proper instruction from this manual.

General Safety Information

- Do not tamper with or bypass the conveyors' safety systems. **Failure to abide could cause fatal injury.**
- Do not assemble, operate, clean, or conduct maintenance on the conveyors while tired or under the influence of drugs, alcohol, or medications.
- Safety glasses, dust masks, and ear protection must be worn when operating the conveyors with a Twister trimming system.
- Do not wear loose clothing or jewellery when assembling, operating, cleaning, or conducting maintenance on the conveyors.
- Confine long hair when assembling, operating, cleaning, or conducting maintenance on the conveyors.



DANGER

CARELESS USE OF THE CONVEYORS, ASSEMBLING, OR OPERATING THEM WITHOUT READING THE INSTRUCTIONS AND ACCOMPANYING DANGER, WARNING, AND CAUTION NOTICES MAY RESULT IN SERIOUS OR FATAL INJURY.

IMPORTANT SAFETY INFORMATION

- Do not assemble, move, clean, or conduct maintenance on the conveyors while power is connected to them.
- The conveyors are heavy. Always use proper lifting technique and two people to lift them.
- Substituting factory parts with third-party parts may result in bodily harm or damage to the conveyors.
- Do not remove safety labels from the conveyors. **Replace any safety labels if they become damaged or obscured.**
- Keep visitors and children a safe distance from the conveyors.

Connection and Electrical Safety Information

- The conveyors must be used in connection with a properly grounded receptacle. Refer to the specifications (starting on page 35) to determine the correct electrical requirements.
- Observe all applicable building and electrical codes.
- Do not overload outlets or extension cords as this can result in fire or electric shock.
- To power down the conveyors, switch off the motors via the control boxes before unplugging the machines.
- Avoid direct high-pressure water spray on the motors.

Assembly Safety Information

- Do not skip any assembly steps. Complete all steps in order.
- Do not connect the conveyors to a power source until they are fully assembled.
- The conveyors are heavy and may damage easily. Use two people to assemble them.

Operation Safety Information

- Ensure the conveyors are fully assembled before operation.
- Never let the conveyors run unattended.
- **Only place plant matter on the conveyors.** Do not put foreign objects on the

conveyors. Doing so may cause bodily harm or damage to the conveyors.

Maintenance Safety Information

- Conduct regular maintenance on the conveyors.
- Do not attempt to service electrical components on the conveyors yourself. **Opening or removing covers may expose you to dangerous voltage and possible fire or electric shock.**
- Do not attempt maintenance not covered in this manual unless directed by Keirton technical support.
- Some repair or damage will require a qualified service technician who is trained in machinery maintenance, service, and repair.
- Improper adjustments may result in damage to the machines.
- Replacement parts are specific to the conveyors and must only be purchased from an authorized dealer. Failure to comply may void warranty, cause bodily harm, and/or damage to the machine.

Parts: Feed Conveyor Components

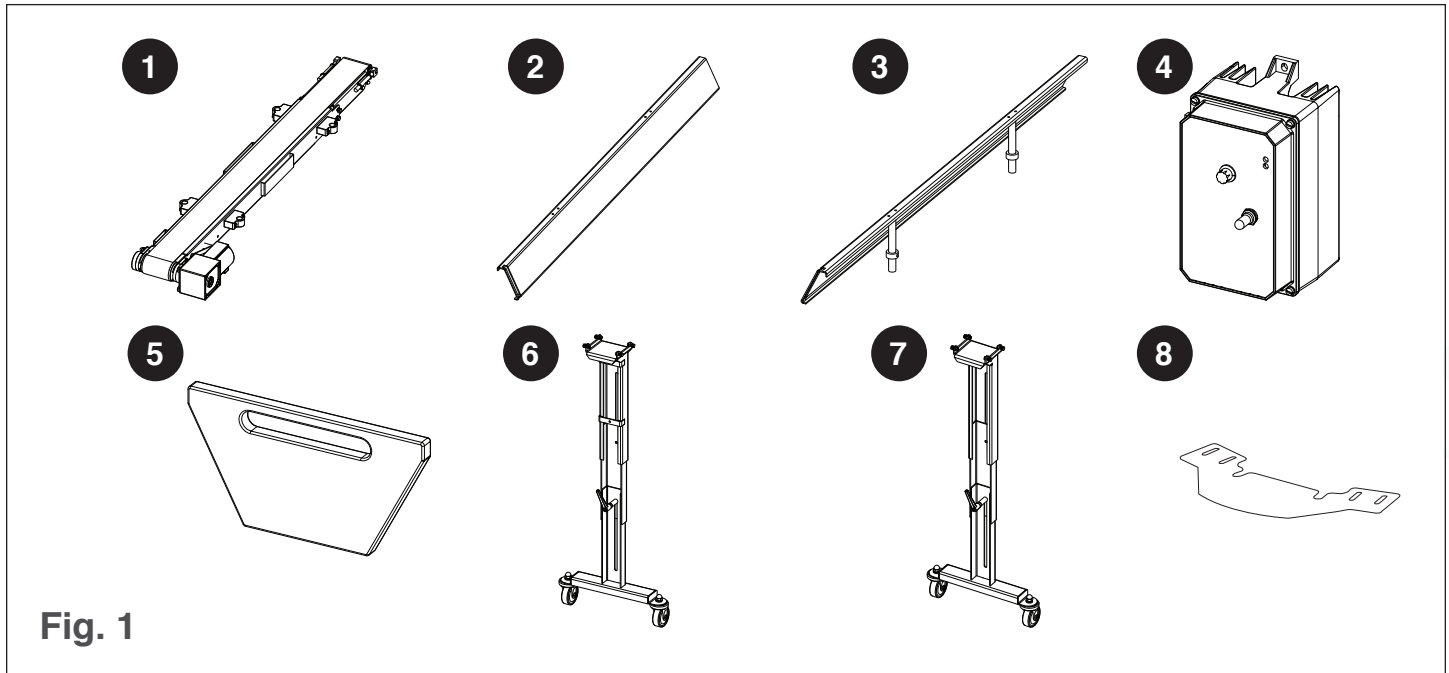


Fig. 1

Reference	Description	Part Number	Quantity
1	Feed Conveyor Bed, Belt, Motor, and Tilt Tail	11-10516A (Bed) 17-10101A (Belt) 15-10419 (Motor) 24-10292A (Tail)	1 1 1 1
2	Feed Left Sidewall, Support Posts, and Collars	11-10522A (Wall) 11-10524A (Post) 14-10217 (Collar)	1 2 2
3	Feed Right Sidewall, Support Posts, and Collars	11-10523A (Wall) 11-10524A (Post) 14-10217 (Collar)	1 2 2
4	SS Conveyor VFD Control Box	15-10386	1
5	Feed End Plate	17-10102A	1
6	Feed Conveyor Front Leg Assembly	24-10294A	1
7	Feed Conveyor Back Leg Assembly	24-10295A	1
8	SS Feed Chute	11-10563A	1

Parts: QC Conveyor Components

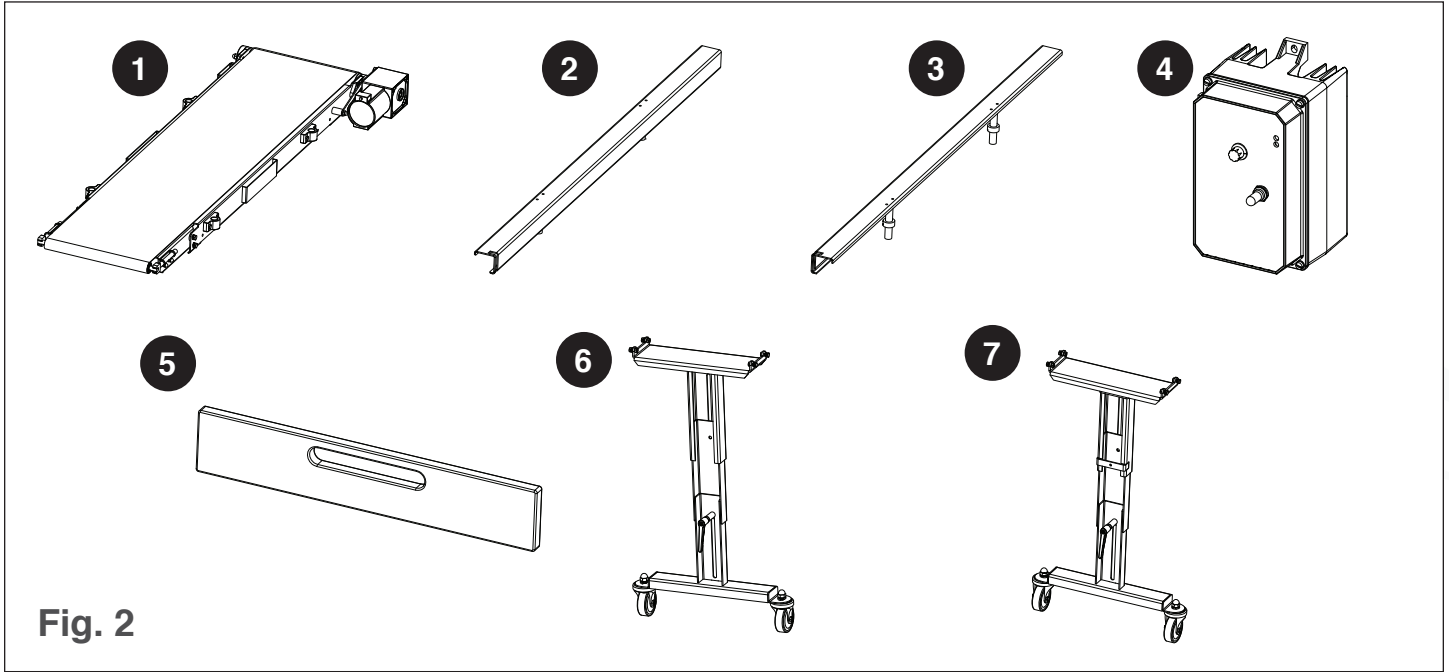
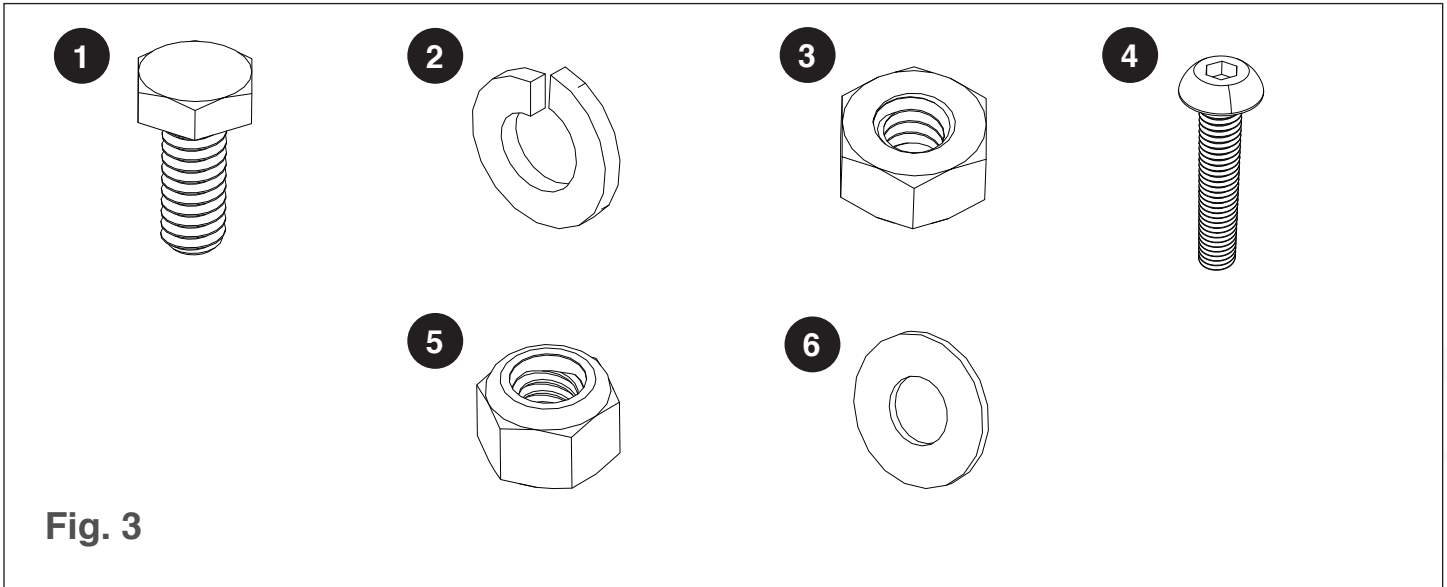


