



## USER GUIDE



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Product of:



## USER GUIDE

### Blind Hole Cleaning Unit



#### EASY TO GET STARTED

- Ready to use with one existing air line.
- Minimal maintenance required.

Date: 01/16/2015

## MiJET User Guide

### Description

MiJET™ is designed to clean parts and capture residue with one easy touch, keeping the work area and surrounding air clean.

The air nozzle is used to blow residue down into the inlet tube, while simultaneously creating suction. This will pull chips and lubricant into the container below.

The captured residue can be recycled ... saving money on expensive lubricants and help to reclaim more chips instead of covering the floor.



### Needed

A MiJET unit comes with a 1/4" FNPT fitting for connecting to an existing shop air line. A high-flow quick-connect adaptor can be attached for ease of use, however, to ensure a sufficient air supply we recommend connecting into the main air supply without any restrictions, such as a quick connect.

It is also recommended to utilize a 3/8" diameter air hose from the main line to supply the MiJET. A smaller diameter, coiled air line, or a line that is too long might not provide an optimum air supply.

### Safety Instructions

**Please read user guide carefully before installing.**





Disconnect the air supply if the unit is taken apart for recycling of coolant, retrieval of parts, or any other maintenance.

**\*\*NOT FOR USE WITH HIGHLY FLAMMABLE LIQUIDS\*\***

## Replacement Parts

13-030		Bucket - Steel with rust-inhibitor interior 13.38" H x 11.75" dia.
13-033		O-Ring Kit Viton, 70 durometer
13-032		T-Handle Knob Nylon with Aluminum insert
13-0061		Loc-Line—1/4" Adjustable Coolant Hose with four different nozzle attachments
13-062		Pressure Gauge for 8" Blind Hole model
13-063		Pressure Regulator for 8" Blind Hole model
13-0064		Pneumatically controlled foot pedal for Blind Hole model
13-065		Hose to connect the foot pedal to the MiJET

## Optional Accessories

- 13-034  MiJET Dolly—5 wheels with 2 locking wheels  
16" x 15.5" x 7"
- 13-057\*  High-Flow Quick Disconnect - Body
- 13-058\*  High-Flow Quick Disconnect - Plug
- 13-044  Air Deflector, for use with any 8" model.  
15" H x 7.5" dia.

## Replacement Parts

- 13-035  Low-Noise Air Nozzle by Silvent
- 13-006  Custom MiJET Filter, for 8" models only  
8" H x 13.63" dia.
- 13-028  Air Nozzle by Prevost, OSHA Compliant  
8.0" x 4.25" x 1.0"
- 13-029  Spiral air hose with swivel end fitting  
13 ft. x 1/4" MNPT, 5/16" ID

