

# TWISTER

T2 TRIPLE RAILS



USER MANUAL

PN: 21-10186A\_REV00



# TABLE OF CONTENTS

Important Safety Information	4
Parts and Tools	6
Assembled Rails	9
Assembly	10
Setup	14
Cleaning	17
Specifications	18
Accessories	19
Contact Us	20

# IMPORTANT SAFETY INFORMATION

This manual is for the Twister T2 Triple Rails. In this manual, the T2 Triple Rails will simply be referred to as the Rails.

The Rails supports high-speed cutting machines and require special safety precautions to be practiced during assembly and usage to reduce the risk of personal injury. Read this manual, including all important safety information, danger, warning, and caution signs before using the Rails.

Only allow persons who understand this manual to assemble or use the Rails. Keirton claims no liability for any damage or injury that results from the use of the Rails by persons who have not read and understood the cautions, warnings, and danger notices contained in this manual or through any misuse of the Rails. You are responsible for your safety while assembling and using the Rails. **Please keep yourself safe!**

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 20).

## General Safety Information

- Do not assemble, use, or clean the Rails while tired or under the influence of drugs, alcohol, or medications.
- Do not wear loose clothing or jewellery when assembling, using, or cleaning the Rails.
- Confine long hair when assembling, using, or cleaning the Rails.



## DANGER

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

## Assembly Safety Information

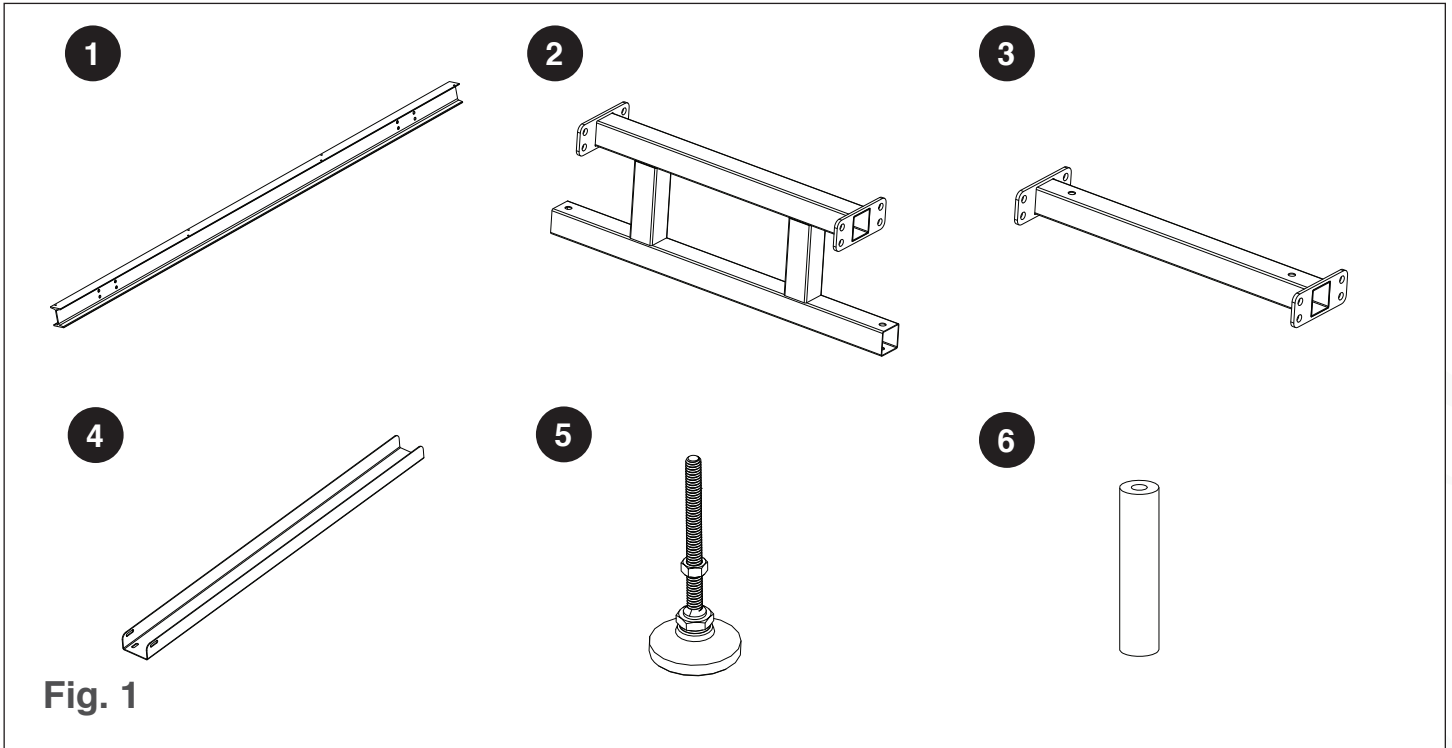
- Substituting factory parts with third-party parts may result in bodily harm or damage to the Rails.
- Do not skip any assembly steps. Complete all steps in order.
- Do not mount T2s onto the rails unless all assembly steps have been completed.
- Some of the Rails components are heavy. Always use proper lifting technique and two people to lift the parts if necessary.
- If specified, torque all bolts to the specifications detailed in this manual.

## Operation Safety Information

- Do not mount T2s onto the rails without having first read this manual.
- Ensure the T2s are unplugged and all motors have come to a complete stop before adjusting the tilt of the rails.
- Ensure nothing is trapped under the rails before mounting any T2s.

