

TWISTER

T4 RAILS



USER MANUAL

PN: 21-10216A_REV00



TWISTERTRIMMER.COM

Front Cover: T4 Tandem Rails

This manual is for both the T4 Tandem and Triple Rails. The only difference between the two rails is that the rail bars (highlighted green in Fig. 1) are longer on the triple rails than the tandem. Otherwise, the rails are identical. For simplicity, only the tandem rails will be pictured in this manual.

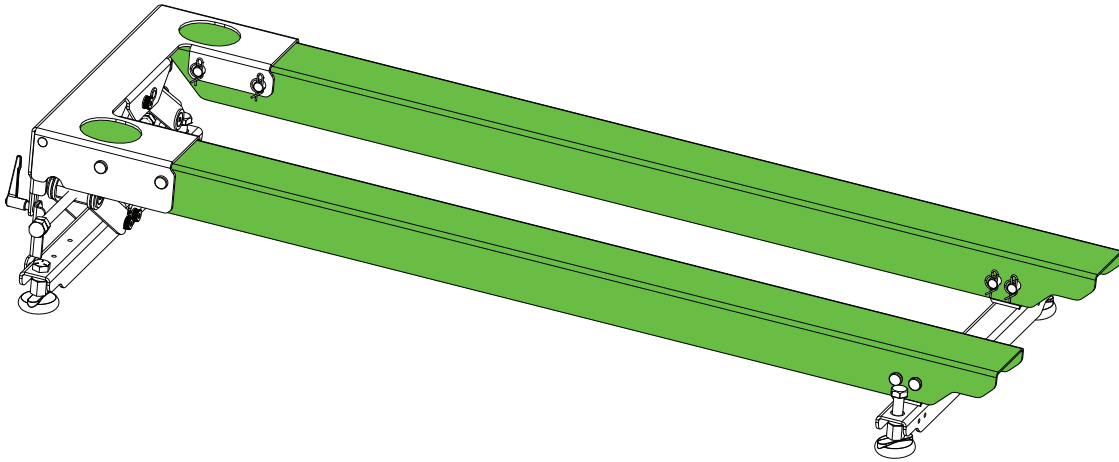


Fig. 1

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IMPORTANT SAFETY INFORMATION

This manual is for the Twister T4 Tandem and Triple Rails. In this manual, the T4 Tandem and Triple Rails will simply be referred to as the Rails.

The Rails support 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 adjust 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 18).

