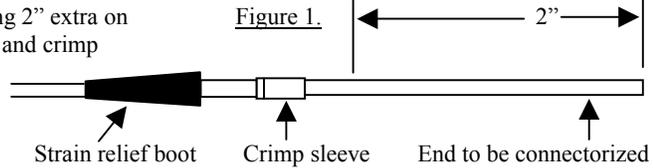


# LC PC AND APC SINGLEMODE AND MULTIMODE CONNECTOR

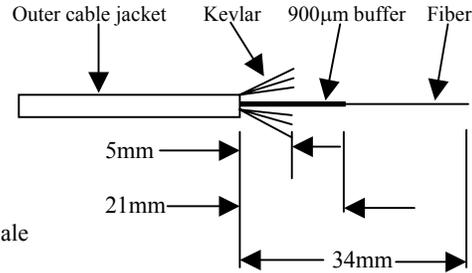
Revision-B 4/14/04

**Step 1.** Cut fiber optic cable to the desired length, allowing 2" extra on Each end for connectorization. Slide the strain relief boot and crimp sleeve onto cable end as shown in Figure 1.



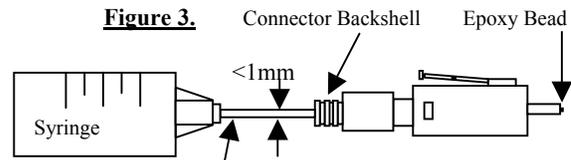
**Step 2.** Using the Appropriate strip Tools and strip Chart (Figure 2), Mark and strip Cable.

**Figure 2. Ceramic Ferrule Strip Chart**



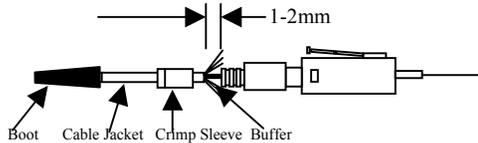
**Step 3.** Mix the epoxy according to the manufacturer's instructions. FIS T60-065-B2, or TRA-CON BA-F113 is recommended. Use a Syringe with a <1mm diameter tip to inject the epoxy into the Connector ferrule as shown in Figure 3. Ensure the syringe tip is Seated properly against the inside of the ferrule and apply a slow Steady pressure to the syringe plunger while injecting epoxy. Apply Such that the epoxy is **delivered only into the connector tip**. Injecting too much epoxy may allow excess to seep back into Connector mechanism and impede spring function. Be careful to Remove any excess epoxy from the rear of the connector backshell.

**Figure 3.**



**\* Important:** The syringe tip must be fully inserted into the connector backshell prior to injecting epoxy. The syringe tip can be felt bottoming out against the inside of ferrule when fully inserted into connector. A bead of epoxy covering 1/3 of the ferrule tip will be visible when applied properly.

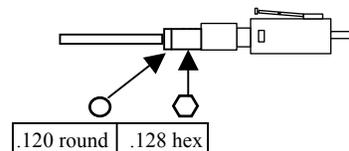
**Figure 4.**



**Step 4.** Fan the kevlar out evenly around the buffer and **ensure That no strands of kevlar are inside the connector backshell.**

This helps ensure proper operation of connector mechanism. now gently feed the bare fiber through the back of the connector body until you feel the buffer bottom out against the base of the ferrule. Properly inserted into the connector, approximately 1-2mm of buffer will be visible between the connector backshell and the outer jacket; approximately 5-10mm of fiber will be visible at the tip of the ferrule.

**Figure 5.**



**Step 5.** Next slide the crimp sleeve onto the connector until it pinches the kevlar onto the connector backshell. Crimp the entire sleeve using a .128" hex die, followed by a .120" round die on the back end of the sleeve. (Note: for 1.6mm and 2.0mm versions, the second crimp is replaced by a heat shrink tube, which should be shrunk down at this time.)

**Step 6.** Cure the connector according to epoxy manufacturer's instructions.

**Note:** While curing, the connector must be oriented vertically, with the fiber pointing downward. This is to prevent the still-liquid epoxy from seeping into the spring mechanism.

**Step 7.** Once cured, cleave the excess fiber.

**Step 8.** Use a step polish procedure-start with 1.5µm diamond film, followed by a .5µm diamond film. A properly assembled and polished FIS LC connector will have an insertion loss below .6dB for multimode; below .3dB for singlemode.