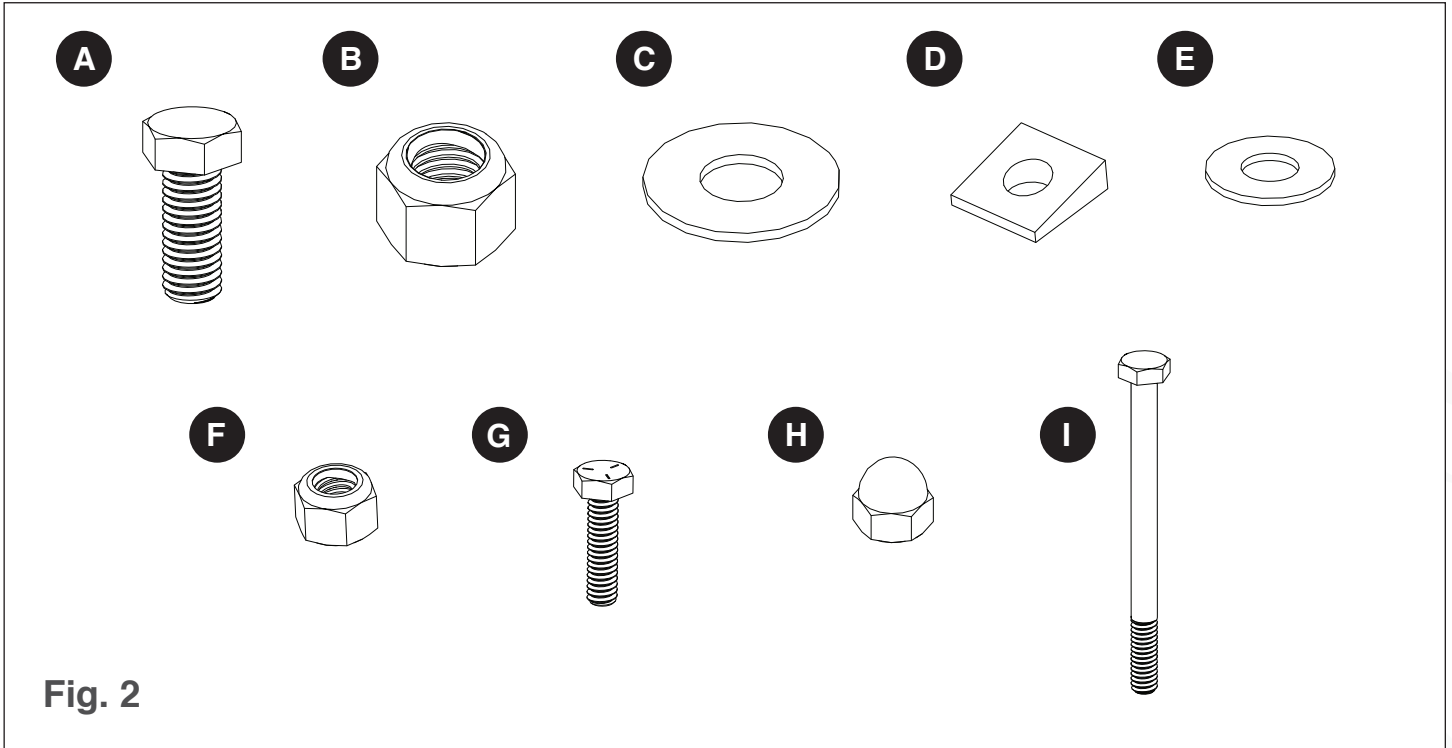
# PARTS AND TOOLS

## Parts: Components



Reference	Description	Part Number	Quantity
1	T2 Triple Rail Bar	11-0363	2
2	Upper Cross Brace	11-0364	1
3	Lower Cross Brace	11-0365	1
4	Top Channel	11-0362	6
5	Leveling Foot	14-0056	4
6	Nylon Spacer	14-0054	6

## Parts: Fasteners



Reference	Description	Part Number	Quantity
A	1/2"-13 x 1 1/4" Cap Screw	13-0247	16
B	1/2"-13 Nyloc Nut	13-0385	16
C	1/2" Flat Washer	13-0471	32
D	1/4" Leveling Washer	13-0248	12
E	1/4" Flat Washer	13-0046	36
F	1/4"-20 Nyloc Nut	13-0062	12
G	1/4"-20 x 1" Bolt	13-0322-00	12
H	1/4"-20 Acorn Nut	13-0065-00	6
I	1/4"-20 x 3 1/4" Cap Screw	13-0249	6

## Tools Needed

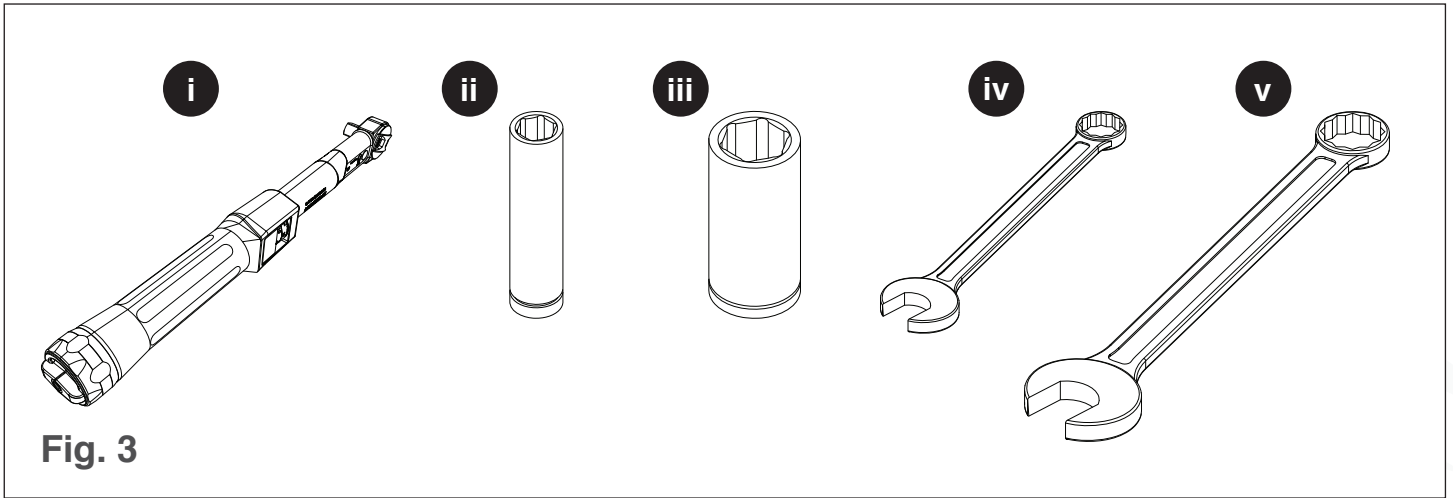


Fig. 3

Reference	Description	Quantity
i	Torque Wrench	1
ii	7/16" Socket	1
iii	3/4" Socket	1
iv	7/16" Wrench	1
v	3/4" Wrench	1