Fig. 2

Reference	Description	Part Number	Quantity
1	QC Conveyor Bed, Belt, Motor, and Tilt Tail	11-10493A (Bed) 17-10096A (Belt) 15-10418 (Motor) 24-10274A (Tail)	1 1 1 1
2	QC Left Sidewall, Support Posts, and Collars	11-10504A (Wall) 11-10506A (Post) 14-10217 (Collar)	1 2 2
3	QC Right Sidewall, Support Posts, and Collars	11-10505A (Wall) 11-10506A (Post) 14-10217 (Collar)	1 2 2
4	SS Conveyor VFD Control Box	15-10386	1
5	QC End Plate	17-10099A	1
6	QC Conveyor Front Leg Assembly	24-10277A	1
7	QC Conveyor Back Leg Assembly	24-10276A	1

Parts: Feed & QC Conveyor Fasteners

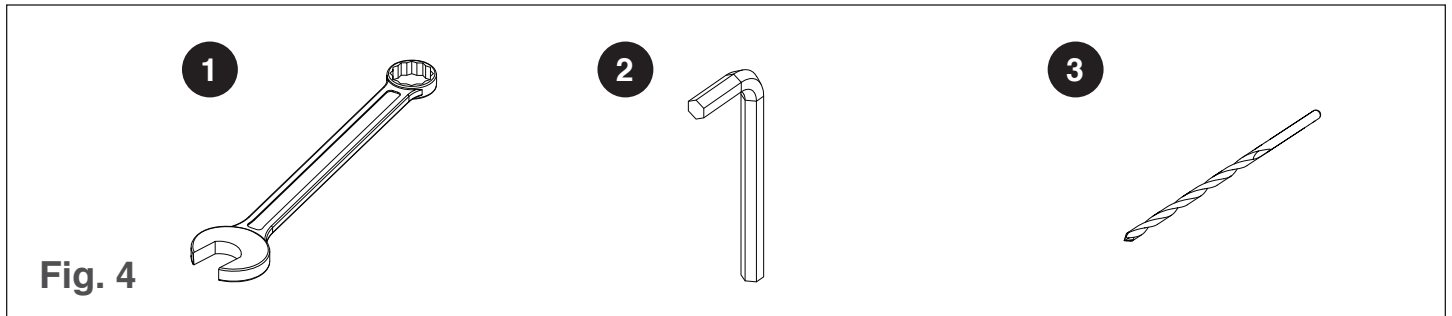


Reference	Description	Part Number	Quantity
1	1/4"-20 x 5/8" Hex Head Bolt	13-10348	8*
2	1/4" Split Washer	13-0019	10*
3	1/4"-20 Stainless Steel Hex Nut	13-0017	8*
4	1/4"-20 x 3/4" Button Head Cap Screw	13-0159	2*
5	1/4"-20 Stainless Steel Nyloc Nut	13-0062	4**
6	1/4" Stainless Steel Flat Washer	13-0046	4**

*Per conveyor.

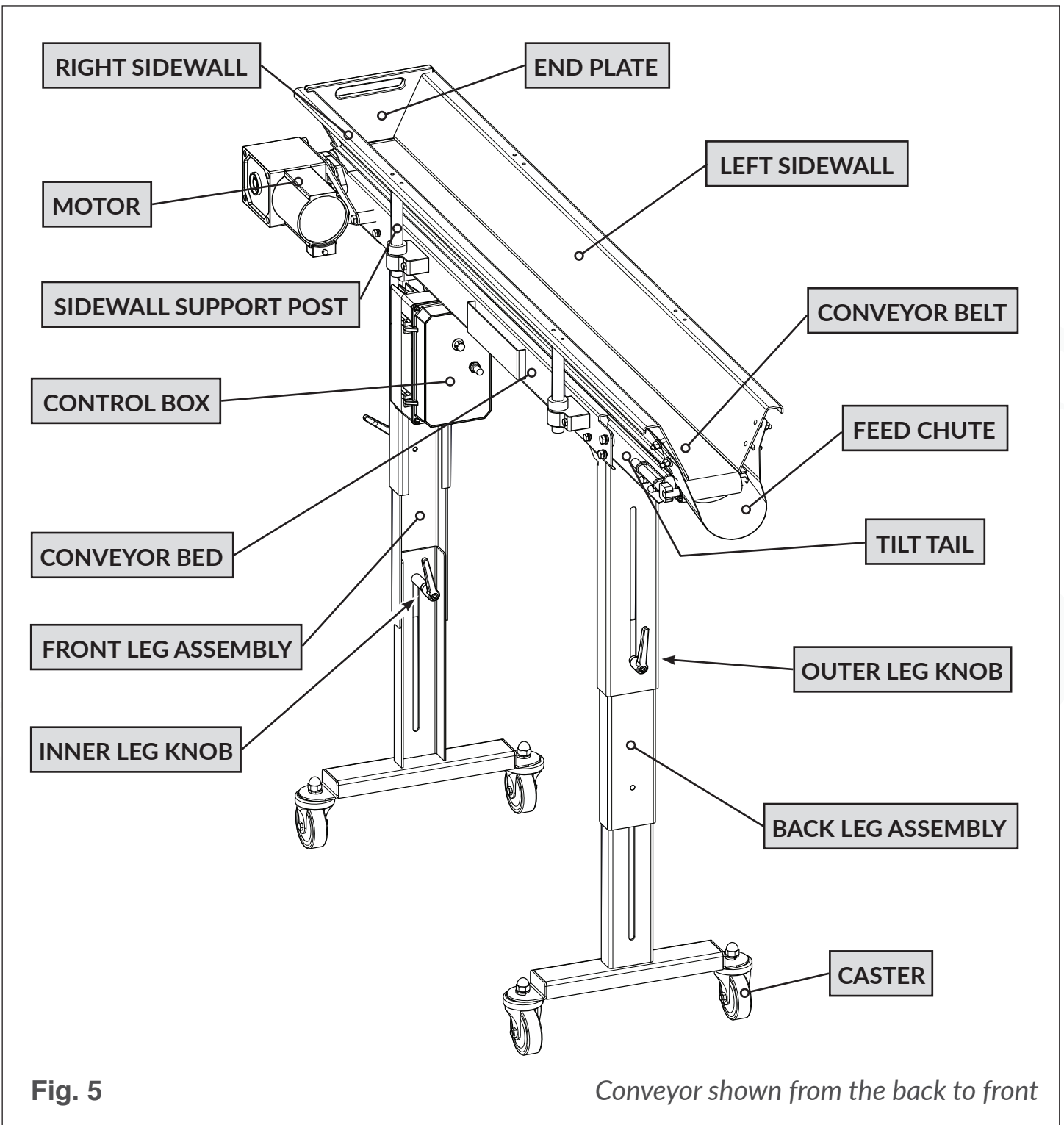
**Feed conveyor only.

Tools Needed for Feed and QC Conveyor Assembly

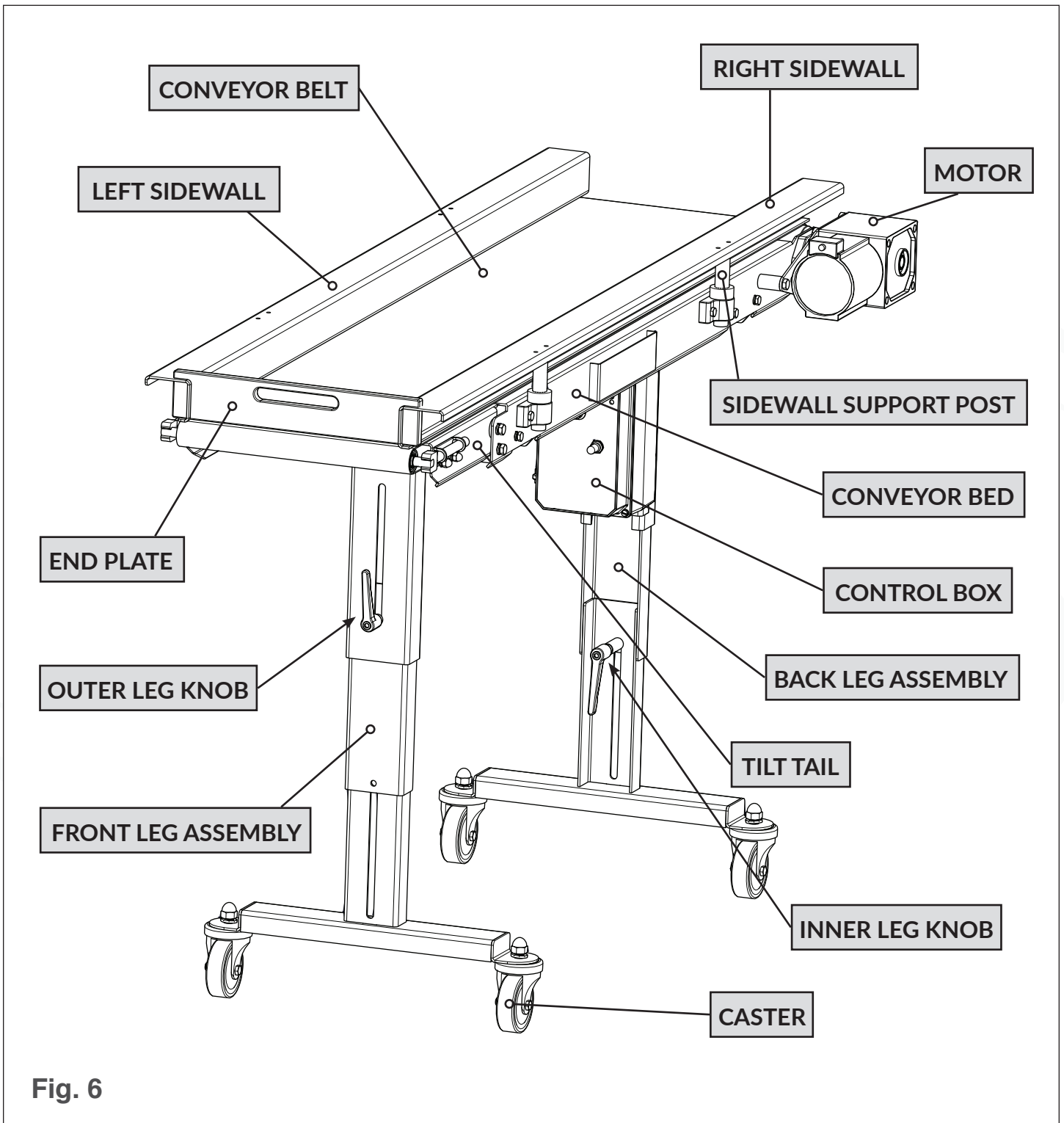


Reference	Description	Quantity
1	7/16" Wrench	2
2	5/32" Hex Key	1
3	(Optional) 1/8" Thick Object (such as a drill bit)	2

ASSEMBLED FEED CONVEYOR



ASSEMBLED QC CONVEYOR



Most assembly steps for the Feed and QC Conveyors are identical. Unless otherwise stated, conduct the following steps on both conveyors. For identical steps, the Feed Conveyor is pictured.