## Table of Contents

*MiJET Diagram* ..... Page 4

*Air Supply Requirements* ..... Page 5

*Instructions* ..... Page 6

*Cleaning a Blind Hole* ..... Page 8

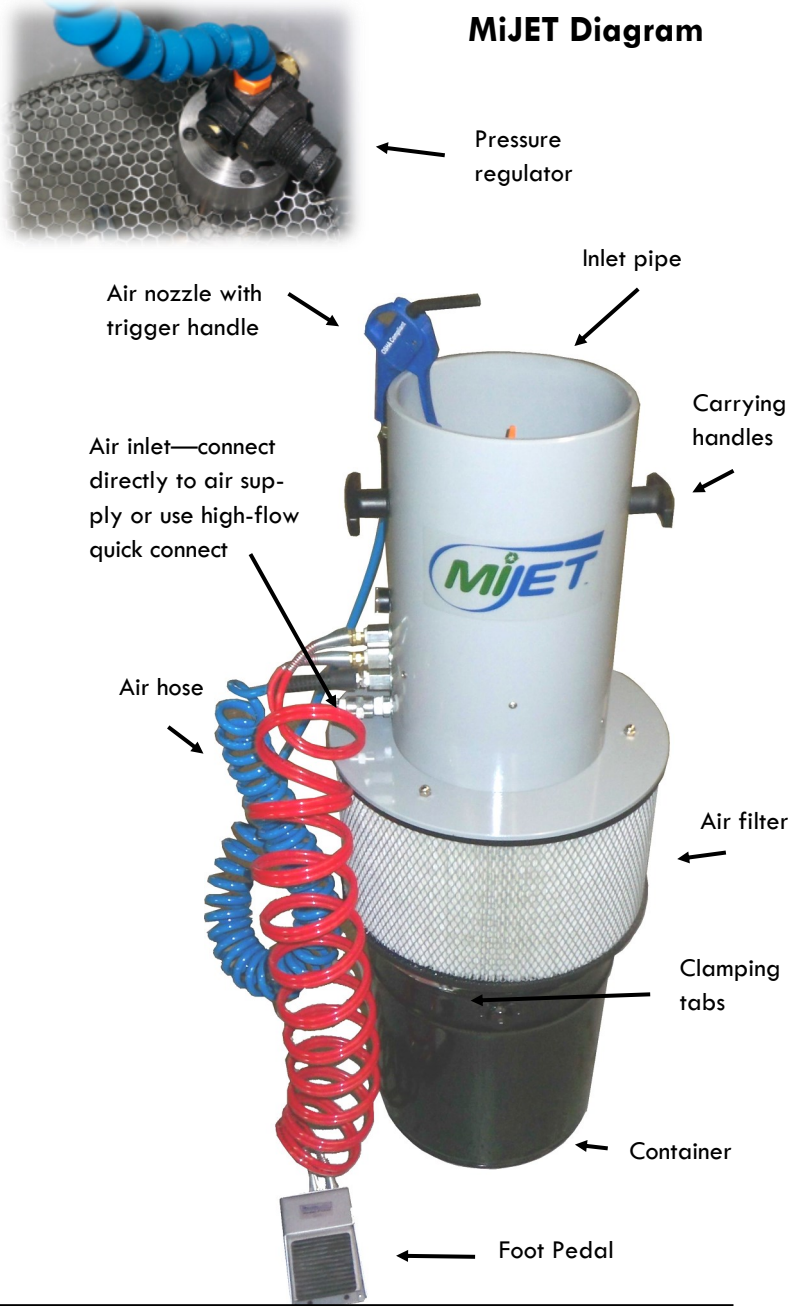
*Maintenance* ..... Page 9

*Installing the Air Deflector* ..... Page 12

*Troubleshooting* ..... Page 13

*Optional Accessories* .....Page 14

*Replacement Parts* .....Page 15



## Troubleshooting

**Q: The part is blown off and the air nozzle is not in use, but the motor runs for an extended amount of time.**

- A: There are Viton O-rings that need to stay lubricated, try adding air tool oil, refer to the maintenance steps on page 9.
- B: Check for air leaks at air nozzle hose connections and air nozzle itself. Replace leaking components if needed. Contact us for replacement air gun.

**Q: The air motor sounds like it runs slower than when the unit was brand new.**

- A: Try adding air tool oil, refer to the maintenance steps on page 6.

**Q: The suction is reduced from when the unit was brand new.**

- A: Try adding air tool oil, refer to the maintenance steps on page 6.
- B: Check filter and if oil-soaked or dirty, it is time to replace the filter. Contact us for replacement filter.

**Q: The blow off pressure has decreased while using the air nozzle.**

- A: Ensure all fittings and connections are correct, if so, try connecting the MiJET to the air supply line without use of any quick-disconnect fitting.
- B: Try connecting an airline from the main air supply to the MiJET with a large enough diameter (3/8") air hose to supply enough CFM to the unit.
- C: Try removing the blue air nozzle and replace with the operators' usual air nozzle often creates familiarity with usual process of blowing off parts.

## Installing the Air Deflector



Figure 14

1. Using a 7/32 Allen key, unscrew the black screws from each handle, as seen in Figure 14.
2. Take each screw and handle off of the unit.



Figure 15

3. Place the air deflector into the MiJET. Try to line-up the hole on the air deflector (Figure 15) with the hole on the MiJET.



Figure 16

4. Insert the screw through the air deflector and then through the MiJET.
5. Tighten both screws with the 7/32 Allen key. Hold the black plastic handle while tighten to ensure the correct orientation of the T-Handle.
6. Repeat the same procedure for the second screw of the opposite side. The final product should look like the MiJET pictured in Figure 16.

## Air supply

In order to optimize the performance of the MiJET consider the following:

**The air hose to the MiJET should be as short as practical and at least 3/8 inch diameter, (larger is better).**

- Low pressure at the air nozzle can be the result of too small diameter or too long air hoses from main air supply.
- Coiled air hoses from the main air supply to the MiJET are not recommended.

**Low pressure can also be the result of restrictive quick connects.**

- Having two common hardware store quick connects in line with the MiJET can reduce the MiJET air nozzle pressure by 30%.
- If quick connects are needed, use high flow quick connect such as MiJET accessory #13-057 Coupler body, and #13-058 Coupler plug. See accessory page 14 for further description.



High-flow Quick Disconnect



Straight hose supplies the MiJET with compressed air.

