

# TWISTER

STANDARD CONVEYORS



USER MANUAL

PN: 21-0100-00\_REV02

Front Cover: Twister Standard Height Feed and QC Conveyors



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# IMPORTANT SAFETY INFORMATION

This manual is for the Twister Standard and Extended Height Conveyors. In this manual, the Standard and Extended Height Conveyors will simply 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 48).

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. If necessary, use two people to lift.
- 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 43) 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 and control box.

## 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.

# IMPORTANT SAFETY INFORMATION

- 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 adjustment may result in damage to the machine.
- 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

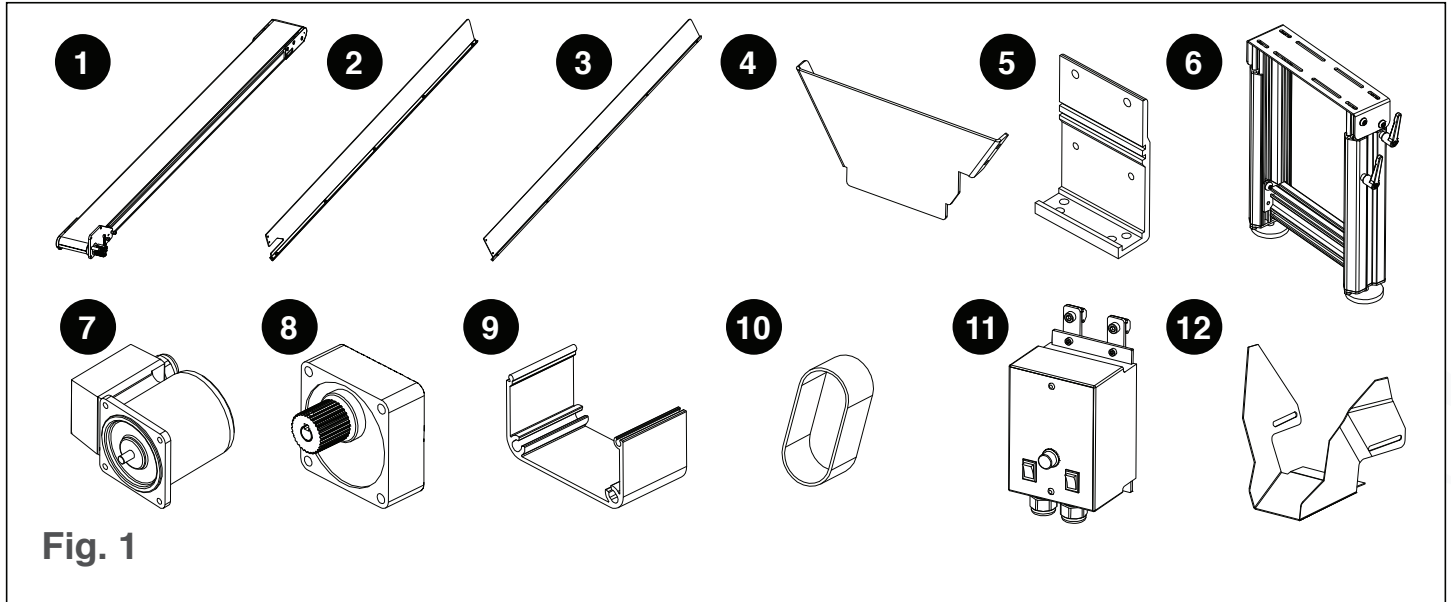
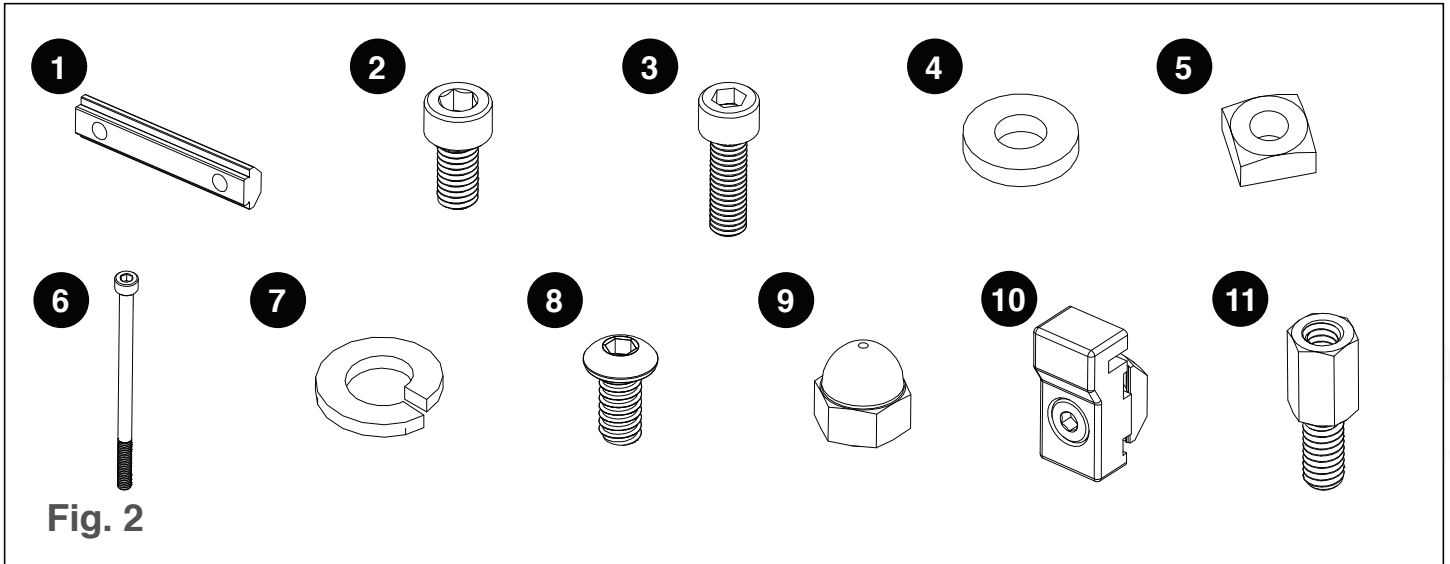


Fig. 1

Reference	Description	Part Number	Quantity
1	Feed Conveyor Bed and Belt	26-0006 (Bed Assembly) 26-0033 (Belt)	1 1
2	Feed Right Flare and Guide Rail	26-0023 (Flare) 26-0052 (Rail)	1 1
3	Feed Left Flare and Guide Rail	26-0024 (Flare) 26-0052 (Rail)	1 1
4	Feed End Plate	26-0025	1
5	Mounting Bracket	26-0038	4
6	Standard Feed Support Stand/Extended Height Feed Support Stand	26-0044/26-0099	2
7	Standard Conveyor AC Motor	26-0011	1
8	Gearhead	26-0013	1
9	Gearhead Cover Plate	26-0095	2
10	Timing Belt	26-0035	1
11	Standard VFD Control Box	26-0046	1
12	Standard Conveyor Feed Chute	11-10564A	1

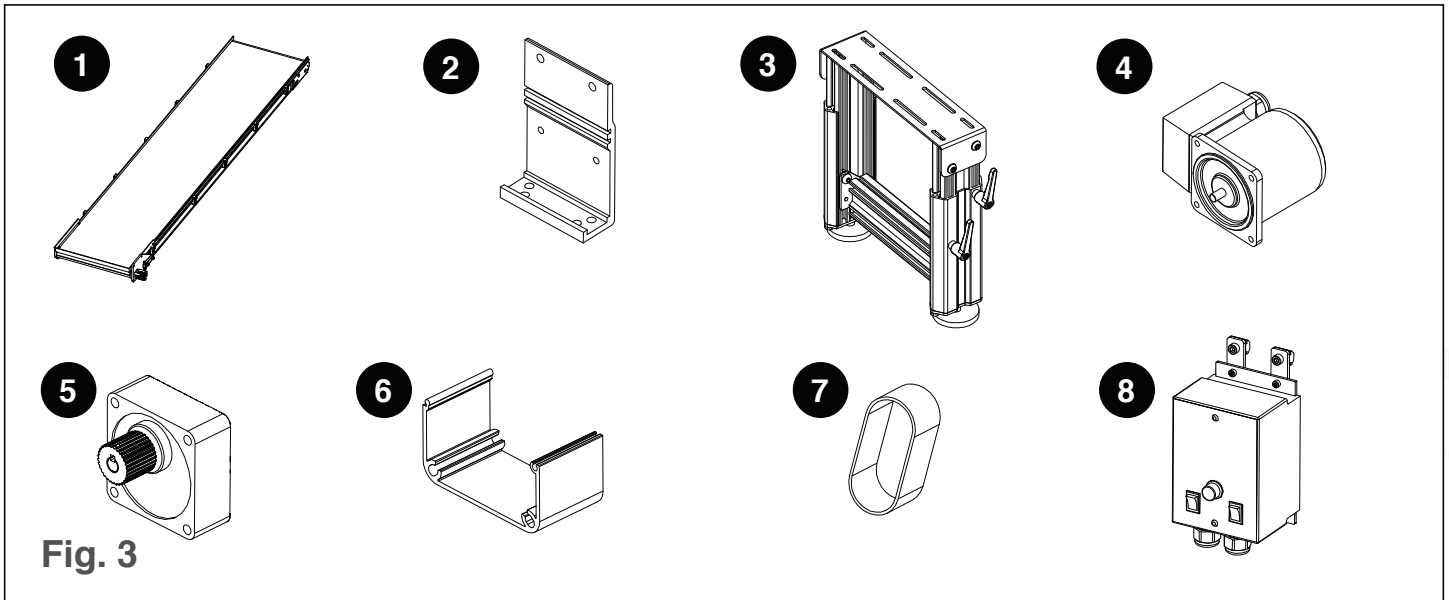
## Parts: Feed Conveyor Fasteners



Reference	Description	Part Number	Quantity
1	M6-1.0 Double T-Bar	26-0050	4
2	M6-1.0 x 12mm Bolt	13-0094	8
3	M6-1.0 x 20mm Bolt	13-0159	8
4	M6 Washer	26-0039	8
5	M6-1.0 Square Nut	13-0160	8
6	M5-0.8 x 90mm Bolt	13-0368	4
7	M5 Split Washer	13-0370	4
8	8-32 x 3/8" Bolt	13-0345	4
9	8-32 Acorn Nut	13-0344	4
10	Conveyor Guide Clip	26-0075	8
11	8-32 Standoff	13-10363	2



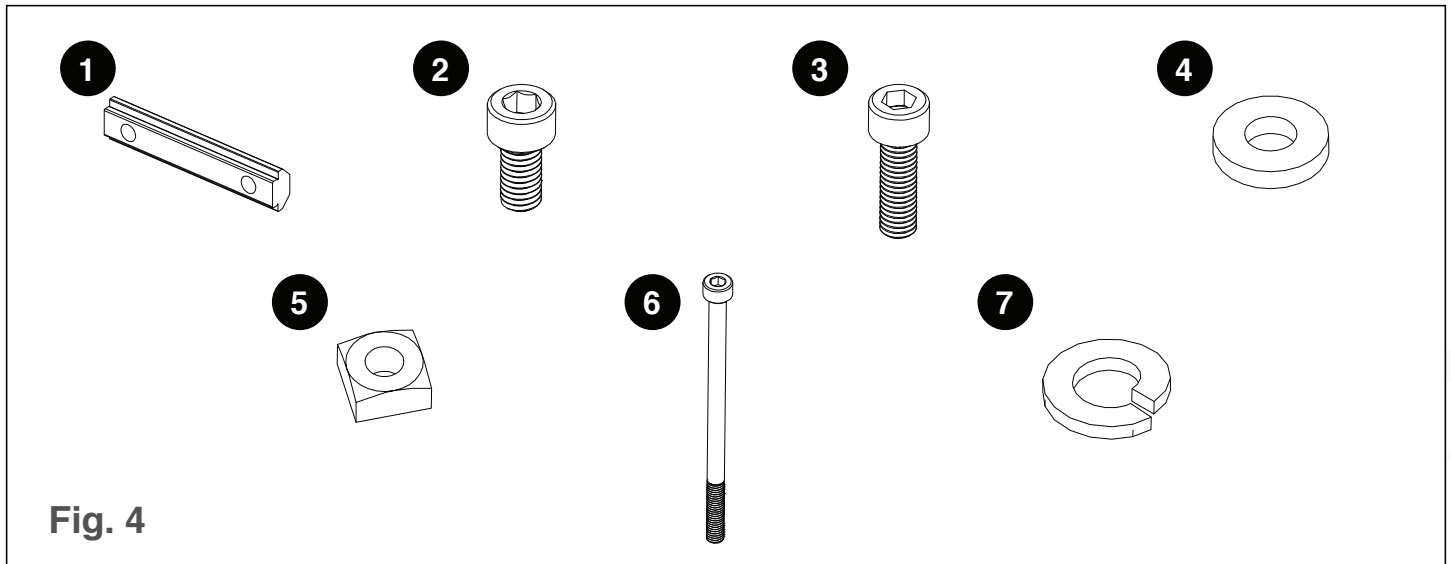
## Parts: QC Conveyor Components



Reference	Description	Part Number	Quantity
1	QC Conveyor Bed, Belt, Guide Rails, Clips, and End Flare	26-0009 (Bed, Belt, and Clips) 26-0027 (Rails) 26-0032 (Flare)	1 2 1
2	Mounting Bracket	26-0038	4
3	Standard QC Support Stand/Extended Height QC Support Stand*	26-0049/26-0044	2
4	Standard Conveyor AC Motor	26-0011	1
5	Gearhead	26-0013	1
6	Gearhead Cover Plates	26-0095	1
7	Timing Belt	26-0035	1
8	Standard VFD Control Box	26-0046	1

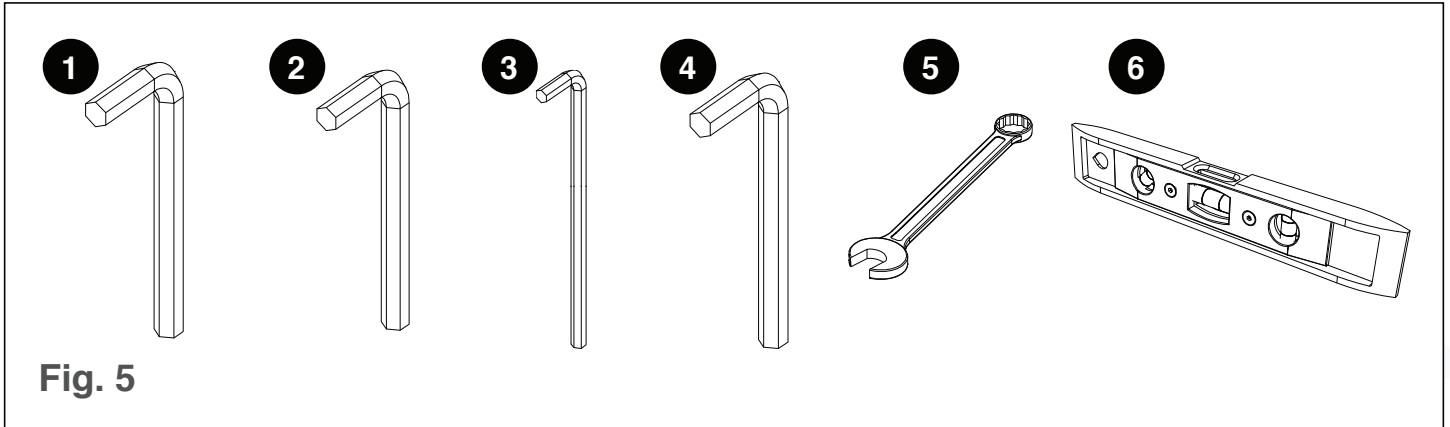
\*The extended height QC support stands are identical to the standard feed support stands.

