



**CARPENTER MFG. CO., INC.**

110 Fairgrounds Drive • P.O. Box 188 • Manlius, NY 13104-0188 USA • 315.682.9176 • FAX: 315.682.9160

# OPERATOR'S MANUAL



## Model 25F

## Rotary Wire Twister

PRODUCTION WIRE PROCESSING EQUIPMENT

## CARPENTER MODEL 25F ROTARY WIRE TWISTER

### **INTRODUCTION**

Thank you for choosing Carpenter Mfg. Co. Inc. Wire Processing Equipment. For over 60 years Carpenter has been a leader in Wire Processing Technology and Service. Our desire has always been to bring you reliable products. We look forward to a long healthy relationship with you and our company.

The MODEL 25F can process a wide range of wire as referenced on the following page.

These processing specifications are based upon the most commonly manufactured wire. Special applications may arise with wires that are within the specification limits of the machine but are very difficult or unsuccessful to process. Likewise, wires that exceed the specified limits of the machine can sometimes be processed. Because there are many variables involved in Wire Processing we strongly recommend a free Wire Evaluation at our factory followed by a demonstration from a Carpenter representative to insure the ultimate success of your Wire Processing Application.

This operating manual explains how to operate the MODEL 25F. To ensure the best performance of your machine, read this manual carefully until you familiarize yourself thoroughly with its operation and features. After you have read through the manual, keep it available for reference. If you have any questions about this machine or service please let us know.

Our phone number is 315.682.9176, fax number 315.682.9160.  
Website: [www.carpentermfg.com](http://www.carpentermfg.com), E-mail: [wire@carpentermfg.com](mailto:wire@carpentermfg.com).

## CARPENTER MODEL 25F ROTARY WIRE TWISTER

### **IMPORTANT NOTICE**

The products in this shipment left our facility in good working condition.

Their safe delivery is the responsibility of the carrier  
that delivered this shipment to you.

Our stated shipping terms are F.O.B. our facility at  
110 Fairgrounds Drive, Manlius, NY 13104.

According to applicable laws, the responsibility for this  
shipment was transferred to you as soon as the carrier  
accepted the goods at our warehouse.

If concealed damage is discovered after unpacking this shipment,  
you must submit a damaged freight claim with the carrier.

Carpenter Mfg. Co., Inc. cannot submit your claim for you.

In order for you to collect for concealed damage,  
the carrier must be notified with 5 days  
of the date you receive this shipment.

You must leave the damaged items and packing material as is  
(i.e. return all merchandise and all packing material to the shipping container)  
until the claim has been inspected by the carrier.

Also, the carrier will not accept a claim if the goods  
have been moved from the point of the  
carriers delivery to another street address.

If you have any questions or problems,  
please give us a call at 315.682.9176.

## CARPENTER MODEL 25F ROTARY WIRE TWISTER

### APPLICATION

The Model 25F Wire Twister quickly restores a twist to pre-stripped stranded conductors in the 13 to 24 AWG (2 to 5mm) range. A standard Guide Sleeve drilled to .046" is furnished with the machine and enables smaller size wires to be twisted.

<u>AWG</u>	<u>DRILL SIZE</u>
13-14	.089"
15-19	.070"
20-24	.046"

To twist a larger size wire, drill out the Guide Sleeve to the correct size. Correct hole size is determined by noting diameters of the stranded conductors and its insulation. Select a drill size that will freely admit the stranded conductor but not its insulation.

Additional **#1929**Guide Sleeves, are available and can be drilled to any specified size.

### MACHINE SET UP

Guide Spacers, in thicknesses of 1/8", 1/4" and 1/2" used singularly or in combination, permit the Model 25F to be used for twist lengths up to 1". Also, the **#1930** Twister Bits can be installed in 2 different positions. The longer "V" should be used for twisting larger gauge wires and the shorter "V" should be used for smaller gauge wires. To insure all strands are engaged by the Twister Bits when the insulation contacts the Guide Sleeve, the total open distance between Guide Sleeve and Twister Bits (or between guide sleeve, guide spacers and twister bits) should not exceed 1/8".

### MACHINE OPERATION

Insert wire or wires up to the face of the properly sized guide sleeve and withdraw. Strands will be twisted, ready for further processing.

## CARPENTER MODEL 25F ROTARY WIRE TWISTER

### **WARRANTY**

Carpenter Mfg. Co., Inc. manufactures its products to be free from defects in materials and workmanship. Should any defect occur within 1 year after shipment, Carpenter Mfg. Co., Inc. will at its option, exchange or repair the defective device.

Repairs or adjustments to equipment under warranty can be performed at our factory or at the customer location, at the option of Carpenter Mfg. Co., Inc. In most cases a 1-2 day turn around time will be necessary to repair equipment at our facility. When equipment is returned to our factory for repair or replacement, freight charges will be borne by the customer. Repaired or replaced equipment will be returned at Carpenter's expense via U.P.S. ground service. If alternate shipping is requested by the customer, the difference in shipping charges will be billed to the customer.

This is a limited warranty and is in lieu of all other representations and expressed and implied warranties (including the implied warranties of merchantability and fitness for use.) Under no circumstances shall Carpenter Mfg. Co., Inc. be liable for any incidental or consequential property damages or losses subsequent to misuse or improper maintenance of this equipment.

#### **Not covered by this warranty are:**

- Consumable parts (blades, belts, guides, springs, inserts, stripping wheels, etc.)
- Cosmetic problems (nicks, scratches, etc.)
- Damages caused by any repairs or modifications by unauthorized personnel
- Abuse
- Damage caused by shipping
- Damage caused by environmental and/or atmospheric conditions.