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.**

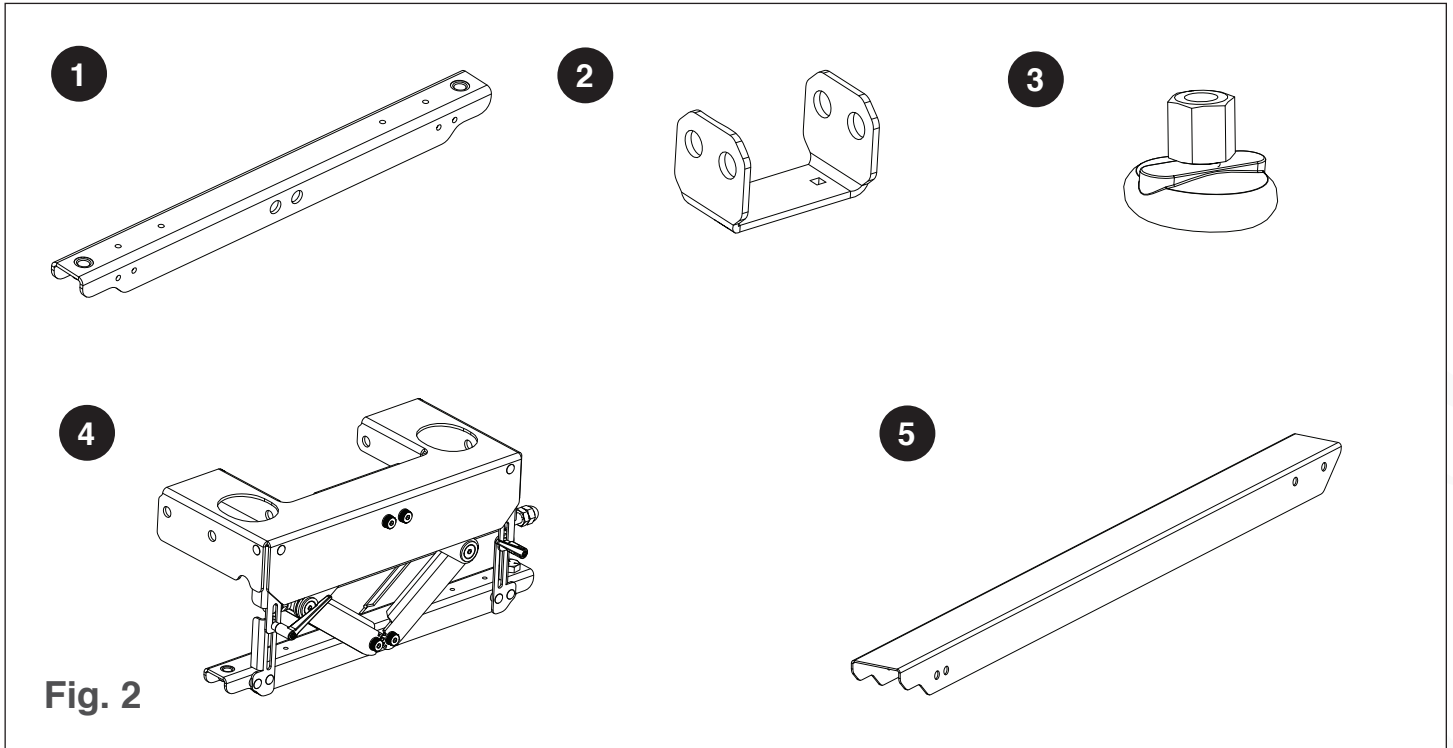
Assembly Safety Information

- 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 T4s 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

- Ensure both rail bars are level before mounting T4s onto the rails.
- Ensure the T4s are shut off and unplugged before mounting the T4s onto the rails.
- Ensure the area under the rails is clear before mounting any T4s.
- Ensure the T4s are unplugged and all motors have come to a complete stop before adjusting the tilt of the rails.

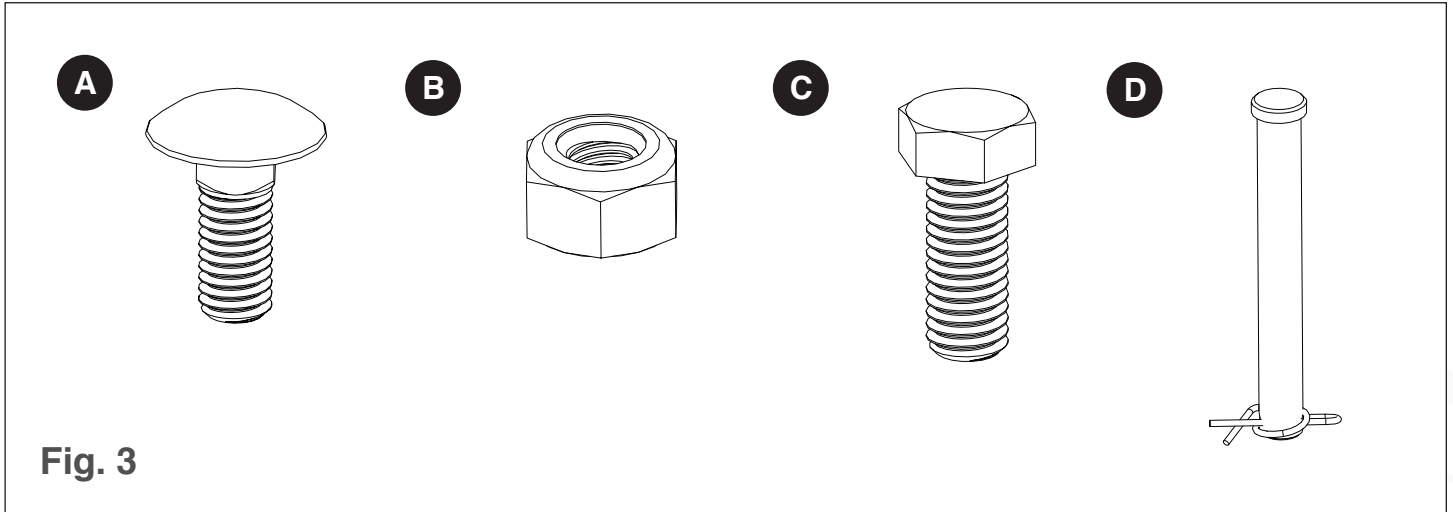
Parts: Components



Reference	Description	Part Number	Quantity
1	Rails Base	11-0142	1
2	Rails Base Support	11-0143	2
3	Plastic Foot	13-0317	4
4	Lift Assembly	24-0137*	1
5	Rail Bar	11-0156 (Tandem)/ 11-0157 (Triple)	2

*Components other than the Lift Assembly are included in this part number.

