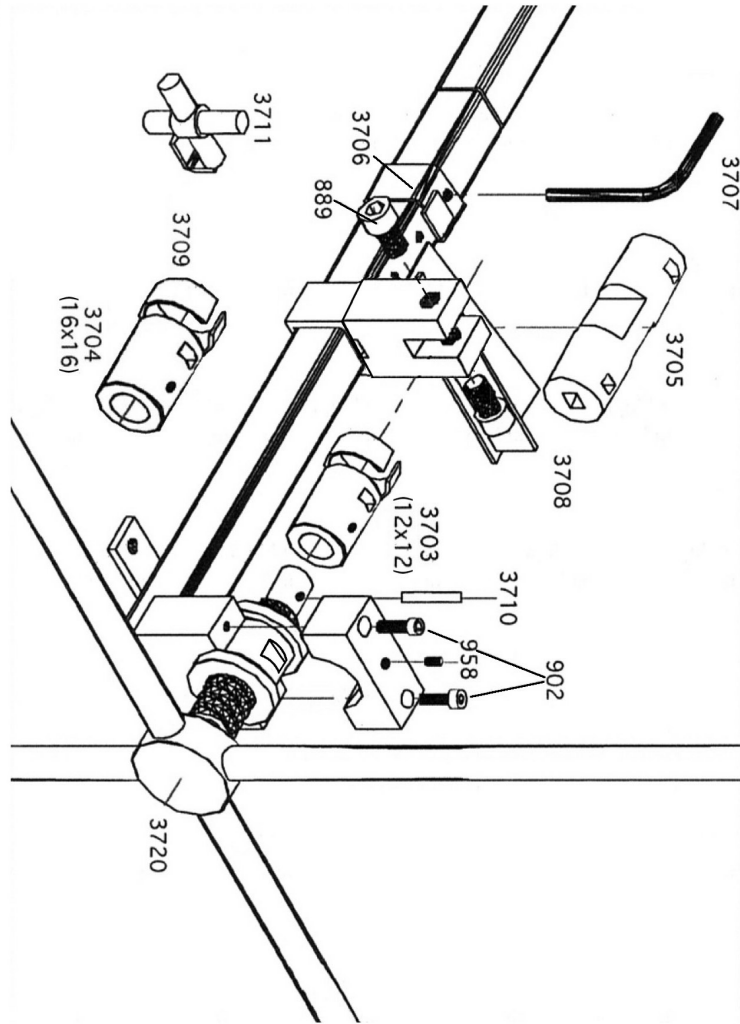


MODIFICATIONS

NOT TO SCALE



J & C R WOOD  
HULL ENGLAND

**BASKET MAKER COMPONENTS**  
(for use on XL Twister only)  
Part No. 1000  
Version No.1

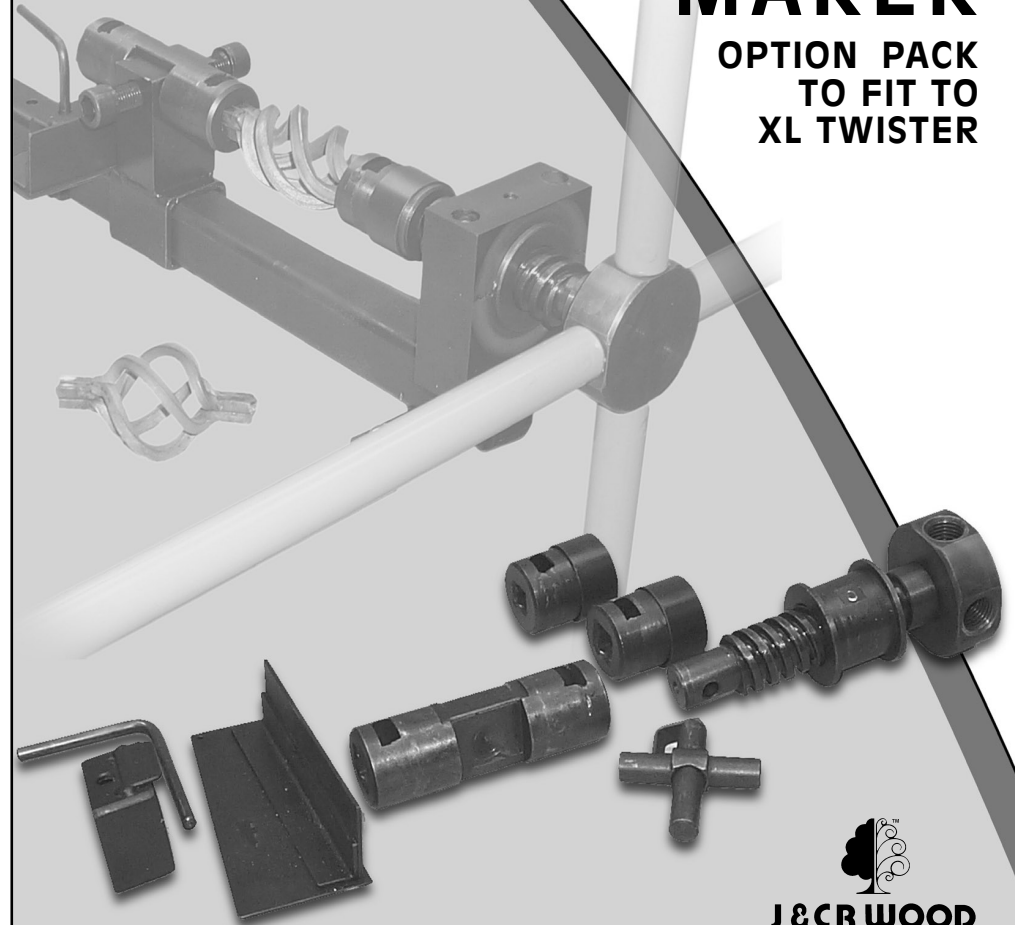
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OPERATING INSTRUCTIONS