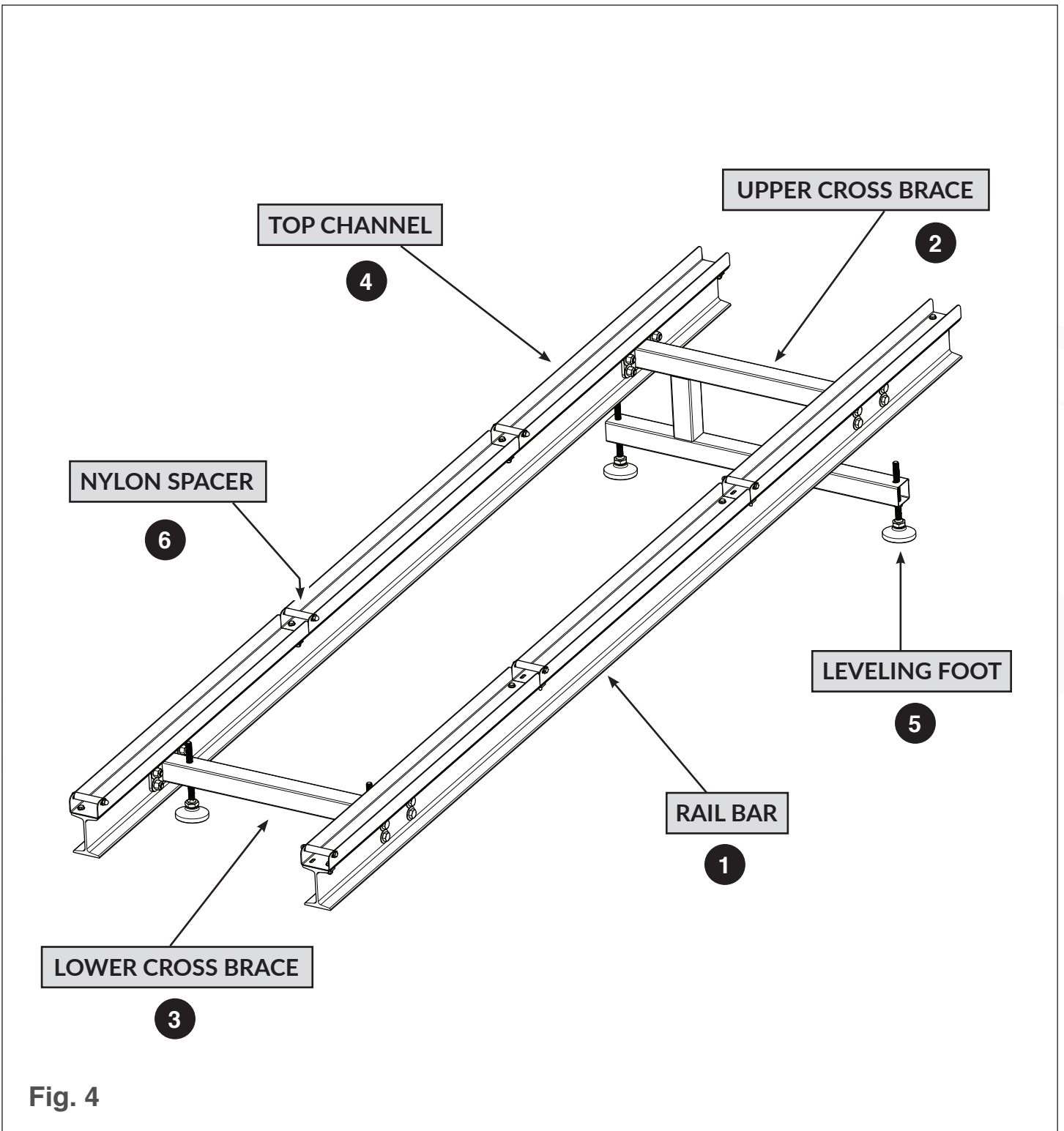
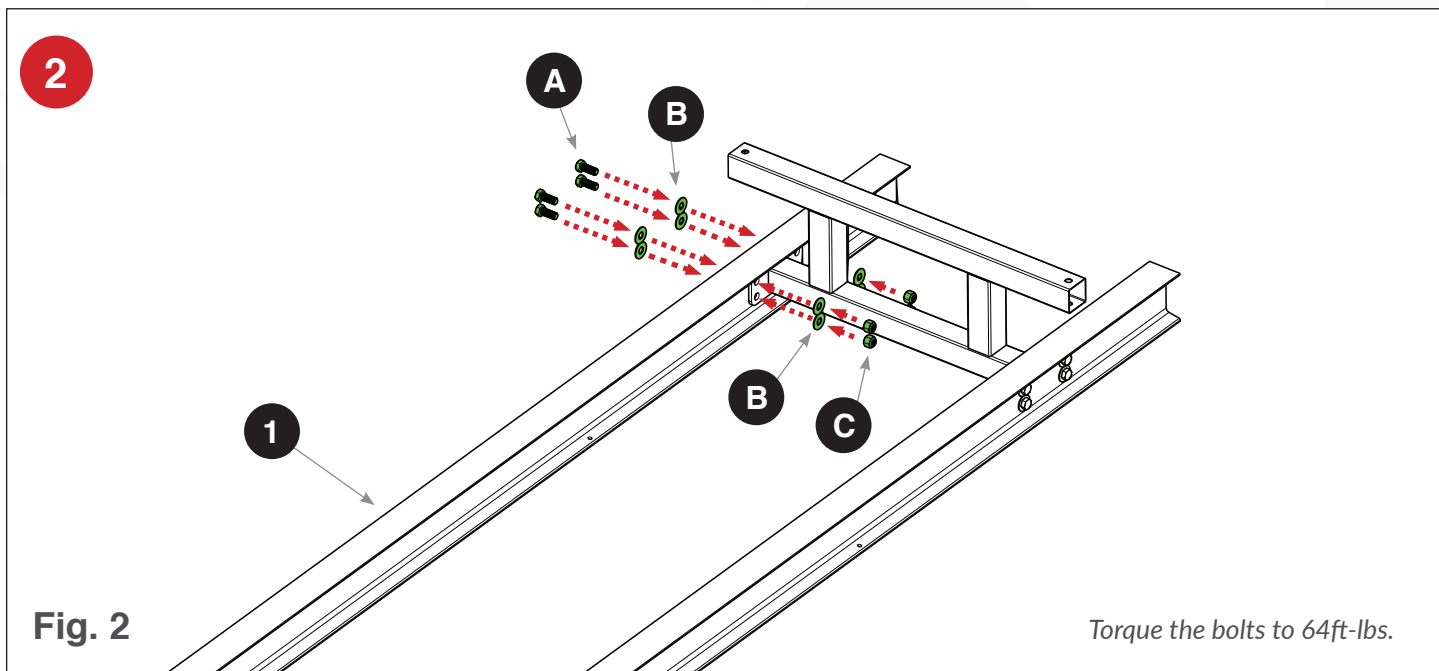
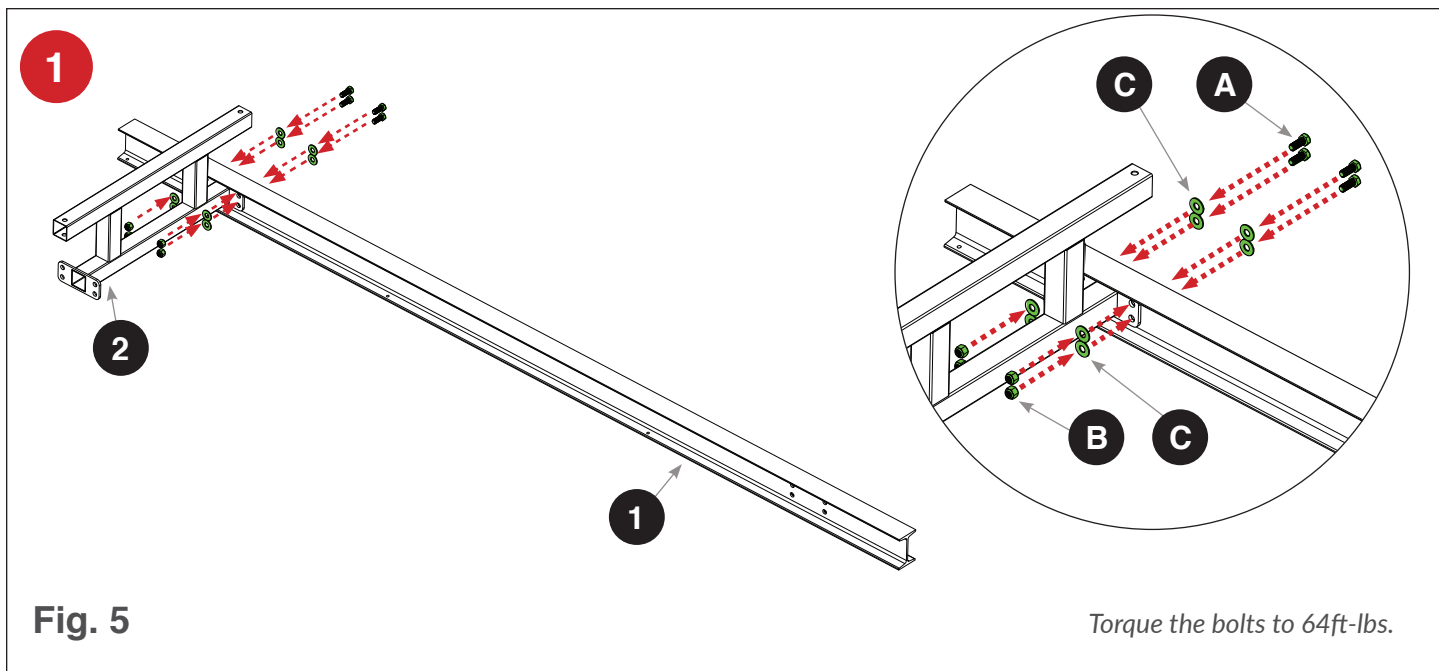
