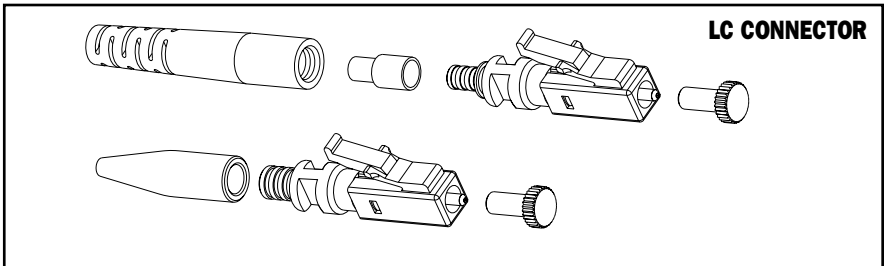
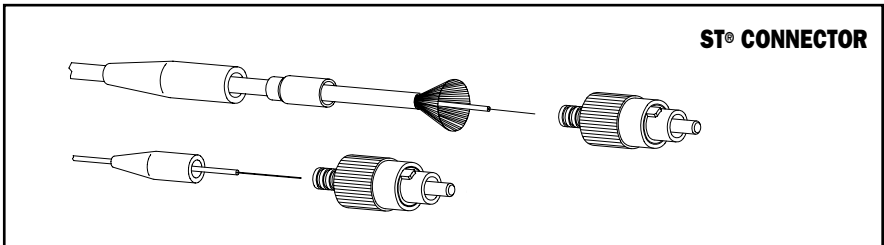
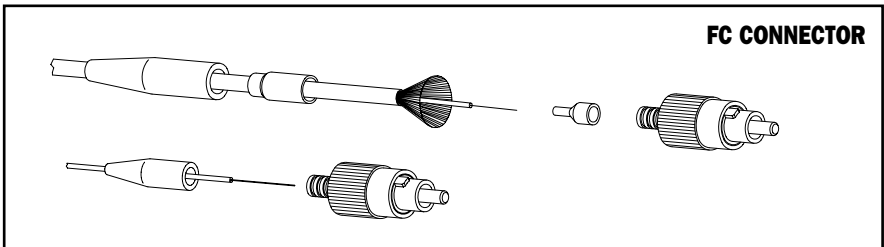
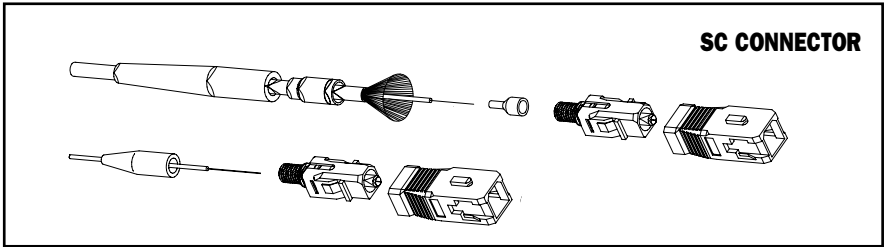


Fast Cure Fiber Optic Connector



Assembly Instructions

A. PREPARE

All Connector Types:

NOTE: If using buffered cable, do not use the crimp tube in step 1.

1. Slide the boot and the crimp tube onto the cable, with the small end inserted first. **(Figure 1)**

For 3mm Jacketed Cable: Use the ribbed boot, provided.

For 900µm Buffered Cable: Use the smooth boot, provided.

NOTE: If using an SC Connector on 900µm fiber, you must install the SC body before continuing to step 2.

Align the body with the connector housing, then insert the body into the housing until it snaps into place.

2. Strip the jacket and/or buffer using the measurements provided in the chart below, and strip in increments of 1/4". If using jacketed cable, trim the aramid strands as indicated, below. **(Figure 2a-c)**

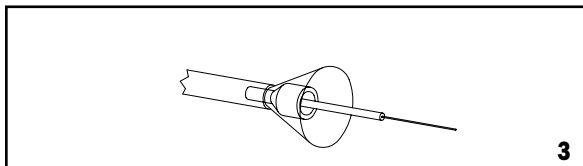
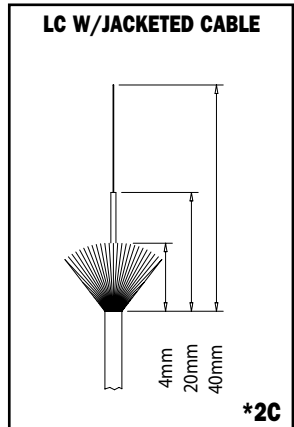
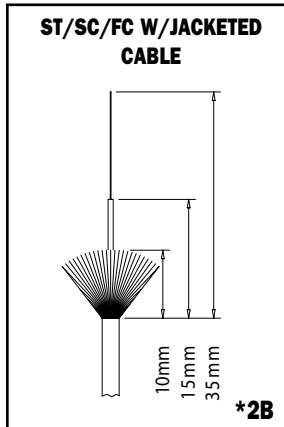
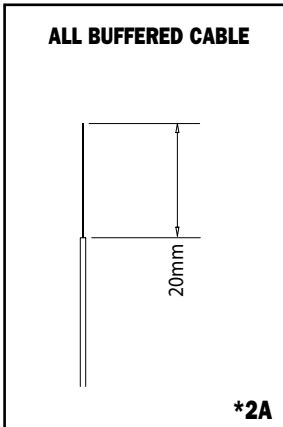
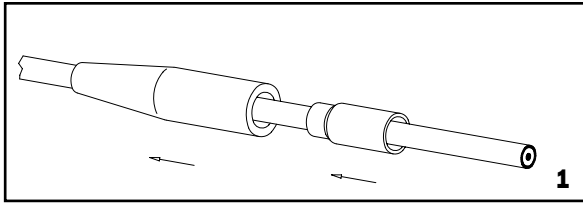
NOTE: To help avoid tool, buffer and fiber contamination, clean jacket and exposed buffer with a 99% alcohol wipe, then with a lint-free wipe, both before and after stripping.