metalcraft™

# BASKET MAKER

OPTION PACK  
TO FIT TO  
XL TWISTER



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19/05/06

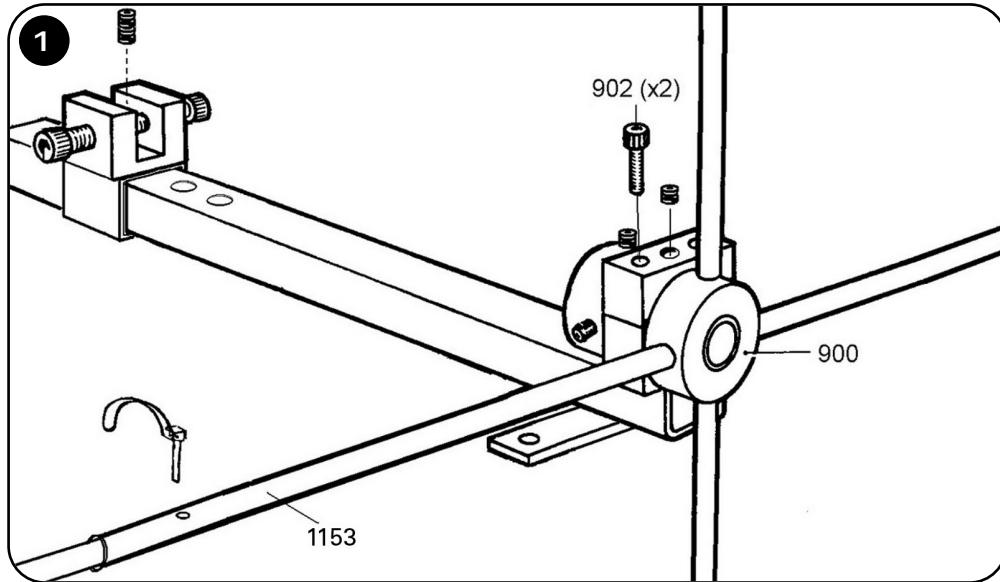


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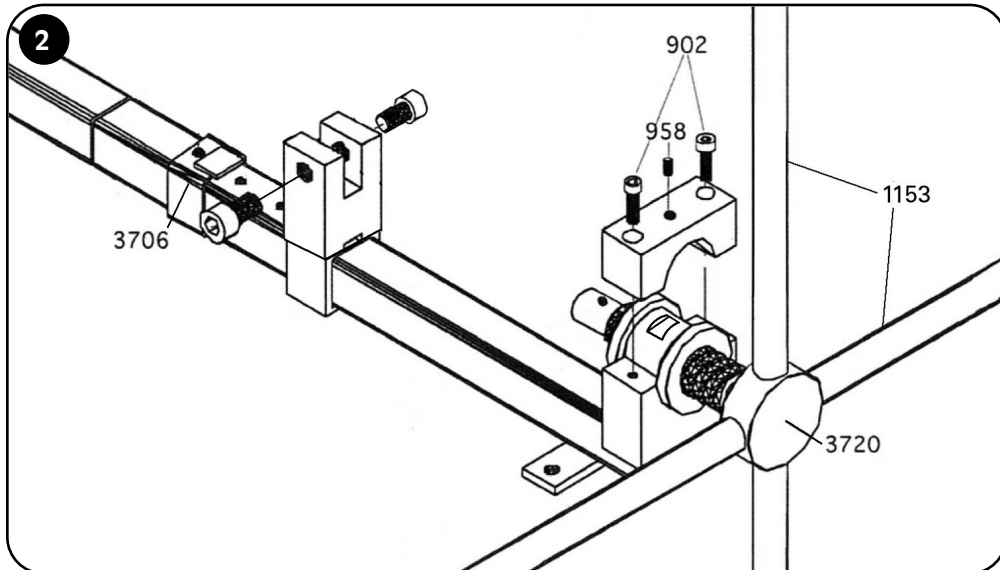
