

# B4



## Operation Manual



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# IMPORTANT SAFETY INFORMATION

This document refers to the Twister B4 bucking machine as the B4.

The B4 is a high-power machine that requires special safety precautions to be practiced while in operation to reduce the risk of personal injury.

Improper use of the B4 may cause serious or fatal injury. Please read the precautions and warning labels before using the B4.

Do not lend out or rent your B4 without this operating manual. A first time operator should obtain proper instruction before using this machine.



## SAFETY PRECAUTION

Operating the B4 without reading the instructions that accompany a cautionary label i.e.: a “Danger”, “Caution”, “Warning” or “Notice” symbol, may result in serious or fatal injury.

### General

- Do not move, disassemble, clean or inspect the B4 while the power is connected to the machine.
- The B4 is very heavy. Never lift alone and always use proper lifting techniques.
- Ensure unit is secured to stand. Do not cantilever cartridge over a conveyor or bin without securing frame.
- Replacement parts are specific to the B4 and must be purchased from an authorized dealer only.
- Substituting factory parts with third-party parts may result in bodily harm or damage to the B4.
- Keep everyone a safe distance from your work area. Never operate the B4 around children.

### Connection

- Like any home appliance, the B4 must be used in connection with a properly grounded receptacle.
- Never plug in or power up the B4 with protective guards removed.
- Do not use extension cords smaller than 14 gauge or longer than 50ft (15m) in length to power up your B4. Using unrated extension cords can cause motor overheating and premature failure.

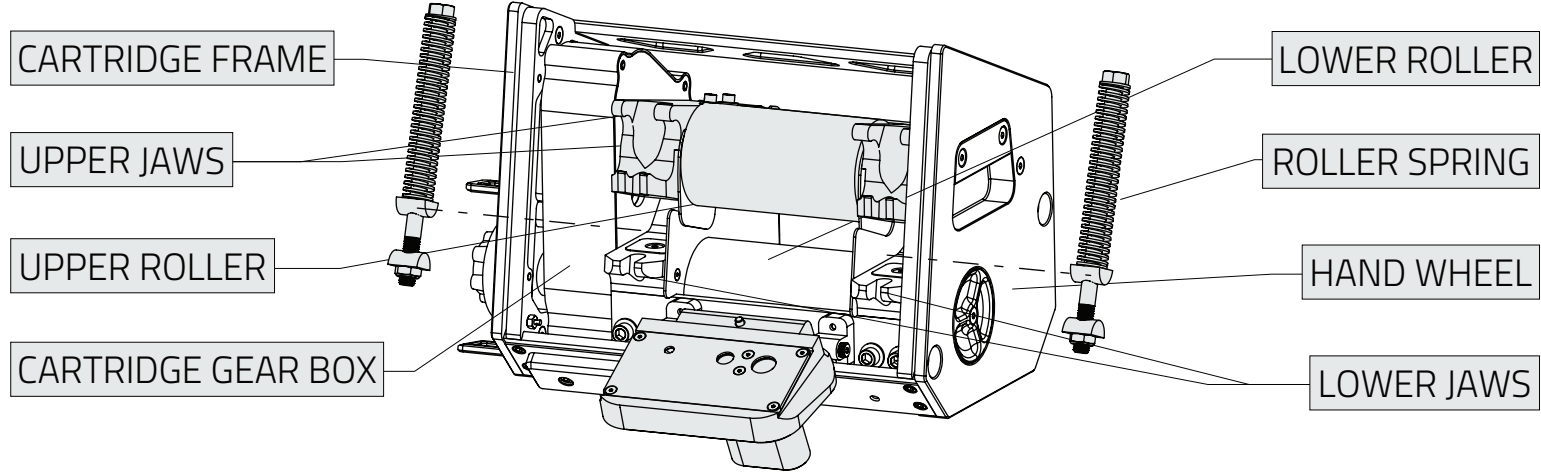
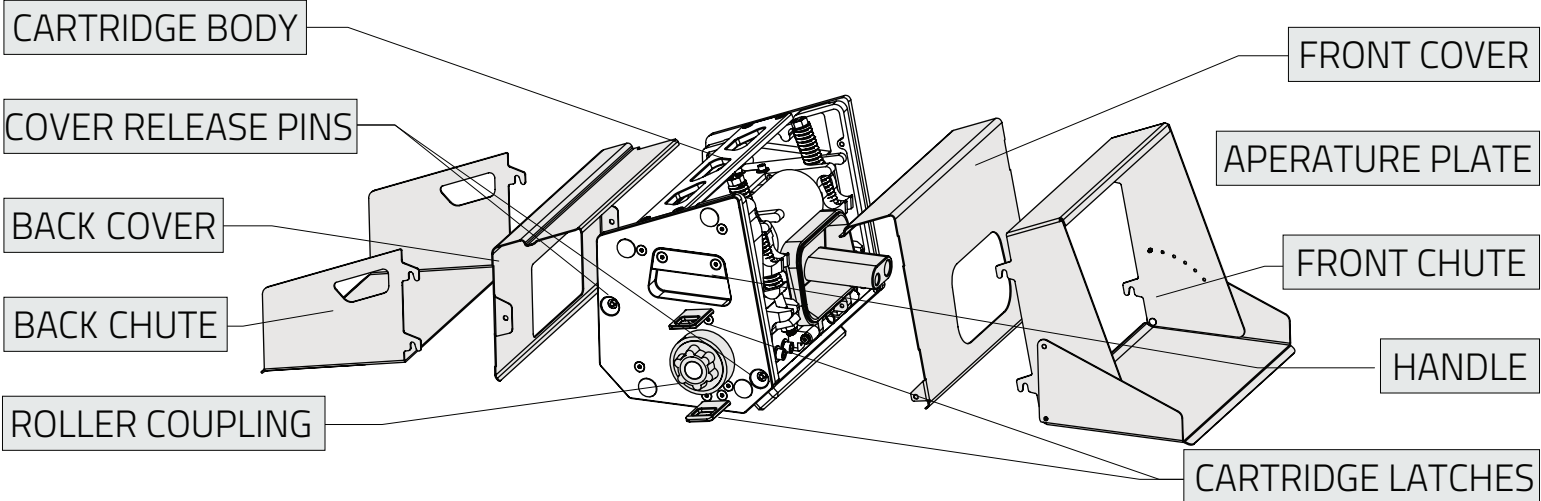
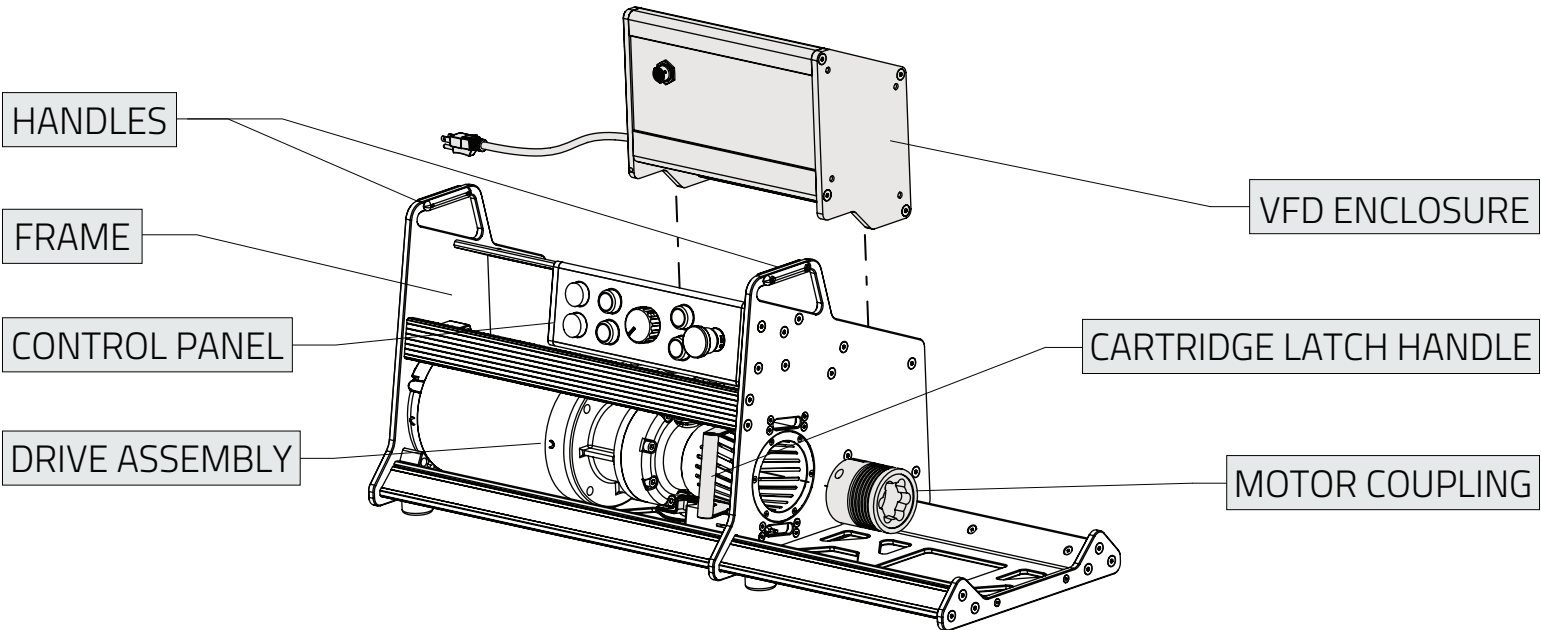
### Operation

