



# Smart Parts Ion Bolt Replacement

This guide will help you replace the eyes on the Smart Parts Ion paintball gun.

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## INTRODUCTION

If the Ion is not shooting properly, the bolt's o-rings may need to be lubricated, or the bolt may be damaged from wear and tear. While working on the Ion, the user should be aware of the pressure due to air inside the gun. Pressurized air can be forceful, causing particles to be ejected from the gun into your eyes and/or skin. When air bubbles enter the bloodstream, they can block blood vessels and cause embolisms. To avoid this, make sure to point the gun in a safe direction when degassing the Ion.

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### TOOLS:

- [3/32" Allen Wrench](#) (1)
  - [Tweezers](#) (1)
  - [Phillips #2 Screwdriver](#) (1)
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## Step 1 — Hopper and the Air Tank



- Remove the air tank by rotating it counterclockwise.
- ⚠ Do not pull the trigger or jostle the gun, there will still be pressurized air inside the gun that could be expelled and cause bodily harm if injected into eyes and/or skin.
- ⓘ The pressure gauge will indicate the leftover air in the gun.

## Step 2



- Remove the hopper by pulling it out of the feed tube, located on the top of the body. The hopper should easily come off when pulled straight up.

### Step 3 — Smart Parts Ion De-Gassing



- Turn the gun on by pressing the power button until the red light blinks.
- Turn vision mode off by pressing the power button again.
- ⓘ Red light should be flashing in a double blink sequence.

### Step 4



- Pull the trigger to release the air in the gun.
- ⚠️ Pressurized air can be forceful, causing particles to be ejected from the gun into your eyes and/or skin. When air bubbles enter the bloodstream, they can block blood vessels, causing embolisms. To avoid this, make sure to point the gun in a safe direction when pulling the trigger because air will be released from the gun.

## Step 5 — Grip



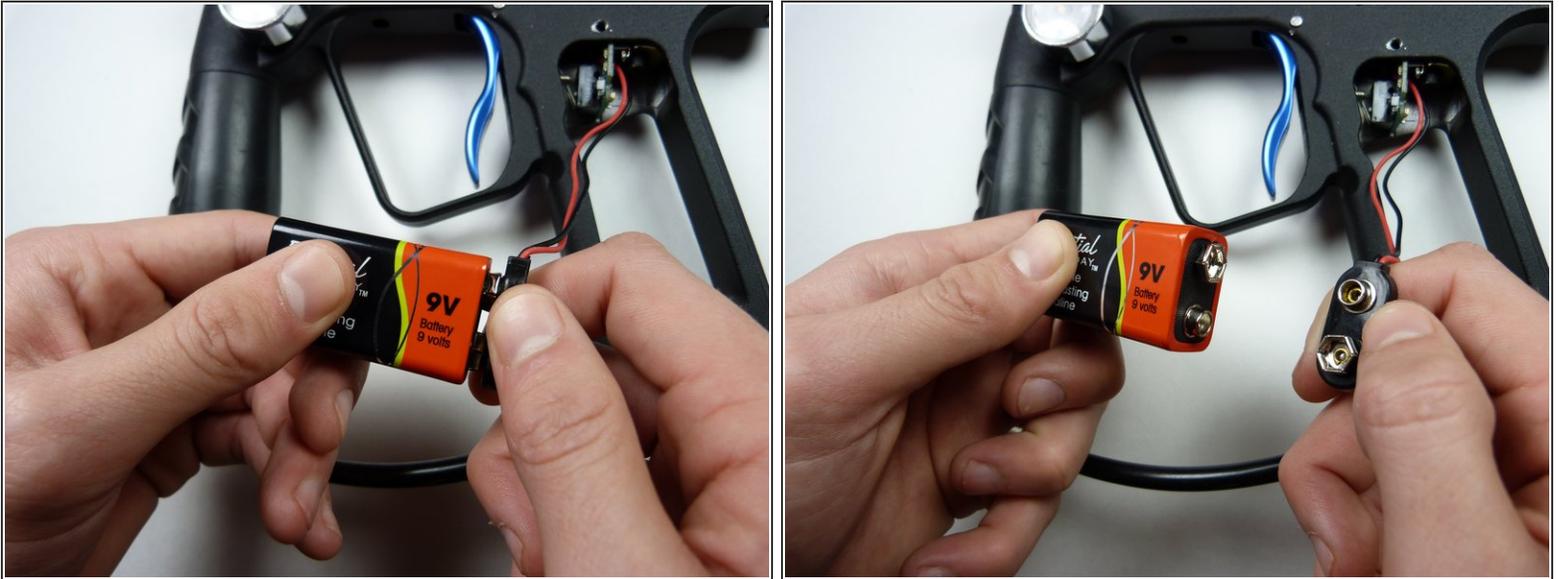
- Remove the four 8mm screws on each side of the gun's grip using a Phillips #2 screwdriver.