Parts: Fasteners



Reference	Description	Part Number	Quantity
A	10-32 x 1/2" Carriage Bolt	13-0176	4
B	10-32 Nyloc Nut	13-0179	4
C	1/2"-13 Hex Head Cap Screw	13-0318	3
D	1/2" x 3 3/4" Clevis Pin with Cotter Pin	13-0182	8

Tools Needed

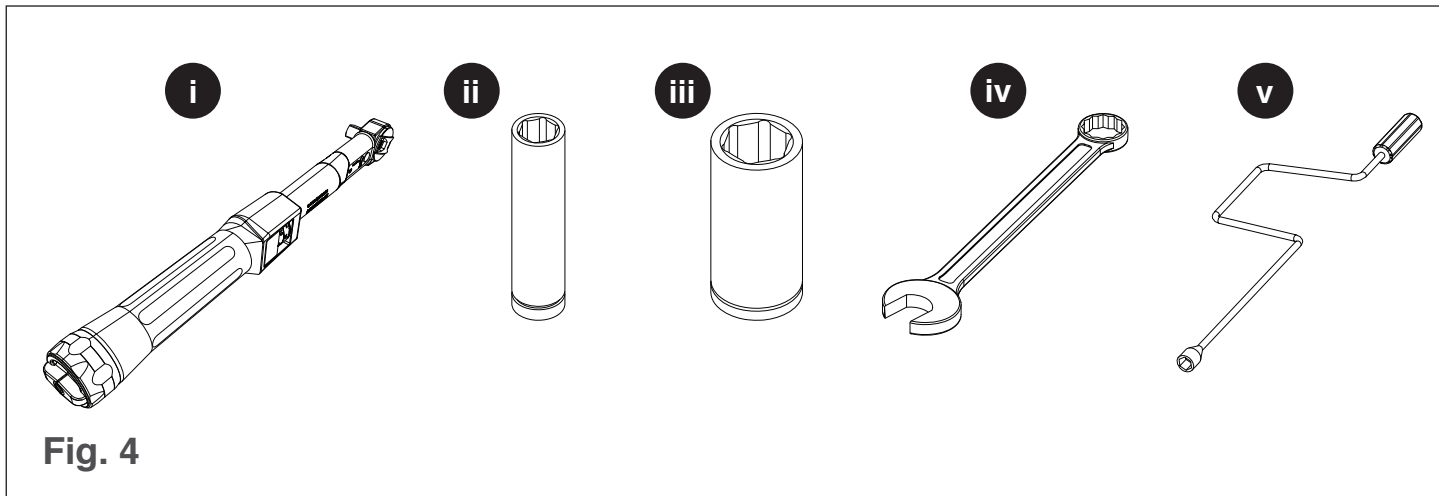


Fig. 4

Reference	Description	Quantity
i	Torque Wrench	1
ii	$\frac{3}{8}$ " Socket	1
iii	$\frac{3}{4}$ " Socket	1
iv	$\frac{3}{4}$ " Wrench	1
v	$\frac{3}{4}$ " Hand Crank*	1

*Provided with the T4 rails. The hand crack is for adjusting the height of the rails—not assembly.

