Assembly Instructions

P/N: Z1200-4-1

Type: ST*, Field Installable, ST*II Compatible

Mode: Multimode

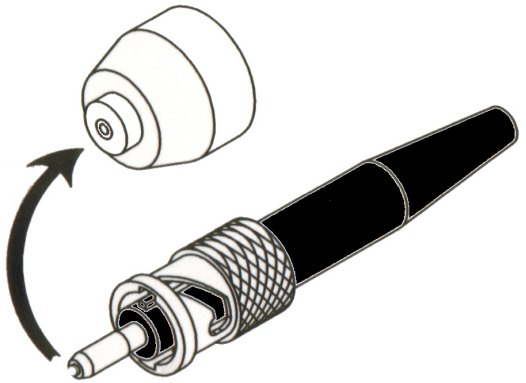
Ferrule material: Zirconia sleeve w/glass insert

Curing type: UV Curable

Instructions for: .9mm Buffered Fiber

Number of Steps: 17

Date of last revision: 4/23/2002



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Curing Do's and Don'ts Regarding Pine Valley's UV Connectors

DO'S

- Check batteries in UV Light
- Keep log of hours UV light has been used.
- Check expiration date on Norland 81 UV Adhesive
- Store Norland 81 UV Adhesive properly as per technical data sheet
- Follow Pine Valley termination instructions for UV connectors
- Prepare a test piece for curing.

DON'TS

- Do not use any batteries other than alkaline w/tester on them. Adapters are not recommended and are hazardous to use with alkaline batteries.
- Exceeding approximately 1000 hours operating time will weaken UV ability.
- If Norland 81 UV Adhesive has been left out in heat and not stored as per technical data sheet instructions, viscosity will be affected and its sensitizer will decrease.

Remember: Check batteries, UV light, and Norland 81 optical adhesive before you terminate. If batteries are weak, or light has reached 1000 hours operating time, curing of connectors may be affected. The lamp may operate electrically for many thousands of hours after it ceases to emit adequate UV light, therefore Pine Valley recommends 1000 hours of operating time for the UV light.

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Step 1
Take apart ST* Connector

Step 2
Slide the flame retardant boot onto .9mm buffered fiber optical cable.