- The B4 comes from the manufacturer set with the optimal roller compression. The initial set up will show assembly instructions to put the front and rear chutes on.
- Safety glasses and dust masks must be worn at all times when operating the B4.
- Do not operate the B4 while tired or under the influence of drugs, alcohol or medication.
- Do not put objects in the feed rollers that cannot be properly processed by the B4. Doing so may cause bodily harm or damage to property. **Plant matter only.**

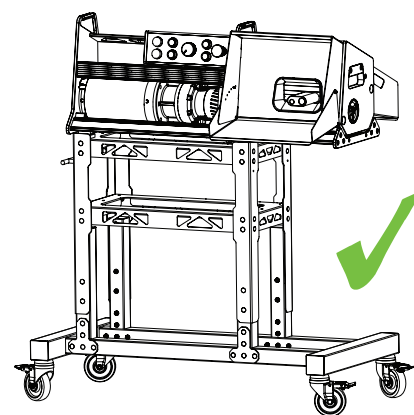
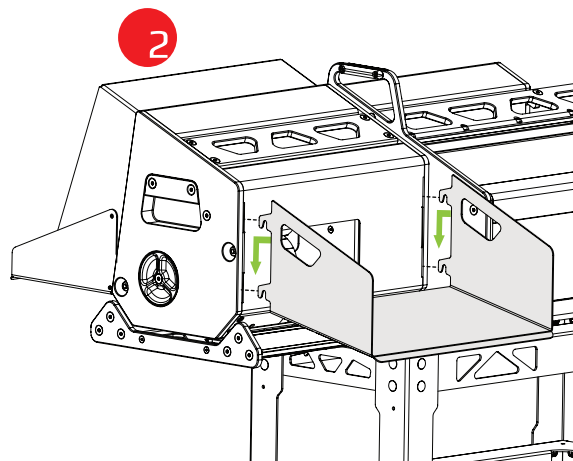
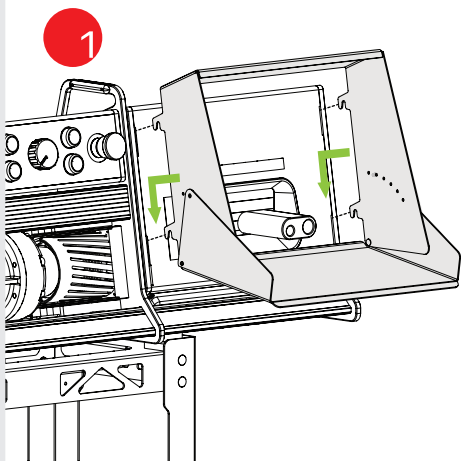
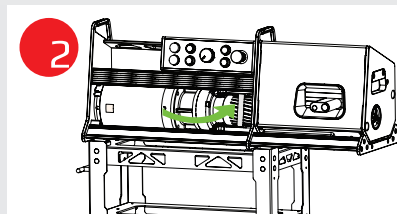
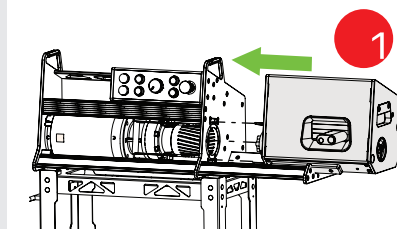
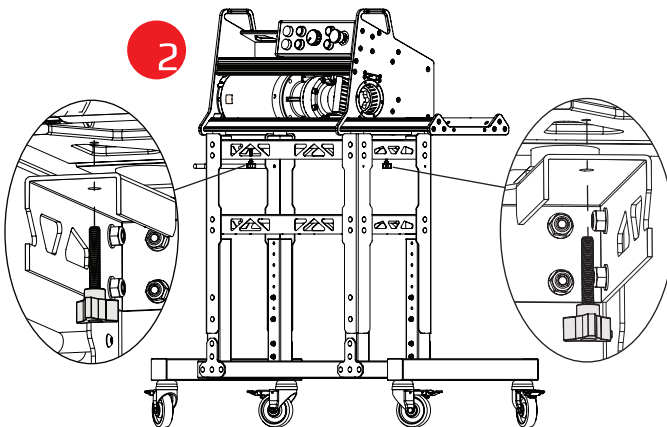
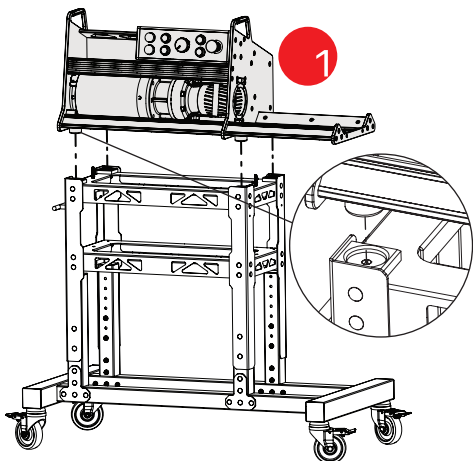
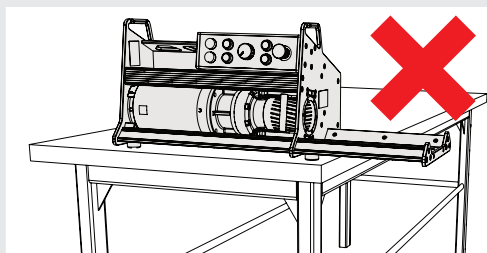
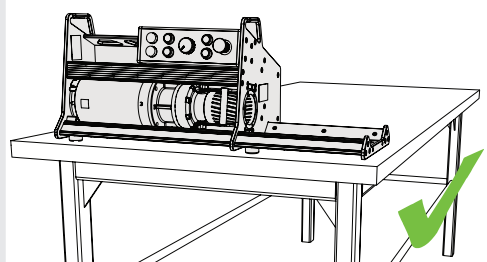
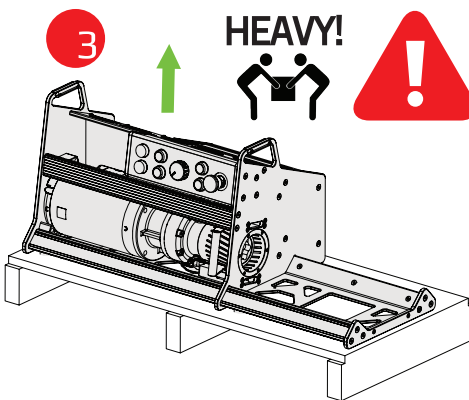
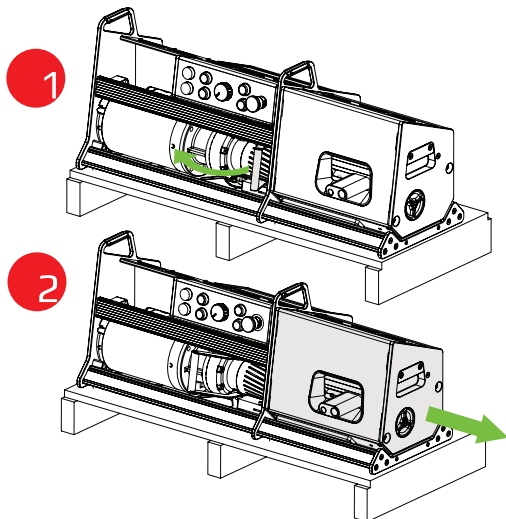
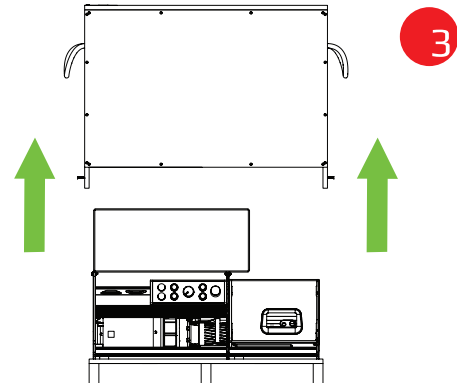
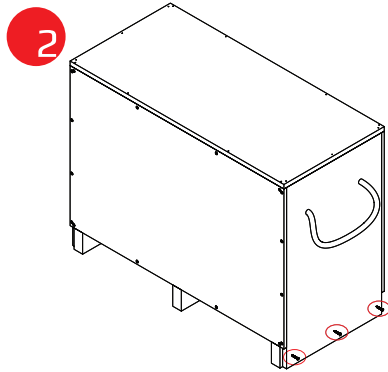
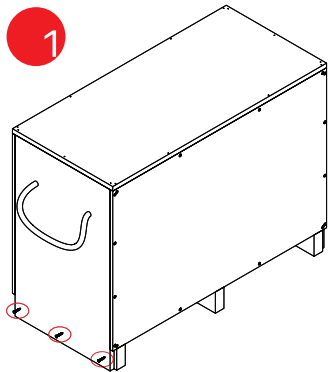
### Maintenance

- Never let the B4 run unattended.
- Never conduct maintenance while the B4 is plugged in.
- Ensure the B4 is powered off and the machine is unplugged before cleaning.
- Do not change or modify any part of the B4 or its accessories. Doing so may cause bodily harm or damage to property.