Step 1: Attach the Legs to the Conveyor Bed

1. Raise the conveyor bed onto two secure supports several feet from the ground (see Fig. 7). This is to prevent the bed needing to be rested on its motor-side when attaching the legs. Do not rest the conveyor bed on its motor-side.
2. Align the first leg with the conveyor bed:
 - If attaching a leg to the Feed Conveyor:
 - i. Align the four bolts holes in the top of the **front leg assembly** with the four bolt holes in the conveyor bed's motor-end (see Fig. 8). The front leg assembly has two cross bars on the outer leg (see Fig. 9). Ensure the outer leg is facing the motor end.
 - If attaching a leg to the QC Conveyor:
 - i. Align the four bolt holes in the top of the **back leg assembly** with the four bolt holes in the conveyor bed's motor-end. The back leg assembly has two cross bars on the outer leg (see Fig. 9—elements are similar to the Feed Conveyor leg). Ensure the outer leg is facing the motor-end.
3. Secure the first leg to the conveyor bed:

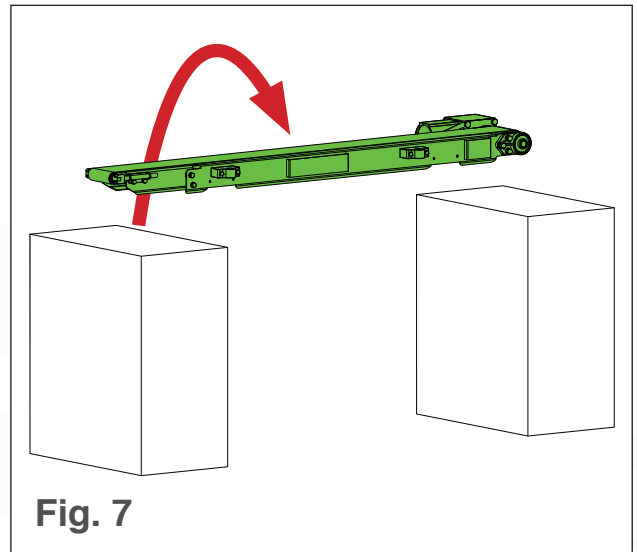


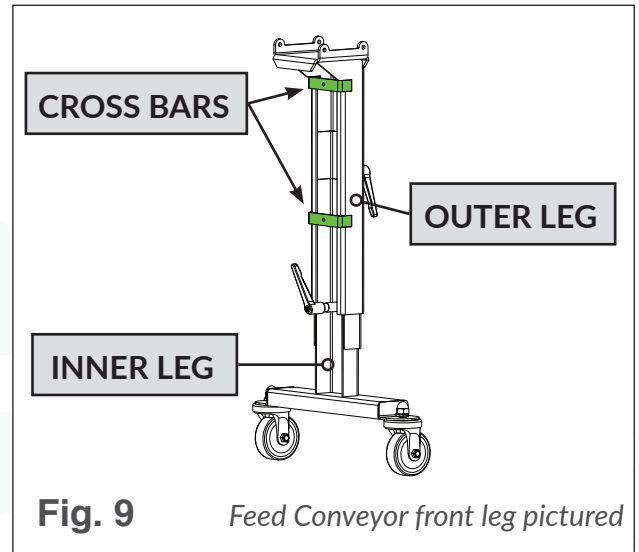
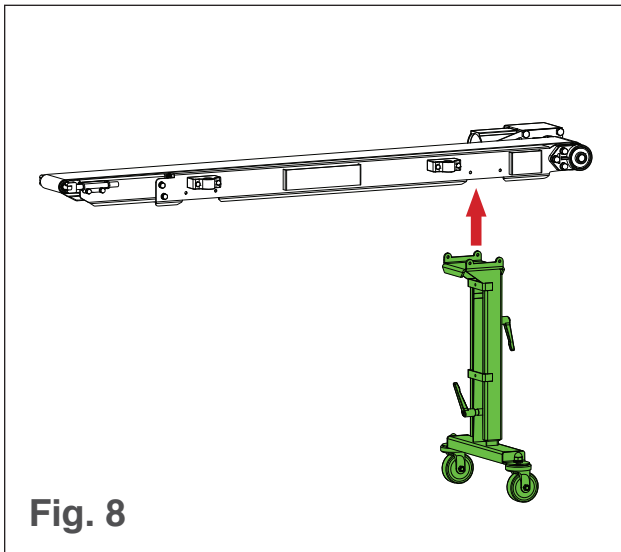
Fig. 7



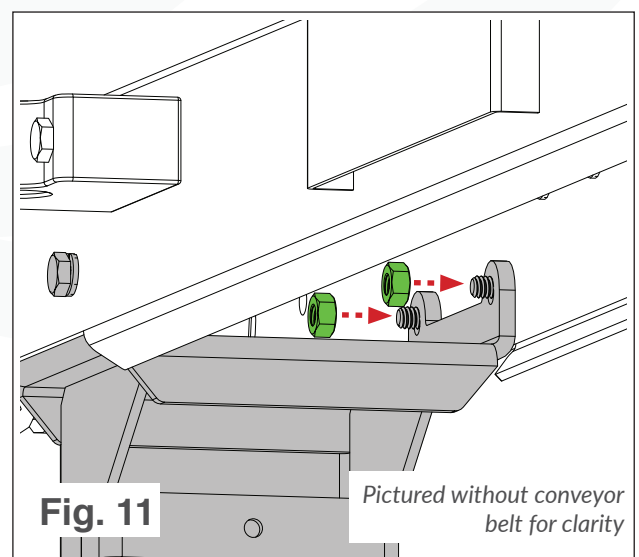
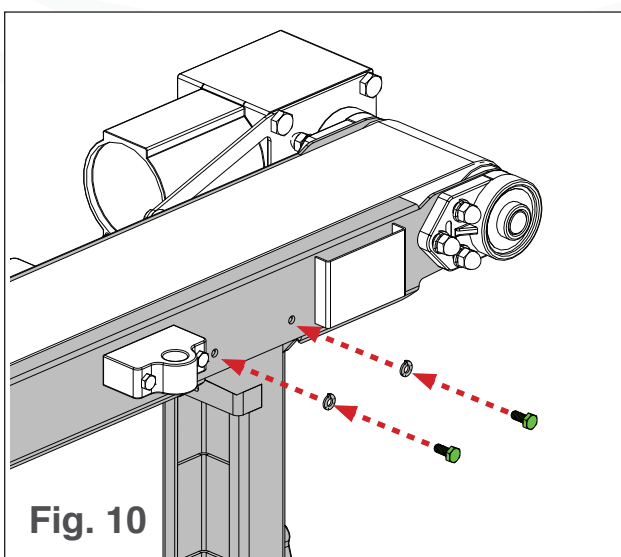
CAUTION

DO NOT REST THE CONVEYOR BED ON ITS MOTOR-SIDE.

ASSEMBLY

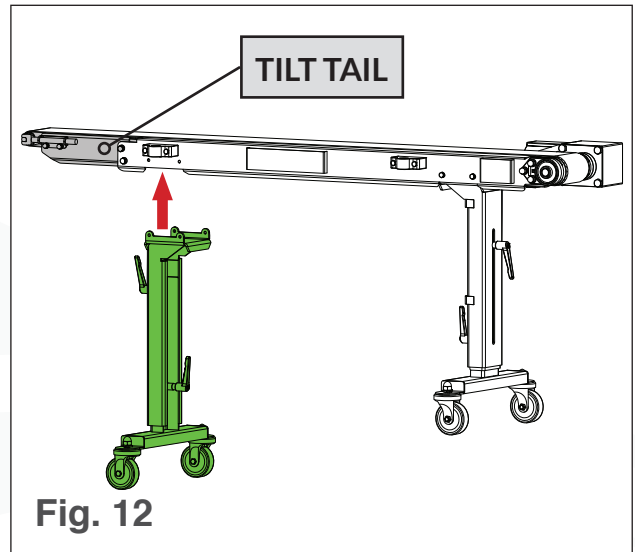


- a. Place two $\frac{1}{4}$ "-20 x $\frac{5}{8}$ " hex head bolts through $\frac{1}{4}$ " split washers, then through the outside of the conveyor bed and into the top of the aligned leg on both sides of the conveyor (see Fig. 10).
- b. Secure a $\frac{1}{4}$ "-20 stainless steel hex nut over the end of each bolt (see Fig. 11).



4. Align the second leg with the conveyor bed:

- If attaching the second leg to the Feed Conveyor:
 - i. Align the four bolt holes in the top of the **back leg assembly** with the four bolt holes in the bed near the tilt tail (see Fig. 12). Ensure the outer leg is facing the tilt tail.



- If attaching a leg to the QC Conveyor:
 - i. Align the four bolt holes in the top of the **front leg assembly** with the four bolt holes in the conveyor bed near the tilt tail. Ensure the outer leg is facing the tilt tail.

5. Secure the second leg to the conveyor bed:

- a. Place two $\frac{1}{4}$ "-20 x $\frac{5}{8}$ " hex head bolts through $\frac{1}{4}$ " split washers, then through the outside of the conveyor bed and into the top of the aligned leg on both sides of the conveyor.
- b. Secure a $\frac{1}{4}$ "-20 stainless steel hex nut over the end of each bolt.

Step 2: Attach the Control Box to the Leg

1. Align the bolt holes on the control box with the bolt holes in the cross bars on the motor-end leg.
2. Secure the control box to the leg with two $\frac{1}{4}$ "-20 x $\frac{3}{4}$ " button head cap screws and $\frac{1}{4}$ " split washers (see Fig. 13).

Step 3: Attach the Sidewalls to the Conveyor Bed

1. Slot the right sidewall support posts into the support post slots on the conveyor bed:
 - If attaching the right sidewall of the Feed Conveyor, when the wall is slotted into the conveyor bed's motor side, the top of the wall should lean away from the conveyor bed, and the end plate notch should be on **the motor end** (see Fig. 14).
 - If attaching the right sidewall of the QC Conveyor, when the wall is slotted into the conveyor bed, the flat side should face the conveyor belt, and the end plate notch should be on **the tilt tail end** (see Fig. 15).