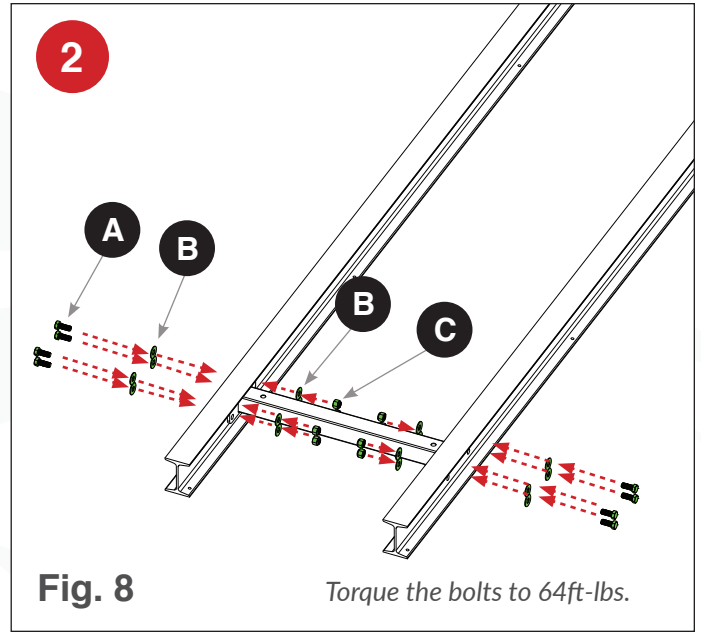
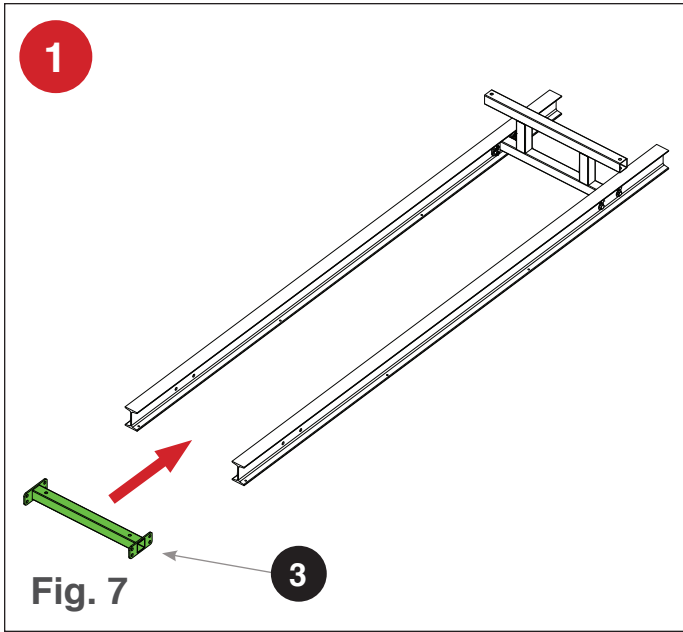