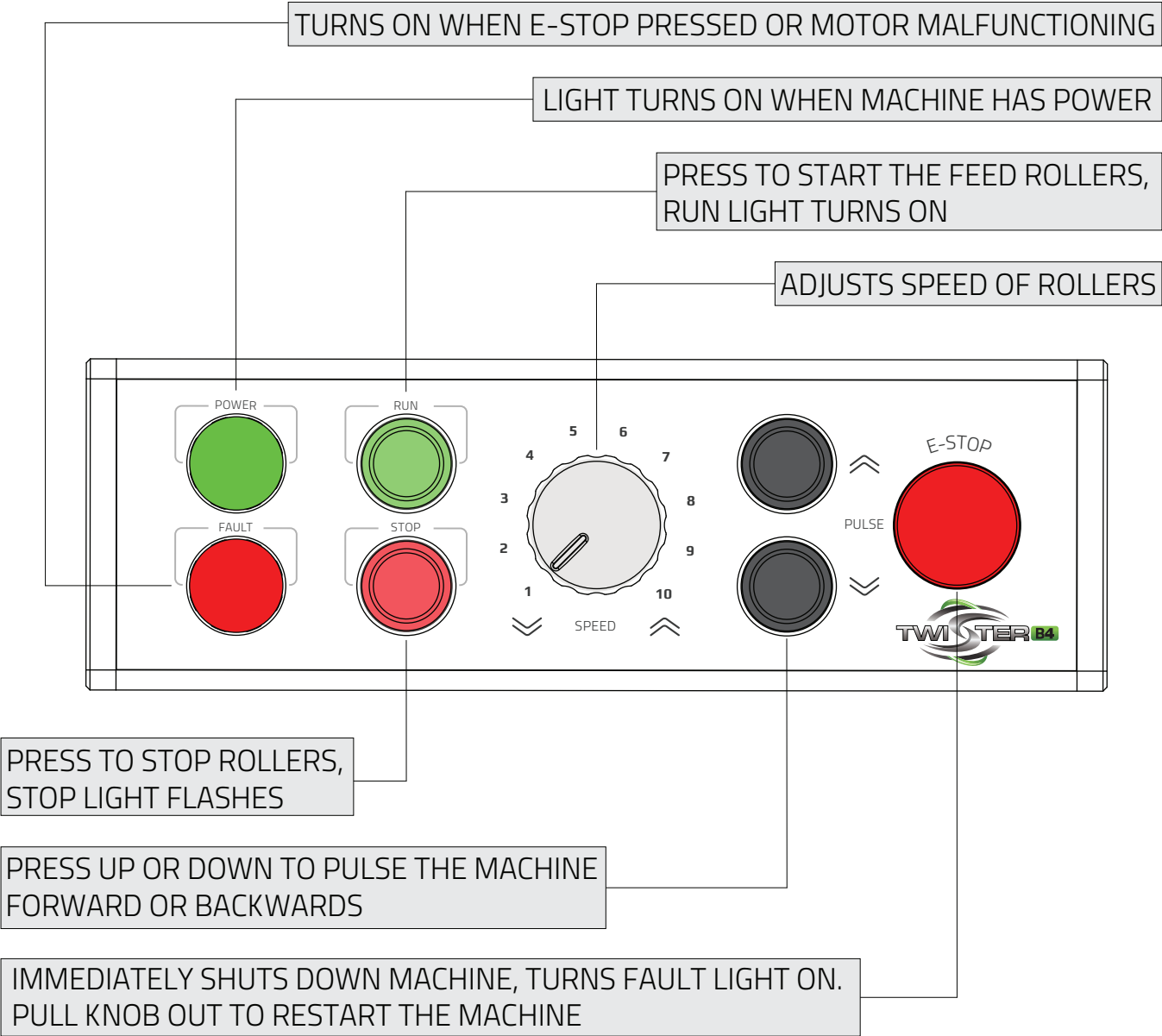
COMPONENT OVERVIEW



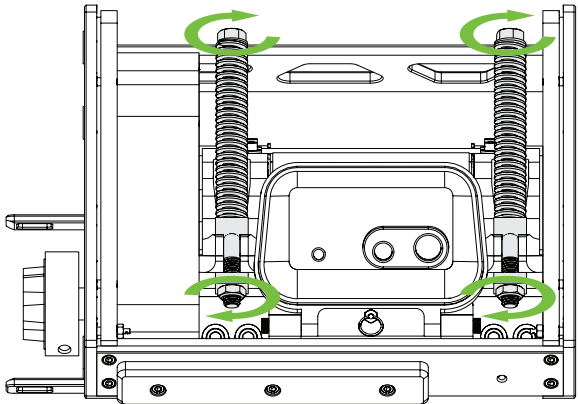
# INITIAL SET-UP



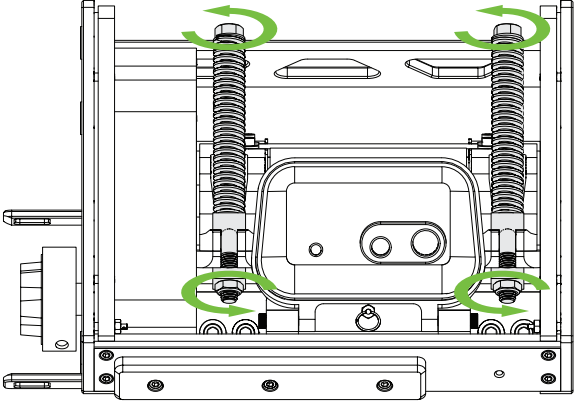
CONTROL PANEL OVERVIEW



SPRING FORCE ADJUSTMENT



HIGHER SPRING FORCE



LOWER SPRING FORCE

The B4 is a precision machine. It is essential that it is operated and cared for with this in mind. It has been adjusted and tested by the manufacturer for optimal performance. However, at initial startup and at the beginning of each use, it is important to inspect the machine for any damage, plant material buildup and check to ensure the rollers spin freely before operating.

It is also highly recommended to clean the machine at the end of every use. This will extend the life of the machine and the drive components, ensure performance of the machine and make cleanup much easier. This is especially important if the machine is to be stored for extended periods of time. Resins and other plant by-products will build up and harden, becoming difficult to remove.