3. Clean exposed fiber with a 99% alcohol wipe followed by a lint-free wipe to remove any contaminants.

SC & FC Connector Types on 3mm Jacketed Cable ONLY:

4. Insert spacer over buffer and push all the way down, until it rests against the jacket. **(Figure 3)**

***NOTE: Images are not to scale.**



B: ASSEMBLE

All Connector and Fiber Types:

1. Remove the dust cap from the connector.
2. Shake the adhesive bottle before using. Remove the cap from the adhesive bottle, and attach the needle by pressing it gently onto the top of the bottle until you feel it set into place.

NOTE: Syringes are also available for inserting adhesive.

3. Insert the needle into the back of the connector, and squeeze the bottle gently, injecting the adhesive into the connector. Continue until a dot of adhesive is visible at the other end, then remove the needle. Wipe away excess adhesive from the end of the ferrule.
4. Dip cleaned fiber into the bottle of primer. Be sure to coat the entire length of exposed fiber with the primer.
5. Insert the fiber into the back of the connector, using continuous motion to prevent premature bonding. Primer will activate adhesive and begin the bonding process.

NOTE: The fiber should be inserted within 45 seconds of priming.

6. Hold the fiber into place for 10-20 seconds, and allow up to 3 minutes for the adhesive to bond.
7. If using any cable type but jacketed fiber, slide the boot back up over the back of the connector, now. If using jacketed fiber, follow the steps, below.
8. For SC and LC Connectors, ensure proper orientation of body by aligning connector housing.

Additional Steps For 3mm Jacketed Cable ONLY:

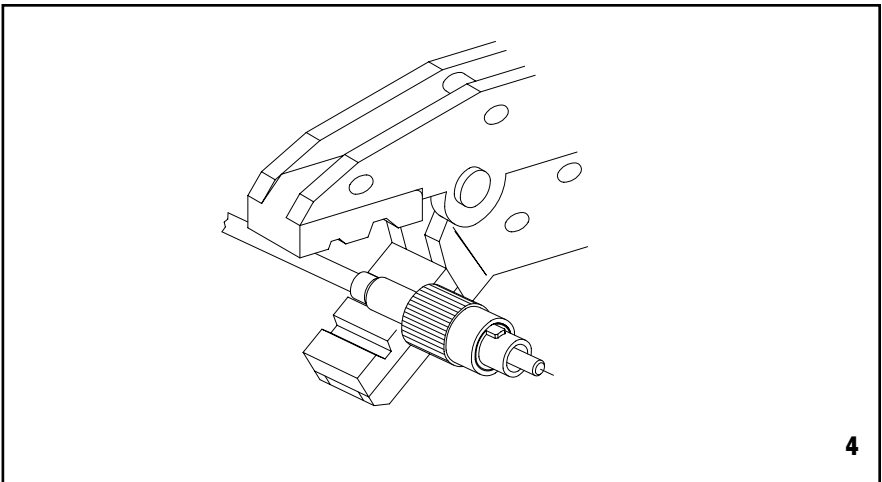
9. Slide the crimp tube over the aramid strands and connector body. Then, using a crimp tool, crimp the tube at both the large end (step 1) and the small end (step 2). **(Figure 4)**

FC/ST/SC - large end: Use the .178" hex die.

FC/ST/SC - small end: Use the .151" hex die.

LC: Use the .128" hex die.

10. Slide the boot back up over the back of the connector.



C. CLEAVE AND POLISH

All Connector and Fiber Types:

NOTE: The Thread-Lock Versa-Cleave tool is NOT recommended for cleaving Fast-Cure Connectors. Doing so may result in damage to the tool.

1. When the adhesive is cured, (no longer wet), scribe the fiber where it meets the bead of adhesive at the end of the ferrule. **(Figure 5)**
2. Gently pull away the fiber stub, and properly dispose of it.