## Parts: QC Conveyor Fasteners



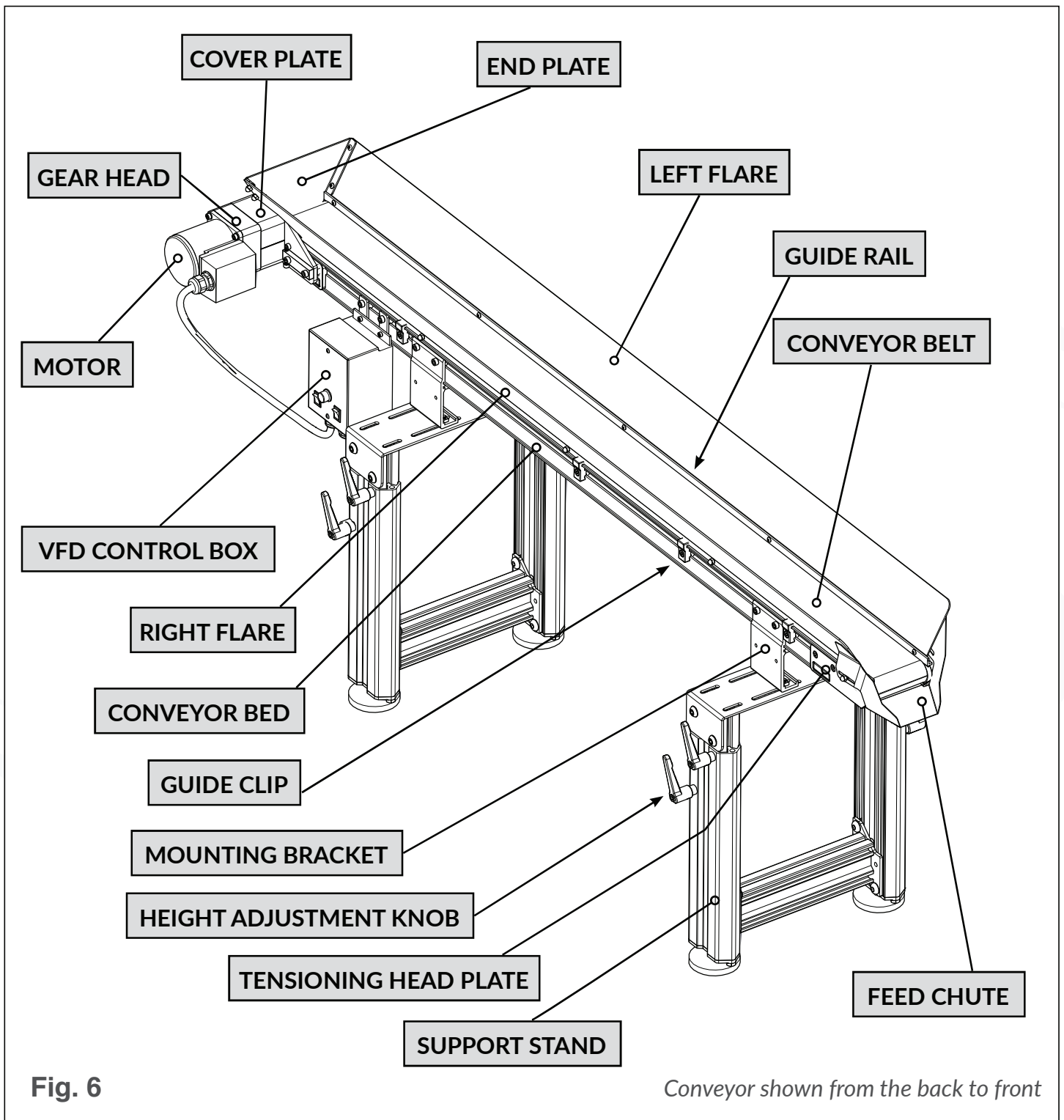
Reference	Description	Part Number	Quantity
1	M6-1.0 Double T-Bar	26-0050	4
2	M6-1.0 x 12mm Bolt	13-0094	10
3	M6-1.0 x 20mm Bolt	13-0159	8
4	M6 Washer	26-0039	8
5	M6-1.0 Square Nut	13-0160	8
6	M5-0.8 x 100mm Bolt	13-0369	4
7	M5 Split Washer	13-0370	4

## Tools Needed for Assembly



Reference	Description	Quantity
1	5mm Hex Key	1
2	4mm Hex Key	1
3	$\frac{3}{32}$ " Hex Key	1
4	$\frac{7}{32}$ " Hex Key	1
5	$\frac{5}{16}$ " Wrench	1
6	Torpedo Level	1

# ASSEMBLED FEED CONVEYOR



# ASSEMBLED QC CONVEYOR

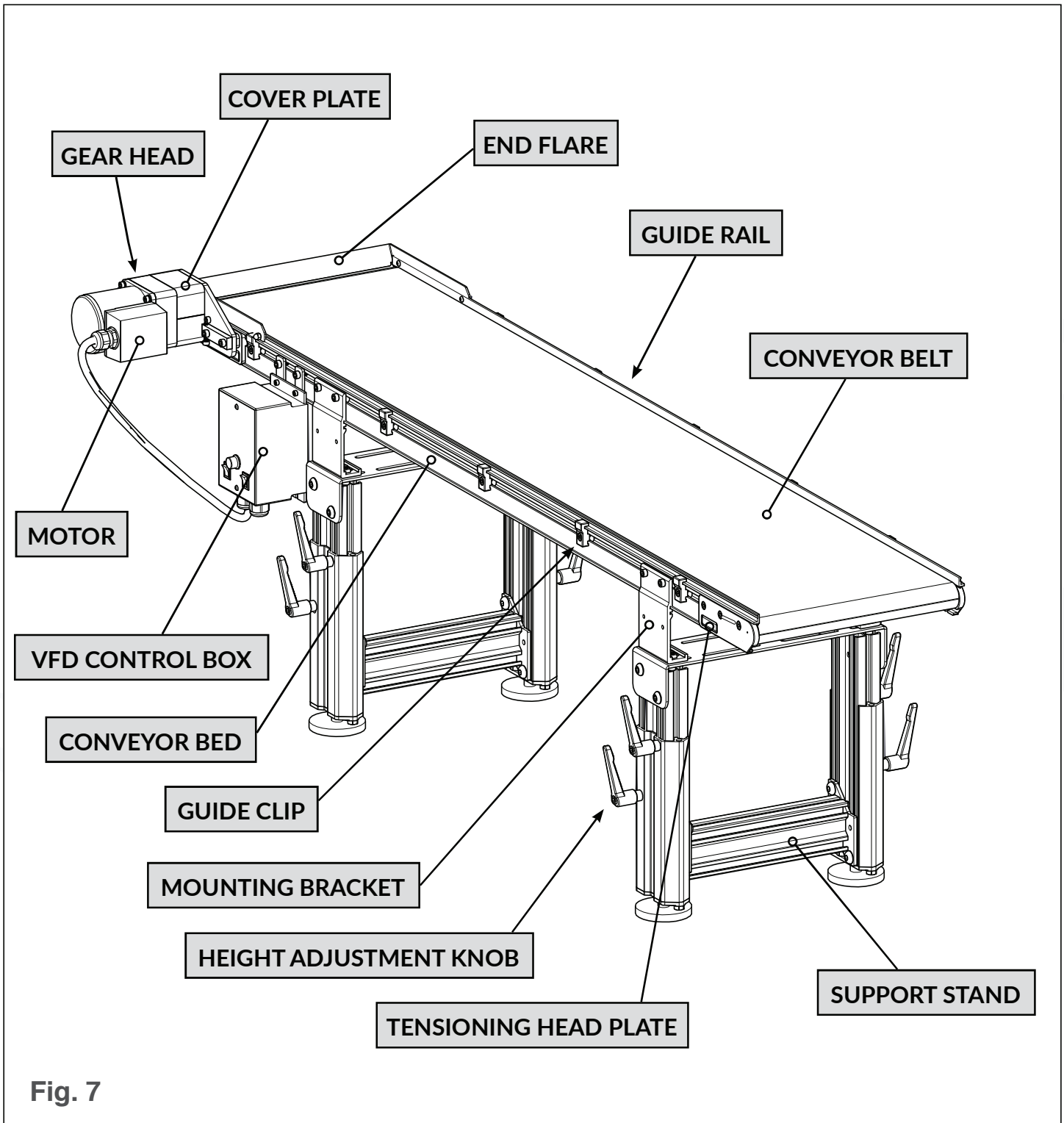
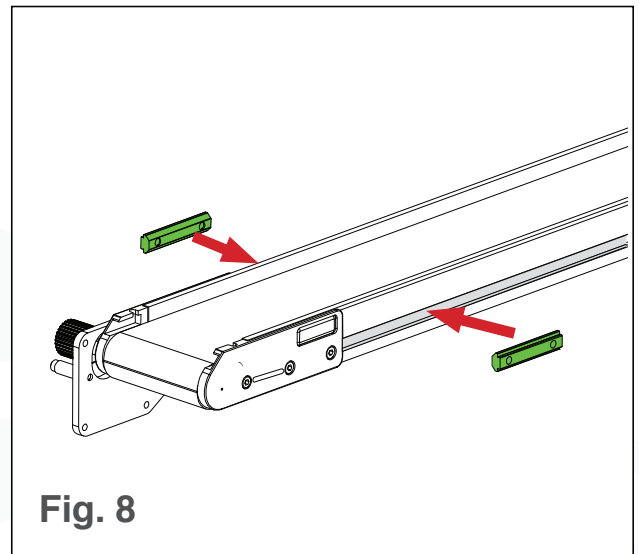


Fig. 7

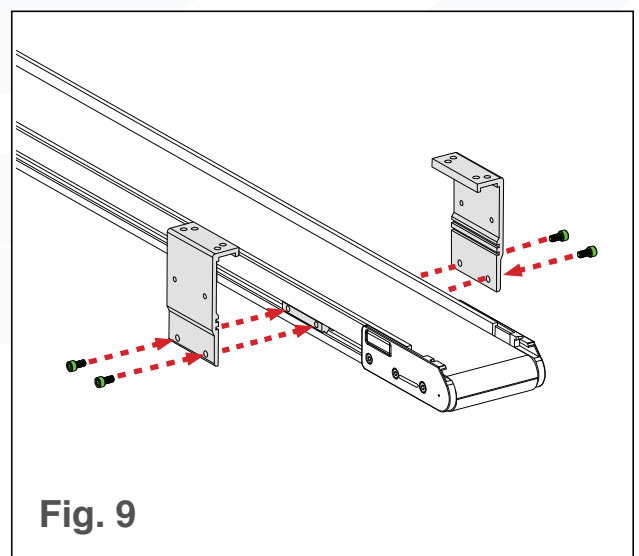
## Step 1: Attach the Mounting Brackets to the Conveyor Bed

1. Place the conveyor bed upside down on a flat surface.
2. Insert two double T-bars into the conveyor bed side slots on both sides of the conveyor about 1' from either end (see Fig. 8). Ensure the flat side of the T-bars is facing out.
3. Place two M6-1.0 x 12mm bolts through the top of each mounting bracket then into the double T-bars (see Fig. 9). **Do not tighten the bolts yet**, and ensure the flat side of the mounting bracket is facing away from the conveyor bed.

