

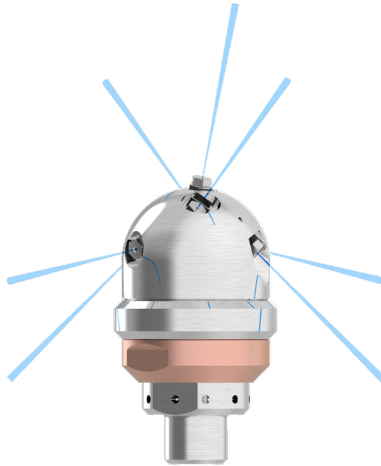


40K 4" J-Force™

JF4X40 (PN 68322, 70490)

PI-205

PRODUCT INSTRUCTIONS



The 40K 4" J-Force™ is a self-powered rotating nozzle that uses up to 7 jets to unclog, clean, and polish pipes with 90° bends at 43,500 psi.

Read these instructions thoroughly before installing, connecting, or using the J-Force tool. If any questions remain, call JETSTREAM at (800) 231-8192 or (832) 590-1300. Also read the yellow JETSTREAM SAFETY WARNING pamphlet included with the shipment of your new J-Force tool and reproduced inside this publication. This product is sold with the understanding that the purchaser agrees to thoroughly train all operators and maintenance personnel in the correct and safe installation, operation and maintenance of the product and to provide adequate supervision of personnel at all times. Retain these instructions for future reference. If this product is resold or otherwise conveyed, purchaser must pass on the instructions to the new user.

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SECTION 1: SAFETY

DANGER

Incorrect Use of High Pressure Waterblast
Equipment May Cause Serious Injury
Read these instructions in their entirety
before using any JETSTREAM products.

This information was prepared to aid in the identification of potentially unsafe conditions when using high pressure waterblast equipment. It should be noted that other potential hazards may exist which might have not been mentioned in this brochure.

In all cases, JETSTREAM products are sold with the understanding that the purchaser agrees to thoroughly train all operating and maintenance personnel in the correct and safe installation, operation of maintenance of waterblast equipment and to provide adequate supervision of personnel at all times.

Read the following in its entirety before connecting, operating or repairing equipment. Purchasers and operators also should be familiar with the current version of the “Industry Best Practices for the Use of High Pressure Waterjetting Equipment” published by the Waterjet Technology Association, as well as any applicable OSHA regulations, standards and guidelines.

Should any questions arise concerning safe and proper procedure, contact JETSTREAM prior to the installation or use at (800) 231-8192 or (832) 590-1300.

GENERAL WATERBLAST

1. Use only clear, clean water in high pressure system.
2. Place barricades with warning signs or barricade tape around work area.
3. Outfit all operators with Personal Protective Equipment (PPE). Hard hat with plastic face shield, rainsuit, non-skid knee boots **with metatarsal protection**, gloves, ear protection and body armor rated for operating pressures are considered minimum safety equipment. Proper respiratory protection is required where dangerous fumes or dust is present or created by the waterblasting operation. Follow applicable OSHA regulations, standards and guidelines regarding the use of respiratory protection if harmful fumes or dust is present during, or created by the waterblasting operation.
4. Use products intended for high pressure waterblasting only.
5. **No product should be altered** without written consent of the manufacturer.
6. **Read and follow all manufacturer's instructions** prior to using any waterblast product. Contact manufacturer.
7. Thoroughly review alternative methods before initiating any potentially dangerous waterblasting operation. Fully automated, semi-automated, and/or mechanized methods should all be considered first. Contact the applicable waterblasting manufacturers for assistance and recommendations.
8. The operator handling the cleaning device (with nozzle) must always have control of water pressure. A surface cleaning operator should operate a trigger style control gun capable of instantaneously stopping pressure to nozzle. A tube cleaning lance operator should operate a foot gun capable of instantaneously stopping pressure to the lance.
9. Inspect the condition of all components prior to use. Use no items which are in questionable condition.

10. Check the condition of thread connections prior to the make-up of any high pressure connection. Use Teflon tape and anti-seize on male pipe (NPT) thread for sealing purposes. Do not let tape overlap the male pipe thread end. Tape fragments may enter system water stream and clog nozzle's orifices.

Do Not use a component with missing or damaged threads on the high pressure connections.

11. Properly tighten all high pressure connections. All NPT connections must have a minimum engagement of four (4) threads. Pipe (NPT) connections should be made up hand tight plus two (2) full wrenched turns. Do not tighten NPT threads past two (2) wrenched turns.

⚠ CAUTION Use wrench flats (when available) or a properly adjusted smooth jaw plier wrench (JS PN 64119) for tightening components. Avoid using pipe wrench as wrench marks will cause high pressure components to crack and fail.

12. All high pressure hose connections require a hose restraint (whip check), including connection at fluid end discharge.

13. Before attaching a nozzle to the control gun or tube cleaning lance, **operate the pump at low speed to purge** dirt and debris from system. **Dirt and debris can clog nozzle orifice(s) and cause excessive system pressure which could lead to a lance failure.**

14. With nozzle installed, **operate the pump at a low speed (low pressure) for test.** Should system repairs or adjustments be necessary, stop pump and relieve all pressure before making required repairs or adjustments. The pump operator should watch the nozzle operator at all times in case any difficulty arises and it becomes necessary to depressurize system. If the pump operator does not have a clear line of sight to the nozzle operator, it may be necessary to have another employee available to communicate between the nozzle and pump operators.