Fig. 4

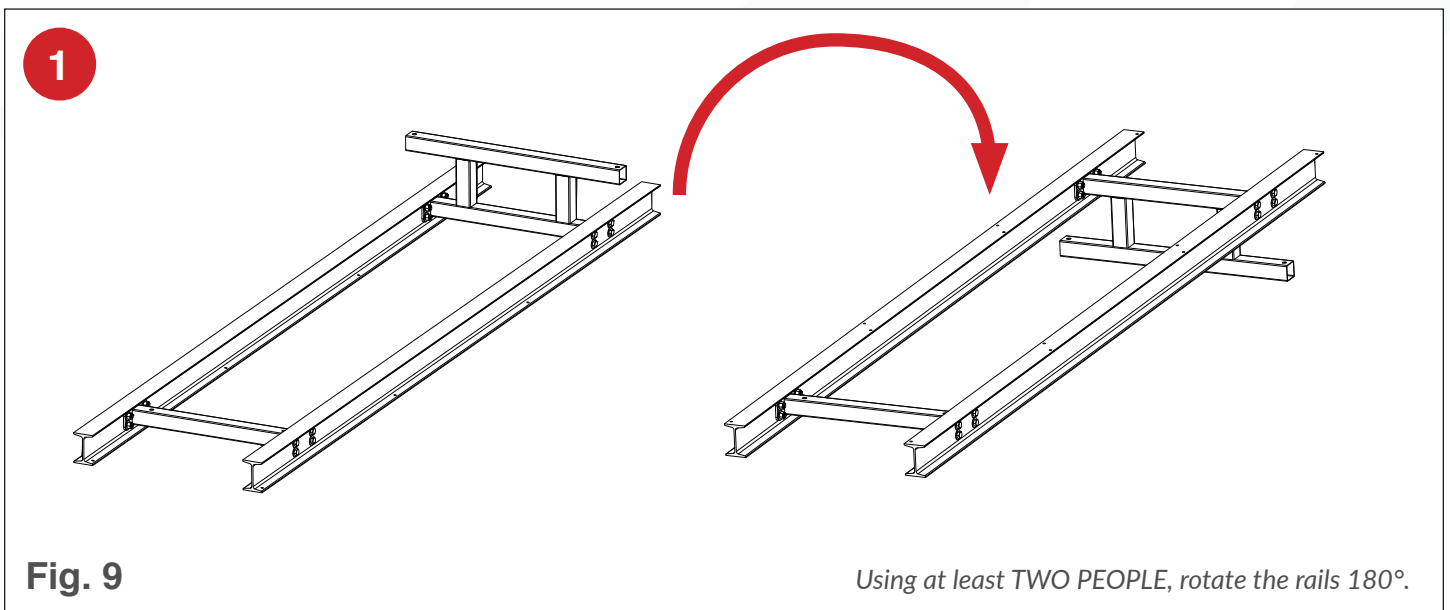
## Step A: Attach the Upper Cross Brace to the Rail Bars