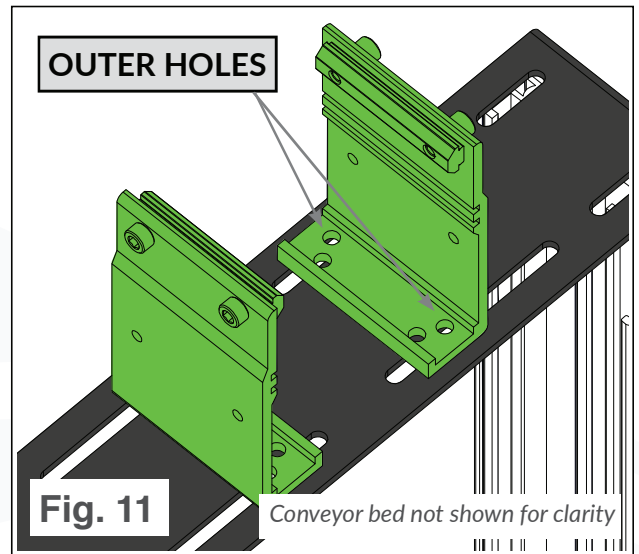
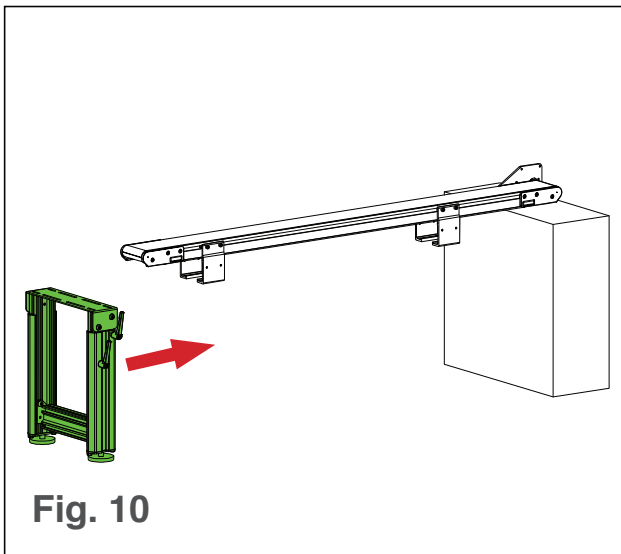


## Step 2: Attach the Mounting Brackets to the Support Stands

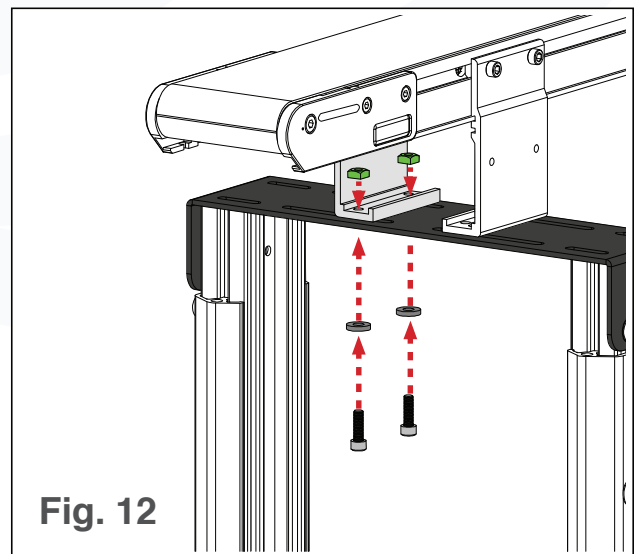
1. Rotate the conveyor bed back upright.
2. Prop one end of the conveyor bed on a support 18-24" from the ground.
3. Slide one of the support stands under the unsupported end of the conveyor bed (see Fig. 10).
4. On the unsupported end, align the outer holes in the bottom of the mounting brackets with the slots in the top of the support stand (see Fig. 11).
5. Place two square nuts on the top of



# FEED CONVEYOR ASSEMBLY



- each outer hole in one of the mounting brackets (see Fig. 12).
6. Place a M6-1.0 x 20mm bolt through a M6 washer, then up through the bottom of the mounting bracket and into the square nuts (see Fig. 12). **Do not tighten the bolts yet.**
  7. Repeat steps 6 and 7 on the second mounting bracket.
  8. Adjust the mounting brackets so they are:
    - 6-12" from each end of the conveyor bed (see Fig. 13)
    - Aligned with each other (see Fig. 13)
    - Placed in the center of the support stand.
  9. Using a 4mm hex key, tighten the two bolts in the top of each mounting bracket.
  10. Using a 5mm hex key, tighten the two bolts in the bottom of each mounting bracket.

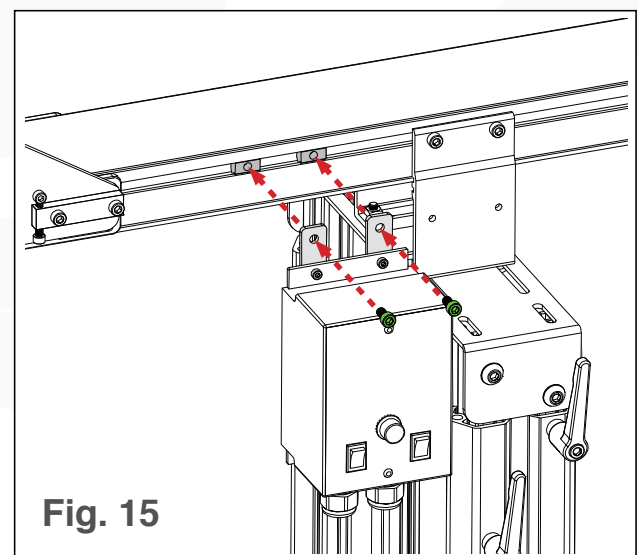
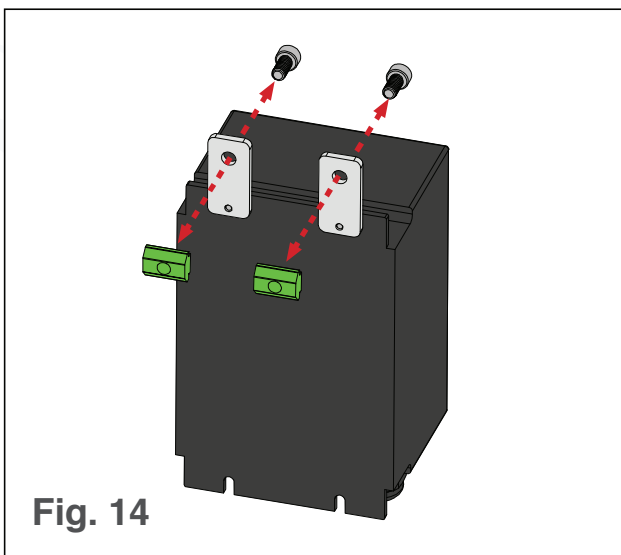
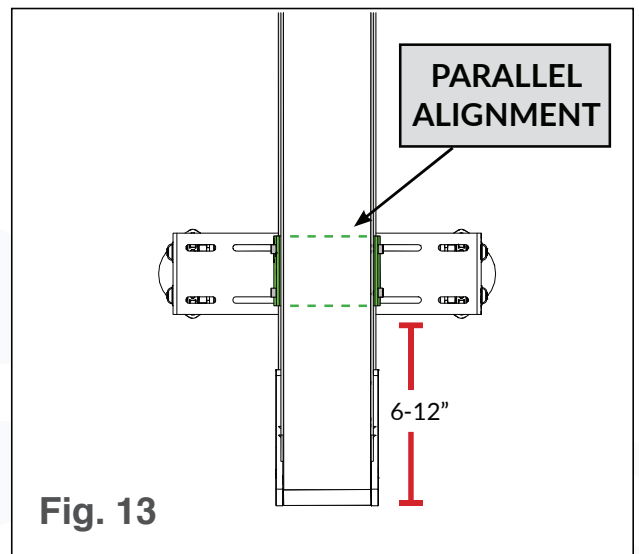


# FEED CONVEYOR ASSEMBLY

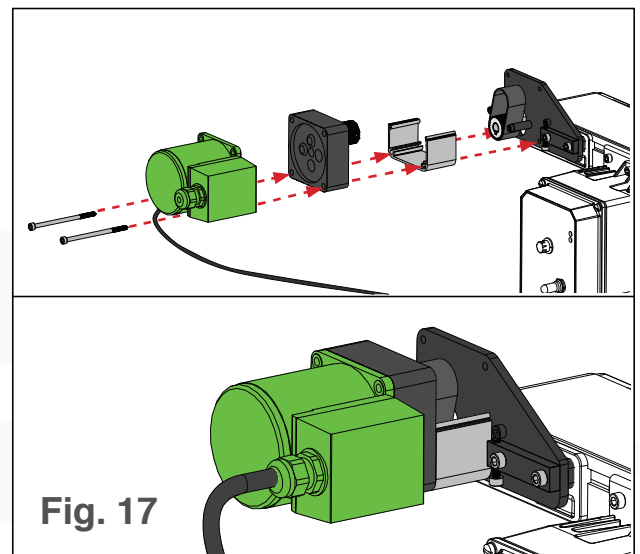
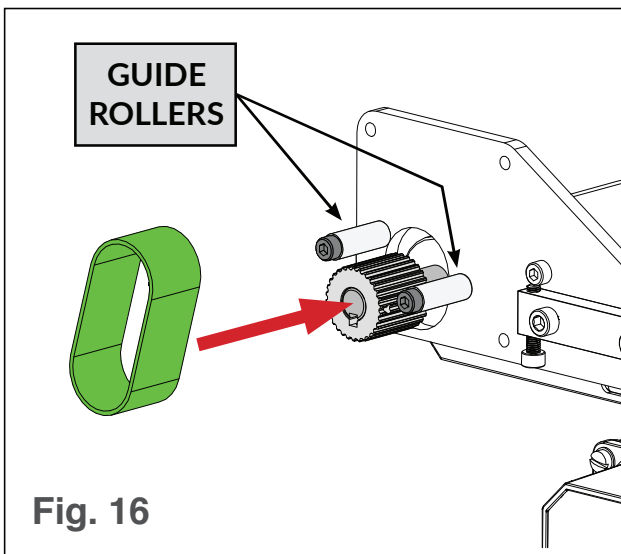
11. Repeat steps 3–10 on the other end of the conveyor bed with the second support stand.

## Step 3: Attach the Control Box to the Conveyor Bed

1. Remove the two single T-bars and bolts attached to the top of the control box (see Fig. 14).
2. Place the two single T-bars into the conveyor bed side slot next to the motor mounting bracket. Ensure the flat sides of the T-bars are facing out.
3. Using a 5mm hex key, thread the two removed bolts through the top of the control box then into the T-bars (see Fig. 15).

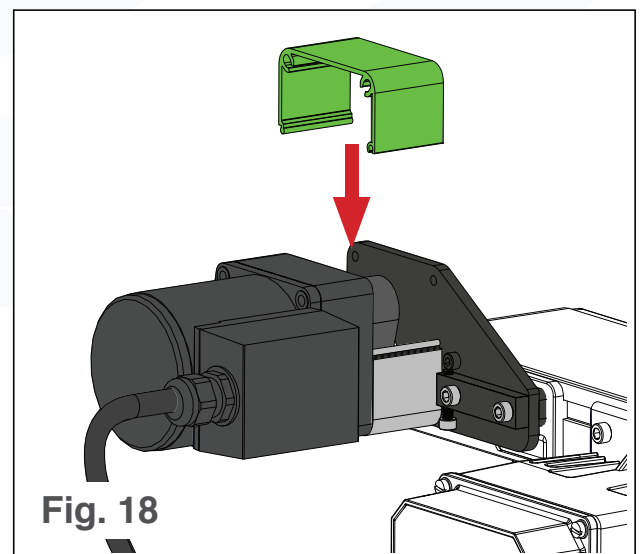


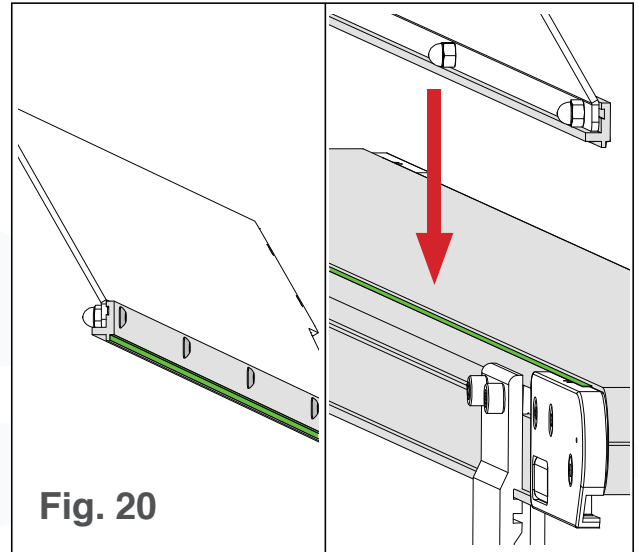
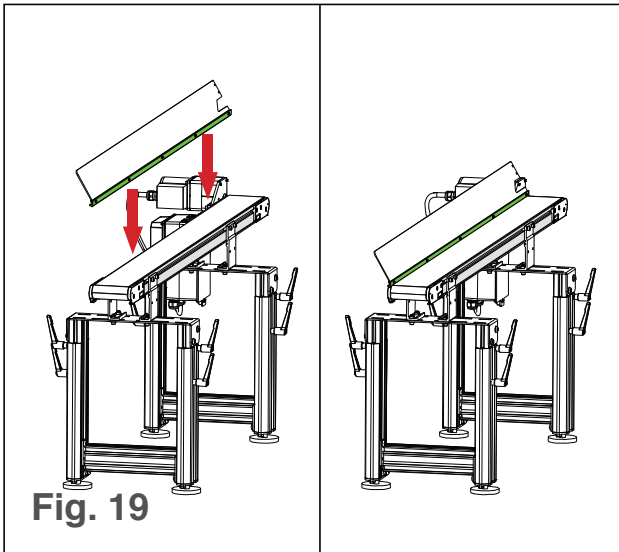




## Step 4: Attach the Motor to the Conveyor Bed

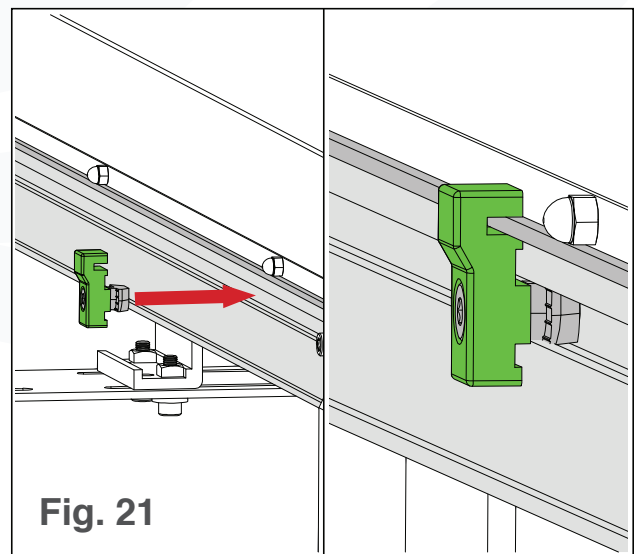
1. Place the timing belt around the drive pulley between the two belt guide rollers (see Fig. 16).
2. Align the motor with the gear head, one of the cover plates in the lower position, and motor mounting bracket (see Fig. 17). Ensure the pulley on the gear head is in the top position and the timing belt loops around both pulleys. If the timing belt cannot stretch around both drive pulleys, see **The Drive Pulleys are Too Far Apart** on page 39.
3. Using a 4mm hex key, thread two M5-0.8 x 90mm bolts through split washers, then through the bottom two holes in the motor, gearhead, cover plate, and motor mounting bracket (see Fig. 17).
4. Snap on the remaining cover plate. Expect some resistance on the cover plate (see Fig. 18).
5. Repeat step 3 with the remaining two M5-0.8 x 90mm bolts in the top two bolt holes.