15. With the system operating properly, **increase pump speed slowly until operating pressure is reached** and adjusted. Pressure adjustments should always be made slowly. The nozzle operator shall be warned before any pressure adjustment is made by the pump operator. A sudden change in reaction force may cause the nozzle operator to lose balance. Use **minimum pressure required** for cleaning. Do not exceed the operating pressure of the system's lowest pressure-rated component. All equipment pressure rating markers and warning tags should be left intact.
16. Waterblast operators must be made aware that the **cleaning nozzle's discharge jets(s) can inflict serious body wounds**. Supervisors should demonstrate the potential danger of discharge jet(s) by showing all new operators the effect of a waterjet by cutting a scrap piece of wood such as a 2" x 4".
17. If equipment malfunctions or a system malfunction is suspected, immediately stop cleaning activity and relieve the pressure in the system before attempting any repairs. Always follow the manufacturer's repair instructions.
18. Only trained persons should be authorized to perform any maintenance or repair.
19. Following any repairs, the system should be operated at low pressure for test. Bring equipment up to operating pressure slowly.
20. For shutdown in freezing conditions, even for brief periods, drain water from all components. Prior to starting operations in freezing conditions, the operation of all equipment components must be checked carefully to make sure components are not frozen and can be operated.
21. Store components properly by protecting them from damage when not in use. Be sure all safety warning tags and markers remain intact.

PRESSURE RELIEF DEVICES

1. **Read General Safety** section prior to installing Relief Valve and/or Pressure Relief Devices.
2. A waterblast system should include both primary and secondary pressure relief protection:

- A. For primary protection a primary rupture disc assembly or spring-loaded relief set at 1.2 times, maximum operating pressure is recommended (i.e. relief valve is set at 12,000 psi if maximum operating pressure is 10,000 psi)
- B. For secondary protection a rupture disc assembly containing a manufacturer's approved disc having a burst rating of 1.4 times maximum operating pressure is recommended.

⚠ WARNING Only use a rupture disc holder which will NOT permit the use of coins or other objects in place of discs.

- 3. Relief devices should never be mounted so the discharge could strike personnel.
- 4. Never install a shut-off valve between the pump and relief device.
- 5. "Set pressure" must be prominently displayed on all relief devices. Never install or use a relief device unless its "set pressure" is known.
- 6. Do not attempt to correct a leaking relief valve by increasing spring tension as this will increase its set pressure.
- 7. Do not use a pressure relief valve as a combination relief and throttling device.
- 8. Keep relief valve dry during freezing conditions.

NOTE: Pressure relief devices are imperative for the protection of both operator and equipment from dangerous over-pressurization.

HIGH PRESSURE HOSE

- 1. **Read General Safety** section prior to connecting high pressure hose.
- 2. Do not use a high pressure hose with a burst rating less than 2.5 times the pressure at which it will operate. 10,000 psi operating pressure high pressure must have a minimum 25,000 psi burst rating. 8,000 psi operating hose must have a minimum 22,000 psi burst rating.
- 3. Do not use a high pressure hose that has an unknown burst rating or manufacturer's operating pressure rating.

4. Use of a Safety Shroud is strongly recommended for added safety where hose connects to control gun. Use of hose restraint (whip check) is required at all hose connections, including connections at fluid end.
5. Always apply wrench to wrench flats when making threaded connections. Do not apply wrench on the end fitting ferrule (collar).

6. Remove hose from service if:

- A. Cover is damaged and reinforcing wires are exposed to rust and corrosion;
 - B. Cover is loose, has blisters or bulges;
 - C. Hose has been crushed or kinked;
 - D. End fitting shows evidence of damage, slippage, or leakage.
 - E. Hose has been exposed to pressures greater than 50% of burst rating; or
 - F. Hose is three or more years old, regardless of condition.
8. Disconnect, drain, coil and store hose properly after use.
 9. Never attempt to repair or recouple high pressure hoses in field. High pressure hose end fittings are the permanently crimped type and can only be properly installed with hydraulic crimping equipment.

NOZZLES

1. Read General Safety section.

2. Nozzle flow ratings must be compatible with pump discharge and pump pressure rating. (See Nozzle Flow Rating Chart on page 28.)
3. Use only nozzles with a manufacturer's pressure rating of at least the operating pressure or a burst rating or no less than 3.0 times the desired operating pressure.
4. Prior to installation, make sure the nozzle has no clogged orifices.

5. **⚠ CAUTION** Use wrench flats (when available) or a properly adjusted smooth jaw plier wrench (JS PN 64119) to tighten nozzle. Avoid using pipe wrench as wrench marks will cause nozzles to crack and fail.
6. Blocked orifice(s) can cause excessive system pressure and failure. If orifice(s) appear clogged or partially blocked with dirt or debris, remove nozzle from J-Force and clean immediately.
7. **Remove nozzle from service if:**
 - A. Nozzle is split or damaged;
 - B. Nozzle sidewall is worn by more than 25% at any point;
 - C. Nozzle's ability to hold pressure is questionable
 - D. Threads are missing or damaged

FLEXIBLE TUBE CLEANING LANCES

1. **Read General Safety** section and Nozzle Safety Warnings prior to connecting flex lances.
2. **Do not** use a flex lance with a burst rating less than 2.25 times the pressure at which it will operate.
3. **Do not** use a flex lance that has an unknown burst or unknown manufacturer's operating pressure rating.
4. **Never use a lance which is kinked, worn, frayed** or whose abilities to hold pressure is questionable.
5. **Do not** use a lance which has damaged or missing threads.
6. **Clearance** between lance and tube deposits **must be sufficient** to allow unrestricted backflow of water and debris. With tubes containing hard deposits this clearance should be 1/8" **minimum** on the diameter (or 1/16" per side) of the lance. With tubes containing soft, pliable deposits this clearance should be greater. **Insufficient side clearance may cause lance to blow back toward operator.**
7. **⚠ WARNING** Serious injury may occur should a lance with live nozzle exit tube. Use anti-withdrawal device to prevent lance from exiting tube unexpectedly.