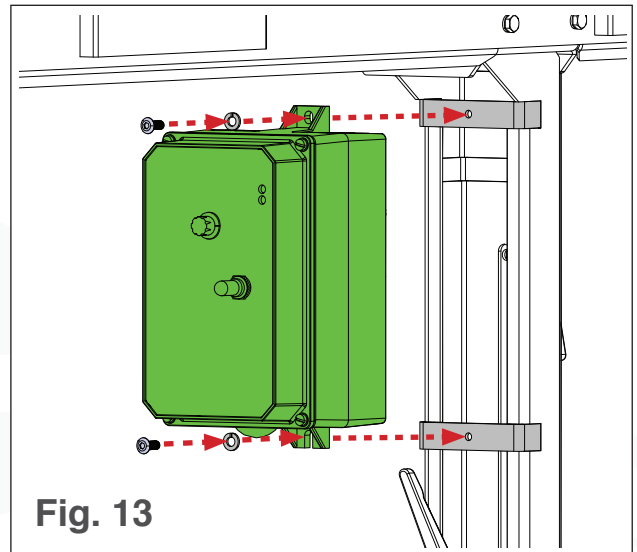


Fig. 13

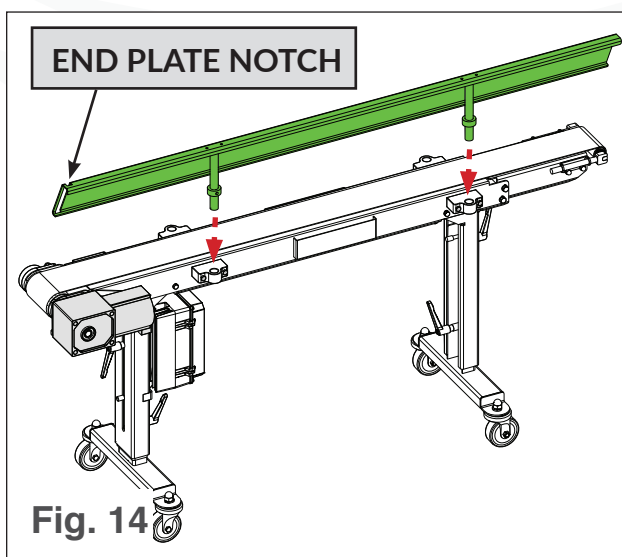


Fig. 14

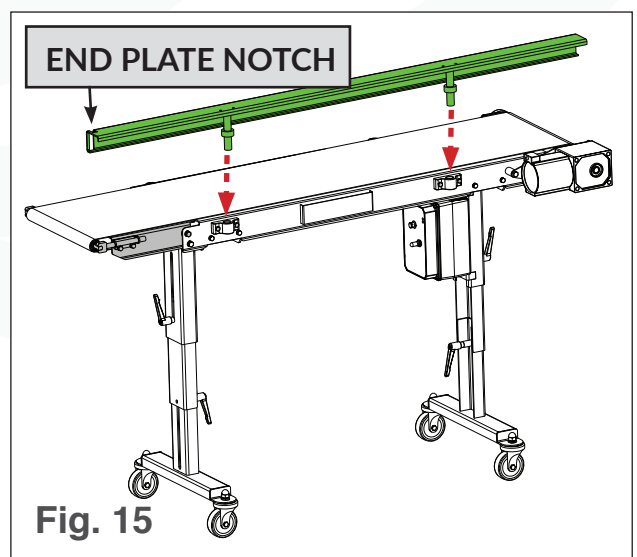
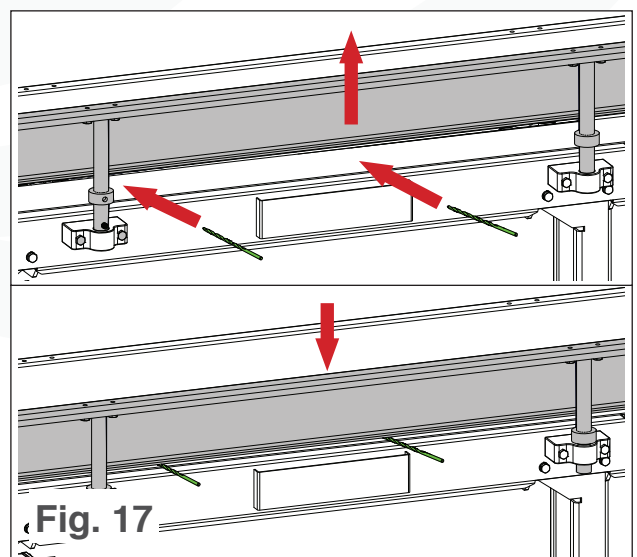
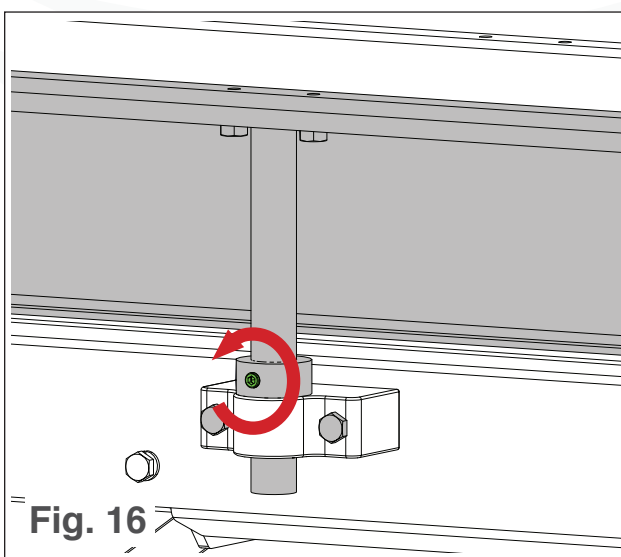


Fig. 15

2. Slot the left sidewall support posts into the support post slots on the conveyor bed:
 - If attaching the left sidewall of the Feed Conveyor, when the wall is slotted into the conveyor bed, the top of the wall should lean away from the conveyor bed, and the end plate notch should be on **the motor end**.
 - If attaching the left sidewall of the QC Conveyor, when the wall is slotted into the conveyor bed, the flat side should face the conveyor belt, and the end plate notch should be on **the tilt tail end**.

Step 4: Adjust the Sidewall Heights

1. Loosen the set screws on both sidewall collars on one of the sidewalls (the ring on the support post—see Fig. 16).
2. Lift the sidewall and place two objects that are approximately $\frac{1}{8}$ " in thickness (such as a $\frac{1}{8}$ " drill bit or plate) under the sidewall at least 1" apart (see Fig. 17).
3. Lower the sidewall onto the $\frac{1}{8}$ " objects.
4. Tighten the sidewall collar set screws.
5. Repeat steps 1–4 on the second sidewall.



Step 5: Attach the End Plate to the Sidewalls

1. Slot the end plate into the notches on the sidewalls (see Fig. 18).

Step 6: Attach the Feed Chute

1. Loop the slots in the feed chute around the threaded standoffs on one of the sidewalls so the chute is pointing forward (see Fig. 19).
2. Secure a flat washer, then a nyloc nut over the end of both standoffs (see Fig. 20). **Do not fully tighten the nuts yet.**
3. Bend the chute and repeat steps 1 and 2 with the other side of the chute on the other sidewall (see Fig. 21).
4. Adjust the position of the chute so the back of it lightly contacts the roller.
5. Tighten all four nyloc nuts.

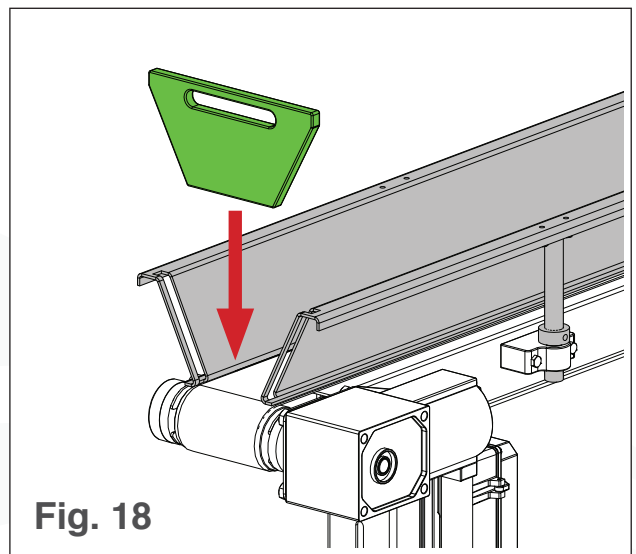


Fig. 18

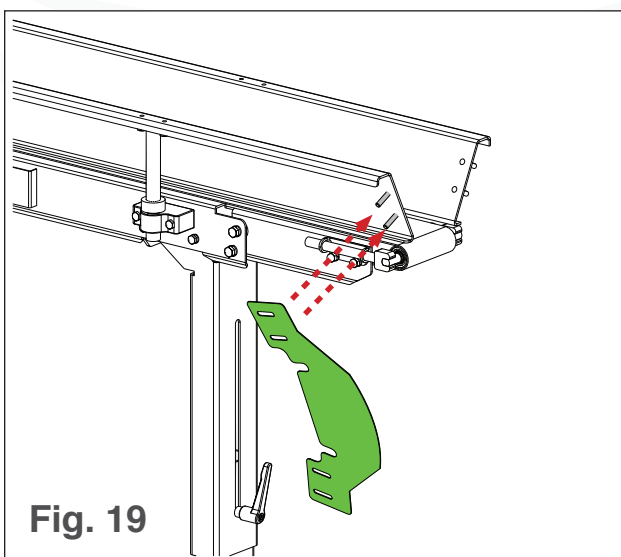


Fig. 19

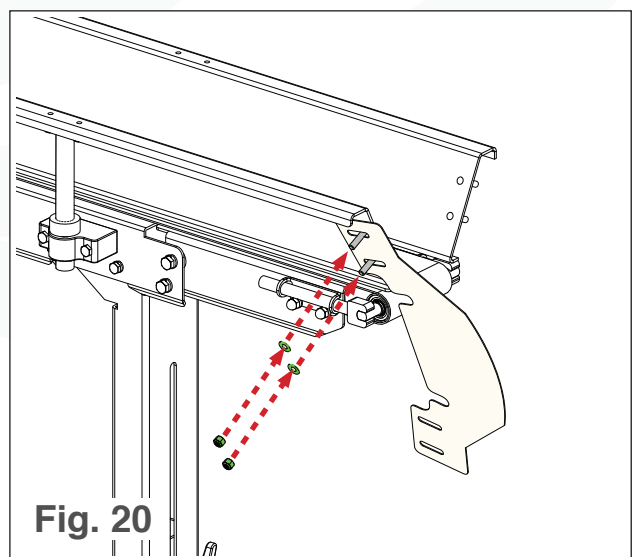


Fig. 20

Step 7: Inspect the Belt Contact

1. Plug in the conveyors and turn them on (see **Operation** on page 22).
2. Inspect if the side walls or end plate contact the belt while running. If they do, readjust the sidewall height (see **Step 4: Adjust the Sidewall Heights** on page 15).