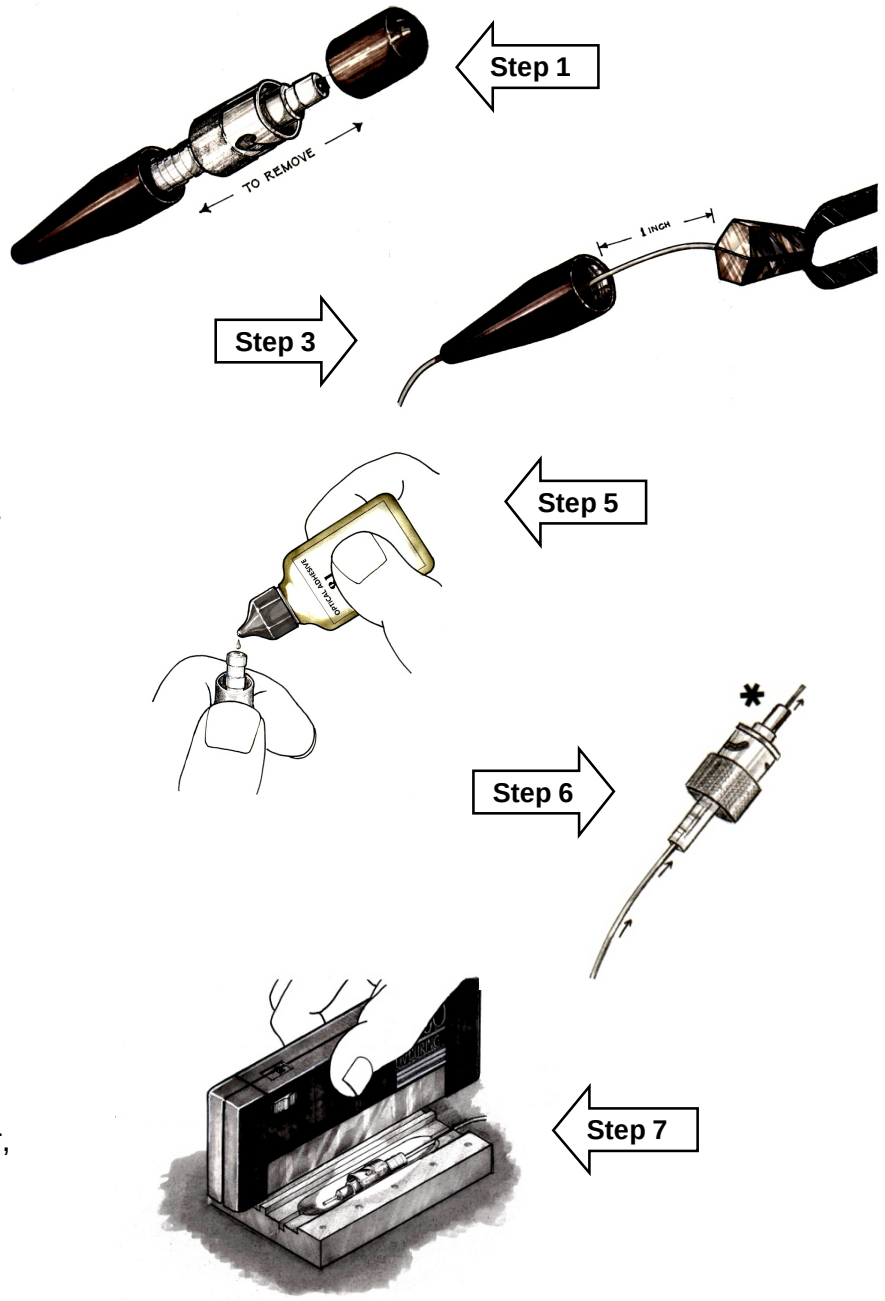
Step 3
Strip approx. .500/.740” of the buffer tube, as per template, from the fiber with No Nik Stripper. Set aside carefully.

Step 4
This step is very important. Clean stripped fiber with isopropyl alcohol soaked lint free cloth or a dry lint free cloth. To clean fiber fold cloth in half over fiber and gently squeeze on the fiber and pull it through the cloth. This will clean the fiber of debris.

Step 5
Apply about 1 drop of Norland 81 optical adhesive into the back (clear) end of the ferrule holder. Allow 6 seconds for the capillary action to draw the adhesive into the ferrule holder.

Step 6
Thread the fiber through the back end of the ferrule holder until it bottoms out. Approximately 1/4” of fiber will be showing in front of the connector.*

Step 7
Place connector in curing fixture with “J” slot facing up. Place UV light over connector, insuring that the blue UV light covers the fiber, connector, and entire ferrule holder. Place light into curing fixture. Cure for 60 seconds.
(PVP curing fixture recommended.)



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Step 8
Slide flame retardant boot up back of ferrule holder.

Step 9
Cleave fiber on two sides. Pull straight up. Carefully dispose of cleaved fiber.

Step 10
Place PVP rubber mat over PVP lapping plate and line with 15, 5, 1 & .3 micron lapping film.

Step 11
Add 3 drops of water to each lapping film. Place connector into ST* polishing puck.

