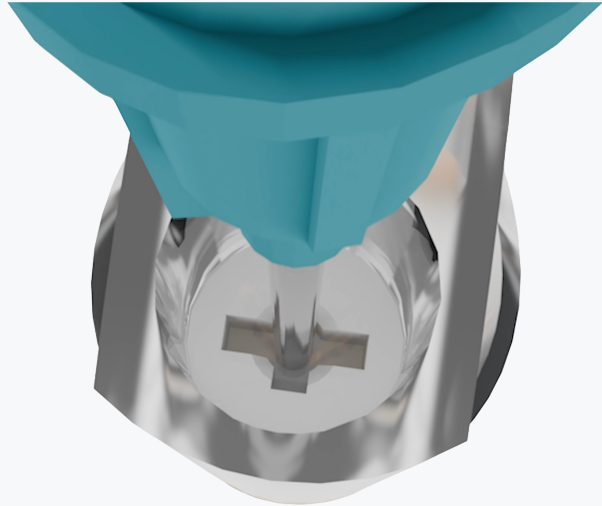


MONO FILLING & CAPPING SOP



Filling Temperature

140–167°F / 60–70°C – Thicker viscosity oils

122–140°F / 50–60°C – Thinner viscosity oils



Temperature Warning

Always use the lowest temperature possible: filling at excessively high temperatures can oversaturate the coil and may cause leaking and/or clogging



Filling Equipment

16 gauge blunt tip needle.

Use of a blunt fill/filter needle is mandatory.



Equipment Warning

Never use a sharp or beveled needle. A pointed tip can pierce or tear the silicone seal causing leaks, loss of vacuum integrity, and product failure.



Locate the + and Target the Center

Locate the + in the silicone seal on the mouthpiece side. **Insert the needle straight down through the center of the +.** Off-center entry can tear the slit and cause leaks.



Filling to Volume

1g → 1.0 mL / 2g → 2.0 mL. Keep the cart upright.

Fill slow and steady to avoid air pockets. **Avoid lateral movement while inserting the needle.**



Withdraw & Self-seal

Pull the needle back out. The silicone closes and seals itself.

Avoid lateral movement while withdrawing the needle to prevent internal seal damage.



Curing Time

≥24 hours upright before packing, the oil primes the ceramic wick and let settle to prevent transit leaks.

Min. rest time: until there is no visible bubble to ensure proper coil saturation. Store upright.