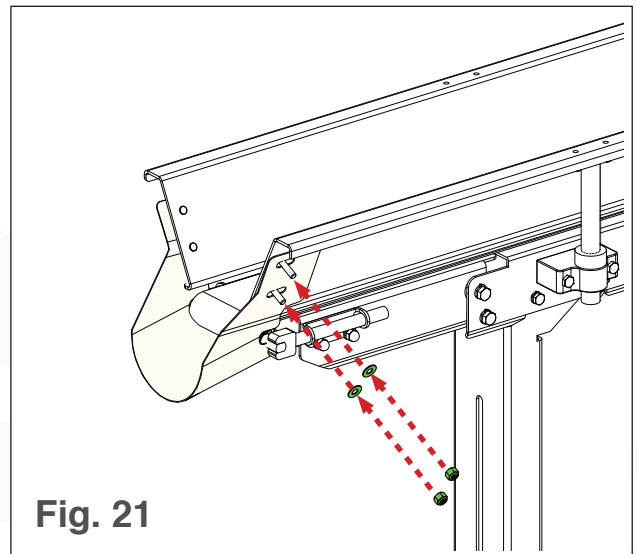
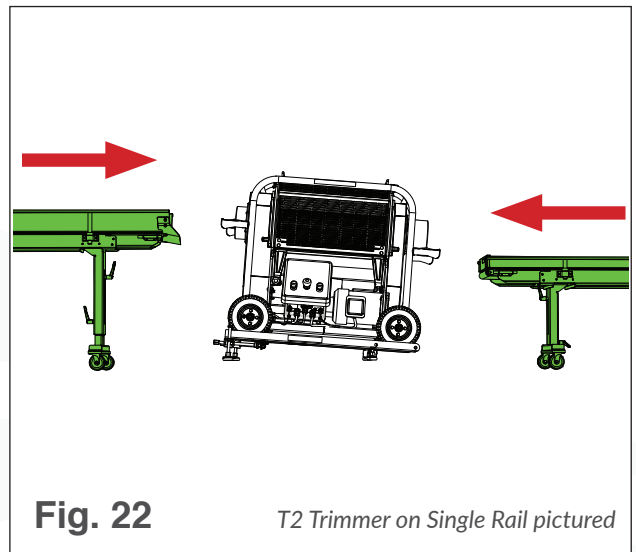


Fig. 21

Step 1: Move the Conveyors

1. Unlock the casters on the conveyors, and wheel them near to the trimmer (see the *T2 or T4 User Manual* for recommended placement guidelines):
 - Place the Feed Conveyor 1' away from the raised end of the tumbler (see Fig. 22). **Do not place it directly next to the tumbler yet.**
 - Place the QC Conveyor 1' away from the lower end of the tumbler (see Fig. 22). **Do not place it directly next to the tumbler yet.**



Step 2: Adjust the Conveyor Heights

1. Ensure the conveyors are at least 1' away from the tumbler.
2. Have one person support the weight of the conveyor bed so it does not drop when the leg knobs are loosened.
3. Have a second person loosen the inner leg knob on the leg closest to the tumbler (see Fig. 23).
4. Lift the conveyor bed's tumbler facing end to its desired height or as high as it will go (see Fig. 24 and **Conveyor Height Guidelines**).



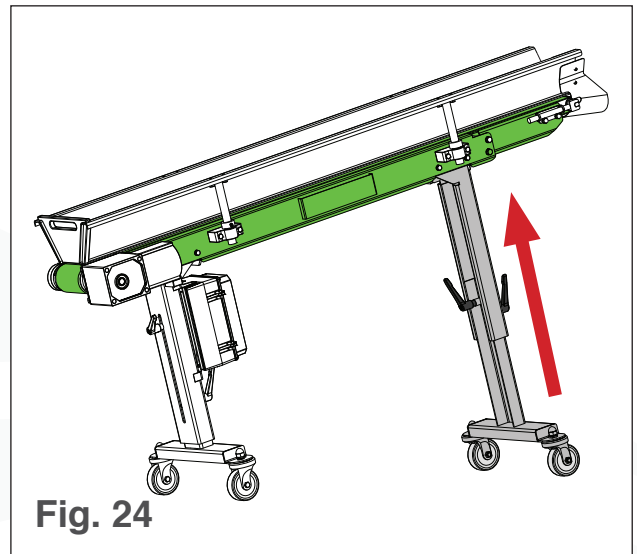
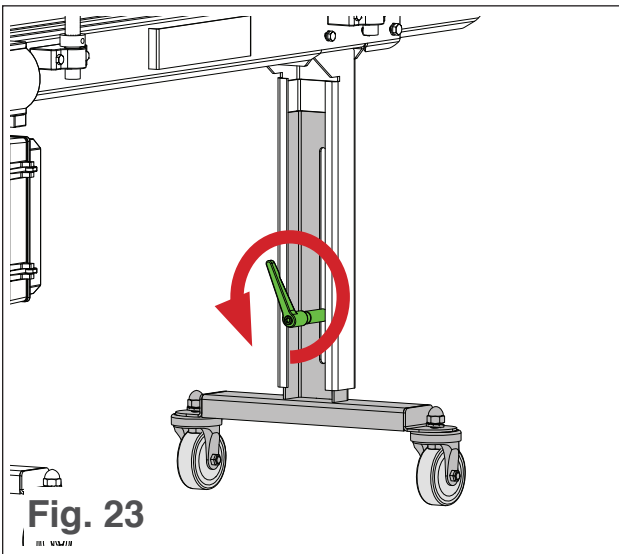
WARNING

THE CONVEYORS ARE HEAVY.
USE AT LEAST TWO PEOPLE
ADJUST THEIR HEIGHTS.



WARNING

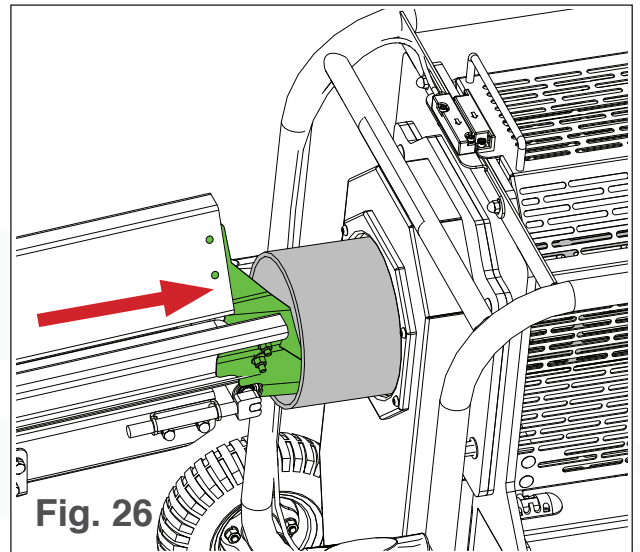
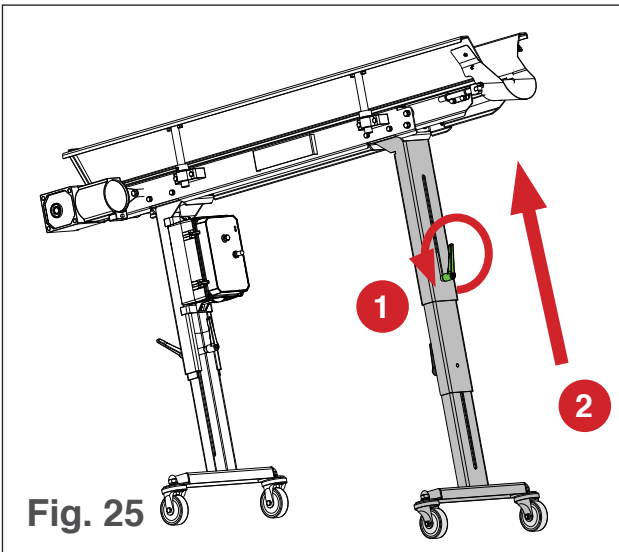
SUPPORT THE WEIGHT OF THE
CONVEYORS WHILE THE LEG
KNOBS ARE LOOSE SO IT DOES
NOT DROP.



5. While still supporting the conveyor bed, retighten the inner leg knob.
6. Repeat steps 2-5 on the other leg.
7. If the conveyor is still not high enough, repeat steps 2-6, but loosen the outer leg knob instead of the inner leg knob (see Fig. 25).

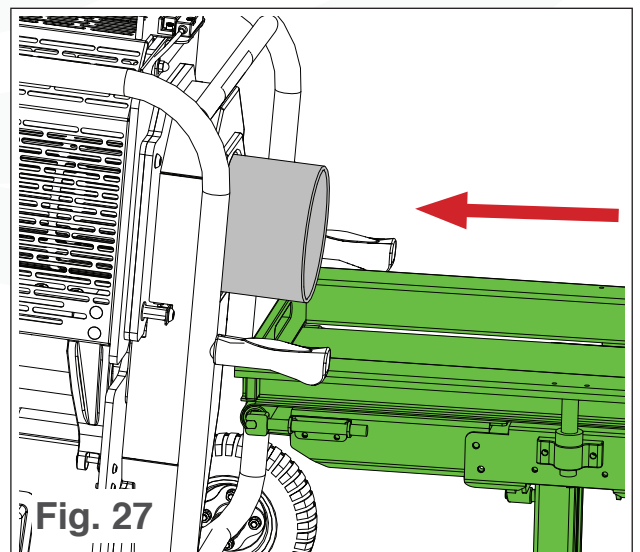
CONVEYOR HEIGHT GUIDELINES

- For effective operation, the T2 and T4 Trimmers must be tilted with one end of the tumbler higher than the other (see the respective trimmer manual for tilt guidelines).
- The open end of the Feed Conveyor should be adjusted to a height where the feed chute can enter the tumbler without the conveyor rollers or sidewalls contacting the tumbler.
- The closed end of the QC Conveyor should be adjusted to a height where it is just below the lower end of the tumbler without it contacting the tumbler.