# BASKET MAKER

Please keep these instructions in a safe place for any future reference to the parts diagrams.

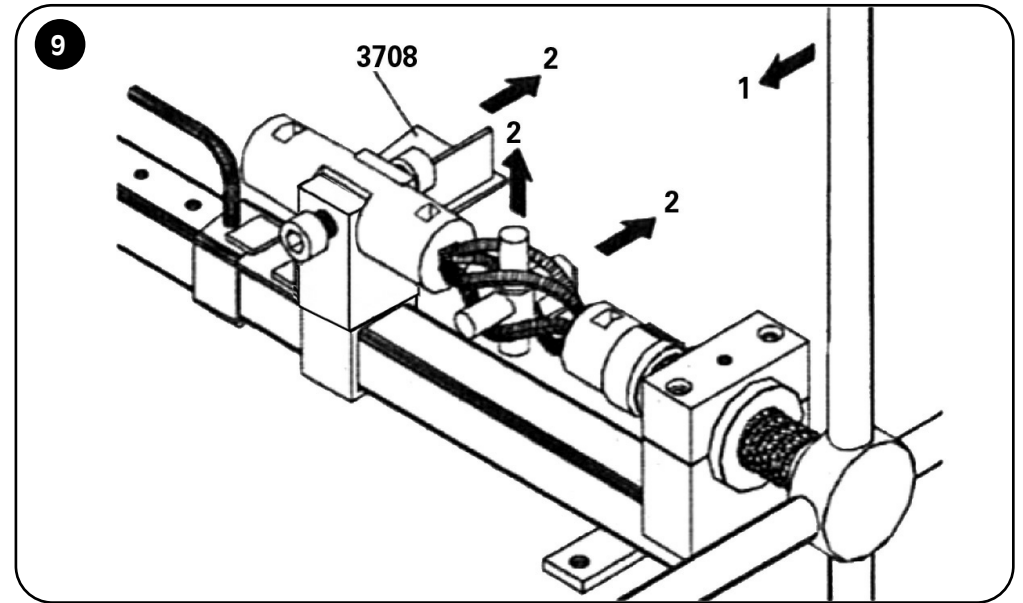
**IMPORTANT** - Ensure all moving parts are regularly lubricated and all bolts kept tightened.