## Inspection

Inspection of the B4 should be conducted prior to each use following the upcoming disassembly section and these steps:

- Unplug the B4 and visually inspect all of the components for wear, damage and plant matter buildup
- Remove the roller cartridge, chutes and guards. See disassembly section for instructions.
- Inspect the rollers for damage or cracking
- Remove springs and ensure the upper jaw rotates up and down freely
- Ensure rollers spin freely, with both top and bottom roller moving opposite directions
- Visually inspect the couplings for damage and/or worn teeth

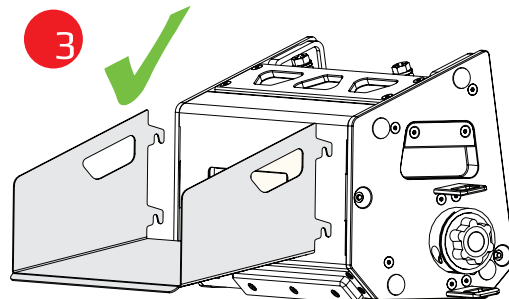
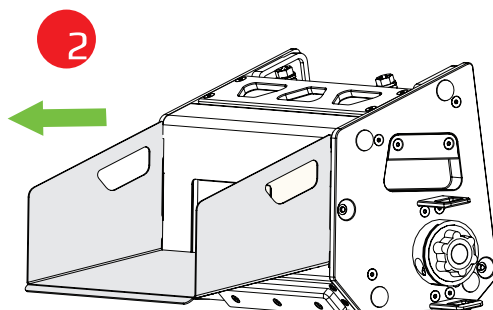
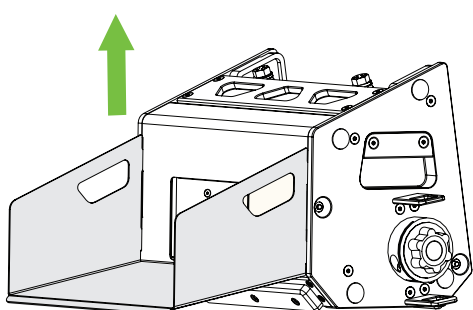
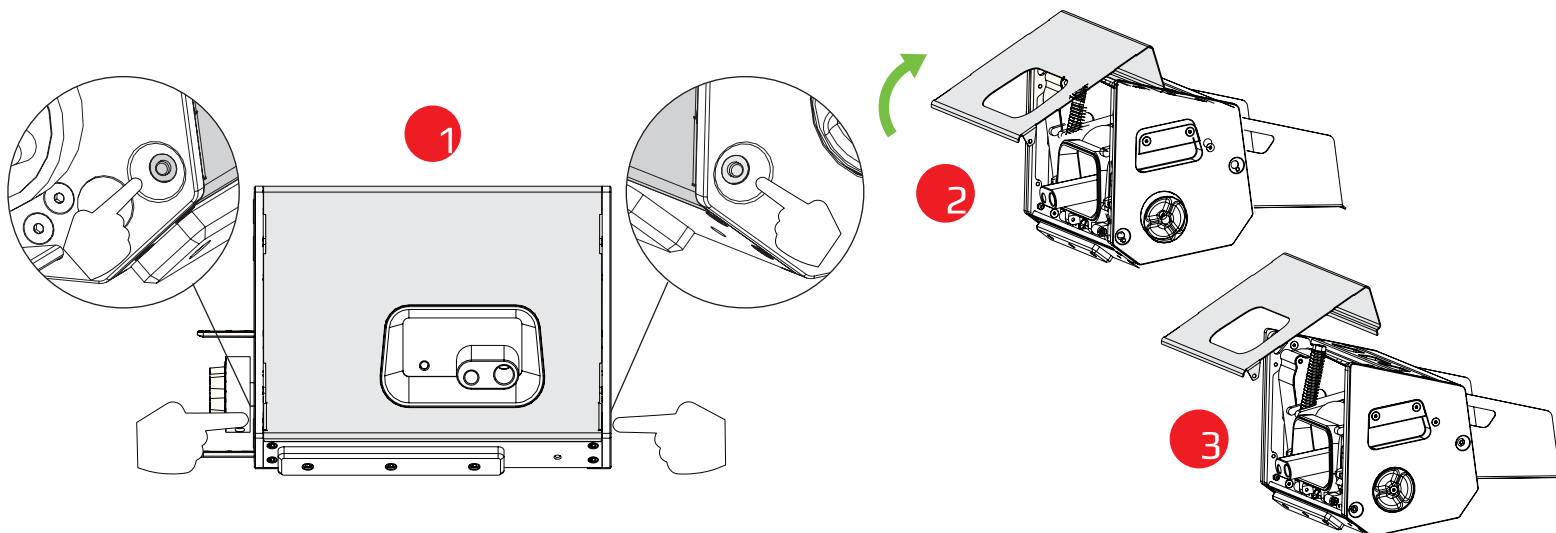
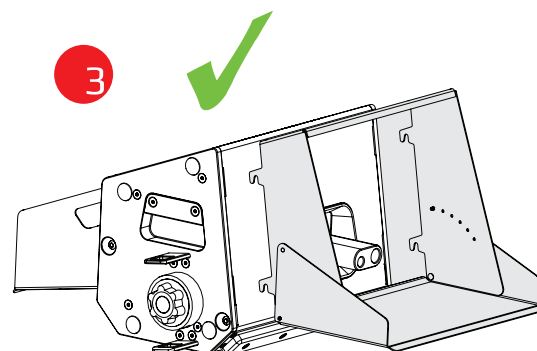
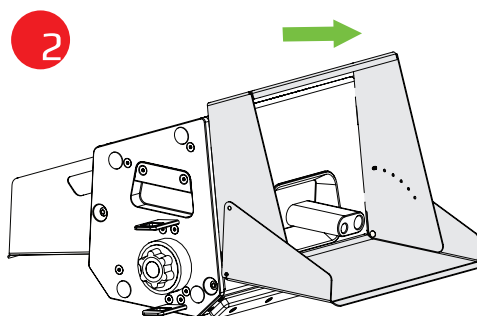
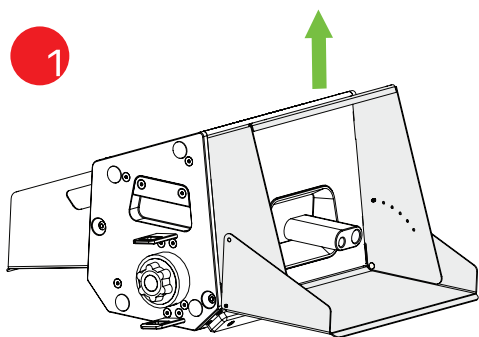
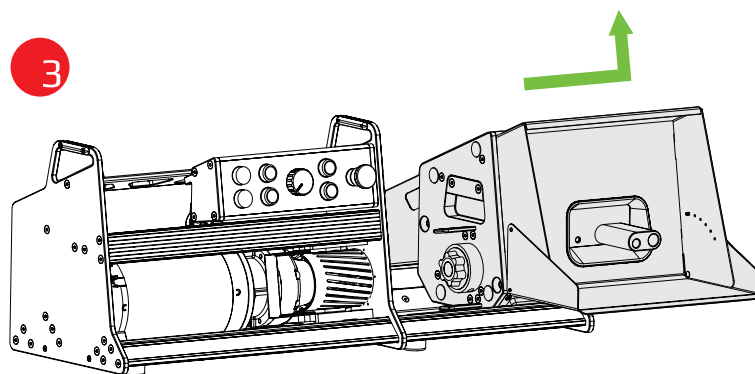
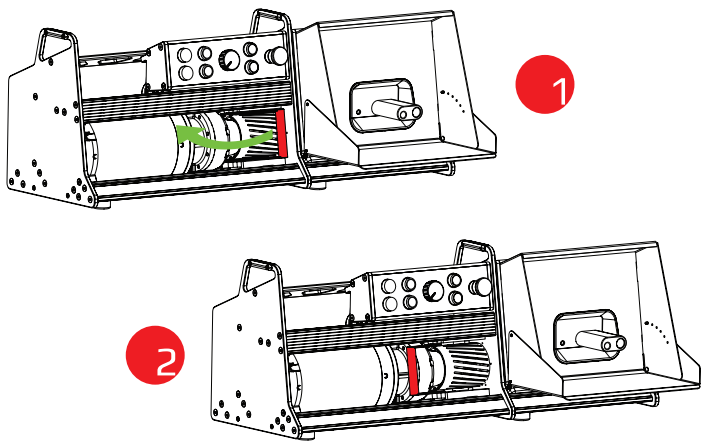
## Cleaning