## Instructions

1. Remove MiJET from box.
2. Remove the plastic protector from the lower fitting shown in Figures 1a and 1b.

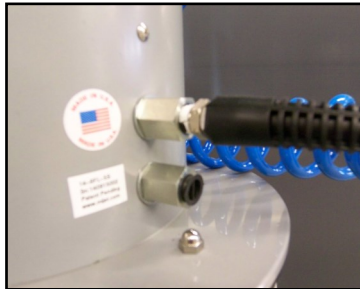


Figure 1a



Figure 1b

3. Screw a 1/4" MNPT adapter into the MiJET fitting (1/4" FNPT) on the side of the valve as seen in Figures 2a.

  - Suggest using a high-flow quick-disconnect adaptor for easy disconnection during maintenance.
  - Monthly oiling of contained air motor is required. See Maintenance section.

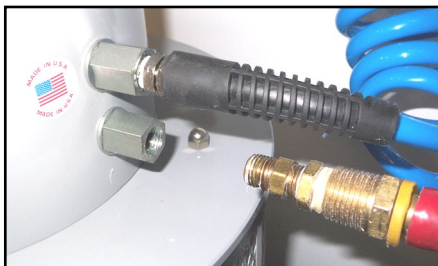


Figure 2a



Figure 2b

## Maintenance

5. Reassemble bucket lid adapter with three (3) nuts, taking care not to over tighten and crush the filter shown in Figure 12.



Figure 12

6. Place the top assembly onto the container.
7. Center it and align the gray plastic ring seen in Figure 12 with the black container lip in Figure 13.
8. Close the two (2) tabs on each side of the bucket to maintain the seal.

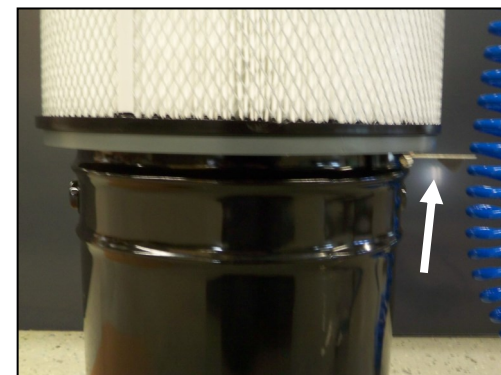


Figure 13

## Maintenance

3. Remove three (3) nuts seen in Figure 10 from bucket filter adapter.



Figure 10

4. Lift up the bucket filter adapter (seen at bottom of picture, the gray plastic ring) and remove filter seen on the left in Figure 11a. Replace with a new filter, re-assemble as shown, over the three threaded rods in Figure 11b.



Figure 11a



Figure 11b

## Instructions

4. Attach a shop air hose to the adapter as shown in Figure 2b.
- Air supply should be capable of 35 CFM at 90 PSI and be filtered.
  - MiJET can be installed down the line from an oiler.

5. With use of the hand-held air nozzle:

Hold the part to be cleaned as far as possible into the opening of the MiJET, see Figure 3.



Figure 3

6. Pull air nozzle trigger and blow off air starts, along with suction.

- Air can be applied as long as necessary to clean coolant and chips away.

7. Captured coolant can be returned to machine reservoir as shown in Figure 4.

- Disconnect air supply before removing container.
- Filter as necessary per company policy.



Figure 4

## Cleaning a Blind Hole

Before cleaning a blind hole, it is recommended to make adjustments to the MiJET unit first. The Loc-Line can be adjusted to the optimal angle for cleaning. There is also a pressure regulator to control the air pressure out of the Loc-Line.

**1. Adjust the Loc-Line to at least a 45° angle, if not more.**

- It is recommended to bend the Loc-Line and orient the nozzle pointed in a horizontal position (Figure 5), instead of a vertical orientation, while cleaning a blind hole.



Figure 5

**2. Place the part with the blind hole over the nozzle.**

- It's important to put the part over the nozzle BEFORE you step on the foot pedal.
- If the blind hole is not completely covering the nozzle there is a potential for oil mist to be sprayed into the operator's face.



Figure 6

**3. Press the foot pedal down to start cleaning, as seen in Figure 6.**

- The foot pedal or the hand-held nozzle can be used to clean the part.

## Maintenance

**After 5000 parts cleaned or monthly:**

- Disconnect shop air supply and place 10 drops of air tool oil into the air hose fitting of the MiJET Figure 7.**
- Captured coolant can be returned to machine reservoir after disconnecting the air supply.**
  - Filter coolant as necessary per company policy.



Figure 7

**Once per year, or as necessary:**

Replace MiJET filter, P/N 13-006, per the following instructions.

- Disconnect shop air supply and unlatch the two metal tabs as seen in Figure 8.**
- Remove MiJET top assembly and place upside down as shown in Figure 9.**



Figure 8



Figure 9