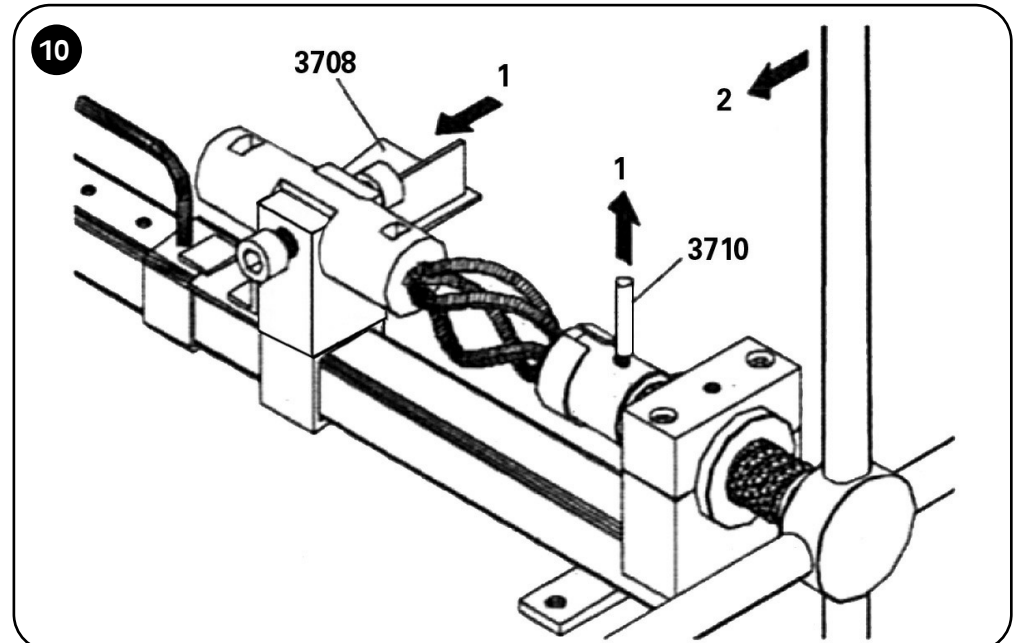
To fit Basket Maker to XL Twister, first remove all 4 Twister Handles (P/N 1153), then remove screws (P/N 902) from the top of the Twister Boss Housing. Remove Twister Boss (P/N 900).