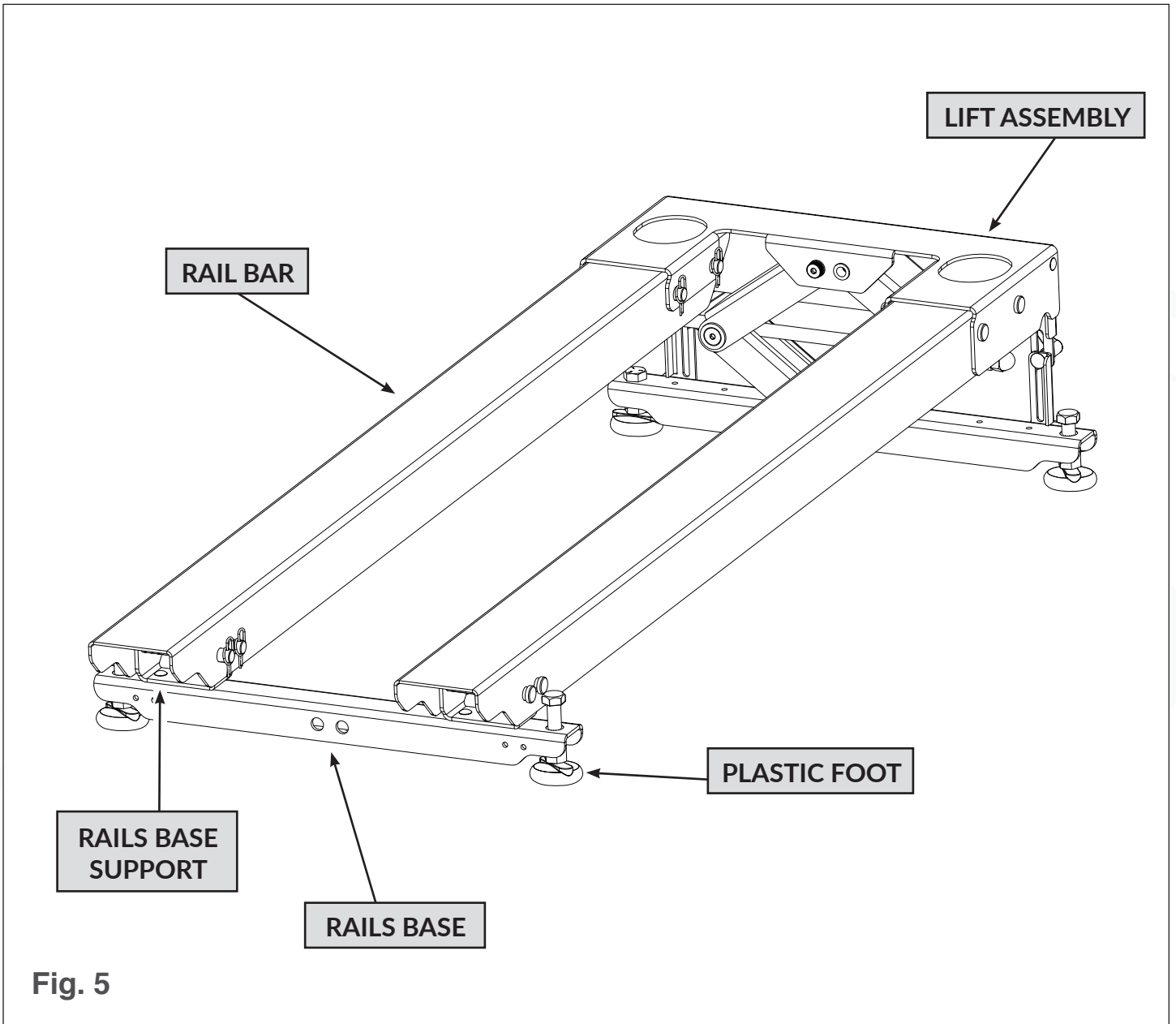
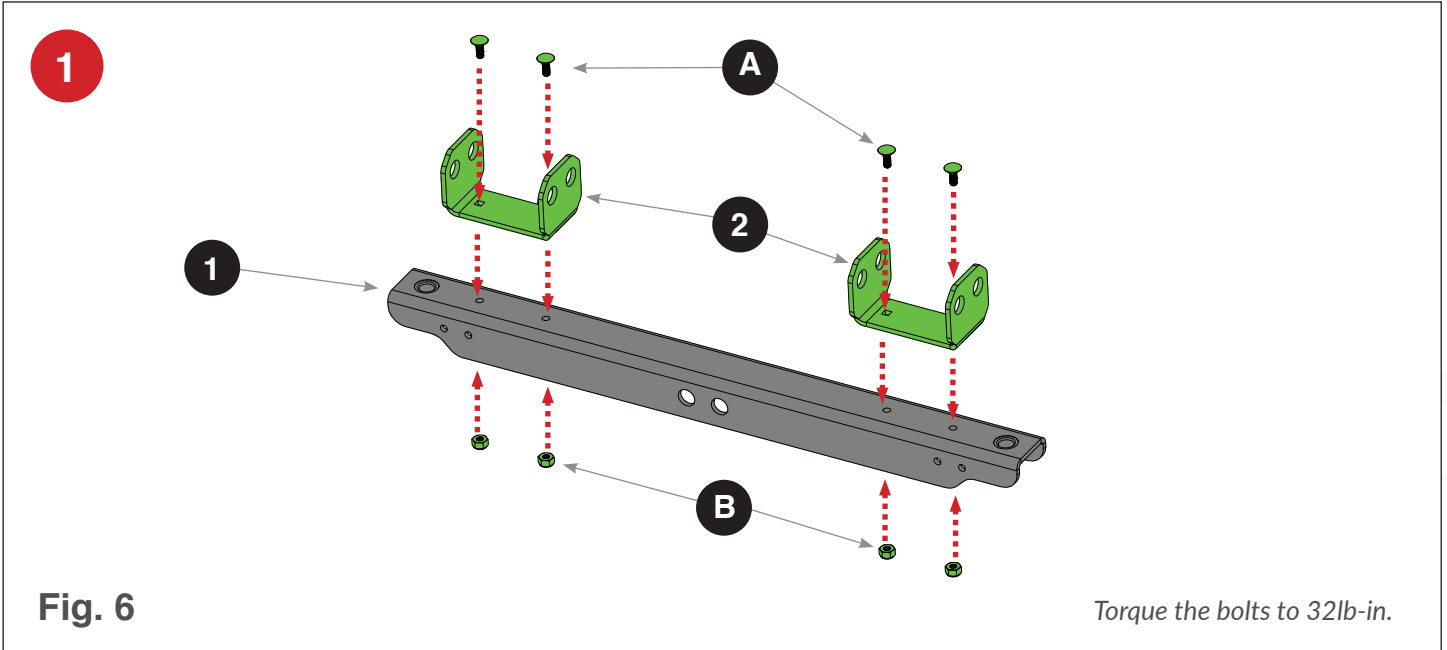