## Step 5: Attach the Flares to the Conveyor Bed

1. Align the right flare guide rail with the side of the conveyor bed (see Fig. 19). Ensure the guide rail surface highlighted in Fig 20 rests on the conveyor bed surface highlighted in Fig. 20.
2. Attach four conveyor clips along the length of the conveyor bed's motor-side:
  - a. Slot the clip's T-bar into the conveyor bed side slot (see Fig. 21).
  - b. Clip the top of the clip onto the guide rail (see Fig. 21).
  - c. Rotate the T-bar 90° to secure the clip in the side slot (see Fig. 22).  
**Do not tighten the clip bolt yet.**
3. Repeat steps 1 and 2 with the left flare on the other side of the conveyor bed.



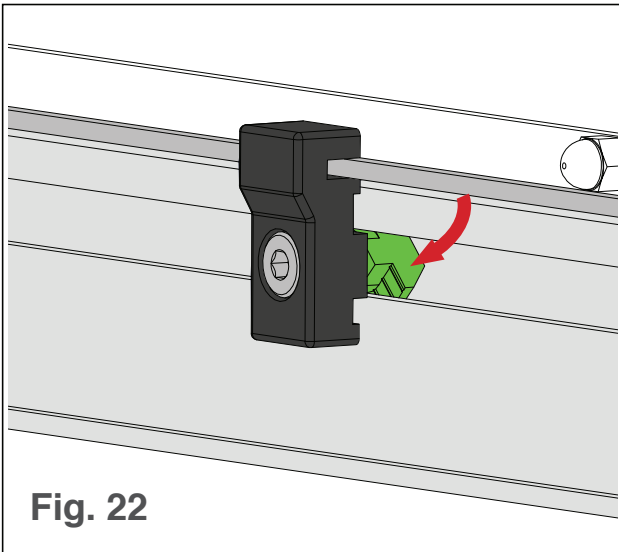


Fig. 22

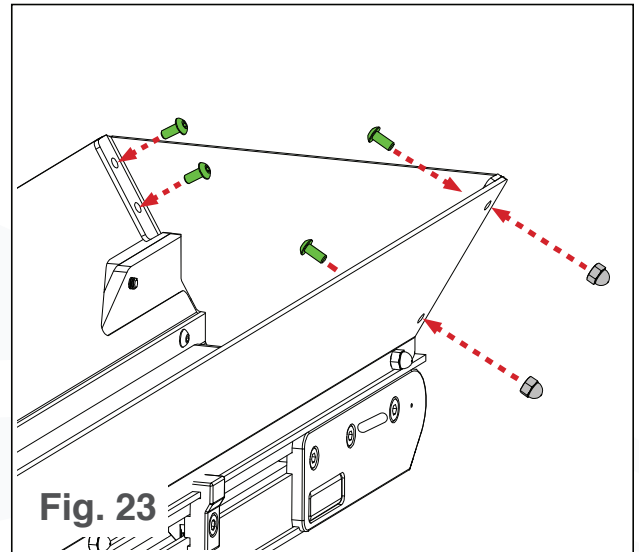


Fig. 23

## Step 6: Attach the End Plate to the Flares

1. Align the end plate with the bolt holes in the ends of the flares.
2. Place all four 8-32 x  $\frac{3}{8}$ " bolts through the end plate and flares (see Fig. 23).
3. Using a  $\frac{3}{32}$ " hex key and a  $\frac{5}{16}$ " wrench, secure the 8-32 acorn nuts over the end of each bolt (see Fig. 23).
4. Adjust the flares so there is a  $\frac{1}{4}$ " gap between the end plate and conveyor belt (see Fig. 24).
5. Using a 4mm hex key, tighten the bolts in all eight guide clips.

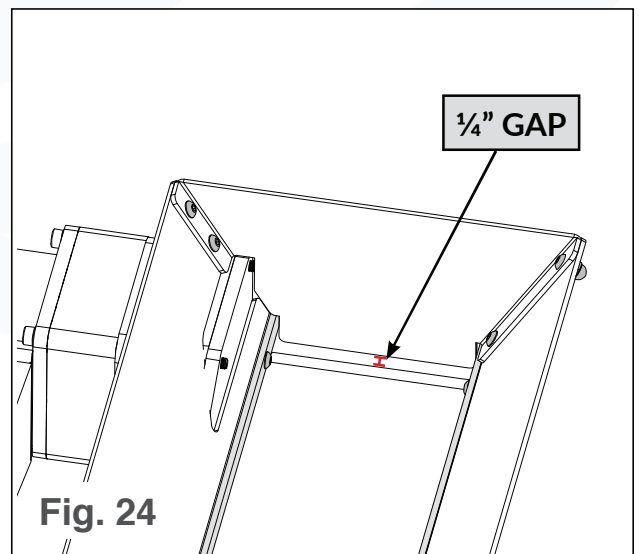
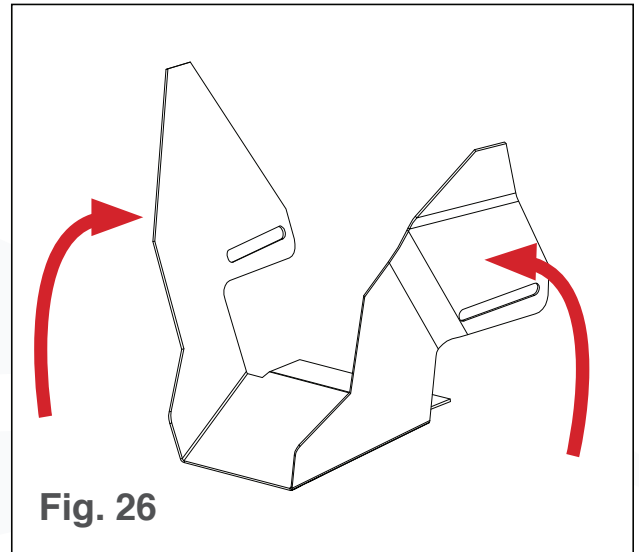
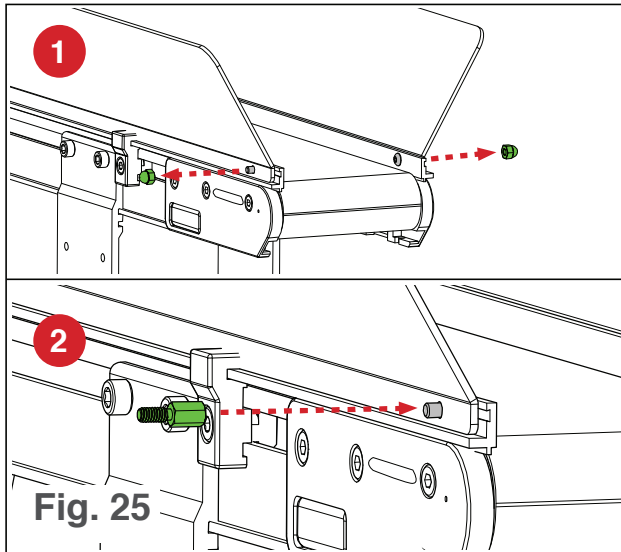


Fig. 24

## Step 7: Tension the Belts

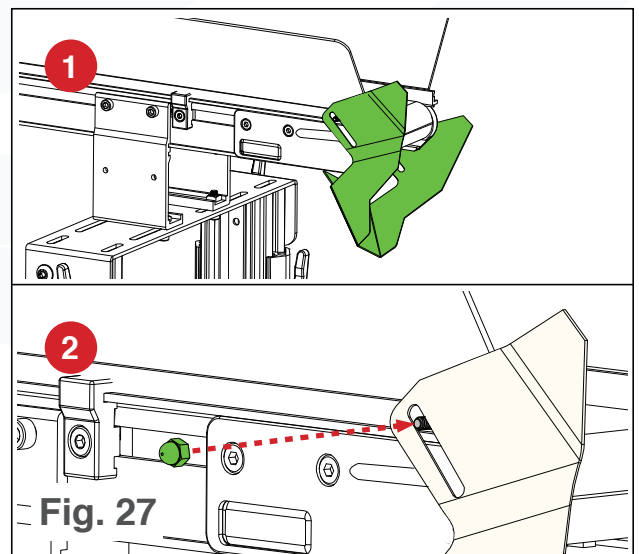
1. Tension the conveyor belt (see **Conveyor Belt Tension Adjustments** on page 33).
2. Tension the timing belt (see **Timing Belt Tension Adjustments** on page 34).

# FEED CONVEYOR ASSEMBLY

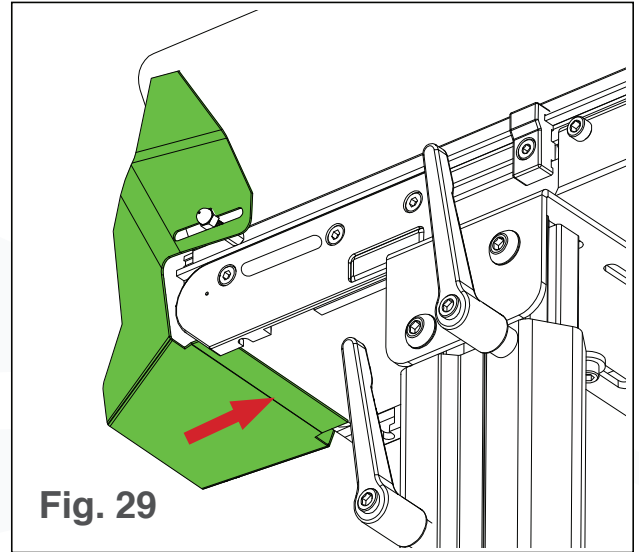
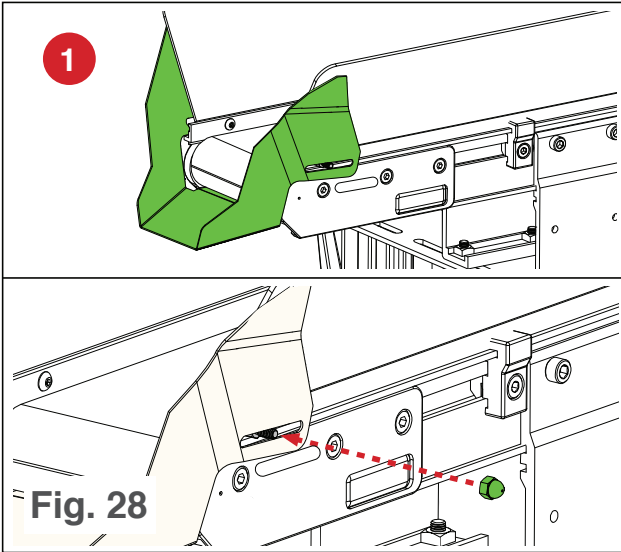


## Step 8: Attach the Feed Chute

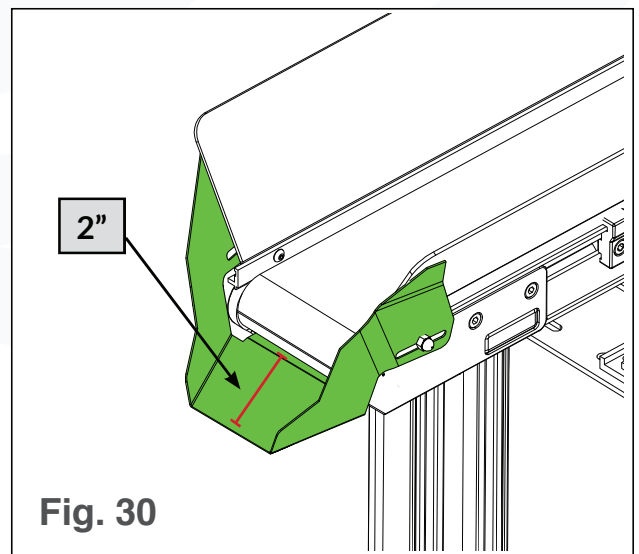
1. Using a  $\frac{3}{32}$ " hex key and a  $\frac{5}{16}$ " wrench, remove the two acorn nuts closest to the open end of the conveyor (see Fig. 25). Place these nuts aside, they will be used later to secure the feed chute.
2. Using a  $\frac{3}{32}$ " hex key and a  $\frac{5}{16}$ " wrench, tighten a  $\frac{8}{32}$  standoff over each guiderail bolt (see Fig. 25).
3. Crease the feed chute so it appears as in Fig. 26.
4. Place the slot in the right side of the feed chute over the right side standoff (see Fig. 27).
5. Using a  $\frac{3}{32}$ " hex key and a  $\frac{5}{16}$ " wrench, secure the right side of the feed chute to the conveyor bed with one of the removed acorn nuts (see Fig. 27). **Do not fully tighten the nut.**
6. Place the slot in the left side of the feed chute over the left side standoff (see Fig. 28).