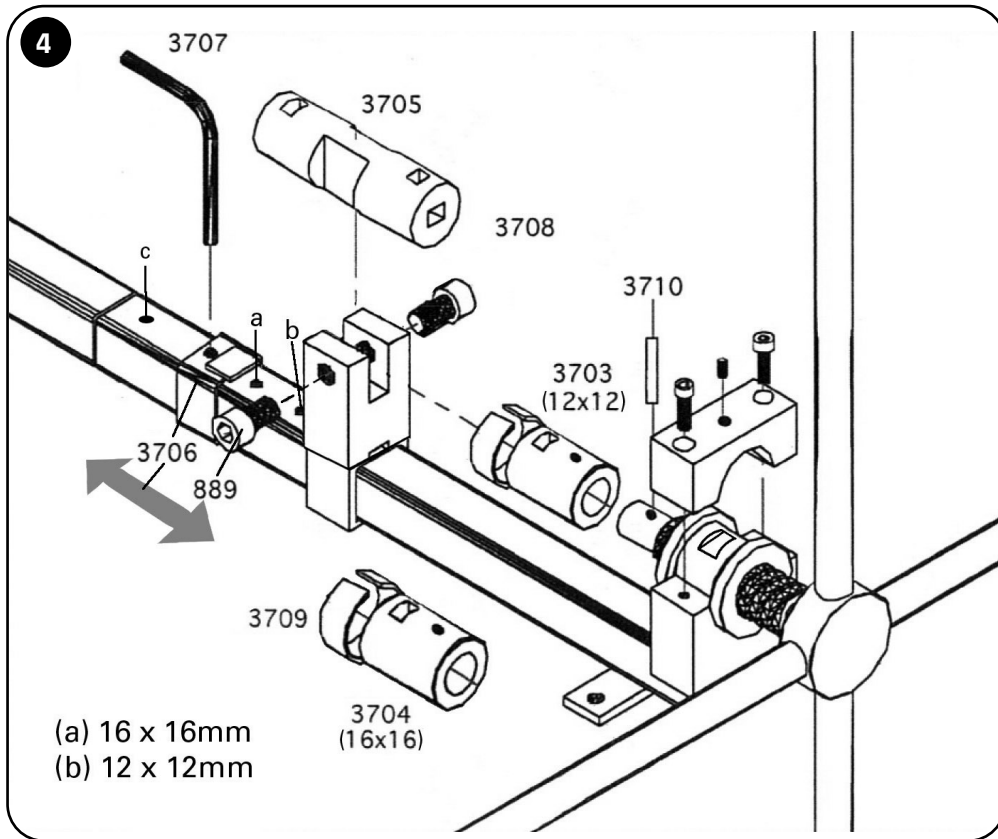
First ensure end stop slide (P/N 3706) is fitted to Twister Body. Then place Basket Maker Drive Thread & Collar (P/N 3720) into Boss Housing as shown with the machined flat on the collar facing upwards. Replace top half of housing firmly with screws (P/N 902) and finally clamp the collar down within the housing using grub screw (P/N 958). Then replace the four handles (P/N 1153).



Then rotate handles further in direction 1 until the 4 bars are consistently spaced. Then remove spacer (P/N 3711) and wedge (P/N 3708). Retract slide to release newly formed basket. If necessary, tap basket lightly with a hammer to ease it out of each gripping ring.