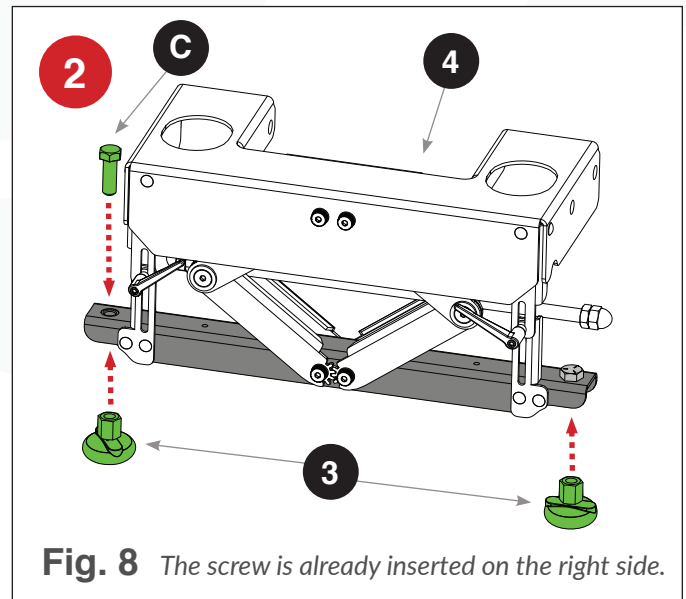
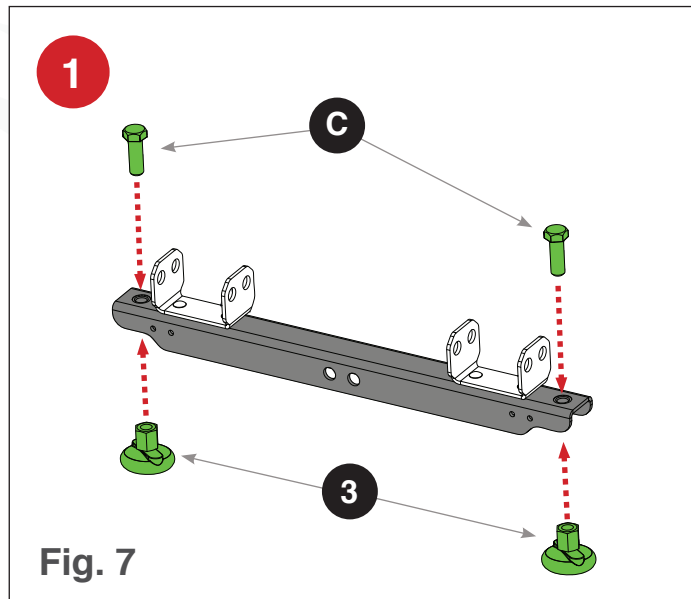