# FEED CONVEYOR ASSEMBLY

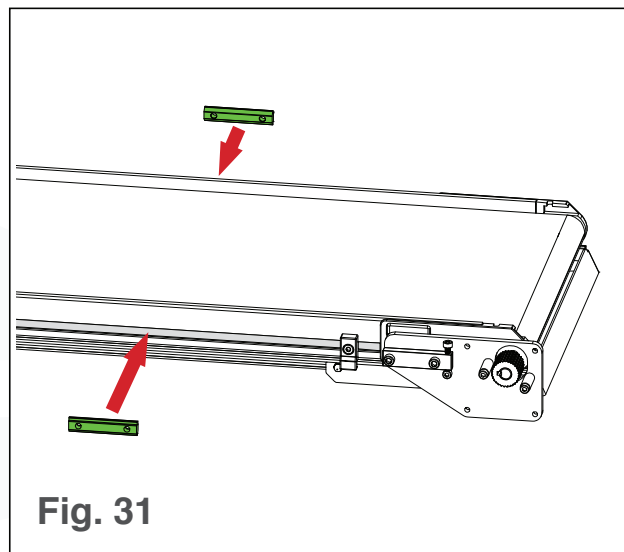


7. Using a  $\frac{3}{32}$ " hex key and a  $\frac{5}{16}$ " wrench, secure the left side of the feed chute to the conveyor bed with the remaining acorn nut (see Fig. 28). **Do not fully tighten the nut.**
8. Adjust the feed chute so the bottom flap is under the conveyor bed (see Fig. 29) and the front of the chute protrudes approximately 2" forward from the conveyor belt (see Fig. 30).
9. Tighten both acorn nuts.



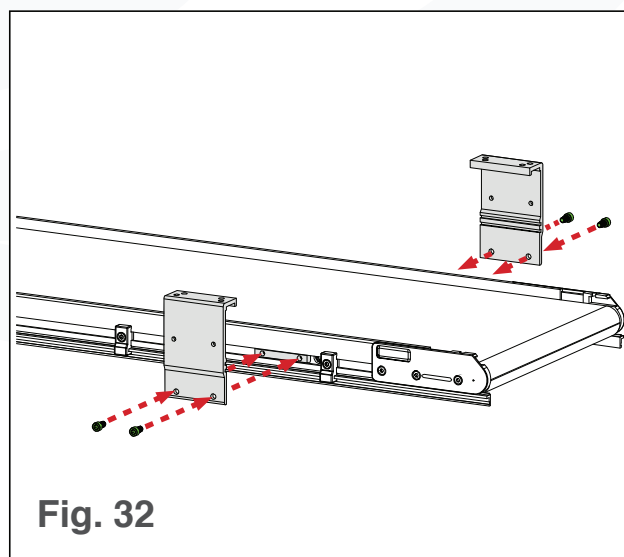
## Step 1: Attach the Mounting Brackets to the Conveyor Bed

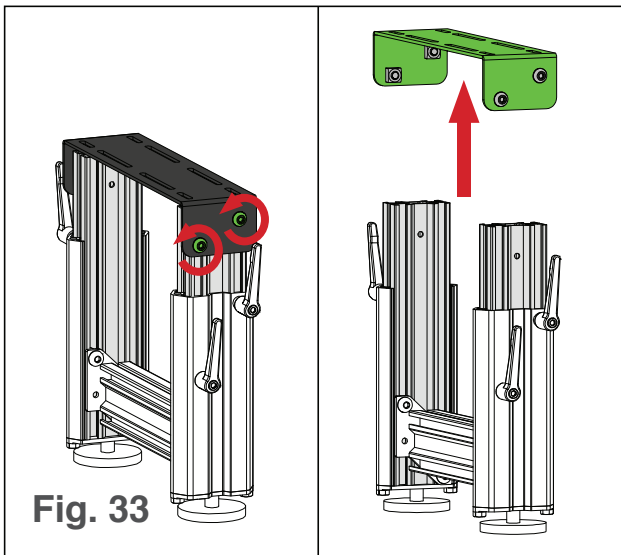
1. Place the conveyor bed upside down on a flat surface.
2. Insert two double T-bars into the conveyor bed side slots on both sides of the conveyor about 1' from either end (see Fig. 31). Ensure the flat side of the T-bars is facing out.
3. Place two M6-1.0 x 12mm bolts through the top of each mounting bracket then into the double T-bars (see Fig. 32). **Do not tighten the bolts yet**, and ensure the flat side of the mounting bracket is facing away from the conveyor bed.



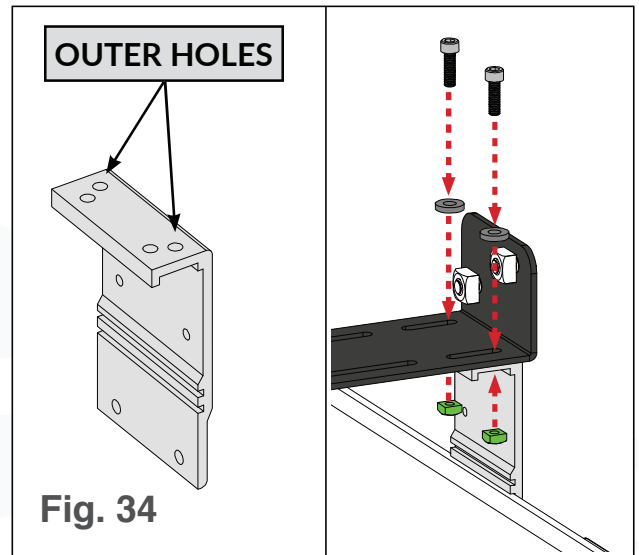
## Step 2: Attach the Support Stand Top Brackets to the Mounting Brackets

1. Using a  $\frac{7}{32}$ " hex key, loosen the bolts connecting the support stand top brackets to the support stand legs (see Fig. 33). **Do not remove the bolts.**
2. Pull the top bracket off the legs (see Fig. 33).
3. Align the outer holes in the bottom of the mounting brackets with the slots in the top brackets (see Fig. 34).
4. Hold a square nut against the bottom of





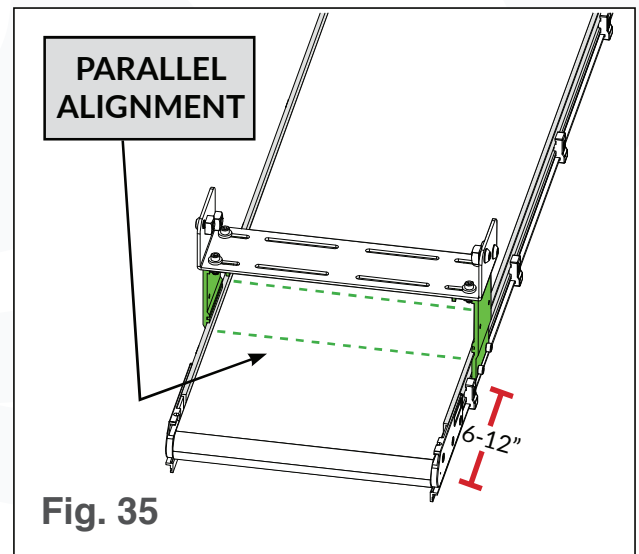
**Fig. 33**



**Fig. 34**

bottom of one of the mounting bracket outer holes (see Fig. 34).

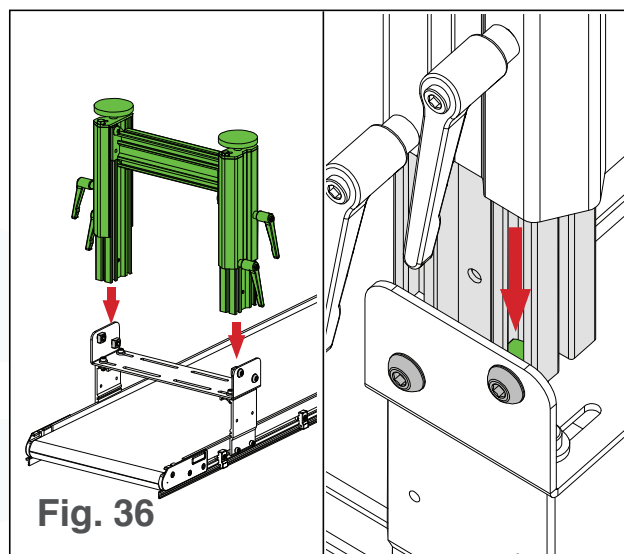
5. Using a 5mm hex key, thread a M6-1.0 x 20mm bolt through a M6 washer, then through the top bracket, mounting bracket, and square nut (see Fig. 34).
6. Repeat steps 3 and 4 on the other three mounting brackets.
7. Adjust the mounting brackets so they are:
  - 6-12" from each end of the conveyor bed (see Fig. 35)
  - Aligned with each other (see Fig. 35).
8. Using a 4mm hex key, tighten the two bolts in the top of each mounting bracket.



**Fig. 35**

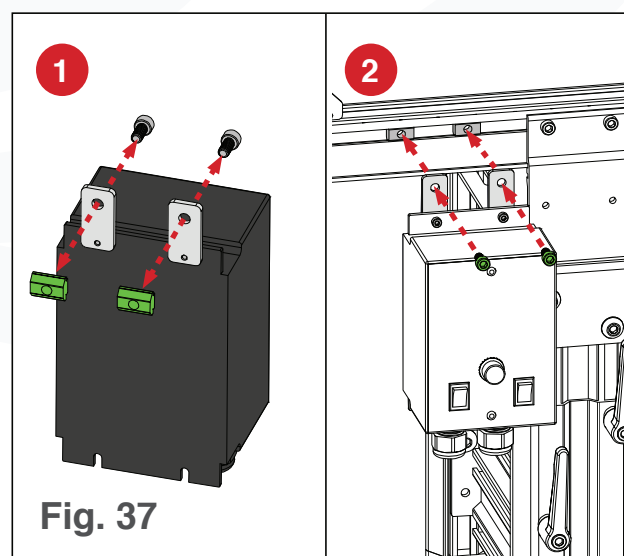
## Step 3: Attach the Support Stand Legs to the Top Brackets

1. Slot the support stand legs over the square nuts in the top brackets (see Fig. 36). The bolts in the square nuts may need to be loosened.
2. Slide the legs down so they contact the M6-1.0-20mm bolts in the top bracket.
3. Using a  $\frac{7}{32}$ " hex key, tighten the bolts in the side of the top brackets.



## Step 4: Attach the Control Box to the Conveyor Bed

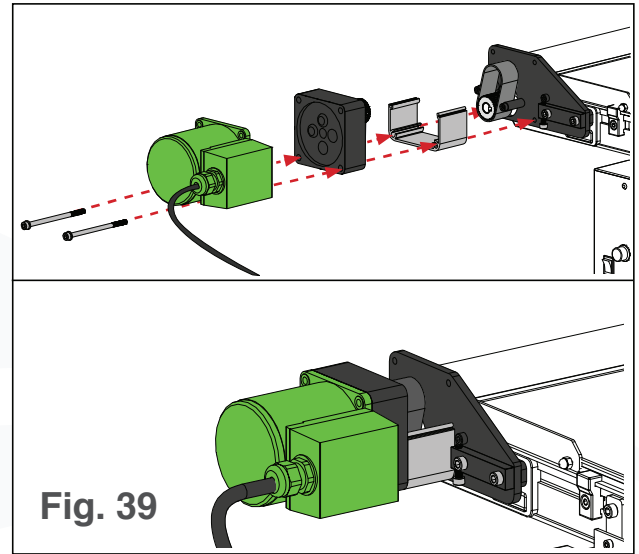
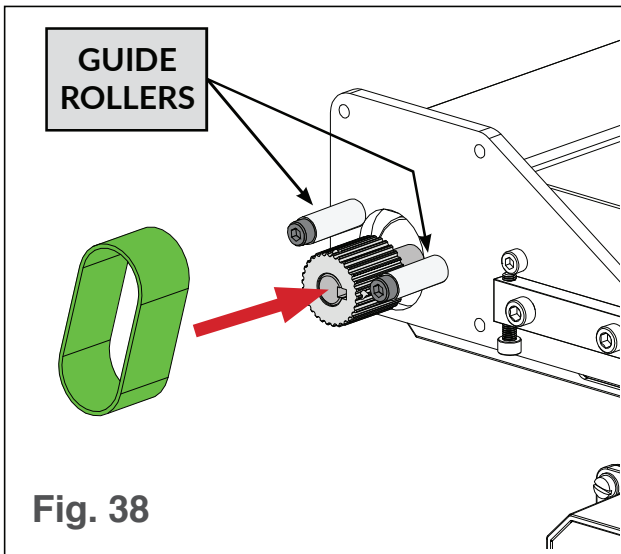
1. Rotate the conveyor back upright.
2. Remove the two single T-bars and bolts attached to the top of the control box (see Fig. 37).
3. Place the two single T-bars into the conveyor bed side slot next to the motor mounting bracket. Ensure the flat side of the T-bars is facing out.
4. Using a 5mm hex key, thread the two removed bolts through the top of the control box then into the T-bars (see Fig. 37).



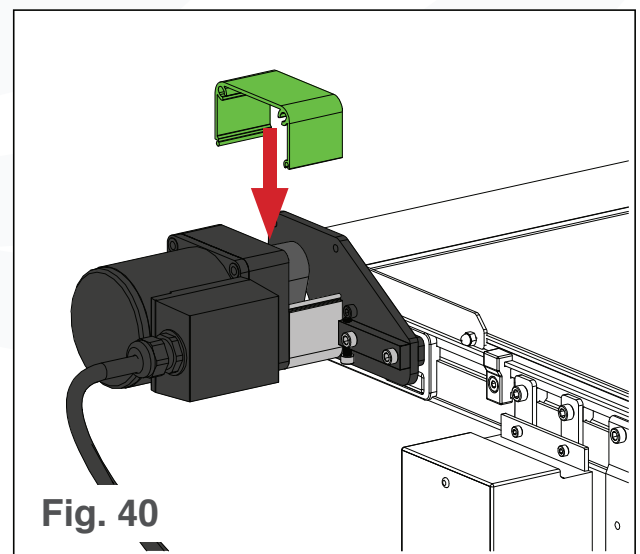
## Step 5: Attach the Motor to the Conveyor Bed

1. Place the timing belt around the drive pulley between the two belt guide rollers (see Fig. 38).





2. Align the motor with the gear head, one of the cover plates in the lower position, and motor mounting bracket (see Fig. 39). Ensure the pulley on the gear head is in the top position and the timing belt loops around both pulleys. If the timing belt cannot stretch around both drive pulleys, see **The Drive Pulleys are Too Far Apart** on page 39.
4. Using a 4mm hex key, thread two M5-0.8 x 100mm bolts through split washers, then through the bottom two holes in the motor, gearhead, cover plate, and motor mounting bracket (see Fig. 39).
5. Snap on the remaining cover plate. Expect some resistance on the cover plate (see Fig. 40).
6. Repeat step 4 with the remaining two M5-0.8 x 100mm bolts in the top two bolt holes.