Step 3: Align the Conveyors with the Tumbler

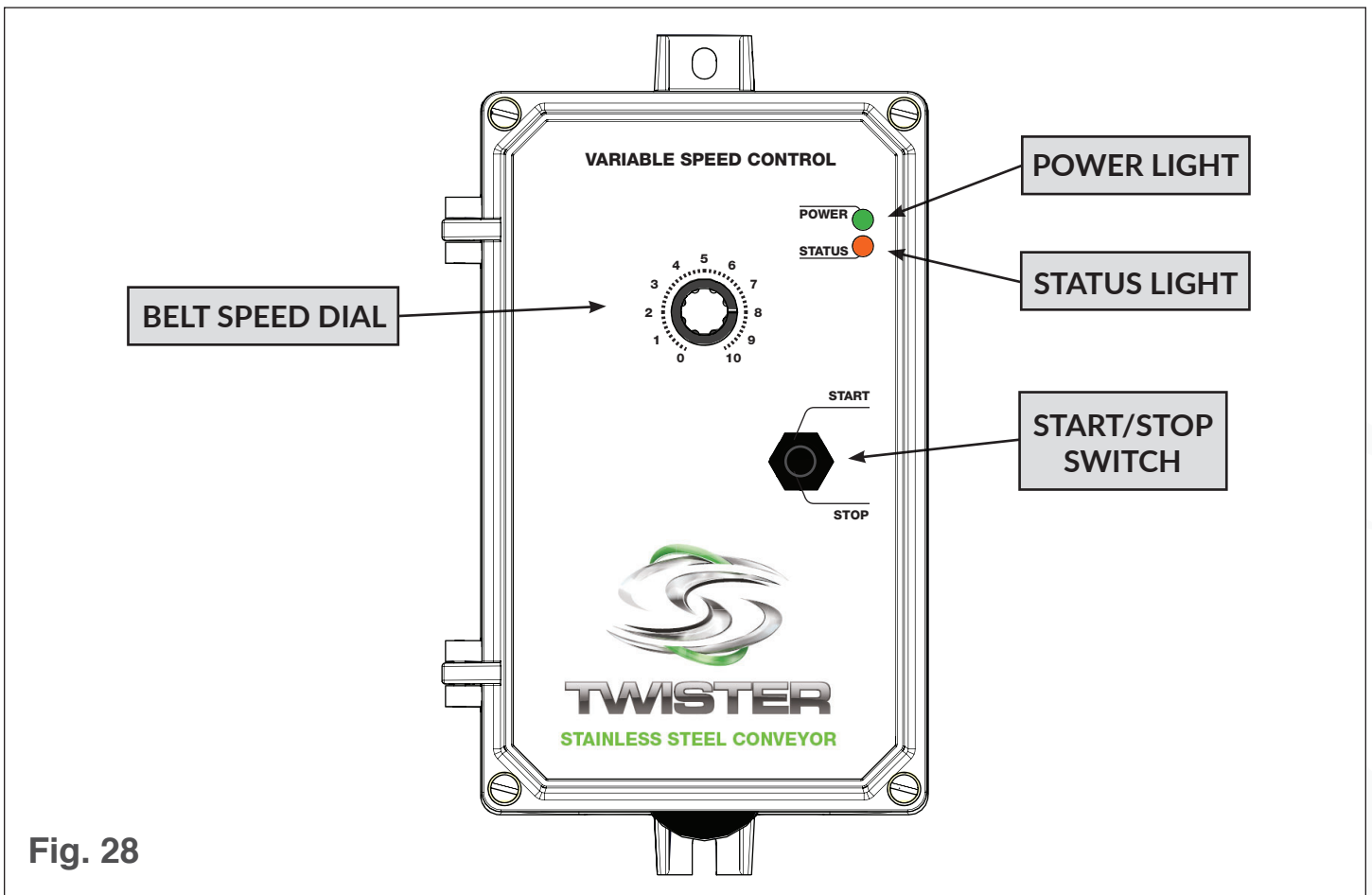
1. Place the feed chute inside the tumbler without allowing the tumbler to contact the conveyor rollers or sidewalls. Adjust the Feed Conveyor height as necessary to achieve this result (see **Step 2: Adjust the Conveyor Heights** on page 18).
2. Place the closed end of the QC Conveyor directly under the tumbler without touching it the tumbler or trimmer (see Fig. 27). Adjust the QC Conveyor height as necessary to achieve this result (see **Step 2: Adjust the Conveyor Heights** on page 18).
3. Lock all casters in place.



CAUTION

ENSURE THE CONVEYORS ARE NOT TOUCHING THE TUMBLER OR TRIMMER DURING OPERATION.

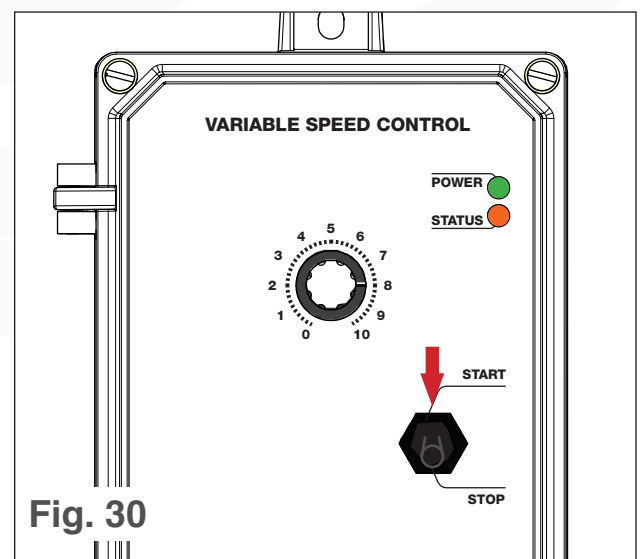
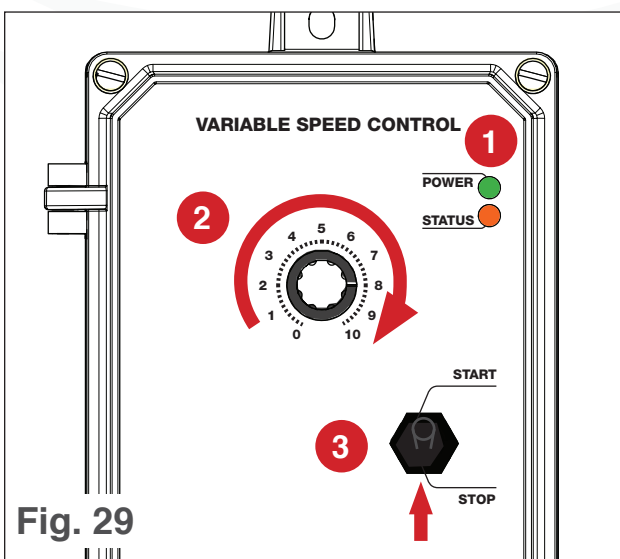
CONTROL BOX OVERVIEW



OPERATION

To operate the conveyors:

1. Ensure the conveyors are fully assembled.
2. Ensure the feed chute is inside the tumbler without the tumbler contacting the conveyor rollers or sidewalls.
3. Ensure the QC Conveyor is directly under the lower end of the tumbler without it touching the tumbler or trimmer.
4. Plug in the conveyors.
5. Ensure the **POWER** light is on (see Fig. 29).
6. Ensure the **STATUS** light is a steady yellow/orange (see Fig. 29 and **Status Light Guidelines**).
7. Twist the belt speed dial to the desired speed (see Fig. 29).
8. Move the start/stop switch to the **START** position (see Fig. 29).
9. Place product on the Feed Conveyor continuously and at a consistent height.
10. During operation, adjust the belt speed dial so the same volume of product enters and exits the tumbler simultaneously.
11. To stop the conveyors, move the start/stop switch to the **STOP** position (see Fig. 30).



STATUS LIGHT GUIDELINES

The **STATUS** light on the control box indicates the drive status. The light will emit various colours at various intervals to indicate different statuses:

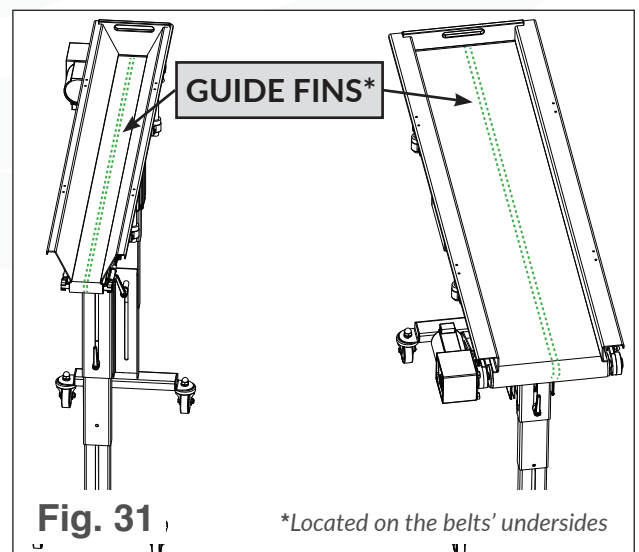
- Slow Flashing Green = Normal Operation When Started
- Steady Yellow/Orange = Normal Operation When Stopped
- Steady Red = Drive Overload
- Quick Flashing Red = Drive Timed Out
- Slow Flashing Red = Short Circuit
- Quick Flashing Red and Yellow/Orange = Undervoltage
- Slow Flashing Red and Yellow/Orange = Overvoltage
- Slow Flashing Yellow/Orange = Stand-By
- Rapid Flashing Yellow/Orange = Input Phase Loss
- Slow then Quick Flashing Red = Overtemperature Trip

If any lights other than the two at the top of the above list appear, contact Keirton technical support (see **Contact Us** on page 39).

INSPECTIONS

To ensure optimal performance of the conveyors, **ALL** of the following inspections should be made on a weekly basis.

1. Inspect the belts for any fraying or other physical damage.
2. Ensure the inner and outer leg knobs are tight.
3. Inspect the Feed Conveyor sidewalls for marks at the open end of the conveyor. If there are marks, the sidewalls are touching the tumbler. Ensure the sidewalls are not touching the tumbler during operation.
4. Ensure the conveyor belt guide fins are seated in the roller grooves (see Fig. 31).
5. Ensure there is a $\frac{1}{8}$ " gap between the sidewall and conveyor belt. If there is not, adjust the sidewalls higher (see **Step 4: Adjust the Sidewall Heights** on page 15).
6. Inspect the belt tensions:
 - a. Turn on the conveyors to a slow speed (see **Operation** on page 22).
 - b. Apply a light resistance to the conveyor belts to inspect for slippage or stuttering.
 - c. Turn off the conveyors.
 - d. If slipping or stuttering occurred on either conveyor, tighten the belts. Only tighten the belt enough to prevent slipping. The belt should be as loose as possible while not allowing any slipping (see **Conveyor Belt Tension Adjustments** on page 25).



To ensure optimal performance of the conveyors, the conveyor belts and feed chute should be sanitized between each use, and the entire conveyors should be cleaned at least once a week.

Belt and Chute Sanitization

1. Ensure the conveyors have been safely switched off and locked out from power using your facility's lockout procedure.
2. Cover the ends of the plugs to prevent water damage and electric shock.
3. Wipe the entire outer surface of the belts and feed chute with water and detergent.
Do not get the motor or control box wet.
4. Rinse the belts with water.
5. Wipe the entire outer surface of the conveyor belts with a sanitizer*.

*Using isopropyl alcohol may wear the belt.

Full Cleaning

1. Ensure the conveyors have been safely switched off and locked out from power using your facility's lockout procedure.
2. Cover the motor, control box, and ends of the plugs to prevent water damage and electric shock. Do not get the motor or the ends of the plugs wet.
3. Remove the nuts and washers securing the feed chute to the sidewalls.



DANGER

TO PREVENT ELECTRIC SHOCK,
ENSURE THE CONVEYORS
ARE UNPLUGGED AND THE
PLUGS ARE COVERED BEFORE
CLEANING.



CAUTION

DO NOT USE STEAM ON THE
CONVEYOR BELT.