Fig. 5

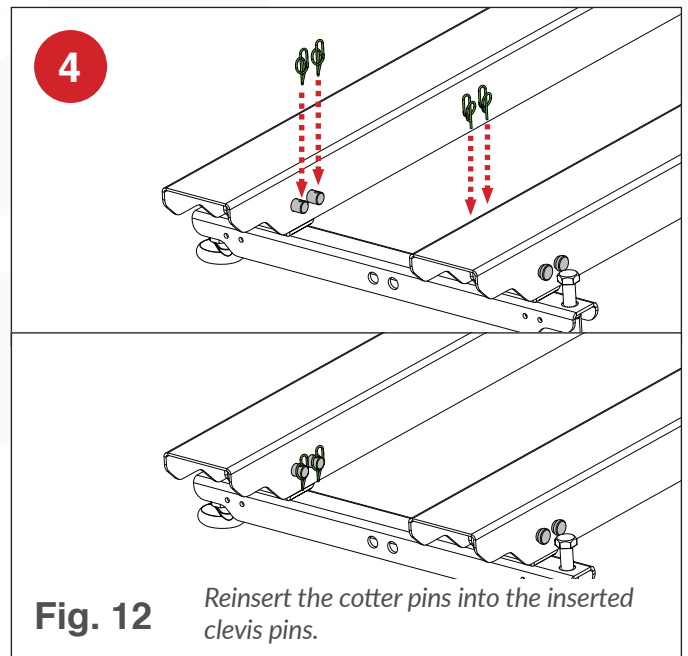
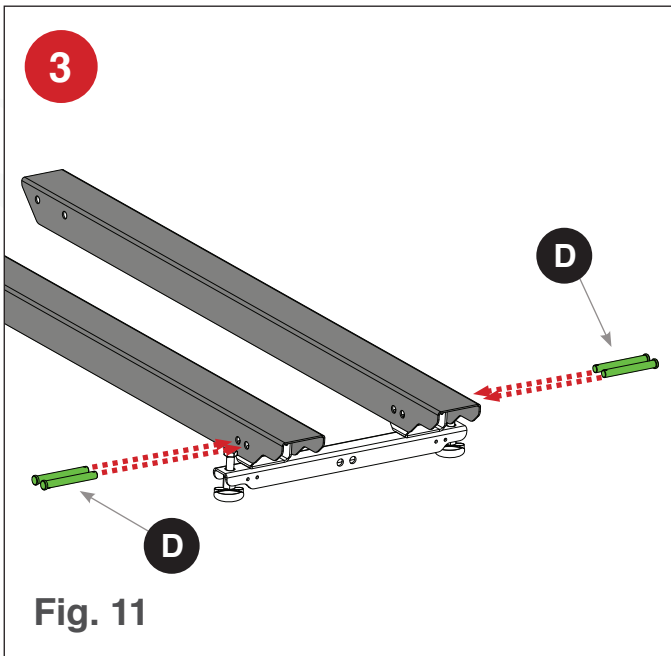
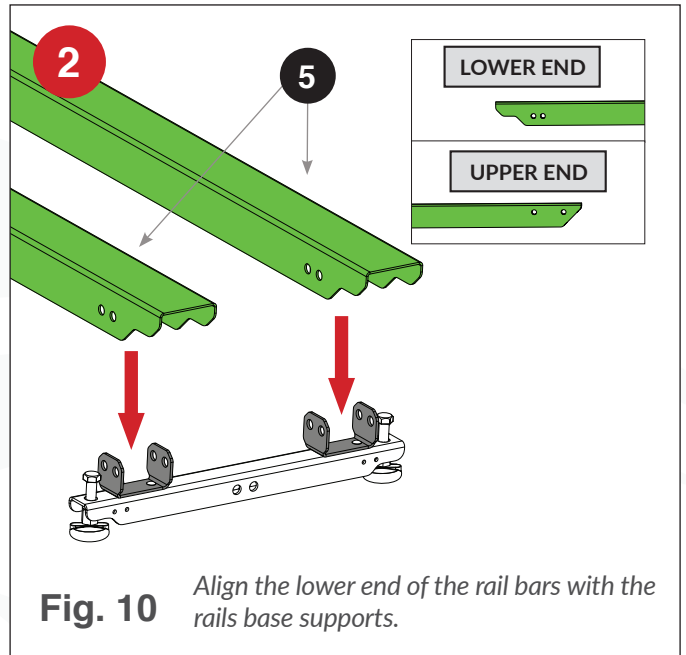
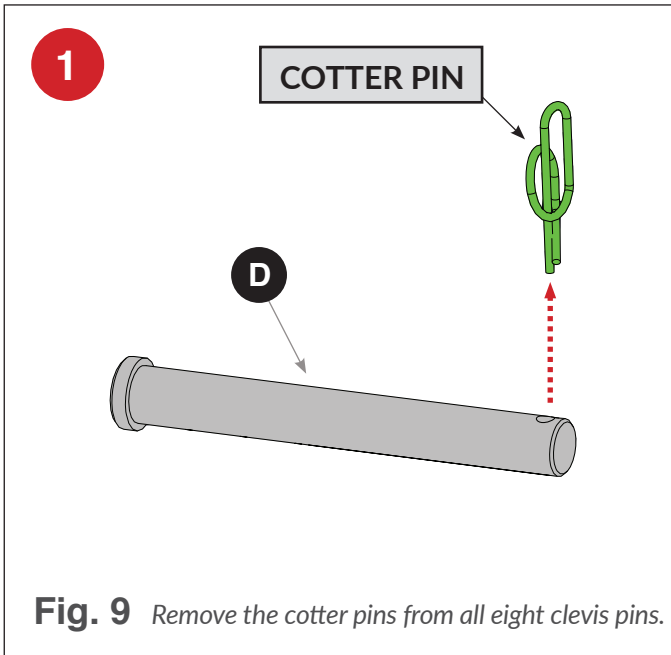
Step A: Attach the Rails Base Supports to the Rails Base