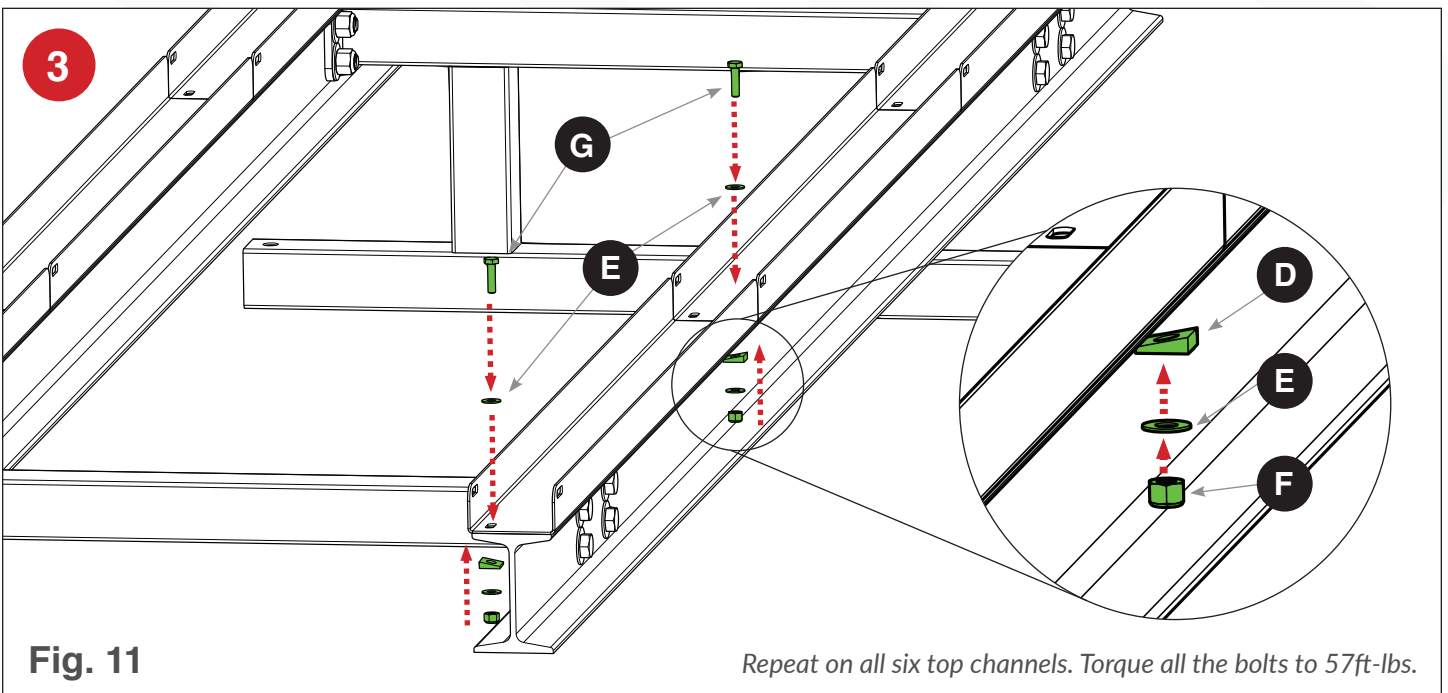
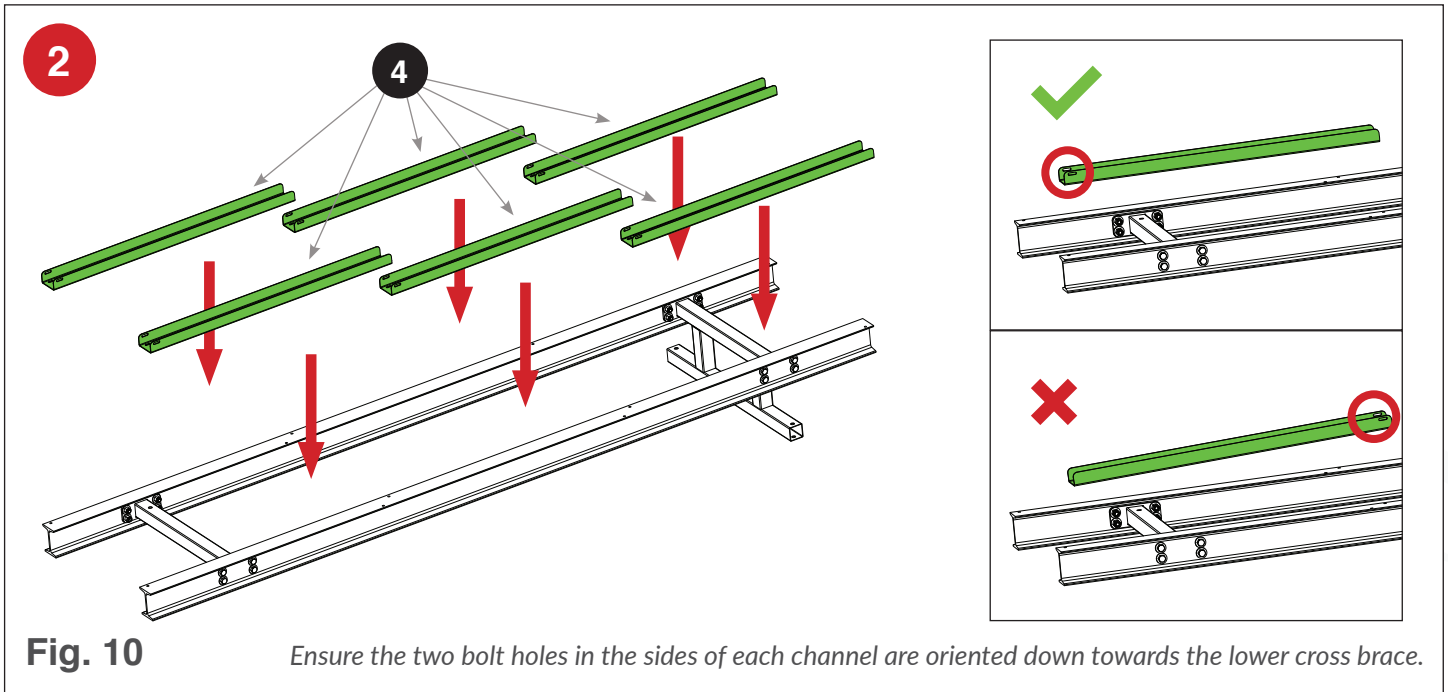


## Step B: Attach the Lower Cross Brace to the Rail Bars

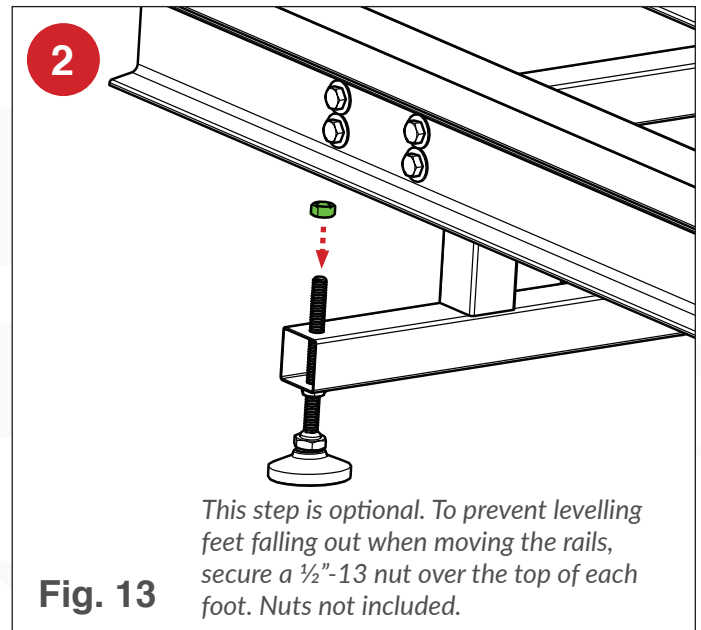
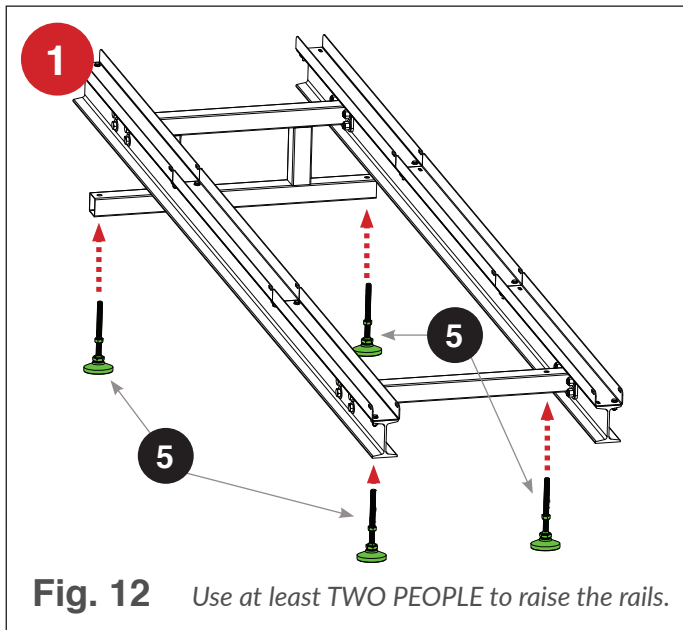