8. The following **JETSTREAM** lance accessories are **strongly recommended** for safer lance operation:

A. Lance Strain Relief –Helps prevent lance inlet end fitting failure.

B. Lance Stinger - Affords the operator greater control of nozzle. Establishes a “safety zone” so operator knows when nozzle is about to exit tube; will eliminate possibility of nozzle and lance “double back” toward operator within large diameter pipe.

C. Anti-withdrawal device prevents the lance from exiting the tube or pipe. Contact JETSTREAM for additional information regarding these products.

9. Use only nozzles designed for use with flex lances (i.e. nozzle drilled with sufficient rearward orifices so nozzle pulls lance through tube.)

10. If lance end fittings do not have wrench flats, use properly adjusted smooth jaw plier wrench (JS PN 64119) to connect lance to pressure source and nozzle onto lance. Apply wrench on lance and fitting **directly behind end fitting thread (not on fitting ferrule or collar)** when installing nozzle on lance. Do not clamp on the lance hose itself with vise when installing nozzle.

11. Avoid rough handling, stretching or straining of lance.

12. Never attempt to “ramrod” flex lance through blockages or to repair or recouple lances.

13. After use, drain, coil and store lance properly. Be sure safety tags remain intact.

RIGID TUBE CLEANING LANCES

1. Read General Safety section and Nozzle Safety Warnings prior to connecting rigid lances.

2. Do not use a rigid lance with a burst rating less than 3.0 times the pressure at which it will operate. 10,000 psi operating pressure rigid lances must have a minimum 30,000 psi burst rating. Do not use a rigid lance that has an unknown burst or unknown manufacturer's operating pressure rating.
3. Clearance between lance and tube must be sufficient to permit the unrestricted backflow of water and debris. With tubes containing hard deposits this clearance should be 1/8" minimum on the diameter (or 1/16" per side) of the lance. With tubes containing soft, pliable deposits this clearance should be greater. Insufficient side clearance may cause lance to blow back toward operator.
4. Be sure nozzle, lance and adapter thread sizes are compatible before installing nozzle and adapter on lance. Do not use a rigid lance that has damaged or missing threads.
5. Use wrench flats (when available) or a properly adjusted smooth jaw plier wrench (JS PN 64119) to connect lance. Do not use pipe wrench as wrench marks will cause high pressure components to crack and fail.
6. A rigid lance over 4 ft long requires two men for support and safe operation. Operator at tube should use a foot control gun so he can instantly relieve system pressure in case of emergency.
7. When using and moving lance, support it in a manner to avoid stress and possible breakage at inlet end connection.
8. Never "ramrod" lance into tube blockage.
9. Transport and store lances in tubes or racks to avoid bending, corrosion or other damage. Damaged lances (bends, mars) should be removed from service.

HIGH PRESSURE FITTINGS

1. Read **General Safety** section prior to installing fittings in system.
2. Use non-brass or non-cast iron fittings which are made for high pressure waterblast use.

3. Use only high pressure fittings which are clearly marked with the operating pressure.
4. High pressure fittings should have a known burst rating of not less than 3.0 times system operating pressure. Never use a damaged or corroded fitting or one with damaged or missing threads.
5. Use only high pressure rated fittings and hose in the waterblast system. For 10,000 psi waterblast service all fittings and hose should have a minimum burst rating of 25,000 psi; for 15,000 psi service they should have a minimum burst rating of 37,500 psi; for 20,000 psi service they should have a minimum burst rating of 50,000 psi.
6. Use wrench flats (when available) or a properly adjusted smooth jaw plier wrench (JS PN 64119) to tighten fittings. Avoid using pipe wrench as wrench marks will cause high pressure fittings to crack and fail.

REPLACEMENT PARTS

1. **Read General Safety** section prior to repairing equipment and installing replacement parts.
2. Only trained persons should be authorized to perform maintenance or repairs to equipment.
3. Read and follow all manufacturer's repair instructions. All tool, torque, clearance and lubrication recommendations should be followed.
4. During replacement of any part, inspect mating part for wear and replace if necessary.
5. Do not attempt to install or use a part whose dimensions, clearances, function or use are suspect.
6. Test repaired equipment carefully and thoroughly before putting it into service. Do not put any piece of repaired equipment into service if its performance is questionable. If repaired equipment performance is questionable, call manufacturer of repair parts for assistance.

This section concludes all the same information included in the yellow JETSTREAM SAFETY WARNING pamphlet (PI-082).

SECTION 2: PRODUCT DESCRIPTION

The 40K 4" J-Force™ is a self-powered rotating nozzle designed to clean 4" pipes with up to 90° bends. The 40K 4" J-Force™ has multiple jet angles that clear blockages, clean, and provide thrust to propel the tool. An eddy-current braking system controls rotation speed for maximum cleaning power and minimum wear. A rotary seal is housed in an innovative, patented cartridge design which allows quick rebuilds in the field. The 40K 4" J-Force™ is rated for 3,000 bar (43,511 psi) maximum working pressure.