## Step 6



- Remove the grip by sliding it towards the front of the gun.

## Step 7 — Battery



- Remove the 9V battery by unsnapping it.

## Step 8 — Separate Body From Grip Frame



- Remove the front and rear 1" screws on the gun's grip frame using a 3/32" Allen Wrench.

## Step 9



- Remove the 12 mm screw on the top of the grip frame using a 3/32" Allen wrench.

## Step 10



- Separate the gun's body from the frame by gently pulling them in opposite directions.

## Step 11



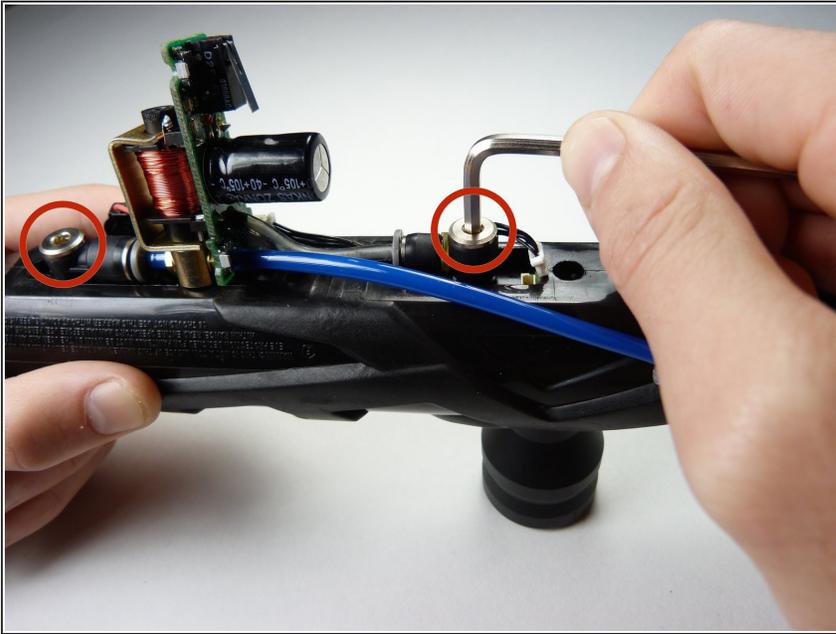
- Remove the 1-1/4" screw that's attached to the blue tube above the front grip using a 3/32" Allen Wrench.

## Step 12 — Removing the Solenoid from the Body



- Gently use tweezers to detach the white vision wire harness, located directly under the feed tube.
- ⓘ Another small tool or your fingers will work for this.

## Step 13



- Remove the two 1-1/4" screws on either side of the circuit board using a 3/32" allen wrench.

## Step 14



- Separate the solenoid from the gun's body by gently pulling it upwards.

## Step 15



- Slide the metal body out of the plastic shell by holding one in each hand and gently pulling apart.

## Step 16 — Bolt



- Separate the front body breach from the fire chamber by rotating the breach counterclockwise.

## Step 17



- Remove the bolt from the front body breach by gently pulling on the bolt.

To reassemble your device, follow these instructions in reverse order.