## Step C: Attach the Top Channels to the Rail Bars

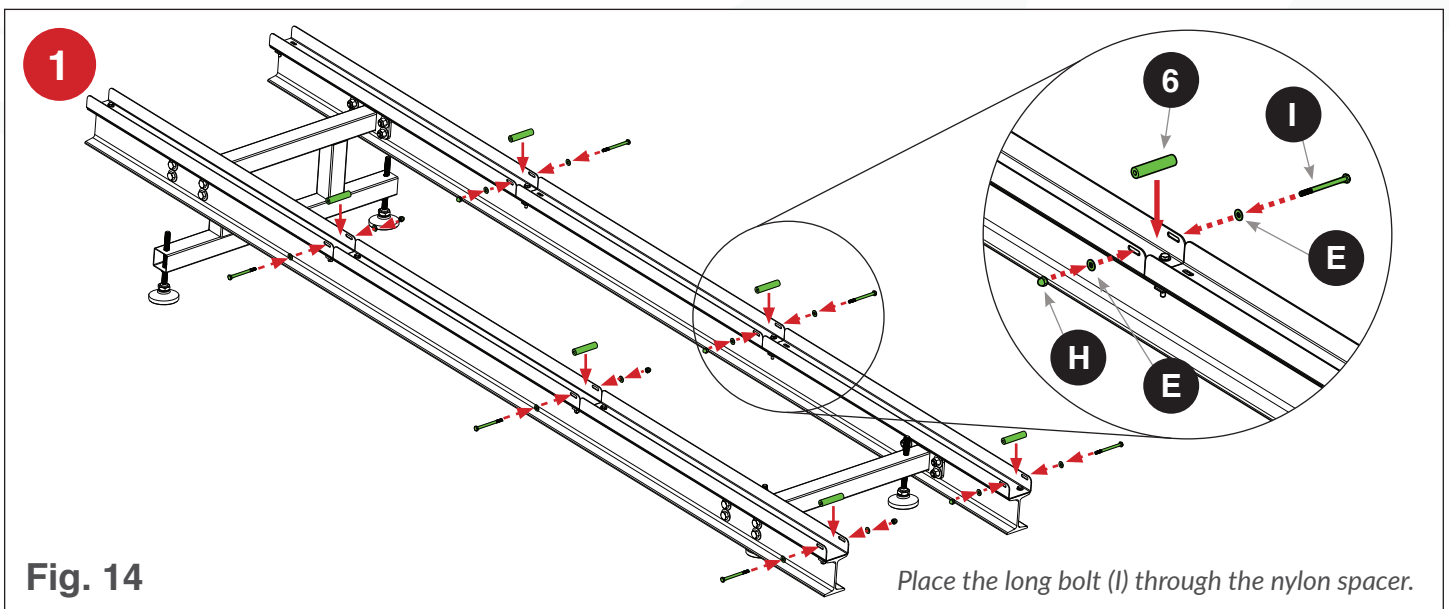




## Step D: Insert the Leveling Feet into the Cross Bars



## Step E: Attach the Nylon Spacers to the Top Channels



## Placement

Using at least two people to lift the rails, place the rails where the T2s will operate. It is recommended to operate the T2s:

- On level ground
- Near a power source
- In a cool environment\*
- With enough space to easily access the tumbler inlet and outlet
- With enough space to adjust the rails' leveling feet.

Keirton can help with trim room floor plans to accommodate a triple T2 setup (see **Contact Us** on page 20).

## Tilt Adjustment

The angle of the rails can be adjusted from 2.9° to 7.3°. For guidelines on how much to tilt the rails, see the *T2 User Manual*.

It is easiest to adjust the tilt of the rails before the T2s are mounted on them; however, the tilt may be adjusted with the trimmers on the rails. If the angle needs to be changed during operation, the user must unplug the T2s and wait for the motors to come to a complete stop before making any adjustments.

To adjust the angle of the rails:

\*It is highly recommended to operate the T2s in as cold of an environment as possible. Operating the T2s in colder environments will improve the machines' performance and significantly reduce buildup on the machine.



## WARNING

THE RAILS ARE HEAVY. USE AT LEAST TWO PEOPLE TO LIFT THEM.

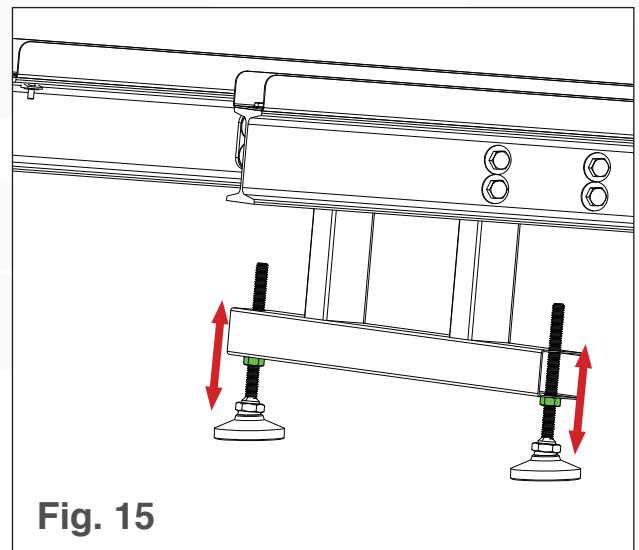


Fig. 15

- Use a  $\frac{7}{16}$ " wrench to twist the adjustment nut on the upper cross brace leveling feet (highlighted in green in Fig. 15).
- Adjust the leveling foot on one side by no more than  $\frac{1}{2}$ " before adjusting the other leveling foot by the same amount. Having the feet at significantly different heights will cause a hazard of the T2s falling.
- Ensure the leveling feet on both sides of the upper cross brace are adjusted to the same height when finished.

## T2 Loading

1. Ensure the T2s are unplugged.
2. Roll the T2s onto the top channels from the bottom of the rails (see Fig. 16). **Ensure the control panels on all three T2s are facing the same way.**
3. Roll the T2s over the nylon spacers until all three machines are safely supported on the rails.
4. Ensure there is at least a  $\frac{1}{8}$ " gap between each tumbler (see Fig. 17):
  - a. Have one person hold one of the T2s so its tumbler is  $\frac{1}{8}$ " away from the next tumbler.
  - b. Have a second person loosen the bolts in the nylon spacers supporting that T2.