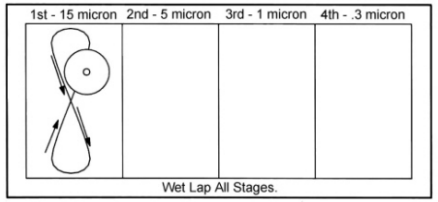
Step 12
Do 10 figure 8's using light even pressure, with **15** micron lapping film. **Be sure to blow off connector and puck after each lapping sequence to prevent contamination and scratching of fiber core.**

Step 13
Do 14 figure 8's using **5** micron lapping film. **Be sure to blow off connector and puck after each lapping sequence to prevent contamination and scratching of fiber core.**

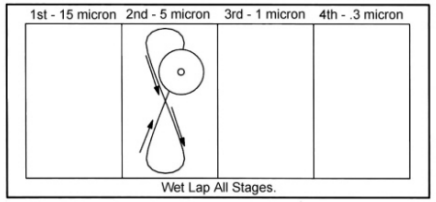
Step 14
Do 15 figure 8's using **1** micron lapping film. **Be sure to blow off connector and puck after each lapping sequence to prevent contamination and scratching of fiber core.**

Step 9

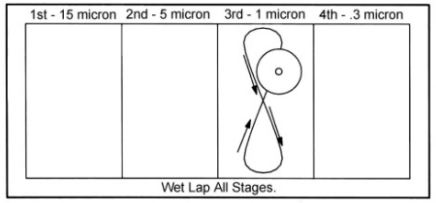
Step 12



Step 13



Step 14



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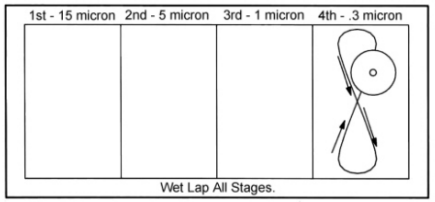
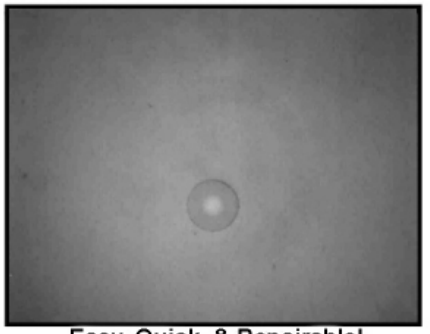
Step 15
Do 15 figure 8's using **.3** micron lapping film. **Be sure to blow off connector and puck after each lapping sequence to prevent contamination and scratching of fiber core.**

Step 15



Step 16
Insert ferrule into angled portion of 100x Inspection Microscope. Verify that fiber is radiused and above glass surface.

Step 17
Then insert ferrule straight up into 100x Inspection Microscope and inspect fiber core. Should appear like the picture to the right.

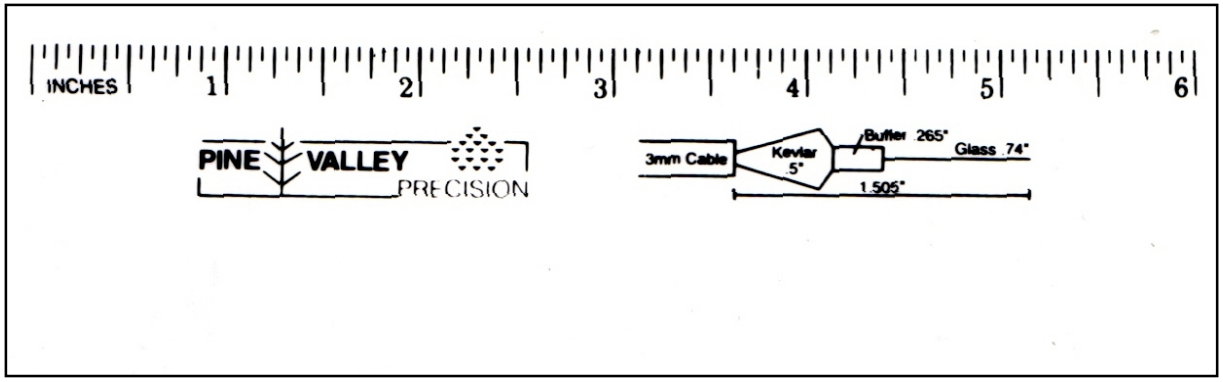


Easy, Quick, & Repairable!

If necessary re-polish by repeating steps 13, 14, & 15.

Need help?
Any questions?
Call 856-663-1855 for Help.

Template



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