

JONA All-in-One Units

Filling Guide + Best Practices

VERSION 1.0

Before You Fill: Compatibility Testing

Send 5–10 mL of your oil for lab verification. We'll test oil compatibility with the Jona device, advise ideal fill temperature & suggested wattage, and help tune for your formulation.

Oil Viscosity Targets

At the time of injection, **your oil should reach a viscosity of 2,000–3,000 mPa·s**. Pre-heat only as needed to achieve this; excessive heat can thin oil and increase leakage risk.

Don't have a viscometer? Send 5–10 mL - we'll measure viscosity and provide the exact fill temperature for your formulation.

Filling

KEEP UNITS FULLY UPRIGHT (90°), IDEALLY IN THEIR FOAM TRAYS, AT EVERY STAGE (PRE-FILL, POST-FILL, PRE-CAP, POST-CAP).

HANDLING AND TRANSPORT PRECAUTIONS

Personal Air Transport

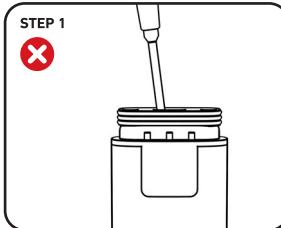
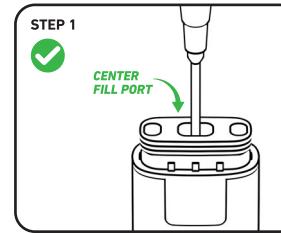
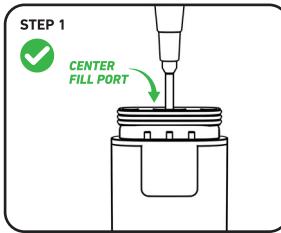
- Carriage of this device by air is **not recommended**. Cabin pressure variations during flight **may result in oil leakage**.
- If air transport is unavoidable, the **device must be enclosed in sealed pressure-resistant packaging** to minimize the risk of leakage.

Vehicle Storage

- Do not leave the device inside a vehicle for more than one hour** without active climate control.
- Do not expose the device to direct sunlight** or place it in a **high-temperature environment** (e.g. parked vehicles under sun exposure).
- Rapid or **extreme temperature fluctuations** may cause internal pressure changes, **leading to potential oil leakage**.

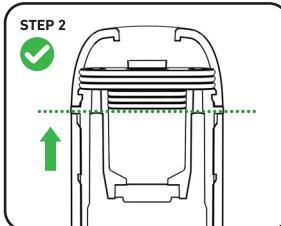
STEP 1 – Proper Needle Insertion

Insert the needle into the center hole of the silicone plug (fill port). Do not insert along the side walls - those are airways. Insert no deeper than $\frac{1}{3}$ of tank depth.



STEP 2 – Fill to the Correct Level

Do not exceed the bottom of the silicone sealing plug.



Capping

STEP 3 – Setup (alignment & Jigs)

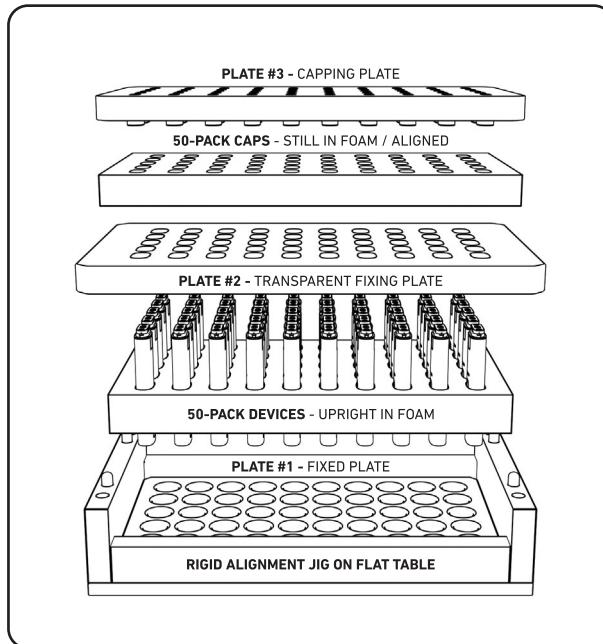
01.) Place the entire 50-pack (devices upright in foam) into the base of the rigid alignment jig.

02.) Place **Plate #1 - Fixed Plate** over the 50 units.

03.) Place **Plate #2 - Transparent Fixing Plate** over **Plate #1**.

04.) Place the entire 50-pack of caps (still in foam) on top of **Plate #2** in a perfectly aligned position. Align the device side windows to the cap windows on the same axis; verify all units are fully aligned.

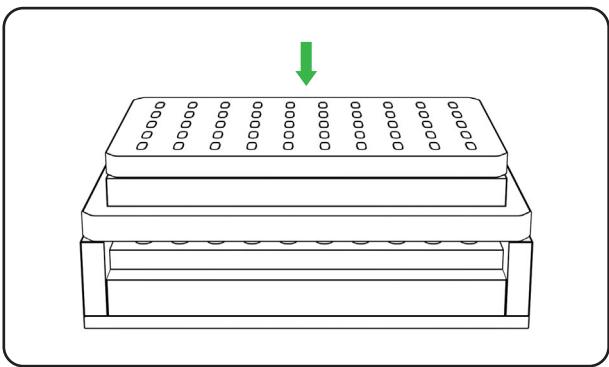
05.) Place **Plate #3 - Capping Plate** over the caps.



STEP 4 – Press

With the jig holding the devices square, use the machine press to push the mouthpieces straight down until they snap flush - **no rocking or tilting**. Cap within 2 minutes of filling.

Quality Control: full snap, no gasket pinch, no visible gap.



Storage & Transport

- Keep upright at 90° (use foam trays whenever possible).
- Store cool ($\leq 75^{\circ}\text{F}$); avoid direct sunlight and hot vehicles.
- FIFO rotation for multiple batches; avoid air shipment of filled units when possible.

WARNING — PRIMARY CAUSES OF LEAKAGE

- Overfilling (above bottom of silicone sealing plug)
- Filling too hot (oil thins and may flood/bleed)
- Misalignment during capping (gasket pinch / incomplete snap)



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