Features:

- Completely field repairable in under two minutes with a patented replaceable seal cartridge.
- A zero maintenance magnetic braking system controls rotation speed for maximum cleaning power and minimum wear. Requires no oil or grease for lubrication or braking.
- Industry-best speed range for maximum versatility.
- Self-propelled with rearward facing jets.
- Compatible with industry standard automation systems.
- Fine tune for your job with Universal, Puller and Unplucker nozzle configuration for optimum performance.
- Designed to easily navigate and clean 4" - 8" (100 - 200 mm) pipes with 90° bends.

⚠ WARNING This system contains several high-energy, rare-earth magnets that produce a magnetic field. Persons with a pacemaker or other electronic medical device must use extreme caution when handling or in close proximity. It is recommended that a minimum distance of 6 inches (152mm) be maintained at all times between the J-Force and any electronic medical devices.

⚠ CAUTION The use of gloves is recommended when handling the tool after operation as the body may reach temperatures greater than 200°F.

Product Specifications

Model Name	JF4X40
Maximum Operating Pressure (psi)	43,511
Minimum Operating Pressure (psi)	30,000
Maximum Flow (gpm)	12
Maximum Operating Pressure (bar)	3000
Minimum Operating Pressure (bar)	2068
Maximum Flow (l/min)	45
Inlet Connection	3/8" HP 9/16 Type M
Tube or Pipe I.D. (in)	4 - 8
Tube or Pipe I.D. (mm)	102 - 204
Speed Range (rpm)	150 - 1000
Nozzle Types Accepted	UHPX, UHPXD, UHPXi
Nozzle Pattern	See Flow Charts pg 20
Diameter (in)	2.74
Length (in)	4.6
Weight (lbs)	3.81
Diameter (mm)	70
Length (mm)	117
Weight (kg)	8.40

SECTION 3: PREPARATION FOR USE

3.0 The 40K 4" J-Force™ mounts to a flexible thermoplastic waterblast hose that allows it to navigate 4" - 8" pipes with bends up to 90°.

3.1 Before use, disassemble the 40K 4" J-Force™ and inspect the seal cartridge for wear, damage, o-ring condition, etc. and repair or rebuild as necessary.

3.2 Clean the 40K 4" J-Force™ by wiping internal components using a soft cloth and a water dispersing lubricant like WD-40.

3.3 See Flow Charts in Appendix C to choose nozzle configuration, flow rate, and desired operating pressure. The 40K 4" J-Force™ features ports angled at 15°, 45°, 100°, and 135°. Choose the nozzle configuration based on the type of cleaning application and desired operating pressure and flow.

SECTION 4: SETUP

4.0 CONNECTING 40K 4" J-Force™

Prior to installing the 40K 4" J-Force™ onto the hose, flush the system to clear any debris.

- A. Apply anti-seize compound to the threads of the inlet connection.
- B. Install the JF4X40 and tighten to 90 lb-ft.

4.1 Prior to installing nozzles in the 40K 4" J-Force™, turn on the pump and run at low pressure to flush debris from the system. Refer to nozzle charts in Appendix C to select the proper nozzle configuration for your application.

NOTE: Nozzle configurations must be carefully selected to ensure that they provide the necessary pull and torque. If a non-standard configuration is required, contact a Jetstream representative to verify that it is safe and that the tool will function properly.

4.2 An anti-withdrawal device (backout preventer) should be used to prevent the tool from accidentally exiting the pipe under high pressure. Hose restraints (whip checks) should be used at all high pressure hose connections including the fluid end discharge. See Appendix B for a list of backout preventers.

4.3 Contact Jetstream representative for assistance.

SECTION 5: OPERATION

5.0 OPERATING J-FORCE

As per the WJTA-IMCA Recommended Practices, all operators shall follow the OSHA regulations for personal protective equipment. (OSHA guidelines for Personal Protective Equipment are available in document number 3151-12R 2004, which can be obtained from www.osha.gov.) All operators shall be issued suitable head protection, eye protection, hearing protection, body protection, hand and foot protection and respiratory protection (if needed). For detailed specifications on all protections required, refer to the WJTA-IMCA 'Recommended Practices for the Use of High Pressure Waterjetting Equipment' Section 6, Protective Equipment For Personnel.

⚠ CAUTION The 40K 4" J-Force™ can be used for minimum service temperature of -20°C (-4°F) and a maximum service temperature of 115°C (240°F). Use at lower or higher than recommended temperatures may result in premature o-ring seal failure.

5.1 Start by slowly increasing pressure to 500 psi and check the entire system, including all connections, for leaks. Increase pressure in increments, pausing at each to inspect system for leaks, proper rotation of tool, temperature, and other operational anomalies. If any problems are discovered, lower pressure back to zero and turn off source of power before making any adjustments.

SECTION 6: SERVICE

JF4X40 (PN 68322, 70490)

6.0 40K 4" J-Force™ MAINTENANCE

When not in use, the 40K 4" J-Force™ should be cleaned to remove any debris, deposits, or contaminants that could impede rotation, and sprayed with water-dispersing lubricant (e.g. WD-40) for storage until next use.

The 40K 4" J-Force™ utilizes seal cartridge technology paired with an eddy-current braking system to control the rotation speed. No oil is required, allowing for a quick and pain-free rebuild of the tool.

See YouTube for videos showing the 40K 4" J-Force™:

 **YouTube** <https://www.youtube.com/user/JetstreamWaterblast>

▲CAUTION The use of gloves is recommended when handling the tool after operation as the body may reach temperatures greater than 200F°.