A thorough cleaning of the B4 should be performed after each use. Any resin buildup on the machine attracts more resin, compounding the problem. Buildup can cause decreased performance, overheating and could trip your circuit breaker. Future cleaning also becomes more difficult if buildup is given a chance to dry out and harden. Operating the B4 in a cold environment will also reduce the resin build up.

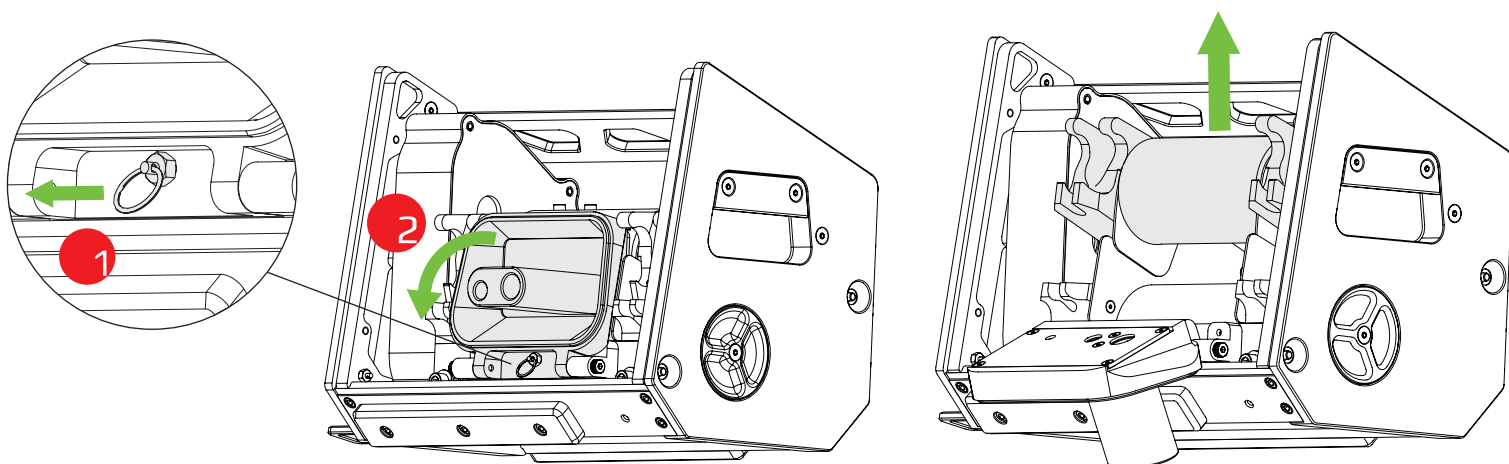
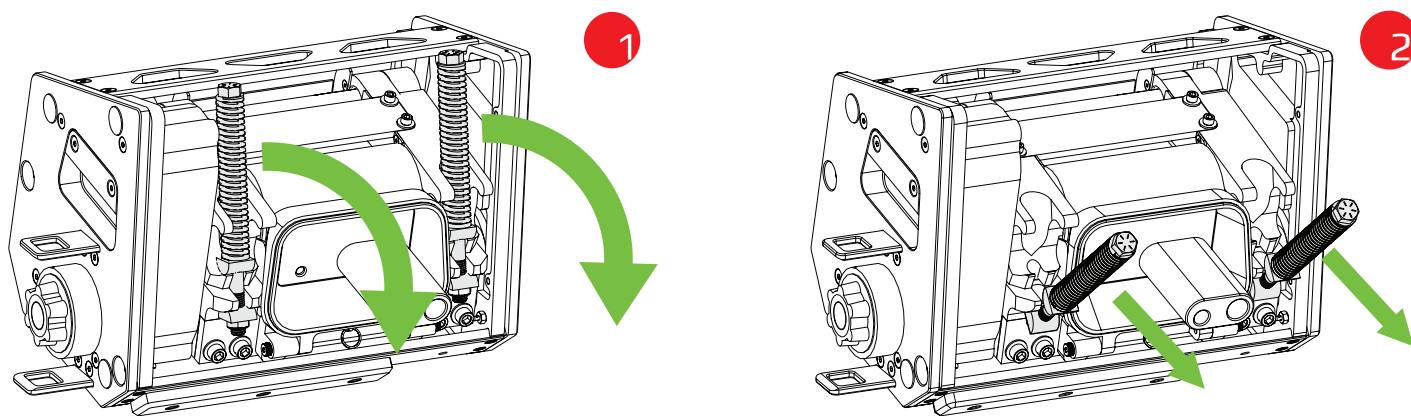
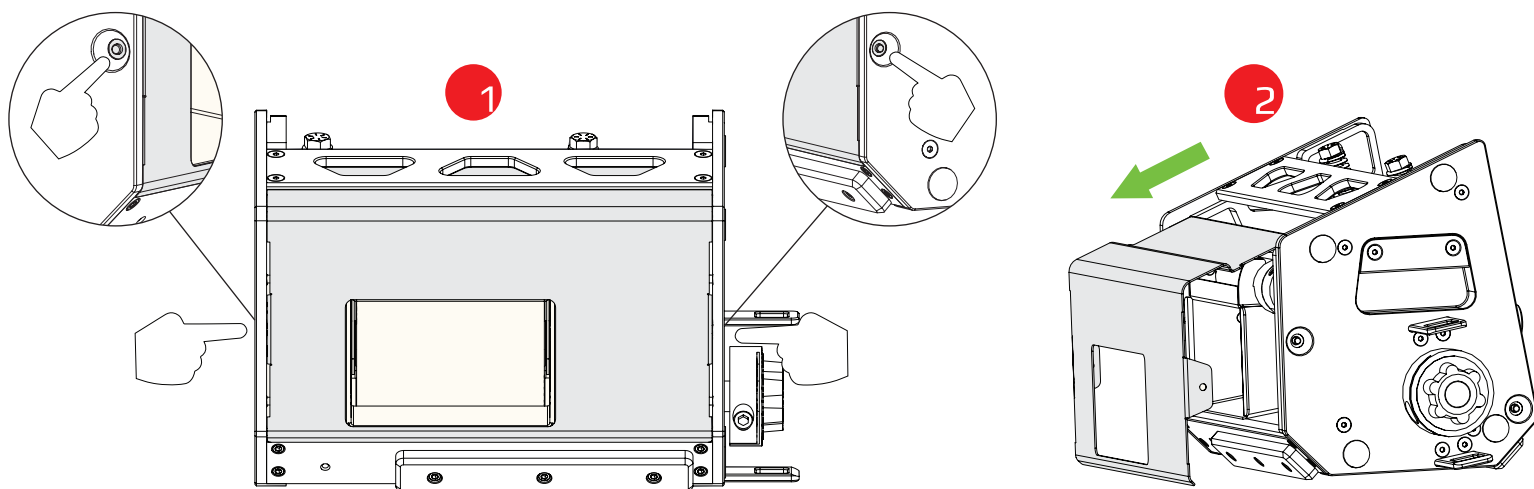
After disassembly, all chutes, springs and guards can be soaked using hot water and Simple Green or isopropyl alcohol. Soak all other surfaces with Simple Green and let sit for 5-10 minutes. Repeat 2-3 times to soften the resin, then powerwash to remove debris. Be sure to wash the under side of the cartridge also. Any stubborn areas, such as the roller jaws, may require scrubbing with a stiff bristled plastic brush or a plastic scraper (do not use a metal scraper). Plant matter buildup is the most obvious sign that more attention is needed in a particular area.