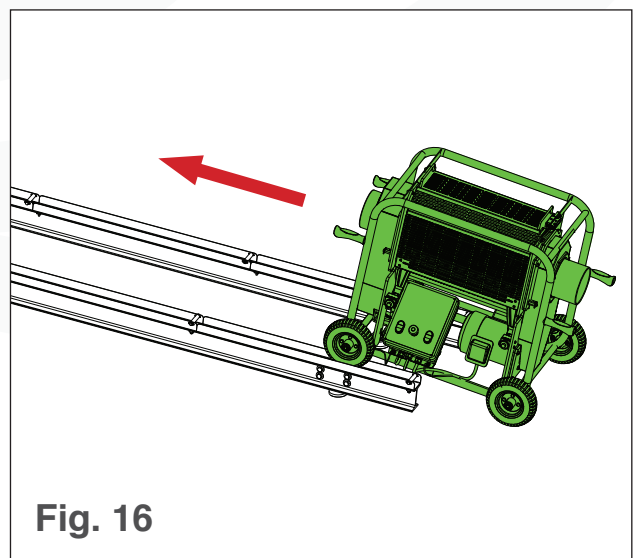
## DANGER

**ENSURE THE RAILS ARE LEVEL BY ADJUSTING THE LEVELING FEET ON BOTH SIDES OF THE UPPER CROSS BRACE TO THE SAME HEIGHT!**



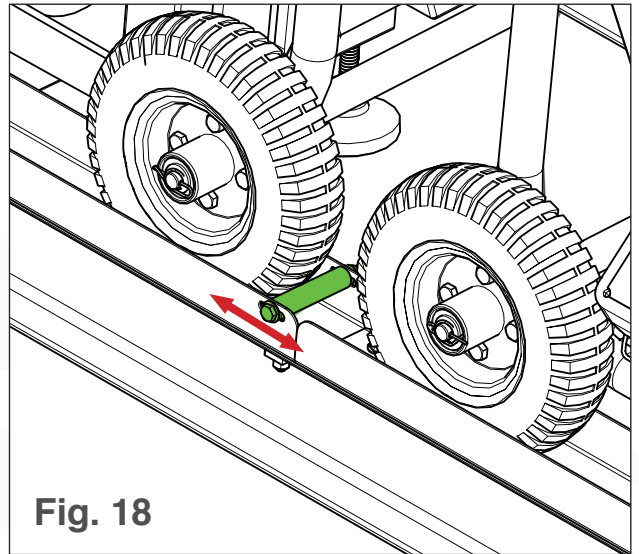
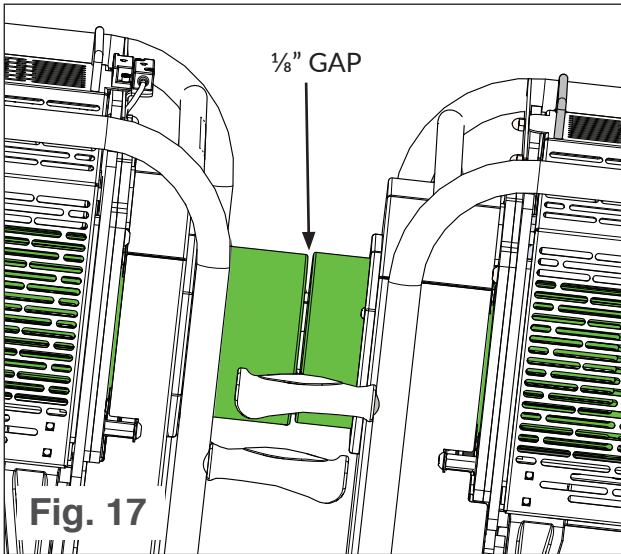
## DANGER

**ENSURE THE T2S ARE UNPLUGGED BEFORE MOVING THEM ONTO THE RAILS.**



**Fig. 16**

# SETUP



- c. Adjust the spacers so they are snug against the front wheels of the T2s (see Fig. 18).
- d. Tighten the bolts again.
- e. Repeat steps **a–d** as necessary on all three trimmers until there is a  $\frac{1}{8}$ " gap on both sides of the middle tumbler.

## Operation

It is very important that the tumblers do not touch during operation. If they are touching, the tumblers will wear out and possibly add metal to the product being trimmed. Ensure the tumblers are not touching before operation, and monitor the tumblers throughout operation as the trimmer may move slightly.



## WARNING

**ENSURE THE TUMBLERS DO NOT TOUCH EACH OTHER DURING OPERATION.**



As the rails are very heavy, it is best to clean them in place if possible. No disassembly is required for cleaning. To clean the rails:

1. Spray the rails with a foaming degreaser, such as Simple Green\*.
2. Allow the detergent to sit for five minutes.
3. Repeat steps **1** and **2** two-three times.
4. Pressure wash the rails to remove the residue (use a plastic scraper to remove any difficult to clean residue).
5. Dry the rails with compressed air.
6. Spray the rails with 70% isopropyl alcohol or another sanitizer.
7. Allow the sanitizer to evaporate.

*\*The Twister Foam Cannon makes spraying foaming degreasers much easier and is available for purchase from Keirton (see **Accessories** on page 19).*

# SPECIFICATIONS

<b>Part Number</b>	24-9036 (whole assembly)
<b>Tilt Adjustment Range</b>	2.9° - 7.3°
<b>Width</b>	31.5"/800.1mm
<b>Length</b>	114.38"/2906mm
<b>Height</b>	15.13"/384mm
<b>Weight</b>	195lb/89kg

The Standard Height Feed Conveyor will not work with a three T2 system. It is recommended to either use a height extension kit on the Standard Feed Conveyor or to purchase Twister's Extended Height or Stainless Steel Feed Conveyors.

Item	Product Number
Standard Conveyors Extension Kit	27-0006
Extended Height Feed Conveyor	26-0102
Standard QC Conveyor	26-0002
Stainless Steel Feed Conveyor	26-10018A
Stainless Steel QC Conveyor	26-10019A
T2 Vacuum Bypass*	23-0255
Twister Foam Cannon	25-0024

*\*It is recommended to use a vacuum bypass if dry trimming.*

## 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**



