

# ION XE MANUAL ADDENDUM

SMART PARTS



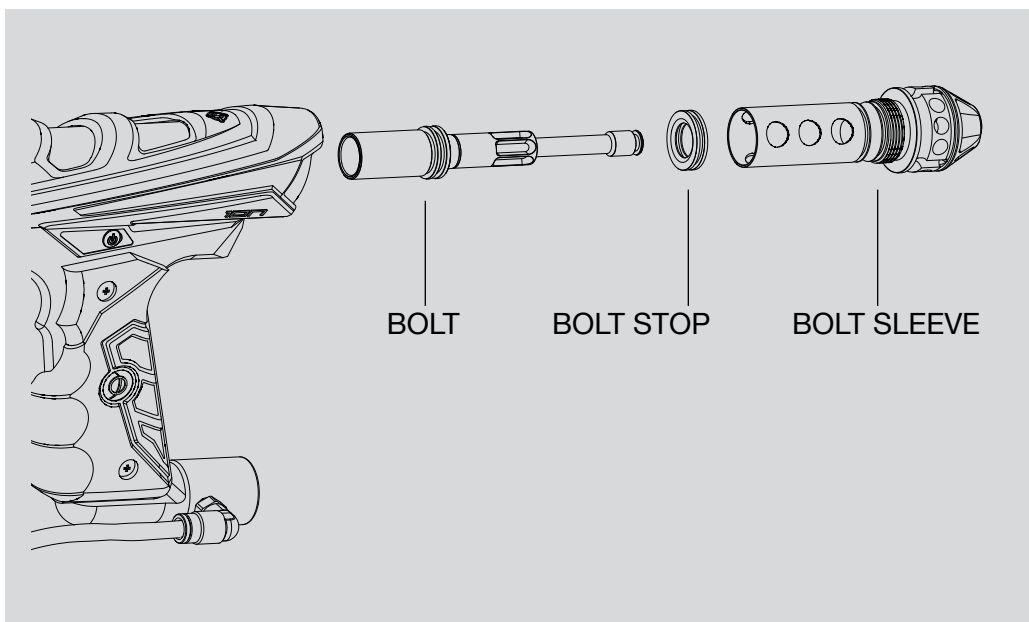
## VITAL STATISTICS

The Ion XE features an innovative new body and field strip system, combining the high-performance and affordable price of the Ion with even easier maintenance. Please thoroughly read both this addendum and the included Ion manual.

While every effort has been made to ensure that the information contained in this guide is accurate and complete, no liability can be accepted for errors or omissions. Smart Parts, Inc. reserves the right to change the specifications of the Ion XE at any time without prior notice. The latest version of this manual may be downloaded free of charge at [www.SmartParts.com](http://www.SmartParts.com).

## DISASSEMBLY/CLEANING

### IMPORTANT



#### WET WEATHER NOTE:

PLAYING IN THE RAIN WILL NOT DAMAGE YOUR ION XE, BUT YOU SHOULD NEVER IMMERSE IT IN WATER. IF YOUR MARKER SHOULD BECOME WATERLOGGED, REMOVE THE BARREL AND RUBBER GRIPS AND ALLOW THEM TO DRY OUT, THEN FOLLOW THE DISASSEMBLY/CLEANING INSTRUCTIONS.

The Ion XE valve system has only one major moving part, making it simple to maintain, but this does not mean maintenance can be ignored. The Ion XE should be disassembled and cleaned any time it shows erratic performance, becomes contaminated with paint, dirt or other debris, or for general maintenance after 3 or 4 days of use.

- 01** Unload and degas the Ion XE (see Ion manual.) Use a 5/16-inch allen wrench to unscrew and remove the bolt sleeve from the back of the Ion XE.
- 02** Using a soft tool, like a wooden chopstick or plastic toothbrush, push the bolt, bolt stop and volume control insert, if present, out the back of the Ion XE.
- 03** Clean the interior of the body, the bolt sleeve, bolt and bolt stop with a clean cloth or paper towel. Inspect their o-rings for signs of damage such as rips or cuts and replace if necessary.
- 04** Lubricate o-rings with SL33K marker lubricant. Slide the volume control insert into the bolt sleeve. Slide the bolt stop onto the bolt from the rear. Slide this assembly into the rear of the Ion XE. Screw the bolt sleeve into place with a 5/16-inch allen wrench – do not overtighten.

This is all that is required for routine maintenance of the Ion XE. Further disassembly to inspect or replace ball detents and Vision or circuit board components may be done by following the disassembly instructions in the Ion manual, with the exception that the rear grip frame screw and banjo fitting now screw directly into the body breach without the need for a swivel donut.