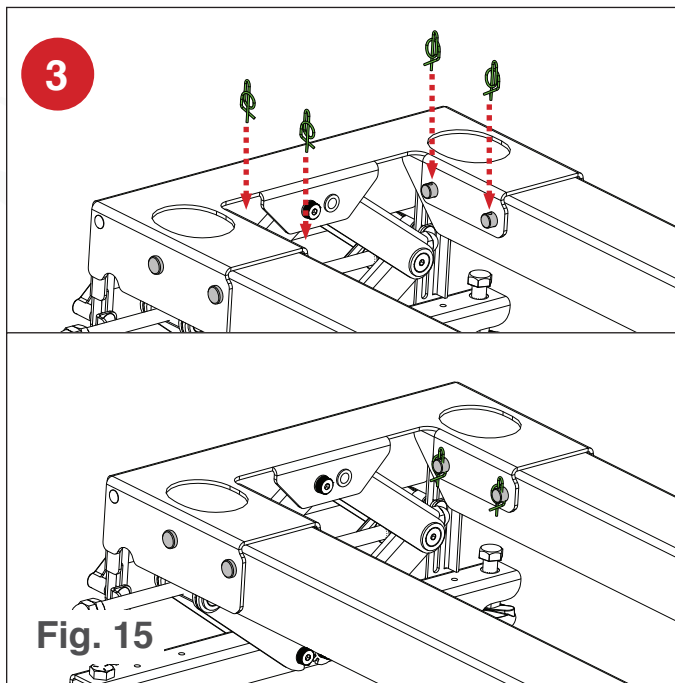
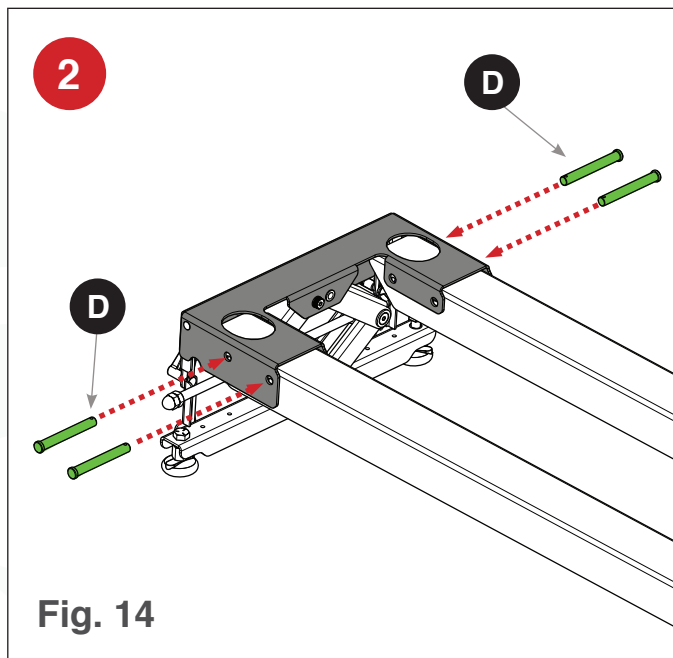
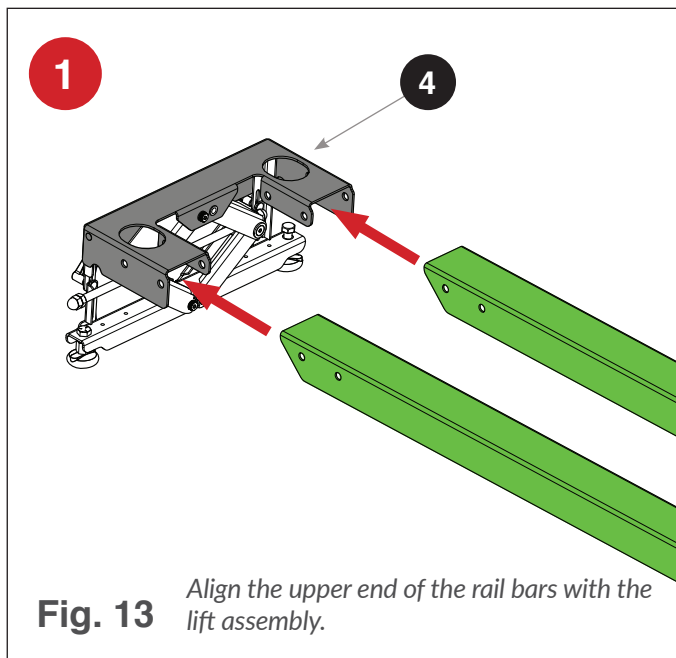
Step B: Attach the Plastic Feet to the Rails Base and Lift Assembly



Step C: Attach the Rail Bars to Rails Base Supports



Step D: Attach the Rails to the Lift Assembly



Placement

Place the rails where the T4s will operate. It is recommended to operate the T4s:

- On level ground
- Near a power source
- In a cool environment*
- With enough space to place conveyors on either side of the trimmers
- With enough space to adjust the rails tilt.
- With enough space to set up the vacuum outlets with plenty of airflow.



Also ensure both rail bars are completely level before mounting any T4s onto the rails (see **Tilt Adjustments**). Keirton can help with trim room floor plans (see **Contact Us** on page 18).