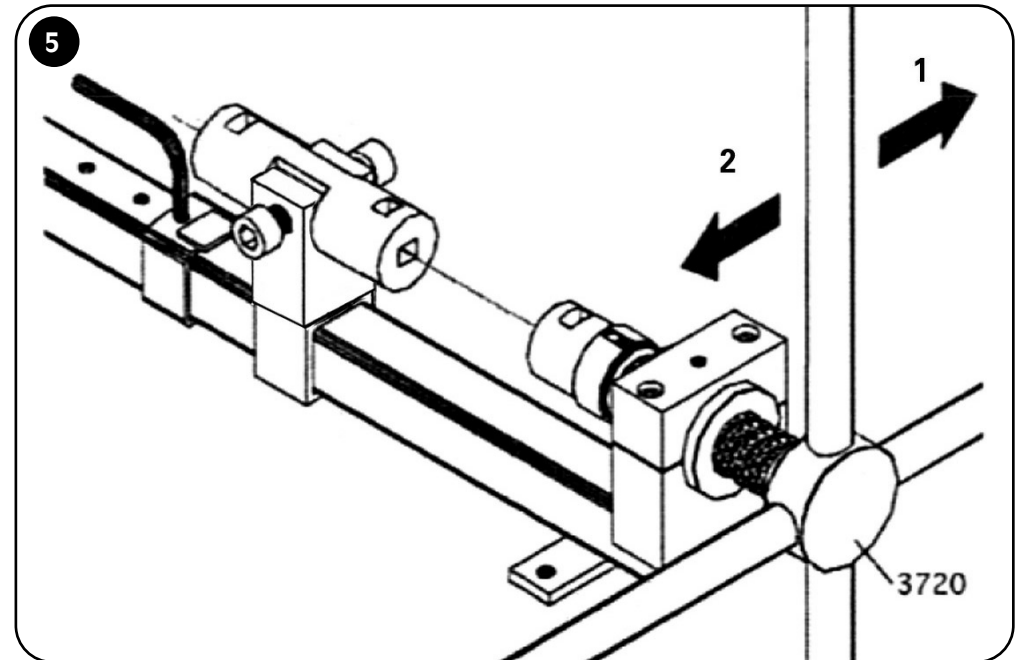


Alternatively, if you want to form more bulbous baskets. Keeping the wedge (P/N 3708) in position, remove the drive pin (P/N 3710) and rotate in direction 2 to apply additional squeeze.

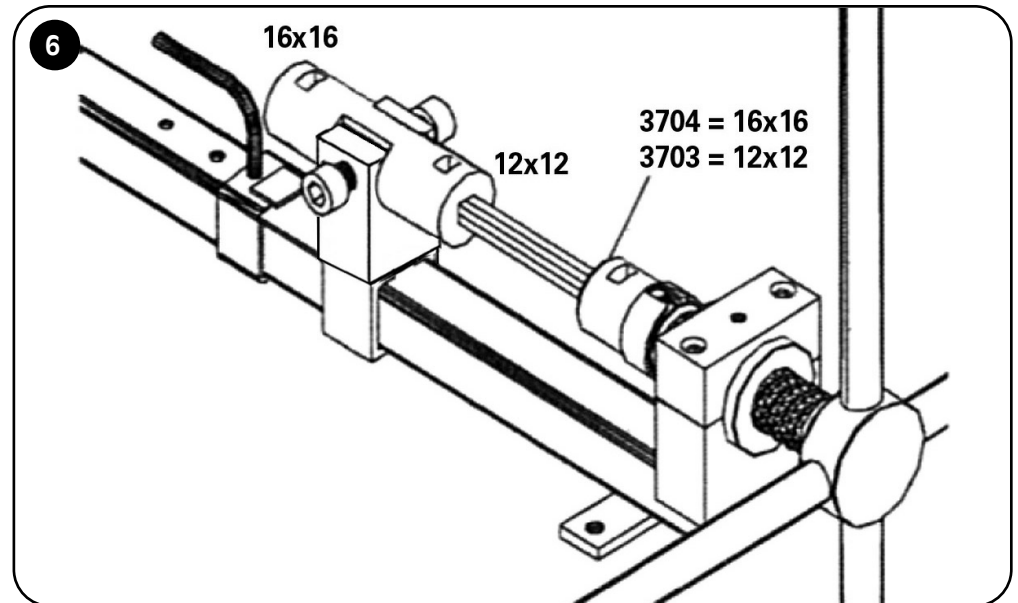


Having selected which size basket to make, slide gripping collar P/N 3703 (for 12mm x 12mm) or P/N 3704 (for 16mm x 16mm) onto end of Drive Thread, and locate Drive Pin P/N 3710 through holes in gripping collar and the end of the Drive Thread. To prevent drive pin falling out, slide on black plastic split ring (P/N 3709). Then select matching end of P/N 3705 to face gripping collar and drop into place in the Twister Slide (P/N 965). Lock into place using screws (P/N 889). Finally, ensure the hole in the top of the moveable end stop (P/N 3706) is aligned to position (a) for 16mm x 16mm or (b) for 12mm x 12mm and locked in place using the key (P/N 3707).