6.1 DISASSEMBLY FOR FIELD MAINTENANCE (See Figure A)

1. While holding the stator (2) stationary in a vice or with a 1-1/4" wrench, unscrew the inlet nut (1) by turning it counterclockwise with a crescent wrench or similar adjustable wrench.
2. Once the inlet nut (1) is unthreaded from the stator, the seal cartridge (10) will be exposed and accessible inside the inlet nut.
3. Remove the seal cartridge (10) from the inlet nut (1) using a Jetstream modified 5/8" socket wrench (Part Number 70630).

▲CAUTION Using a standard unmodified socket wrench will result in stripping the seal cartridge nut (3, Figure B). The modified socket wrench supplied for this tool has a 90° bevel to increase contact and prevent damage to the seal cartridge nut.

4. Tool disassembly is complete. Additional steps for disassembling the seal cartridge (10) on following page.

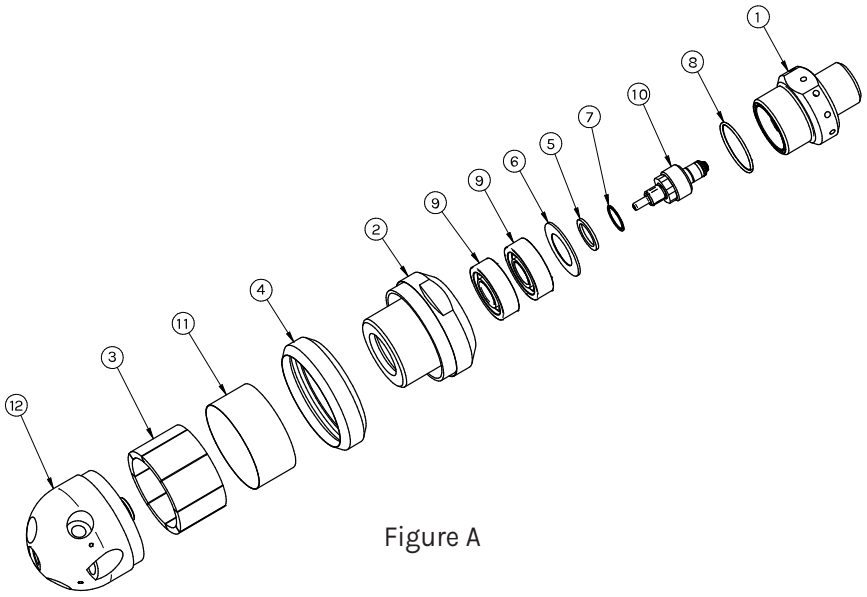


Figure A

Item	Qty	Part Number	Description
1	1	68046	3/8" MP Inlet Nut (68322 Tool)
		70485	9/16" Type M Inlet Nut (70490 Tool)
2	1	67420	Stator
3	6	67422 (N or S)	Magnet
4	1	70591	Wear Ring Assembly
5	1	68142	Washer
6	1	68315	Lip Seal
7	1	68316	Retaining Ring
8	1	68317	O-Ring
9	2	68321	Bearing
10	1	68323	Seal Cartridge
11	1	68832	Magnet Guard
12	1	70338	Rotor

NOTE: Part numbers & descriptions subject to change without notice.

SECTION 6: SERVICE

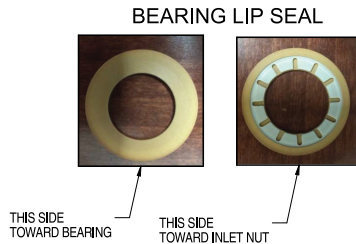
Complete Rebuild Instructions

Overview:

This rebuild will involve disassembling the tool, replacing worn components, and reassembling it following the steps. Ensure that all new parts are verified for accuracy and integrity before installation.

Disassembly Process

1. Power down and disconnect the tool from any pressure source.
2. Gather necessary tools: a Jetstream modified 5/8" socket (PN 70630), flat-head screwdriver, torque wrench, pliers, and replacement parts.
3. Clean the tool to remove debris and contaminants.
4. Orient the tool vertically.
5. Use a aluminum or padded vice jaws and wrench or a pair of adjustable wrenches to to unscrew the inlet nut from the stator.
6. Carefully remove the bearing lip seal and set it aside for inspection or replacement.

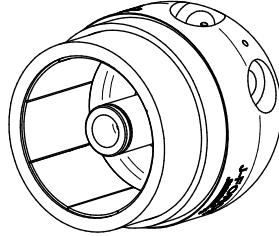


7. Use a flat-head screwdriver to unwind the spiral retaining ring from the stator groove.
8. Separate the rotor and stator, paying attention to the wear ring in between them. Set aside the rotor for magnet inspection or replacement.
9. Slip out the bearings from the stator, taking care not to apply excessive force.
10. Inspect the bearings for wear and replace if necessary.
11. Lift off the magnet guard from the rotor. Visually inspect for cracks, damage or debris. Contact Jetstream to replace any magnets.

Reassembly Process

1. Fit the magnet guard (68832) over the magnets. No adhesive is needed; ensure it sits snugly in place.

MAGNETS AND GUARD

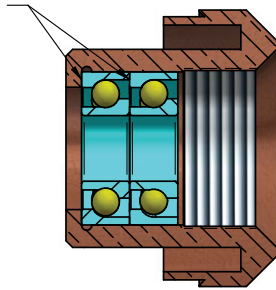


2. Insert the new bearings into the stator, ensuring they are oriented correctly. The fit should be a slip fit—apply gentle pressure to seat them in place.

INSTALL BEARINGS

THE OUTER RACES ARE THICKER ON THIS SIDE.

THE MARKINGS IDENTIFYING THE BEARING ARE ALSO ON THIS SIDE.