## Step 6: Tension the Belts

1. Tension the conveyor belt (see **Conveyor Belt Tension Adjustments** on page 33).
2. Tension the timing belt (see **Timing Belt Tension Adjustments** on page 34).

The conveyors are heavy. Use two people for all of the following steps.

## Step 1: Move the Conveyors

1. Lift and carry the conveyors near 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. 41). **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. 41). **Do not place it directly next to the tumbler yet.**



## WARNING

THE CONVEYORS ARE HEAVY.  
USE TWO PEOPLE TO LIFT, MOVE,  
OR ADJUST THEM.



## 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 height adjustment knobs are loosened.



## WARNING

SUPPORT THE WEIGHT OF  
THE CONVEYORS WHILE THE  
ADJUSTMENT KNOBS ARE  
LOOSENED SO IT DOES NOT  
DROP.

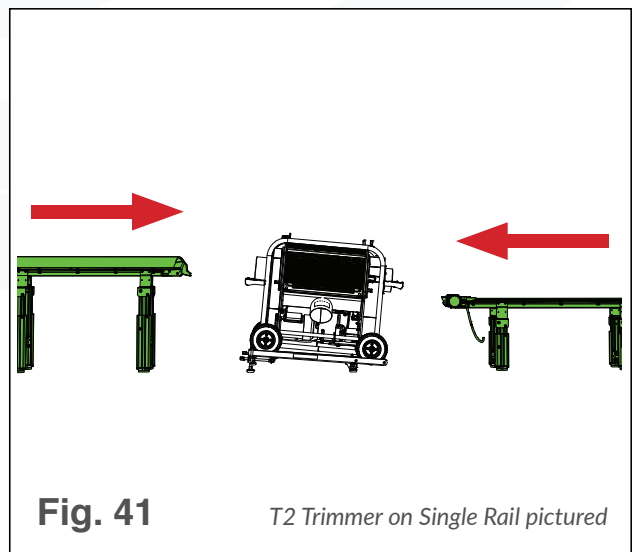
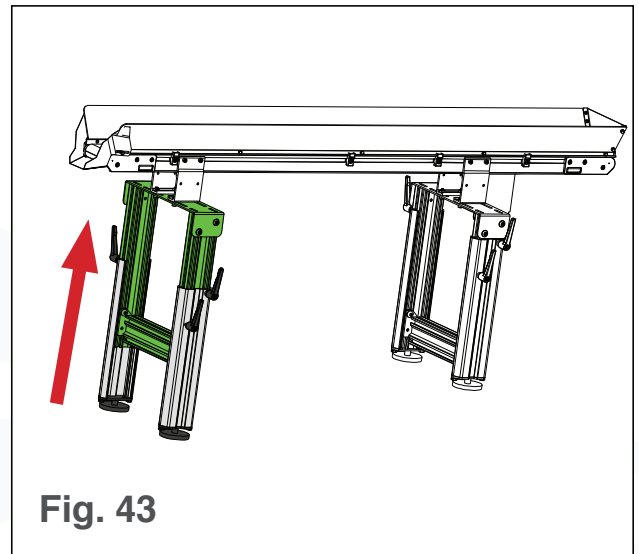
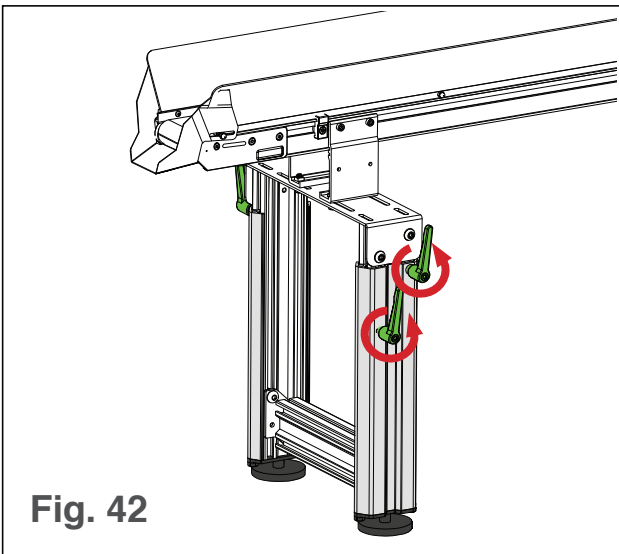


Fig. 41

*T2 Trimmer on Single Rail pictured*

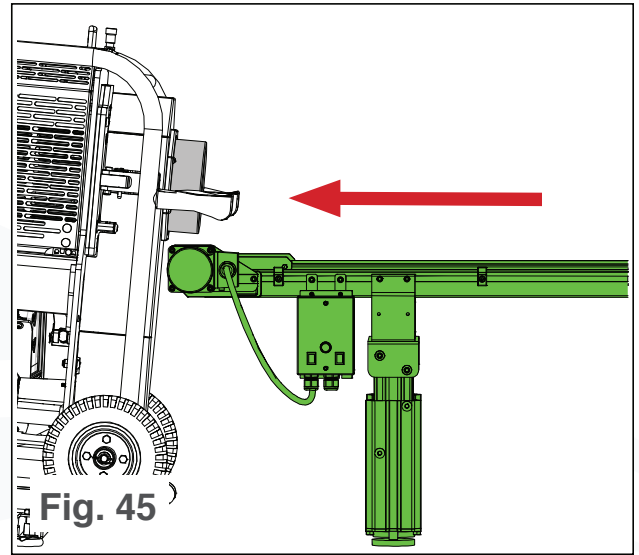
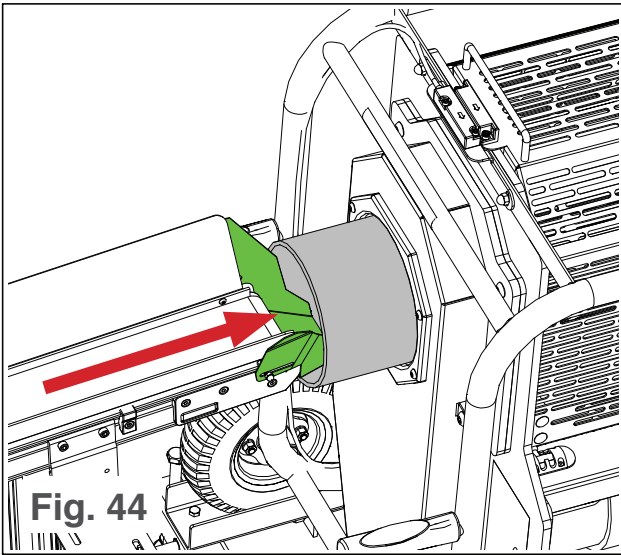
# INITIAL SETUP



3. Loosen the two height adjustment knobs on both sides of one of the support frames (see Fig. 42). **Do not remove them.**
4. Lift that side of the conveyor to the desired height (see Fig. 43 and **Conveyor Height Guidelines**). **Stop lifting the conveyors if the red warning area is showing on the side of the conveyor legs.**
5. While still supporting the conveyor bed, retighten the knobs on both sides of the support frame.
6. Repeat steps 2-5 on the other support frame.
7. Repeat steps 2-6 until the conveyor is at the desired height.

## Step 3: Align the Conveyors with the Tumbler

1. Place the feed chute inside the tumbler without the upper part of the chute contacting the tumbler (see Fig. 44). Adjust the Feed Conveyor height as necessary to achieve this result (see **Step 2: Adjust the Conveyor Heights** on page 25).
2. Place the closed end of the QC Conveyor directly under the tumbler without it touching the tumbler or trimmer (see Fig. 45). Adjust the QC Conveyor height as necessary to achieve this result (see **Step 2: Adjust the Conveyor Heights** on page 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 upper part of the chute 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.
- While the conveyors do not have to be level from end-to-end during operation, both conveyors must be level from side to side.

# CONTROL BOX OVERVIEW

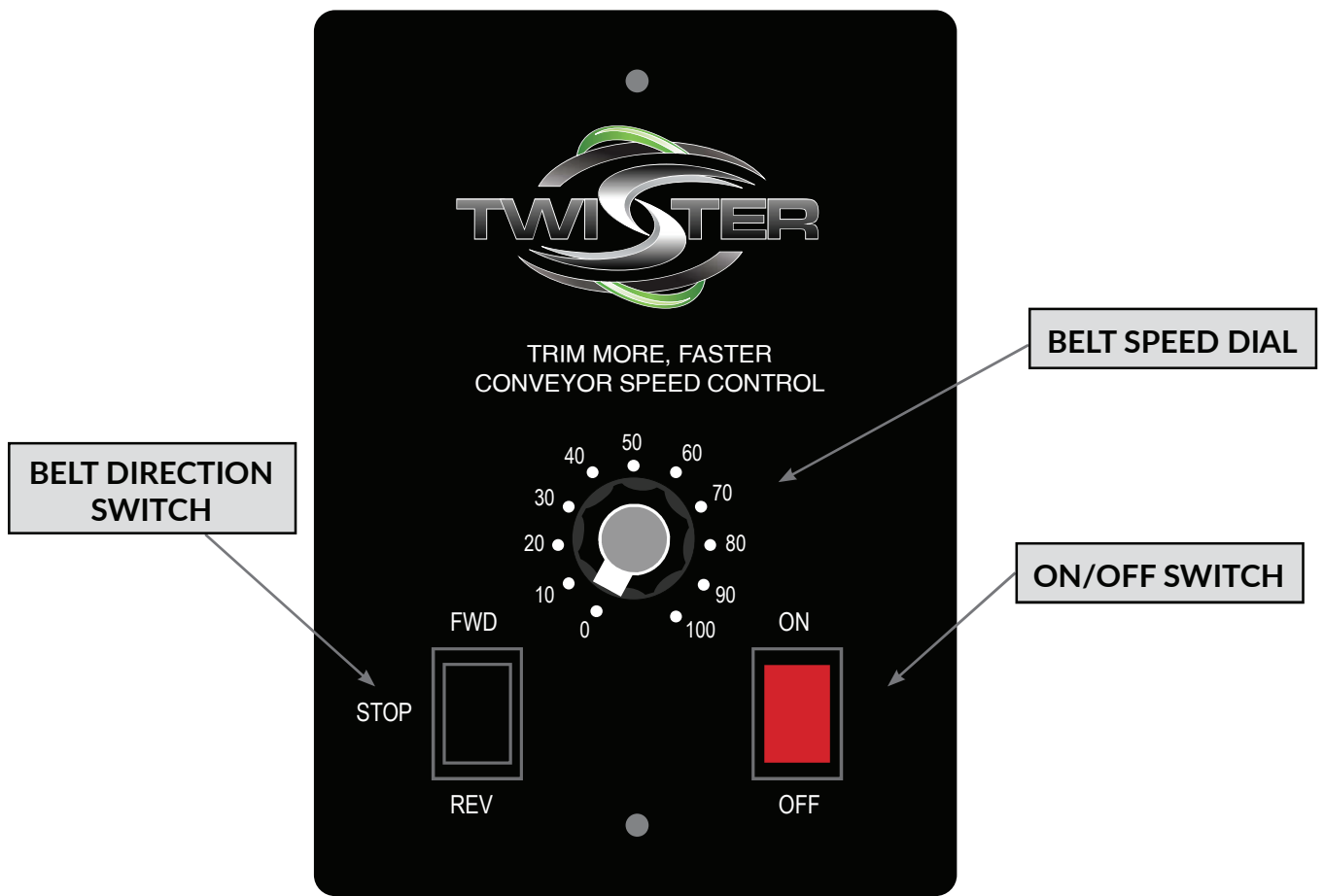
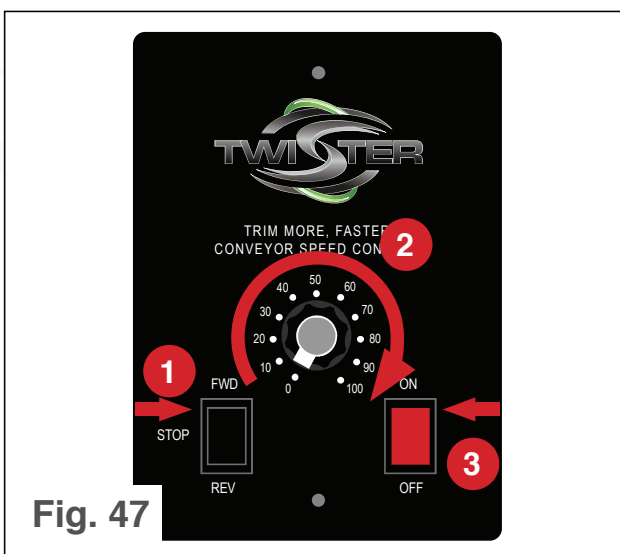


Fig. 46

1. Ensure the conveyors are fully assembled.
2. Ensure the feed chute is inside the tumbler without the upper part of the chute contacting the tumbler.
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 belt direction switch is in the **FWD** position (see Fig. 47).
6. Twist the belt speed dial to the desired speed (see Fig. 47).
7. Press the on/off switch to the **ON** position (see Fig. 47).
8. Place product on the Feed Conveyor continuously and at a consistent height.
9. During operation, adjust the belt speed dial so the same volume of product enters and exits the tumbler simultaneously.
10. To temporarily stop the conveyors during operation, press the belt direction switch into the neutral **STOP** position (see Fig. 48).
11. To stop the conveyors at the end of operation, press the on/off switch into the **OFF** position.