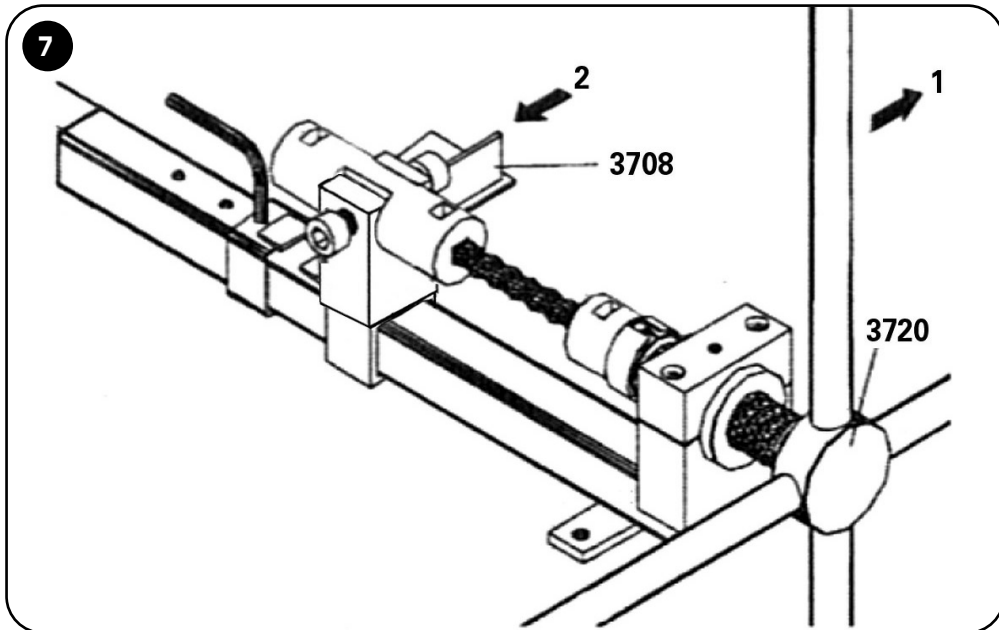
Note - c is a spare hole, available for longer baskets, if required.



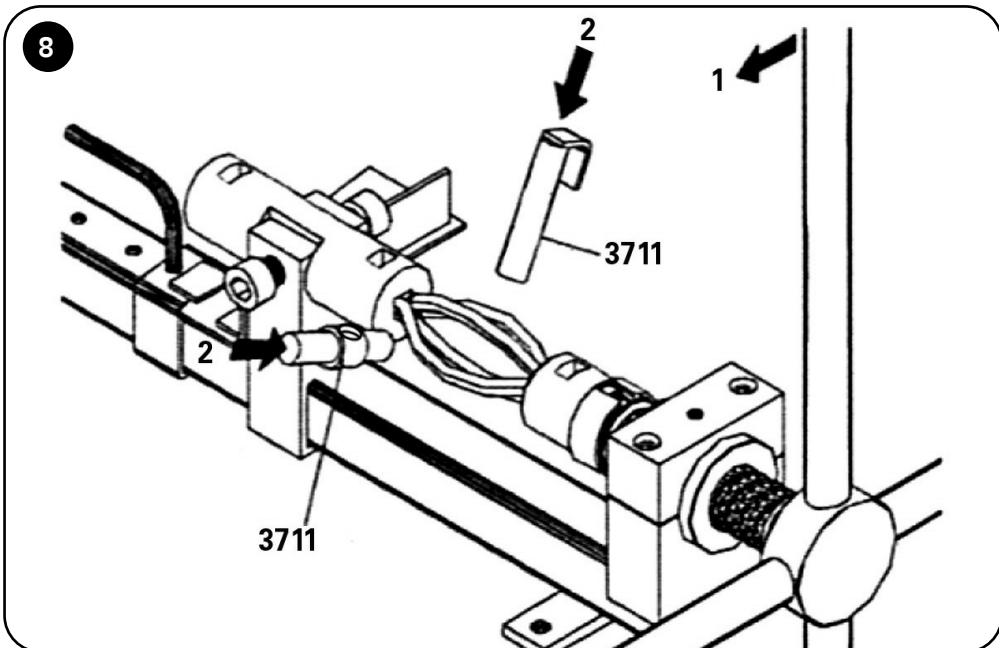
First rotate handle repeatedly in the direction '1' shown until it reaches the limit of its travel. Then rotate it back 1 1/2 turns (in direction '2' shown).