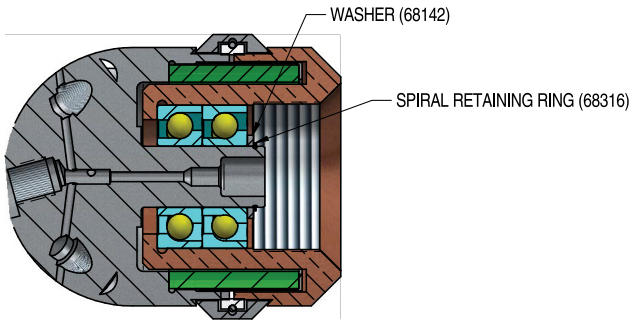


⚠ DANGER

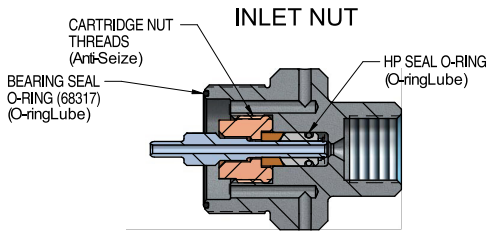
Failure to orient the bearings correctly can result in spontaneous disassembly of the tool under pressure, resulting in danger to workers and equipment

- Place the wear ring assembly between the rotor and stator as shown in the assembly diagram.
- Install the washer (68142) onto the rotor shaft.
- Use a flat-head screwdriver to position the end of the spiral retaining ring (68316) into the groove, winding the ring into place to secure the assembly.

ASSEMBLE ROTOR AND STATOR

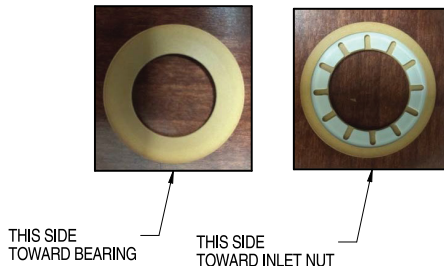


- Apply anti-seize to the threads of the cartridge nut.
- Lubricate the high-pressure seal o-ring with o-ring lube.
- Thread the cartridge nut into the inlet nut and torque it to 30 ft-lb with a Jetstream modified 5/8" socket (PN 70630).



- Lubricate the bearing seal o-ring with o-ring lube and install it into the face seal groove at the end of the inlet nut.

BEARING LIP SEAL



10. Drop the bearing lip seal into the stator, ensuring the flat side sits flush with the bearing.
11. With the tool oriented vertically, thread the inlet nut into the stator, ensuring the bearing lip seal stays in place.
12. Torque the inlet nut to 40 ft-lb.
13. Once fully reassembled, verify all components are secure and properly torqued.
14. Spin the rotor by hand to ensure smooth operation and no binding.
15. Perform a test run, checking for any leaks or abnormal sounds. If necessary, recheck torque values.

SECTION 6: SERVICE

JF4X40 SEAL CARTRIDGE (PN 68323)

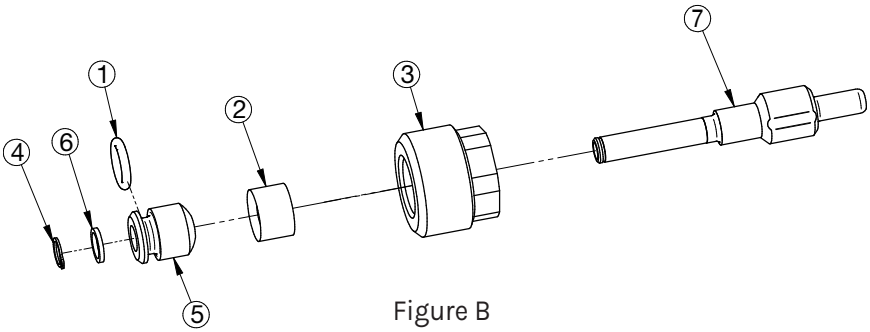


Figure B

Item	Part Number	Description
1	27502	O-Ring
2	57909	Bushing
3	57910	Cartridge Nut
4	57923	Retaining Ring
5	58140	Seal
6	58922	Washer
7	68314	Mandrel

NOTE: Part numbers & descriptions subject to change without notice.

A. Some parts of the cartridge can be reused. If the mandrel (68314) doesn't have a lot of wear, the cartridge can be rebuilt with the seal cartridge assembly 65445. Individual components can also be replaced, such as the plastic seal (27502 and 58140) and bronze bushing (57909). The cartridge nut (57910) can be reused indefinitely.

SECTION 7: TROUBLESHOOTING

7.0 40K 4" J-Force™ TROUBLESHOOTING

Problem	Possible Cause	Remedy
Will not spin	Nozzles worn, plugged, or wrong size	Replace nozzles
	Seal cartridge failure	Replace seal cartridge
	Debris obstructing wear ring	Disassemble rotor to access wear ring and clean
Spins slowly	Incorrect nozzle size or worn nozzles	Consult Jetstream Rep. Replace nozzles
	Debris obstructing internal passages	Clean*
Low pressure	Nozzles worn, plugged, or wrong size	Replace nozzles
	Connections not tight, leak	Find and repair leak
	Seal cartridge failure	Replace seal cartridge
Low Pull	Nozzles worn, plugged, or wrong size	Replace Nozzles
Cartridge Nut Stripped	Incorrect socket used	Use recommended JS socket PN 70630




* To clean the J-Force follow 6.1 DISASSEMBLY FOR MAINTENANCE. If the seal cartridge and rotor mating surfaces are free from high spots and major scratches during inspection and cleaning, and the problem is not resolved, the parts must be replaced. Reassemble according to 6.2 ASSEMBLY..