Dry the machine with a soft cloth or compressed air.

# DISASSEMBLY INSTRUCTIONS



# DISASSEMBLY INSTRUCTIONS



# TROUBLESHOOTING

## 1. Motor is very hot

The motor is designed to operate at higher temperatures, avoid contact with the motor during regular operation. The motor is thermally fused and will shut down automatically if overheating occurs.

## 2. Fault Light is on

First, ensure the E-Stop hasn't been activated. If the E-Stop isn't active, the motor drive is sensing a malfunction. Unplug the machine, disconnect the cartridge, reduce the speed control to the lowest setting and plug the machine back in. Clear the area around the motor coupling and turn the machine on. If the fault persists, there may be an electrical issue – check your electrical service and remove any extension cords. If the fault clears, check for jams in the cartridge by disassembling the cartridge (as shown in the disassembly instructions) and visually check for jams, then try to spin the roller coupling by hand. Assemble the cartridge and install into the machine.

## 3. Machine is jammed with plant matter

This can happen when too large of a stem is put through the machine. Press and hold the reverse pulse button to rotate the rollers backwards while pulling on the stem.

## 4. There is a grinding sound coming from the machine

This can be caused by worn out bearings, misaligned gears or improperly installed components. Try removing the cartridge and rotating the shaft by hand, if the rollers rotate smoothly there is an issue with the drive assembly. If the rollers were recently replaced it is likely an alignment issue, otherwise the bearings are damaged and need replacement.

## 5. Pull force seems weak

This could be caused by excessive debris build-up in the cartridge or the rollers have been damaged. Disassemble, clean and inspect machine to determine the issue.

## 6. Rollers are slipping

Slipping occurs if the motor reaches the torque limit, or the roller friction has been reduced. Roller friction can be reduced by feeding excessively wet material or if any lubricants accidentally get on the rollers. Check to see if the rollers are dry and clean, if slipping persists tighten the roller springs.

## 7. Cartridge does not re-align flush with the frame.

This can happen if the couplings become misaligned. Pull the cartridge release handle while pushing the pulse button to jog the coupling into place.

For all other issues, please contact tech support at [1-888-254-3204](tel:1-888-254-3204) or [support@keirton.com](mailto:support@keirton.com) and we will be glad to help you.

Tech support is available from 7am-7pm PST, 7 days a week.

## WARRANTY INFORMATION

The manufacturer will repair or replace, without charge, any parts proven defective in material or workmanship for a period of 1 year.

The warranty period will begin on the date the machine is purchased by the initial purchaser. B4 warranty defects can be remedied at any authorized service dealer or directly at the manufacturer. Any service work performed and deemed valid due to a defective part will be free of charge. Keirton® reserves the right to use any manufacture approved replacement part for warranty repair.