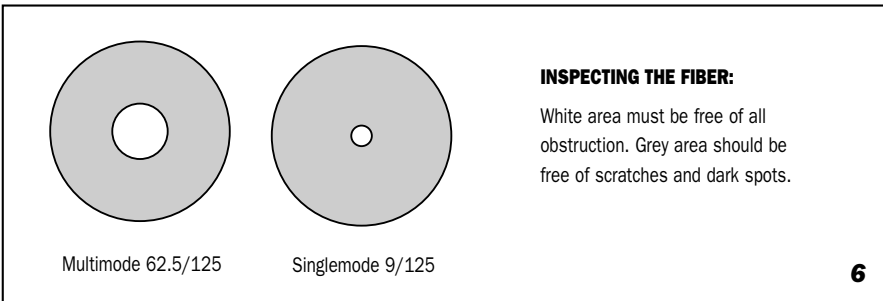
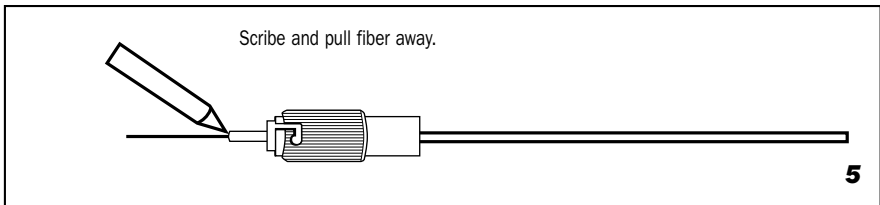
NOTE: Loose fiber cuttings can be dangerous. Be sure to properly dispose of fiber.

3. 12 μm "AIR POLISH" - Begin by "Air Polishing" the connector with 12 μm polishing film. Hold film at the edge with thumb and forefinger. Gently touch connector to film and rotate using 18-20 one-inch circles to remove fiber stub. Leviton's 12 μm film is dark pink in color.

3 μm & .3 μm "PAD POLISH" - Wipe the bottom surface of the polishing puck and the surface of the connector with a 99% alcohol wipe. Place 3 μm film on the polishing pad, dull side up, and set polishing puck on the film. Gently insert the connector into the puck, and trace 15-20 Figure 8's on the film, using very light pressure and proceeding to firmer pressure as you progress. Repeat the same procedure with the .3 μm film. Leviton's 3 μm is yellow and the .3 μm film is light blue in color.

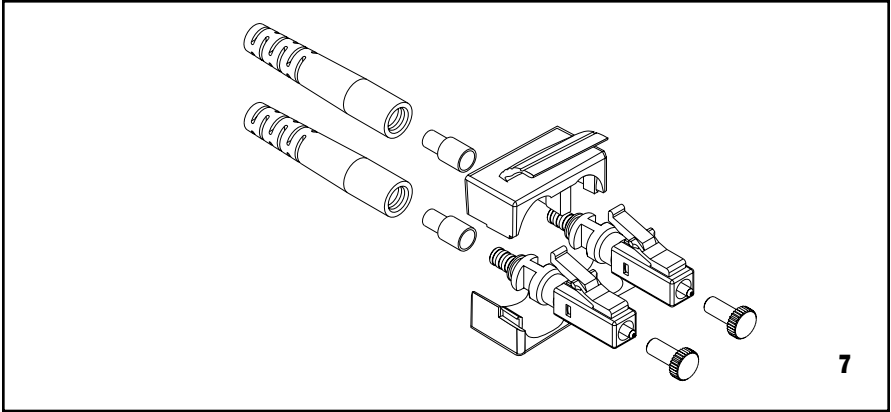
4. Inspect the fiber using the 200x inspection scope, to be sure the fiber is not scratched, cracked or broken. Remove any debris using a lint-free wipe. **(Figure 6)**
5. Repeat the pad polishes if necessary.

NOTE: When polishing LC connectors, use Leviton's 1.25mm Polishing Puck (PN# 49886-LCP).



D. INSTALLING THE DUPLEX CLIP

1. Place the connector (SC or LC) onto one half of the clip housing. Then, place the other half of the clip housing on top of the connector, snapping it into place. **(Figure 7)**



IMPORTANT INSTRUCTIONS

1. Read and understand all instructions.
2. Follow all warnings and instructions marked on the product.
3. SAVE THESE INSTRUCTIONS.

SAFETY INFORMATION

1. Always wear safety glasses when working with fiber optic cable.
2. Never look directly into a laser light source.
3. Always dispose of fiber debris properly.
4. No food or beverages in the vicinity.
5. Thoroughly wash face and hands prior to terminating fiber.

TIPS & RECOMMENDATIONS

1. It is important to clean the exposed fiber and even the buffer repeatedly with isopropyl alcohol, to ensure no dust, oil or debris will remain on the fiber.
2. Do not lay ferrule dust covers on a dirty or dusty surface.
3. When using tightening tools, insert the connector into the tool before inserting the fiber into the connector.
4. To maintain proper end radius of fiber, always use the Leviton polishing pad, polishing puck, and lapping films as instructed in the polishing process (see page 4, section C).