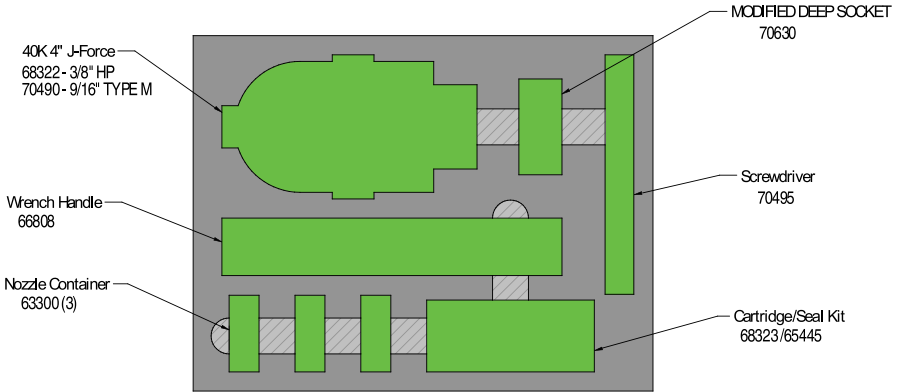
Parts Placement

Figure D

PREMIUMKITS		
PN	INLET CONNECTION	MAX PSI
70564	9/16" TYPE M	40K
70565	3/8" HP	40K

CUTOUT DEPTHS

-  FOAM
-  FINGER CUTOUT
-  INCLUDED IN KIT



APPENDIX B

Accessories

UHPX / UHPXi / UHPXD Nozzles & Plugs



- Premier high productivity sapphire (UHPX and UHPXi) and synthetic diamond (UHPXD) nozzles.
- UHPX and UHPXD have 5/16" external hex, UHPXi have 5/32" internal hex.
- Tapered orifice retainer reduces turbulence and provides a cohesive, aggressive waterjet.

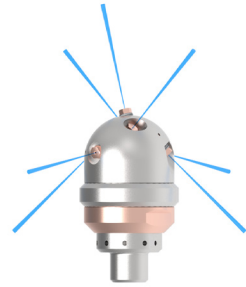
Backout Preventers

- Prevents nozzle from exiting pipe
- 4" - 8" (100-200mm) pipes
- Includes clamp for securing backout preventer to pipe
- Diameter of nozzle must be at least 1-1/2" (38mm)



APPENDIX C

Universal 7 Nozzle Configuration Flow Charts

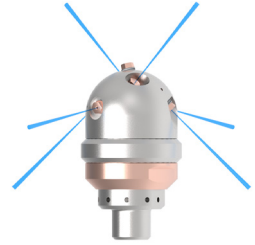


40K 4" J-Force, Universal With Front Nozzle			
Flow (gpm)	40000 psi		
	Pull (lbf)	Nozzle Diameter (inches)	
		Front,Fwd x 2,Side x 2	Rear x 2
4	-24	0.005	0.021
5	-32	0.005	0.024
6	-38	0.005	0.026
7	-44	0.006	0.028
8	-45	0.008	0.029
9	-52	0.008	0.031
10	-59	0.008	0.033
11	-67	0.008	0.035
12	-70	0.009	0.036

40K 4" J-Force, Universal With Front Nozzle			
Flow (gpm)	30000 psi		
	Pull (lbf)	Nozzle Diameter (inches)	
		Front,Fwd x 2,Side x 2	Rear x 2
4	-22	0.005	0.023
5	-28	0.005	0.026
6	-33	0.006	0.028
7	-41	0.005	0.031
8	-46	0.006	0.033
9	-52	0.006	0.035
10	-60	0.005	0.037
11	-45	0.012	0.035
12	-52	0.012	0.037

APPENDIX C

Universal 6 Nozzle Configuration Flow Charts

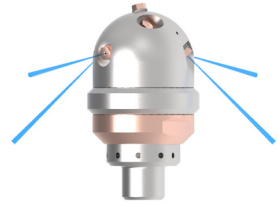


40K 4" J-Force, Universal, No Front Nozzle			
Flow (gpm)	40000 psi		
	Pull (lbf)	Nozzle Diameter (inches)	
		Fwd x 2, Side x 2	Rear x 2
4	-25	0.006	0.021
5	-33	0.005	0.024
6	-39	0.006	0.026
7	-36	0.010	0.026
8	-46	0.009	0.029
9	-54	0.009	0.031
10	-61	0.009	0.033
11	-58	0.012	0.033
12	-41	0.017	0.030

40K 4" J-Force, Universal, No Front Nozzle			
Flow (gpm)	30000 psi		
	Pull (lbf)	Nozzle Diameter (inches)	
		Fwd x 2, Side x 2	Rear x 2
4	-23	0.005	0.023
5	-26	0.007	0.025
6	-30	0.008	0.027
7	-42	0.005	0.031
8	-44	0.008	0.032
9	-53	0.006	0.035
10	-47	0.012	0.034
11	-67	0.006	0.039
12	-60	0.012	0.038

APPENDIX C

Polisher Configuration Flow Charts

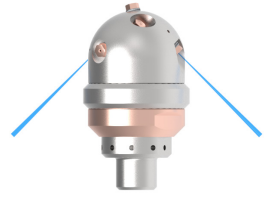


40K 4" J-Force, Polisher			
Flow (gpm)	40000 psi		
	Pull (lbf)	Nozzle Diameter (inches)	
		Side x 2	Rear x 2
4	-21	0.015	0.017
5	-24	0.018	0.018
6	-29	0.019	0.020
7	-33	0.021	0.021
8	-39	0.022	0.023
9	-49	0.020	0.027
10	-46	0.025	0.025
11	-58	0.023	0.029