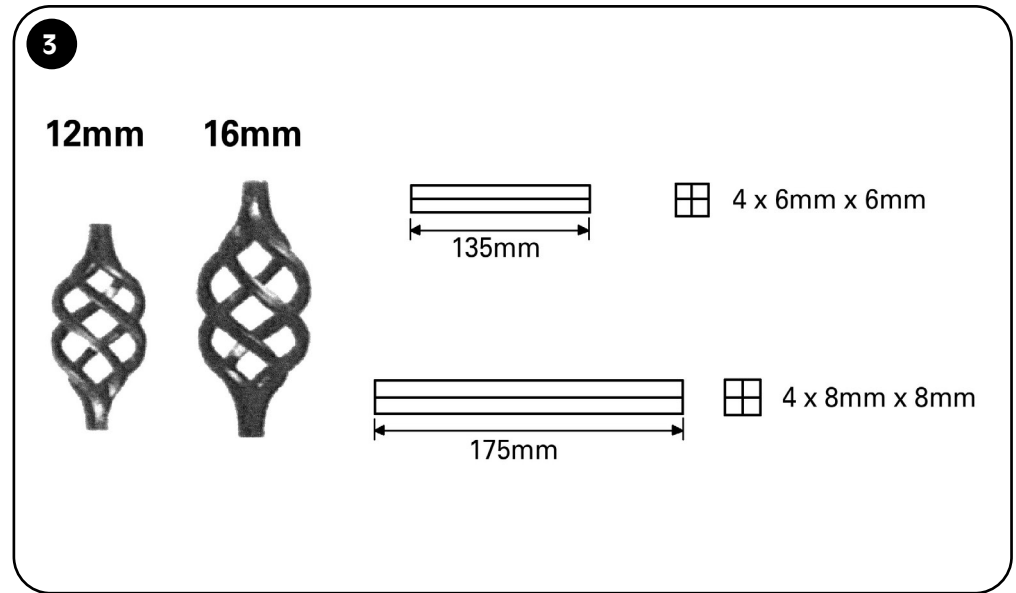
Insert blank into gripping collar (P/N 3703 or 3704) and slide the Twister Slide and reversible gripping collar (P/N 3705) towards opposing gripping collar to hold material firmly.



Rotate handles 1 - 1 1/4 turns in direction 1 shown above. Then insert wedge (P/N 3708) between slide and end stop slide (P/N 3706).



Then rotate handles in opposite direction 1 until the 4 bars are totally opened out. Then insert two halves of spacer (P/N 3711) into basket threading the male half into the hole in the female half and placing the hook of the male section over a strand of the basket. This ensures an even basket



To produce baskets from either 4 x 6mm (square or round) bars or 4 x 8mm (square or round) bars, make blanks to the recommended material lengths shown here. The ends of the blanks must be welded together and ground flat. Prior to forming the baskets, it is recommended that the bars are preheated and cooled to reduce the variance of the stresses in each bar. This will be most beneficial for the 8mm bars.

### CAPACITIES

SIZES OF METAL BAR		LENGTH	
(a)	(b)	(a)	(b)
 16mm x 16mm (4 x 8mm x 8mm)	 12mm x 12mm (4 x 6mm x 6mm)	175mm	135mm

#### NOTE:

1) These sizes are for Hot Rolled Black Mild Steel Bar & Annealed Bright Mild Steel Bar.

2) Working beyond the capacities stated above or with materials of greater strength or hardness will reduce the operational life of the machine.

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