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

- 1) Model and serial number
- 2) Proof of purchase date
- 3) A copy of the original Warranty Registration Card (unless registration was completed online)
- 4) Details of the defect or problem (including photos/video)

The machine or defective part then must be returned to the manufacturer for analysis and replacement.

**NOTICE: 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, neglect, improper maintenance, improper electrical connection, normal wear, accidental damage or unapproved modifications.

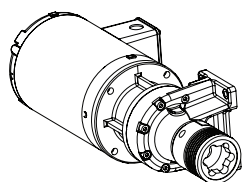
The manufacturer assumes no risk and shall be subject to no liability for damages or loss resulting from the specific use or application made of the product. In no event will the manufacturer be liable for any special, incidental or consequential damages (including loss of use, loss of profit and claims 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 the manufacturer.

The B4 is intended for use on legal aromatic herbs and hops. Please check all municipal, provincial/state and federal laws and regulations before using the B4. Keirton® does not promote or condone the use of the B4 in any way that may be deemed illegal.

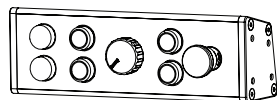
Allow only persons who understand this manual to operate the B4. Keirton® claims no liability for any damage or injury that result from the use of the B4 by persons who have not read and understood the cautions contained in this manual or through any misuse of the B4. You are responsible for your safety while operating this machine - please keep yourself safe!

To receive maximum performance and satisfaction from the B4, it is important that you read and understand the safety and maintenance precautions before using the machine.

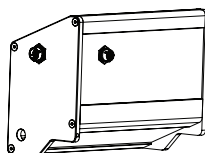
# REPLACEMENT PARTS



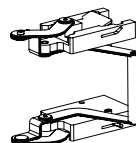
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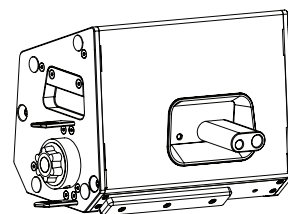
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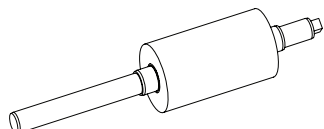
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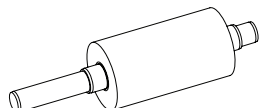
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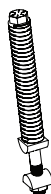
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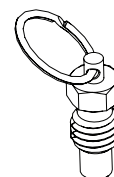
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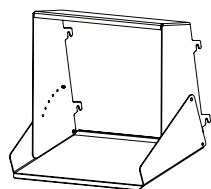
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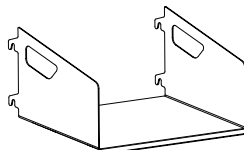
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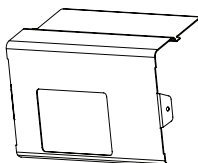
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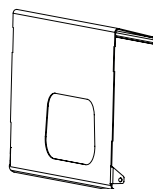
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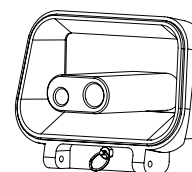
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N



O



P



Q

| REF | PART NUMBER | DESCRIPTION                    |
|-----|-------------|--------------------------------|
| A   | 24-0502     | DRIVE ASSEMBLY                 |
| B   | 24-0500     | CONTROL PANEL ASSEMBLY         |
| C   | 24-0505     | VFD ENCLOSURE ASSEMBLY         |
| D   | 24-0506     | CARTRIDGE LATCH ASSEMBLY       |
| E   | 24-0503     | CARTRIDGE ASSEMBLY             |
| F   | 11-0509     | LOWER FEED ROLLER              |
| G   | 11-0510     | UPPER FEED ROLLER              |
| H   | 24-0 515    | ROLLER SPRING ASSEMBLY         |
| I   | 19-0512     | MOTOR COUPLING, CARTRIDGE SIDE |
| J   | 13-0388     | SPRING PLUNGER                 |
| K   | 27-0011     | BEARING OVERHAUL KIT           |
| L   | 24-0516     | CARTRIDGE FRONT CHUTE ASSEMBLY |
| M   | 11-0538     | CARTRIDGE BACK CHUTE           |
| N   | 11-0534     | CARTRIDGE FRONT COVER PLATE    |
| O   | 11-0535     | CARTRIDGE REAR COVER PLATE     |
| P   | 24-0514     | APERATURE PLATE ASSEMBLY       |
| Q   | 27-0007     | SAFETY DECAL KIT               |

## TWISTER B4 BUCKER

|                             |                               |
|-----------------------------|-------------------------------|
| Input Voltage               | 120V, 60 Hz Single Phase      |
| Current Draw                | <2A Operating, 14.8A Max      |
| Drive Motor                 | 1HP                           |
| Motor RPM                   | 1750 RPM                      |
| Variable Speed              | Yes                           |
| Weight                      | 285lbs / 130kg                |
| Shipping Weight (w/o stand) | 338lbs / 154kg                |
| Length (Shipping)           | 37.5in / 96cm (39in / 100cm)  |
| Width (Shipping)            | 13in / 33cm (17in / 44cm)     |
| Height (Shipping)           | 14.5in / 37cm (28.5in / 72cm) |
| Circuit Breaker Required    | 15A / 120V                    |
| Connector (plug)            | NEMA 5-15P                    |
| Fused                       | Yes, Thermally                |

## TWISTER B4 BUCKER FEATURES

|                      |                           |
|----------------------|---------------------------|
| Feed Throughput      | 150 lbs/hr (Hydrated)     |
| Feed Entry Sizes     | 3-hole (1/4", 1/2", 3/4") |
| Feed Types           | Wet/Dry                   |
| Roller Sets          | Neoprene Rubber           |
| Motor Pulse          | Yes                       |
| Reverse Operation    | Yes                       |
| Duty Cycle           | Continuous                |
| Maintenance Interval | > 1000 hours              |
| Pull Speed           | 10 - 30 in/s              |
| Pull Strength        | > 430 lbs                 |

## TWISTER B4 BUCKER CONNECTIONS

|                                                                                     |            |
|-------------------------------------------------------------------------------------|------------|
| Connector (plug)                                                                    | NEMA 5-15P |
|  |            |

## ADDITIONAL REQUIREMENTS

|                |                             |
|----------------|-----------------------------|
| Extension Cord | 14/3 AWG (minimum AWG size) |
|                | 15m / 50ft max length       |