40K 4" J-Force, Polisher			
Flow (gpm)	30000 psi		
	Pull (lbf)	Nozzle Diameter (inches)	
		Side x 2	Rear x 2
4	-21	0.012	0.021
5	-20	0.019	0.019
6	-25	0.021	0.021
7	-29	0.022	0.023
8	-32	0.024	0.024
9	-37	0.025	0.026
10	-41	0.027	0.027
11	-52	0.024	0.032

APPENDIX C

Puller Configuration Flow Charts



40K 4" J-Force, Puller				
Flow (gpm)	30000 psi		40000 psi	
	Pull (lbf)	Rear x 2	Pull (lbf)	Rear x 2
4	-28	0.025	-32	0.023
5	-33	0.027	-37	0.025
6	-38	0.029	-47	0.028
7	-46	0.032	-54	0.030
8	-52	0.034	-61	0.032
9	-58	0.036	-69	0.034
10	-65	0.038	-73	0.035
11	-71	0.040	-82	0.037

WARRANTY

Limited Warranty. Each Waterblast Unit, Bareshaft Pump, and Fluid End manufactured by Jetstream is warranted against defects in material and workmanship for a period of 12 months or 1,000 hours, provided it is used in a normal and reasonable manner and in accordance with all operating instructions. If sold to an end user, the applicable warranty period commences from the date of delivery to the end user. If used for rental purposes, the applicable warranty period commences from the date of delivery to the party holding the equipment available for rent. This limited warranty may be enforced by any subsequent transferee during the warranty period. This limited warranty is the sole and exclusive warranty given by Jetstream.

Exclusive Remedy. Should any warranted product fail during the warranty period, Jetstream will cause to be repaired or replaced, as Jetstream may elect, any part or parts of such Waterblast Unit, Bareshaft Pump, or Fluid End that the examination discloses in Jetstream's sole judgment to be defective in material or factory workmanship. Repairs or replacements are to be made at Jetstream in Houston, Jetstream FS Solutions Rental Center, the customer's location, or at other locations approved by Jetstream. Labor is furnished only when the unit or part is returned to the factory or when travel and expenses are paid by the purchaser. Freight, travel and expenses incurred in connection with repair or warranty are excluded from this warranty and shall be paid by the purchaser. The foregoing remedies shall be the sole and exclusive remedies of any party making a valid warranty claim.

The Jetstream Limited Warranty shall NOT apply to (and Jetstream shall NOT be responsible for):

1. Major components or trade accessories that have a separate warranty from their original manufacturer, such as, but not limited to: diesel engines, electric motors, electronic soft starter and/or across the line starter panels, axles, PTO's, clutch packs, high pressure gauges, high pressure hoses, flex lances, etc.
2. Normal adjustments and maintenance services.
3. Normal wear parts such as, but not limited to: oil, clutches, belts, filters, packing, cartridges, univalves, face seals, diffusers, gland nut bushings, plungers, nozzles, rupture disks, etc.

4. Failures resulting from the machine being operated in a manner or for a purpose not recommended by Jetstream including failures or malfunctions resulting from corrosion, misapplication, overpressurization, inadequate pump suction conditions, improper water quality, improper maintenance, or misuse.

5. Repairs, modifications or alterations which in Jetstream's sole judgment, have adversely affected the machine's stability, operation or reliability as originally designed and manufactured.

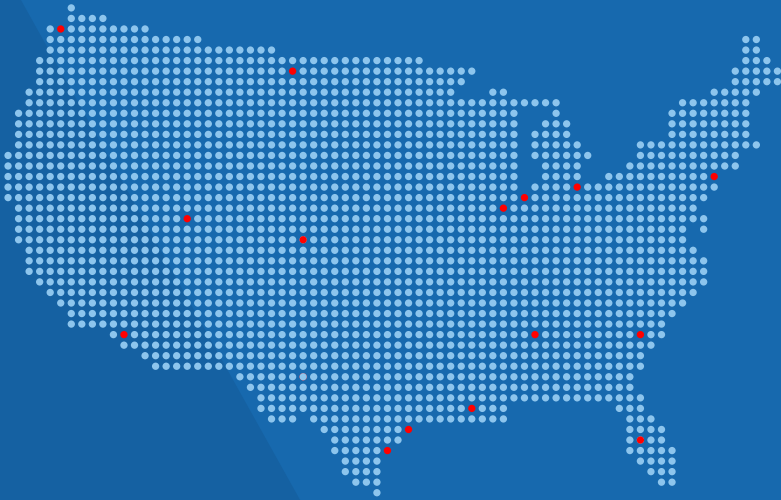
6. Items subject to misuse, negligence, accident or improper maintenance.

NOTE The use of any part other than ones approved by Jetstream may invalidate this warranty. Jetstream reserves the right to determine, in its sole discretion, if the use of non-approved parts invalidates the warranty. Nothing contained in this warranty shall make Jetstream liable for loss, injury, or damage of any kind to any person or entity resulting from any defect or failure in the machine or part.

THIS WARRANTY IS, AND SHALL BE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING WITHOUT LIMITATION, ANY IMPLIED WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE, ALL OF WHICH ARE DISCLAIMED. THIS DISCLAIMER AND EXCLUSION SHALL APPLY EVEN IF ANY WARRANTY POSSIBLY ASSERTED FAILS OF ITS ESSENTIAL PURPOSE.

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