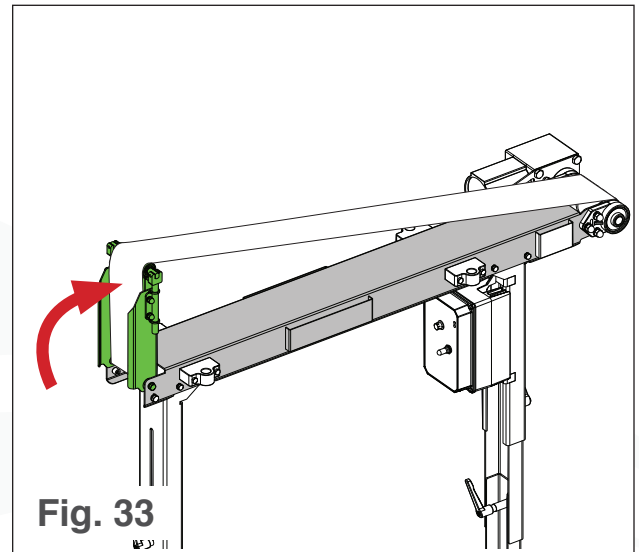
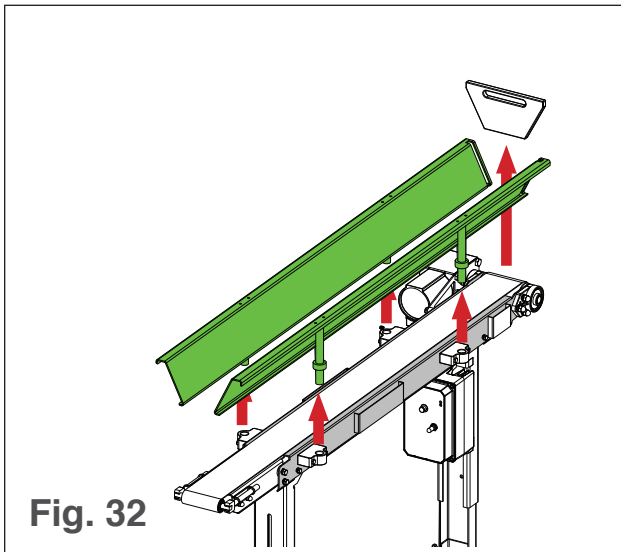


DANGER

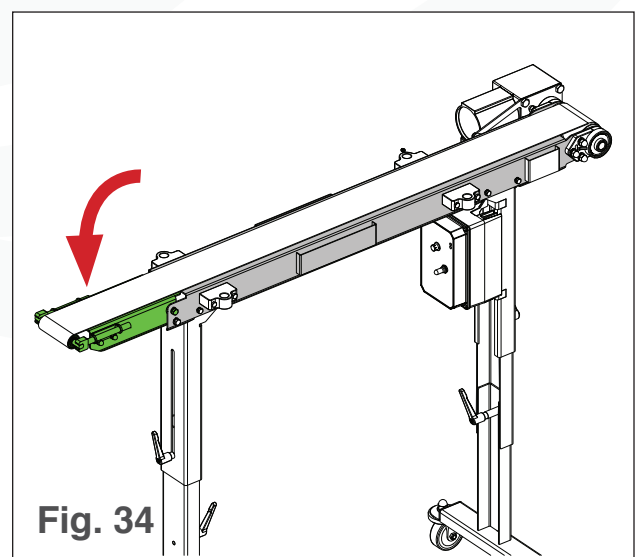
TO PREVENT ELECTRIC SHOCK,
DO NOT GET THE MOTOR OR
CONTROL BOX WET.



CLEANING



4. Remove the chute from the sidewalls.
5. Remove both sidewalls and the end plate from the conveyor bed (see Fig. 32).
6. Flip up the tilt tail so the underside of the belts can be accessed (see Fig. 33).
7. Remove any large, easy-to-remove pieces of product from the conveyors.
8. Except for the motor and control box, spray the entirety of the conveyors—including the removed sidewall, feed chute, and under the belts—with a foaming detergent.
9. Allow the detergent to sit for five minutes.
10. Repeat steps 5 and 6 as necessary.
11. Carefully avoiding the motor and control box, pressure wash the conveyors to remove residue.
12. Dry the conveyors with compressed air.
13. Except for the motor and control box, wipe the entirety of the conveyors with isopropyl alcohol or another sanitizer.



14. Allow the sanitizer to dry.
15. Rotate the tilt tail back down (see Fig. 34).
16. Ensure the guide fin on the underside of the belt is nested in the end roller grooves.
17. Reattach the side walls.

Conveyor Belt Tension Adjustments

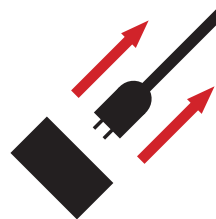
The conveyor belts need tension adjustments when being replaced and over time as they stretch. If the belts are not tensioned enough, they could stutter or jam. To tension the conveyor belts:

1. Ensure the conveyors are switched off and unplugged.
2. Ensure the conveyors are at least 1' away from the tumbler.
3. Spin the belt adjustment nuts on both sides of the conveyors (located on the tilt tail) to push the roller away from/closer to the conveyor (see Fig. 35). Spin each nut the exact same number of rotations to keep the roller parallel to the rest of the conveyor. Do not over-tension the belt. Over tensioning will result in excessive load on the pulley bearings and early wearing of the belt. The belt should be as loose as possible while not allowing any slipping.
4. Turn the conveyor belt to ensure the belt stays in the center of the conveyor. If the belt moves to one side, the rollers are not parallel. Tighten the adjustment nut on the side the belt is moving towards, then repeat this step.



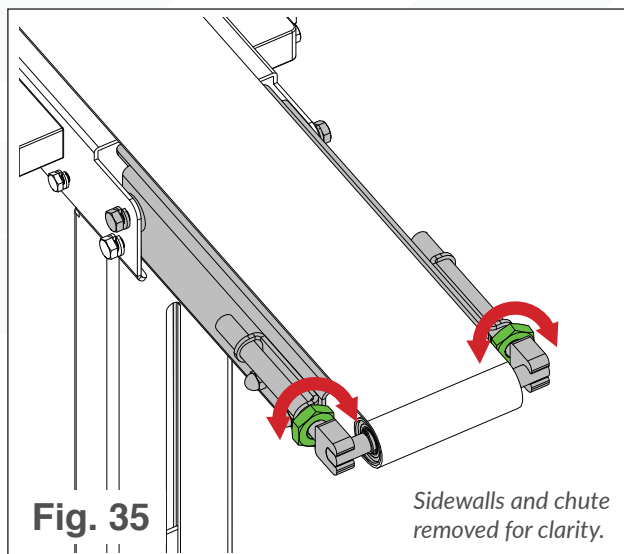
DANGER

**SWITCH OFF THE MOTORS,
THEN UNPLUG THE CONVEYORS
BEFORE CONDUCTING ANY
MAINTENANCE.**



CAUTION

**DO NOT OVER-TENSION THE
BELT.**



Conveyor Belt Replacement

If the conveyor belt begins to fray or suffers any other kind of damage, it should be replaced as soon as possible. To replace the conveyor belt:

1. Ensure the conveyors are switched off and unplugged.
2. Remove the nuts and washers securing the feed chute to the sidewalls.
3. Remove the chute from the sidewalls.
4. Place two supports under the conveyor bed so it does not fall to the ground when the legs are removed (see Fig. 36).
5. Remove the four $\frac{1}{4}$ "-20 x $\frac{5}{8}$ " hex head bolts securing the top of one of the leg assemblies to the conveyor bed (see Fig. 37).
4. Remove the leg assembly from the conveyor bed (see Fig. 38).
5. Repeat steps 3 and 4 on the second leg assembly.

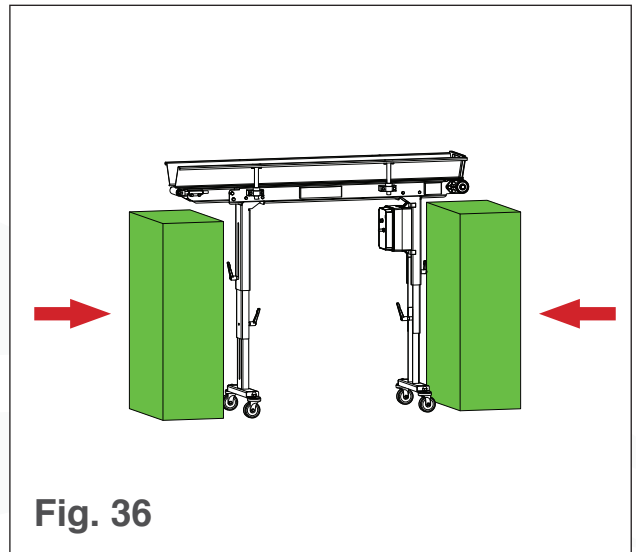


Fig. 36

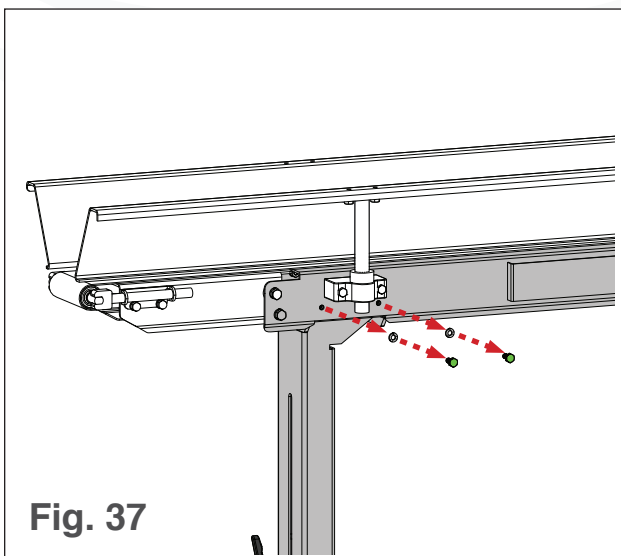


Fig. 37

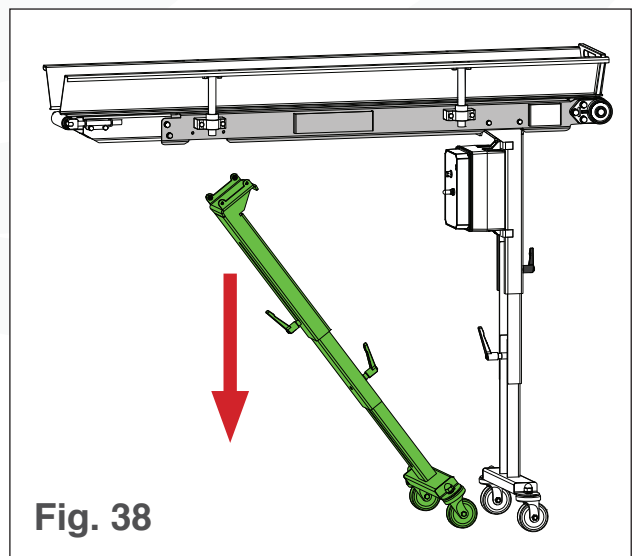


Fig. 38

6. Remove both sidewalls.
7. Flip up the tilt tail (see Fig. 39).
8. Rest the conveyor bed on the side opposite the motor (see Fig. 40). Do not rest the conveyor bed on its motor-side.
9. Slide the old belt off the conveyor bed.
10. Slide the new belt onto the conveyor bed.
11. Rotate the conveyor bed so it is flat.
12. Rotate the tilt tail back down.
13. Ensure the guide fin on the underside of the belt is nested in the end roller grooves.
14. Reattach the leg assemblies (see **Step 1: Attach the Legs to the Conveyor Bed** on page 11).
15. Tension the belt (see **Conveyor Belt Tension Adjustments** on page 28).