Tilt Adjustment

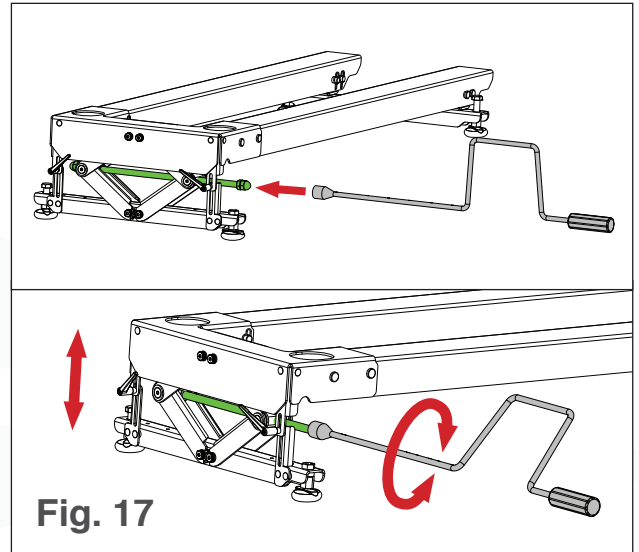
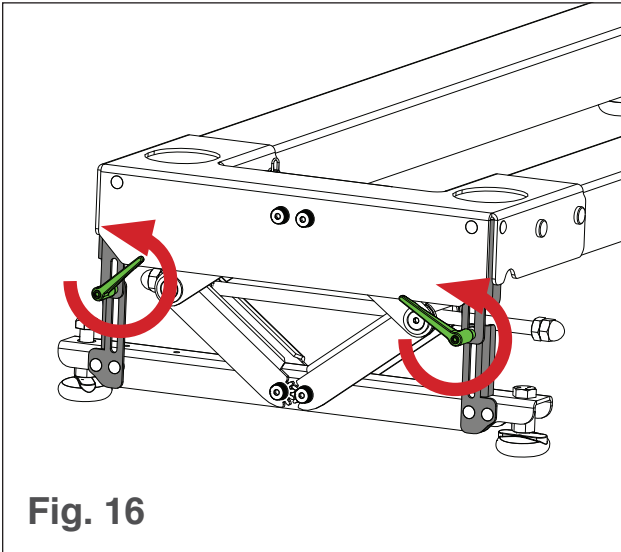
The angle of the tandem rails can be adjusted from 0.7° to 4.9°, and the triple rails can be adjusted from 0.4° to 3.1°. For guidelines on how much to tilt the rails, see the *T4 User Manual*.

It is easiest to adjust the tilt of the rails before the T4s 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 T4s and wait for the motors to come to a complete stop before making any adjustments.

To adjust the angle of the rails:

1. Loosen the stabilizer handles enough so they slide in the slots (see Fig. 16).

**It is highly recommended to operate the T4s in as cold of an environment as possible. Operating the T4s in colder environments will improve the machines' performance and significantly reduce buildup on the machine.*

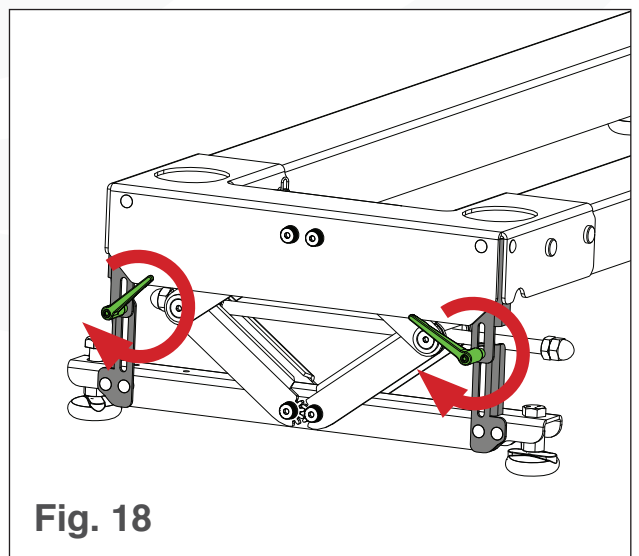


2. Using the hand crank provided with the rails, rotate the adjustment rod to adjust the height of the lift assembly (see Fig. 17):
 - a. Turn the hand crank clockwise to raise the lift assembly.
 - b. Turn the hand crank counter-clockwise to lower the lift assembly.
3. Ensure the rail bars are level with each other.
4. Tighten the stabilizer handles (see Fig. 18).



DANGER

ONCE AT THE FINAL HEIGHT, THE STABILIZER HANDLES MUST BE TIGHTENED TO PREVENT THE RAILS TILTING FROM SIDE TO SIDE DURING OPERATION.



As the rails are 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 17](#)).*

SPECIFICATIONS

T4 Tandem Rails

Part Number	24-0140-P
Tilt Adjustment Range	0.7° - 4.9°
Width	19.5"/495.3mm
Length	51.5"/1307mm
Height	8.9"/225mm
Weight	44lb/20kg

T4 Triple Rails

Part Number	24-0139-P
Tilt Adjustment Range	0.4° - 3.1°
Width	19.5"/495.3mm
Length	76.6"/1946mm
Height	8.9"/225mm
Weight	64lb/29kg

The Standard Height Feed Conveyor will not work with a tandem or triple T4 system, and while the Standard Height QC Conveyor will work, it is not ideal. It is recommended to either use a height extension kit on the Standard Conveyors or to purchase Twister's Extended Height or Stainless Steel Conveyors.

Item	Product Number
Standard Conveyors Extension Kit	27-0006
Extended Height Feed Conveyor	26-0102
Extended Height QC Conveyor	26-0106
Stainless Steel Feed Conveyor	26-10018A
Stainless Steel QC Conveyor	26-10019A
T4 Tandem Adapter - Standard	24-0022-01
T4 Tandem Adapter - Stainless Steel	24-9032
Twister Foam Cannon	25-0024

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**

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