# 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 all the height adjustment knobs are tight.
3. Inspect all the conveyor guide clips for damage, and ensure they are tight.
4. Inspect the the upper part of the chute for signs of wear. If there is wear, the upper part of the chute is contacting the tumbler during operation. Adjust the feed conveyor so the upper part of the chute is not touching the conveyor during operation.
5. Inspect the belt tensions:
  - a. Turn on the conveyors to a slow speed (see **Operation** on page 29).
  - 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 33).



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

## Belt 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 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 the ends of the plugs to prevent water damage and electric shock. Do not get the motor or the ends of the plugs wet.



# 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

3. Decrease the tension on the conveyor belts so the underside of the belts can be cleaned (see **Conveyor Belt Tension Adjustments**).
4. Remove any large, easy-to-remove pieces of product from the conveyors.
5. Except for the motor and control box, spray the entirety of the conveyors, including under the belts, with a foaming detergent.
6. Allow the detergent to sit for five minutes.
7. Repeat steps 5 and 6 as necessary.
8. Carefully avoiding the motor and control box, pressure wash the conveyors to remove residue.
9. Dry the conveyors with compressed air.
10. Except for the motor and control box, wipe the entirety of the conveyors with isopropyl alcohol or another sanitizer.
11. Allow the sanitizer to dry.
12. Retension the belt (see **Conveyor Belt Tension Adjustments**).

## Conveyor Belt Tension Adjustments

The conveyor belts need tension adjustments when cleaning the conveyors and when being replaced. The conveyor belts may also stretch slightly over time also requiring tensioning. 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. If tensioning the Feed Conveyor, remove the chute.
3. Using a 4mm hex key, loosen the two inner tensioning head plate bolts on both sides of the conveyor (see Fig. 49). The belt will lose tension once all the bolts have been loosened.
4. Using a  $\frac{3}{16}$ " hex key, rotate the pinion gear in the head plate slot to achieve the desired tension (see Fig. 50). Do not exceed a torque of 25in-lbs on the pinion gear. Over



## DANGER

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

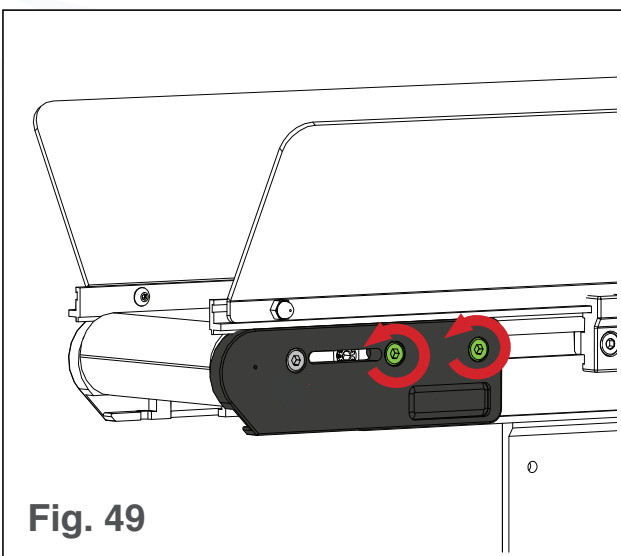
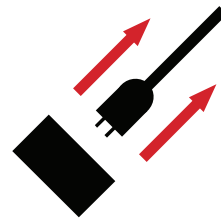


Fig. 49

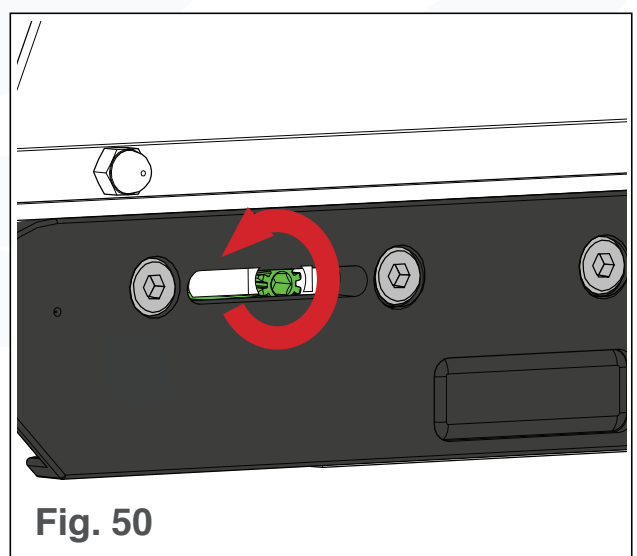


Fig. 50



## CAUTION

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

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.

5. Once the desired tension has been achieved, while still holding the hex key in the pinion gear, retighten the two inner tensioning head plate bolts on both sides of the conveyor (see Fig. 51).

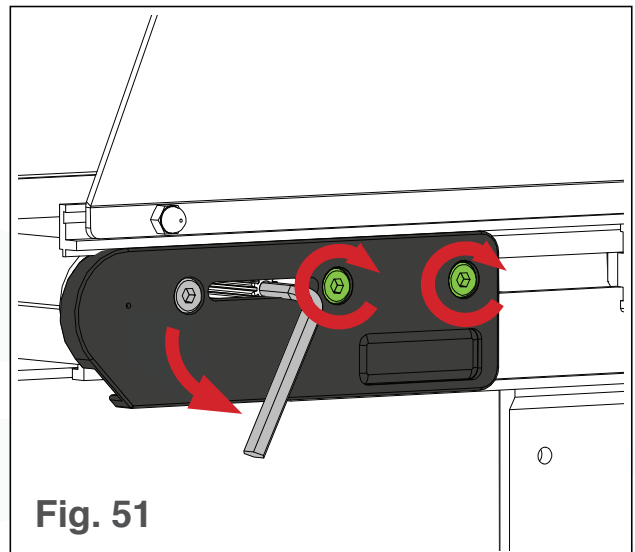


Fig. 51

## Timing Belt Tension Adjustments

If the conveyor belt skips, slips, or operates at inconsistent speeds, the timing belt may need tensioning. To tension the timing belt:

1. Ensure the conveyors are switched off and unplugged.
2. Using a 5mm hex key, loosen the two horizontal tensioning bolts (see Fig. 50). **Do not remove them.**
3. Using a 4mm hex key, tighten the vertical tensioning bolt to 15in-lbs (see Fig. 50).
4. Retighten the two horizontal tensioning bolts to 80in-lbs.

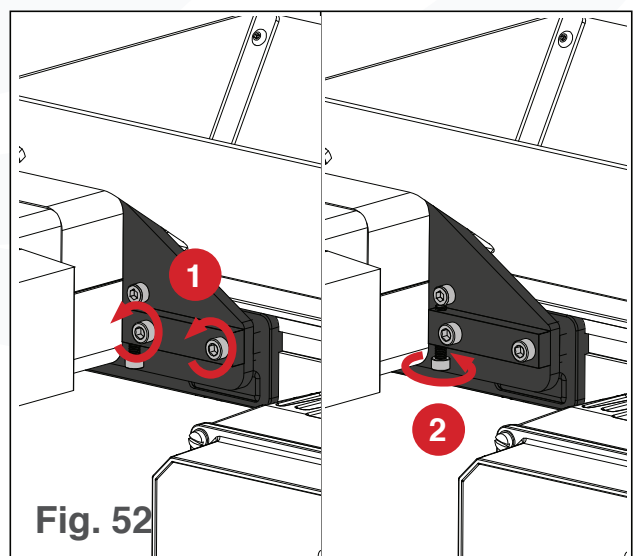


Fig. 52

## Conveyor Belt Replacement

If a 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. If replacing the Feed Conveyor belt, remove the chute.
3. Using a  $\frac{3}{32}$ " hex key and a  $\frac{5}{16}$ " wrench, remove the four bolts securing the end flare/plate to the rest of the conveyor (see Fig. 53).
4. Remove the end flare/plate.
5. Using a 4mm hex key, remove all eight conveyor clips (see Fig. 54).
6. Slide out the guide rails (and flares if replacing the Feed Conveyor belt).
7. Using a 4mm hex key, loosen the two inner tensioning head plate bolts on both sides of the conveyor (see Fig. 53).

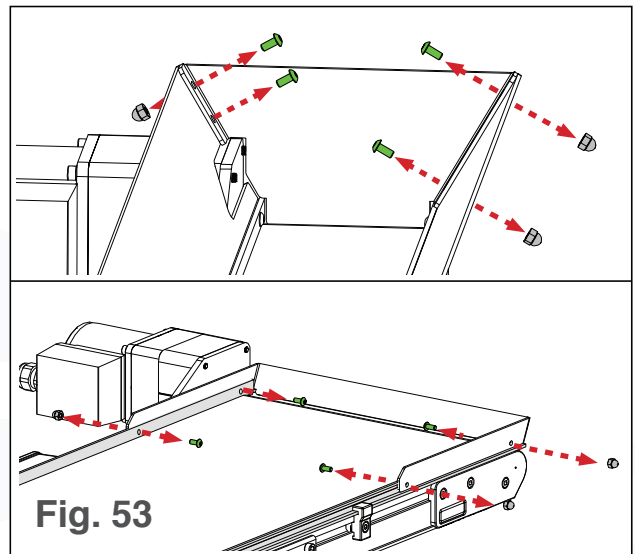


Fig. 53

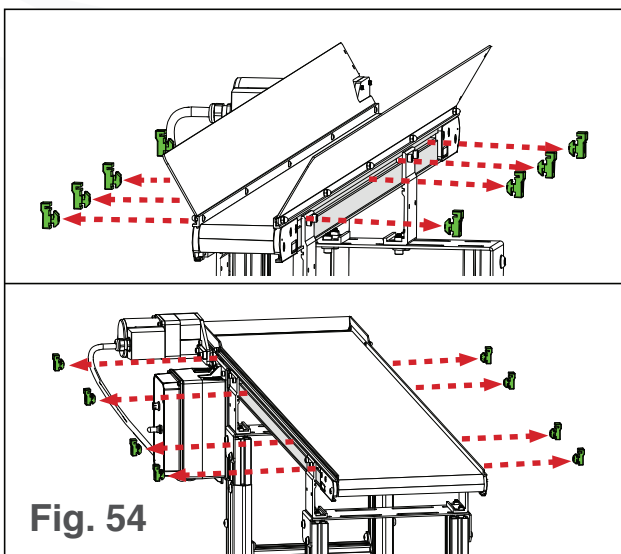


Fig. 54

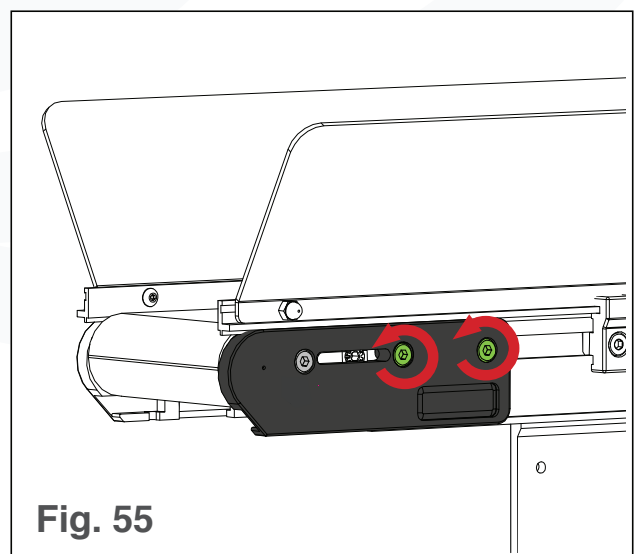
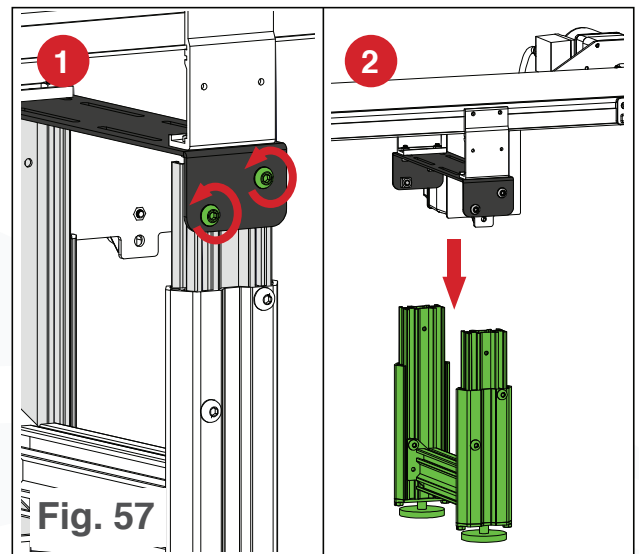
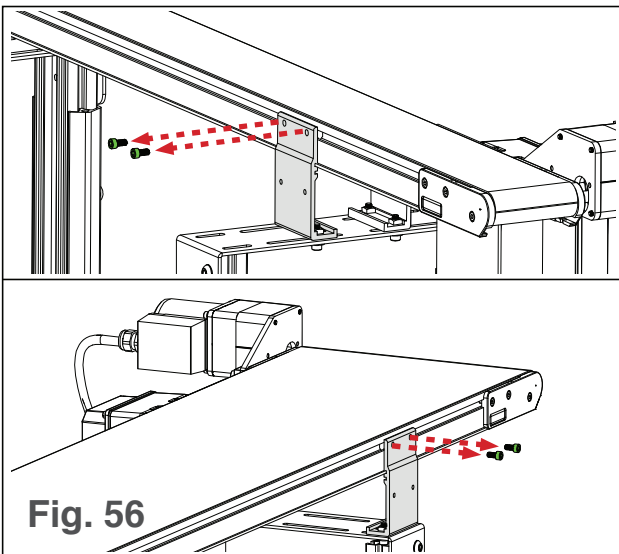
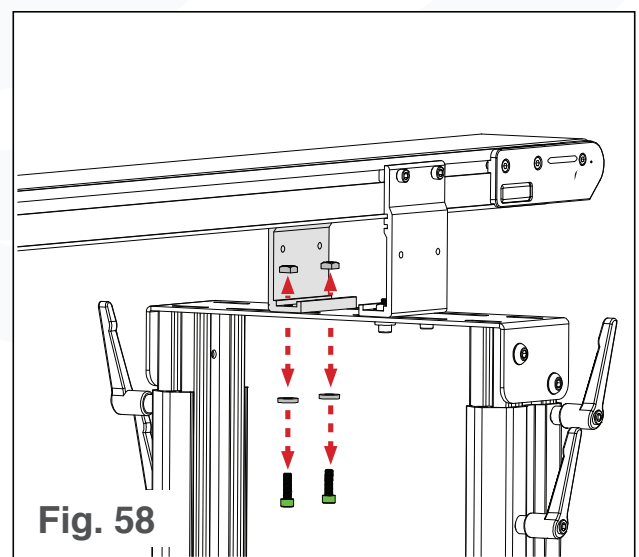


Fig. 55



8. Using a 4mm hex key, remove the two M6-1.0 x 12mm bolts connecting **both** mounting brackets to the conveyor bed on the non-motor side (see Fig. 56).
9. If replacing the QC Conveyor belt:
  - a. Using a  $\frac{7}{32}$ " hex key, loosen the bolts connecting the support stand top brackets to the support stand legs (see Fig. 57). **Do not remove them.**
  - b. Remove the legs from the top brackets (see Fig. 57).
10. Using a 5mm hex key, remove the two M6-1.0 x 20mm bolts connecting both mounting brackets to the support stands on the non-motor side (see Fig. 58).
11. Remove the two non-motor side mounting brackets.
12. Support the weight of the conveyor bed where the mounting brackets were removed. Not supporting the weight of



the conveyor bed may cause damage to the still attached mounting brackets.