CAUTION

DO NOT REST THE CONVEYOR BED ON ITS MOTOR-SIDE.

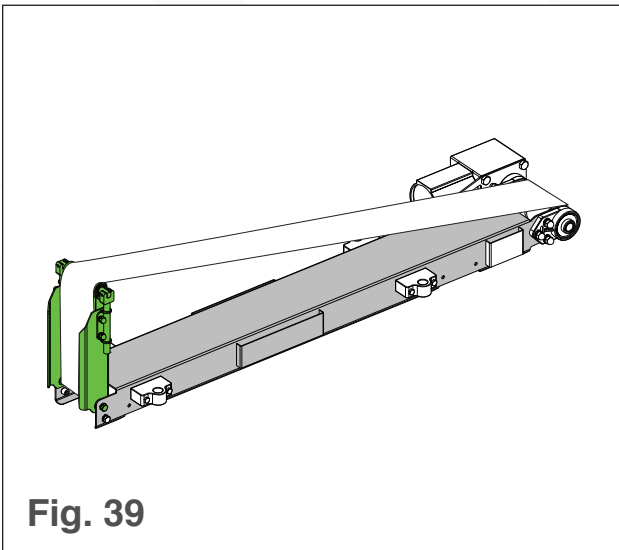


Fig. 39

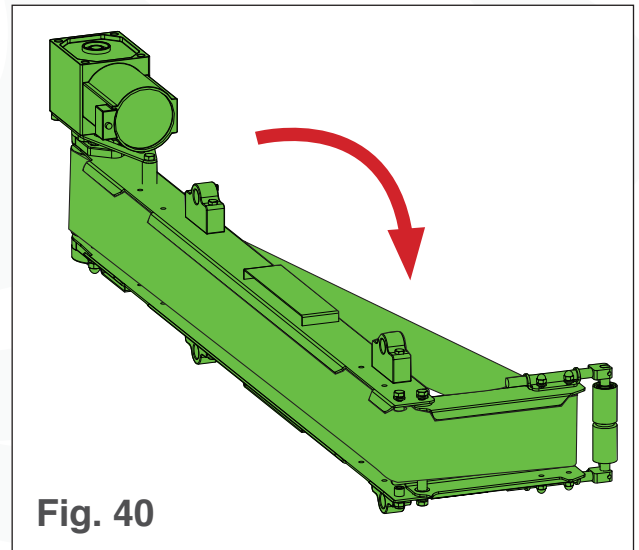


Fig. 40

If any problems not listed in this section arise, or any troubleshooting solutions do not solve the problem, contact Keirton technical support for assistance (see **Contact Us** on page 39).

The Conveyor Belt Jams/Won't Move

Possible Causes

- There is not a sufficient gap between the sidewalls and the belt.
- The motor is not working.
- The belt is not tensioned enough.

Solution:

1. Ensure there is at least a $\frac{1}{8}$ " gap between the conveyor sidewalls and the belt (see **Step 4: Adjust the Side Wall Heights** on page 15).
2. If there is a sufficient gap between the sidewalls and the belt, turn on the motor (see **Operation** on page 22). If the rollers are not spinning, then the motor is not working. Contact Keirton technical support (see **Contact Us** on page 39).
3. If the motors are working, inspect the belt tension (see **Inspections** on page 24). The belt tension should be just tight enough to pull the belt. If it is not, increase the belt tension (see **Conveyor Belt Tension Adjustments** on page 28). Do not over tension the belt.

Product Spills onto the Floor

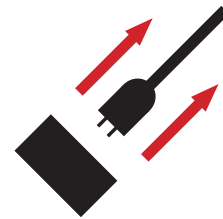
Possible Causes:

- The Feed Conveyor is not close enough to the tumbler.



DANGER

**SWITCH OFF THE MOTORS,
THEN UNPLUG THE CONVEYORS
BEFORE CONDUCTING ANY
TROUBLESHOOTING.**



TROUBLESHOOTING

- The QC Conveyor is not close enough to the trimmer.
- The QC Conveyor is not raised high enough.

Solution:

- If product spills going into the tumbler:
 - a. Inspect if the feed chute is inside the tumbler. If it is not, adjust the conveyor so the feed chute is inside the tumbler (see **Step 3: Align the Conveyors with the Tumbler** on page 20).
- If product spills coming out of the tumbler:
 - a. Inspect if the QC Conveyor is under the tumbler. If it is not, move it closer to the trimmer (see **Step 3: Align the Conveyors with the Tumbler** on page 20).
 - b. If the QC Conveyor is under the tumbler, raise the QC Conveyor higher so it is as close to the bottom of the tumbler as possible without it touching the tumbler (see **Step 2: Adjust the Conveyor Heights** on page 18).

WARRANTY INFORMATION

Keirton will repair or replace any parts proven defective in material or workmanship without charge for a period of one year.

The warranty period will begin on the date the machine is purchased by the initial purchaser. The Stainless Steel Conveyors warranty defects can be remedied at any authorized service dealer or directly by Keirton. Any original parts deemed to be defective will be replaced free of charge. Keirton reserves the right to use any manufacturer approved replacement parts for warranty repair.

If warranty repair is required, please contact Keirton at **1-888-254-3204** or **support@keirton.com** and provide the following information:

- Model and serial number (located on the opposite side of of the conveyor bed to the motor)
- Proof of purchase date
- Copy of the original Warranty Registration Card (unless registration was completed online)
- Details of the defect or problem (including photos and/or video).

Pending approval from Keirton, the machine or defective part must then be returned to Keirton for analysis and replacement. **Do not return the machine to the place of purchase for repair or warranty claims unless you have been authorized by Keirton to do so.** The place of purchase can only sell replacement parts and will not repair warranty issues unless it is noted as an authorized repair dealer and has been authorized to work on your machine.

You may be denied warranty coverage if your machine has failed due to:

- Abuse
- Accidental damage
- Improper maintenance
- Improper electrical connection

WARRANTY INFORMATION

- Neglect
- Normal wear
- Unapproved modifications including the use of unapproved replacement parts.

Keirton assumes no risk and shall be subject to no liability for damages or loss resulting from the specific use or application made of the product. In no event will Keirton be liable for any special, incidental, or consequential damages (including loss of use, loss of profit, and claims of third parties) however caused, whether by negligence of the manufacturer or otherwise. If you have any questions regarding your warranty rights and responsibilities, please contact Keirton.

The Stainless Steel Conveyors are intended for use on legal aromatic herbs and hops. Please check all municipal, provincial/state, and federal laws and regulations before using the Stainless Steel Conveyors. Keirton does not promote or condone the use of the Stainless Steel Conveyors in any way that may be deemed illegal.

Allow only persons who understand this manual to operate the Stainless Steel Conveyors. Keirton claims no liability for any damage or injury that results from the use of the Stainless Steel Conveyors by persons who have not read and understood the cautions, warnings, and danger notices contained in this manual or through any misuse of the Stainless Steel Conveyors. You are responsible for your safety while operating these machines. **Please keep yourself safe!**

North American Specifications

Product Numbers	Feed Conveyor	26-10018A
	QC Conveyor	26-10019A
Certifications	Both Conveyors Certifications	UL, CSA, CE, RoHS
Dimensions	Both Conveyors Belt Length	58"/147.3cm
	Feed Conveyor Belt Width	4"/10.2cm
	QC Conveyors Belt Width	13"/33cm
	Feed Conveyor Belt Height Range	25-44"/63.5-111.8cm
	QC Conveyor Belt Height Range	20-34"/50.8-86.4cm
	Feed Conveyor Side Wall Height	4"/10.2cm
	QC Conveyor Side Wall Height	2.25"/5.7cm
Electrical Requirements	Both Conveyors Input Voltage	115VAC, 60Hz, 1ph
	Both Conveyors Connector Plug	NEMA 5-15P (see Fig. 41)
	Both Conveyors Current During Start-Up	1A
	Both Conveyors Current While Running	0.8A
Materials	Both Conveyors Belt Material	Polyurethane (TPU) FDA Compliant
Motor	Both Conveyors Motor Power	1/10hp, 75W
Speed	Feed Conveyor Speed Range	0-24ft/min (0-7.3m/min)
	QC Conveyor Speed Range	0-12ft/min (0-3.6m/min)
Weight	Feed Conveyor Weight	100lbs/45kg
	QC Conveyor Weight	130lbs/59kg

SPECIFICATIONS

**NEMA
5-15P**

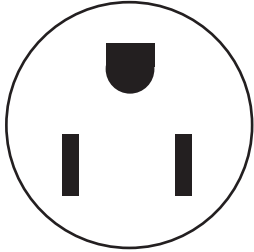


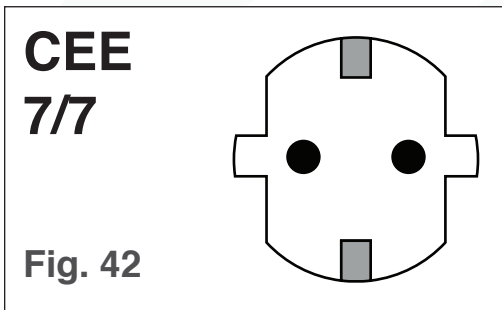
Fig. 41

European Specifications

Product Numbers	Feed Conveyor	26-10053A
	QC Conveyor	26-10054A
Certifications	Both Conveyors Certifications	UL, CSA, CE, RoHS
Dimensions	Both Conveyors Belt Length	147.3cm/58"
	Feed Conveyor Belt Width	10.2cm/4"
	QC Conveyors Belt Width	33cm/13"
	Feed Conveyor Belt Height Range	63.5-111.8cm/25-44"
	QC Conveyor Belt Height Range	50.8-86.4cm/20-34"
	Feed Conveyor Side Wall Height	10.2cm/4"
	QC Conveyor Side Wall Height	5.7cm/2.25"
Electrical Requirements	Both Conveyors Input Voltage	230VAC, 50Hz, 1ph
	Both Conveyors Connector Plug	CEE 7/7 (see Fig. 42)
	Both Conveyors Current During Start-Up	0.5A
	Both Conveyors Current While Running	0.4A

SPECIFICATIONS

Materials	Both Conveyors Belt Material	Polyurethane (TPU) FDA Compliant
Motor	Both Conveyors Motor Power	1/10hp, 75W
Speed	Feed Conveyor Speed Range	0-7.3m/min (0-24ft/min)
	QC Conveyor Speed Range	0-3.6m/min (0-12ft/min)
Weight	Feed Conveyor Weight	45kg/100lbs
	QC Conveyor Weight	59kg/130lbs



Cleaning Equipment

Item	Product Number
Twister Foam Cannon	25-0024

Spare Parts*

Item	Product Number
T2/T4 SS Conveyor Belt	17-10101A
T2/T4 SS Conveyor Caster	14-10219
T2/T4 SS Conveyor Feed Chute	11-10563A

*Not listed in the **Parts and Tools** section.

Keirton technical support is available between 7 a.m. and 7 p.m. Pacific Standard Time seven days a week at:

- **1-888-254-3204**
- **support@keirton.com**



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