13. Slide the old belt off the conveyor bed.
14. Slide the new belt onto the conveyor bed.
15. Reattach the two mounting brackets by following steps **8–11** in reverse.
16. Tension the belt (see **Conveyor Belt Tension Adjustments** on page 33).
17. Reassemble the conveyors by following steps **1–5** in reverse.



## CAUTION

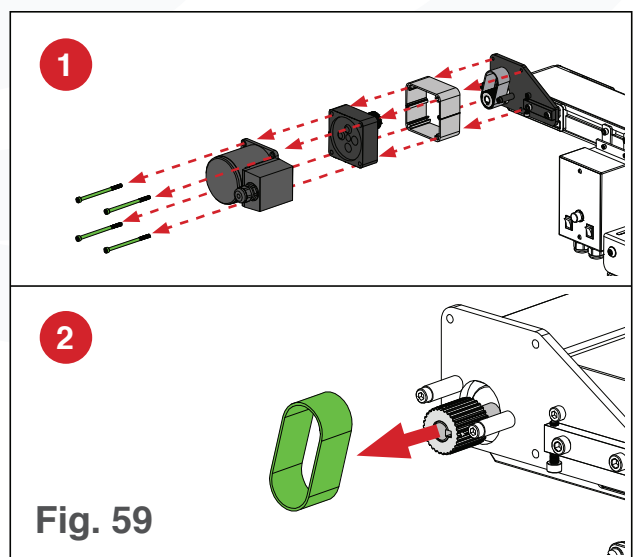
**SUPPORT THE WEIGHT OF THE CONVEYOR BELT WHEN THE MOUNTING BRACKETS ARE REMOVED.**

## Timing Belt Replacement

If the conveyor belt skips, slips, or operates at inconsistent speeds, the timing belt may need replacing.

To replace the timing belt:

1. Ensure the conveyors are switched off and unplugged.
2. Remove all four M5-0.8 bolts securing the motor to the motor mounting bracket (see Fig. 56).
3. Remove the motor, gearhead, and gearhead cover plates from the motor mounting bracket (see Fig. 59).
4. Pull the old timing belt off the drive pulley (see Fig. 59).
5. With the new belt, follow the assembly steps under **Step 4: Attach the Motor to the Conveyor Bed** on page 15 for the Feed Conveyor or **Step 5: Attach the Motor to the Conveyor Bed** on page 22 for the QC Conveyor.



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 48).

## TROUBLESHOOTING PROBLEMS

- The Conveyor Belt Jams/Won't Move.
- The Conveyors Do Not Adjust High Enough.
- The Drive Pulleys are Too Far Apart.
- Product Spills Onto The Floor.

### The Conveyor Belt Jams/Won't Move

#### Possible Causes

- There is product buildup around the rollers.
- The motor is not working.
- The conveyor belt is not tensioned enough.
- The timing belt is not tensioned enough.

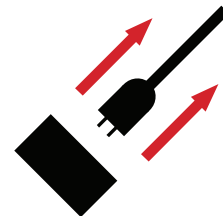
#### Solution:

1. Inspect the rollers for product buildup. If there is product buildup, clean the conveyors (see **Cleaning** on page 32).
2. If there is no product buildup around the rollers, turn on the motor. If the rollers are not spinning, then the motor is not working. Contact Keirton technical support (see **Contact Us** on page 48).



## DANGER

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





3. If the motor is working, inspect the belt tension (see **Inspections** on page 30). The belt tension should be just high enough to pull the belt. If it is not, increase the tension (see **Conveyor Belt Tension Adjustments** on page 33). Do not over tension the belt.
4. If the conveyor belt is appropriately tensioned, increase the tension on the timing belt (see **Timing Belt Tension Adjustments** on page 34).

## The Conveyors Do Not Adjust High Enough

### Possible Causes:

- Standard conveyors are being used with trimmers placed on rails.

### Solution:

1. Purchase a Conveyor Leg Extension Kit or Extended Height Conveyors (see **Spare Parts and Accessories** on page 47).

## The Drive Pulleys are Too Far Apart

### Possible Causes

- The drive pulleys have been over tensioned.

### Solution:

1. Loosen the two horizontal tensioning bolts (see Fig. 60). **Do not remove them.**
2. Loosen the vertical tensioning bolt (see Fig. 60) until the drive rollers are just close enough for the timing belt to loop around both.

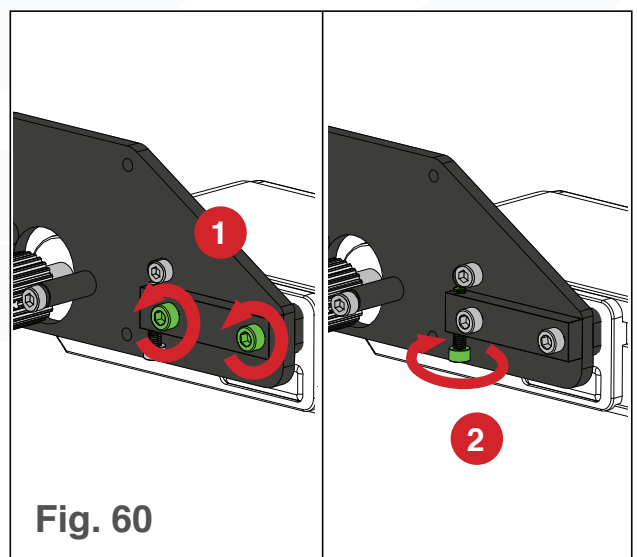


Fig. 60

## Product Spills onto the Floor

### Possible Causes:

- The feed chute is not inside the tumbler.
- The QC Conveyor is not close enough to the trimmer.
- The QC Conveyor is not raised high enough.

### Solution:

1. Inspect if the feed chute is inside the tumbler during operation. If it is not:
  - Adjust the position of the feed chute so it is as far into the tumbler as possible without the upper part of the chute contacting the tumbler (see **Step 3: Align the Conveyors with the Tumbler** on page 26).
2. 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 26).
3. If the QC Conveyor is under the tumbler, raise the QC Conveyor higher so it is as close to the bottom of the tumbler without touching the tumbler (see **Step 2: Adjust the Conveyor Heights** on page 25).

# 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 Standard and Extended Height 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 back of the control box mounting bracket if using a later edition control box)
- 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

# WARRANTY INFORMATION

- Improper electrical connection
- 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 Standard and Extended Height 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 Standard or Extended Height Conveyors. Keirton does not promote or condone the use of the Standard or Extended Height Conveyors in any way that may be deemed illegal.

Allow only persons who understand this manual to operate the Standard or Extended Height Conveyors. Keirton claims no liability for any damage or injury that results from the use of the Standard or Extended Height 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 Standard or Extended Height Conveyors. You are responsible for your safety while operating this machine. **Please keep yourself safe!**

## North American Specifications

<b>Product Numbers</b>	Standard Feed Conveyor	26-0001-02
	Standard QC Conveyor	26-0002-02
	Extended Height Feed Conveyor	26-0102
	Extended Height QC Conveyor	26-0106
<b>Certifications</b>	All Conveyors Certifications	UL, CSA, RoHS
<b>Dimensions</b>	All Conveyors Belt Length	60"/152cm
	Feed Conveyors Belt Width	3.75"/9.5cm
	QC Conveyors Belt Width	12"/30.5cm
	Standard Feed Conveyor Belt Height Range	23-33"/58-84cm
	Standard QC Conveyor Belt Height Range	19-24"/48-60cm
	Extended Height Feed Conveyor Belt Height Range	32.5-48.75"/82-123cm
	Extended Height QC Conveyor Belt Height Range	29-45.25"/73.6-115cm
	Feed Conveyors Wall Height	3.5"/8.9cm
<b>Electrical Requirements</b>	All Conveyors Input Voltage	115V, 50/60Hz
	All Conveyors Connector Plug	NEMA 5-15P (see Fig. 61)
	All Conveyors Current	1.3A
<b>Materials</b>	All Conveyors Belt Material	Urethane (FDA Approved)
<b>Motor</b>	All Conveyors Motor Power	1/30Hp
<b>Speed</b>	Feed Conveyors Speed Range	0-35ft/min (0-12m/min)
	QC Conveyors Speed Range	0-15ft/min (0-5m/min)

# SPECIFICATIONS

<b>Weight</b>	Standard Feed Conveyor Shipping Weight	44lbs/20kg (Crate) 38lbs/17kg (Support Stands Box)
	Standard QC Conveyor Shipping Weight	72lbs/33kg (Crate) 33lbs/15kg (Support Stands Box)
	Extended Height Feed Conveyor Shipping Weight	44lbs/20kg (Crate) 46lbs/21kg (Support Stands Box)
	Extended Height QC Conveyor Shipping Weight	72lbs/33kg (Crate) 38lbs/17kg (Support Stands Box)

**NEMA  
5-15P**

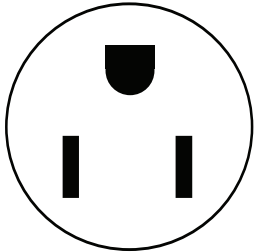


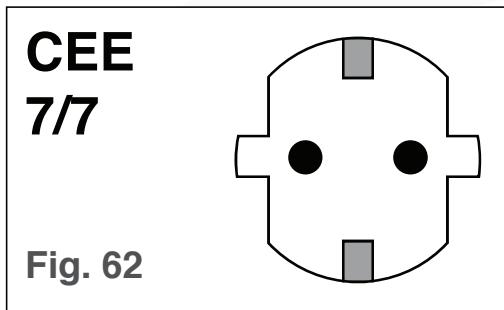
Fig. 61

## European Specifications

<b>Product Numbers</b>	Standard Feed Conveyor	26-0001E-02
	Standard QC Conveyor	26-0002E-02
	Extended Height Feed Conveyor	26-0102E
	Extended Height QC Conveyor	26-10021A
<b>Certifications</b>	All Conveyors Certifications	UL, CSA, RoHS
<b>Dimensions</b>	All Conveyors Belt Length	152cm/60"
	Feed Conveyors Belt Width	9.5cm/3.75"
	QC Conveyors Belt Width	30.5cm/12"
	Standard Feed Conveyor Belt Height Range	58-84cm/23-33"
	Standard QC Conveyor Belt Height Range	48-60cm/19-24"
	Extended Height Feed Conveyor Belt Height Range	82-123cm/32.5-48.75"
	Extended Height QC Conveyor Belt Height Range	73.6-115cm/29-45.25"
	Feed Conveyors Wall Height	8.9cm/3.5"
<b>Electrical Requirements</b>	All Conveyors Input Voltage	230V, 50/60Hz
	All Conveyors Connector Plug	CEE 7/7 (see Fig. 62)
	All Conveyors Current	0.75A
<b>Materials</b>	All Conveyors Belt Material	Urethane (FDA Approved)
<b>Motor</b>	All Conveyors Motor Power	25W
<b>Speed</b>	Feed Conveyors Speed Range	0-12m/min (0-35ft/min)
	QC Conveyors Speed Range	0-5m/min (0-15ft/min)

# SPECIFICATIONS

<b>Weight</b>	Standard Feed Conveyor Shipping Weight	20kg/44lbs (Crate) 17kg/38lbs (Support Stands Box)
	Standard QC Conveyor Shipping Weight	72lbs/33kg (Crate) 33lbs/15kg (Support Stands Box)
	Extended Height Feed Conveyor Shipping Weight	20kg/44lbs (Crate) 21kg/46lbs (Support Stands Box)
	Extended Height QC Conveyor Shipping Weight	72lbs/33kg (Crate) 38lbs/17kg (Support Stands Box)





## Cleaning Equipment

Item	Product Number
Twister Foam Cannon	25-0024

## Height Extension Tools

Item	Product Number
Conveyor Leg Extension Kit	27-0006

## Spare Parts\*

Item	Product Number
Conveyor Guide Clip Assembly	26-0075
Height Adjustment Knob Kit	27-10069A
Standard and Extended Height Feed Conveyor Belt	26-0033
Standard and Extended Height QC Conveyor Belt	26-0034
Standard and Extended Height Conveyor Feed Chute	11-10564A

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

## CONTACT US

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](mailto:support@keirton.com)**



