FuseConnect™ FC-SF cord
Assembly manual

Always wear eye protection when handling optical fibers. Dispose of any fiber cut and cleaved fiber ends properly.

1. Components
Fuseconnect-SC-SF Cord is assembled with parts shown below.
- Coupling unit
- Connector holder
- Fusion splice sleeve
- Boot unit
- Stopring unit

2. Assembly & Fiber cable preparation tools
- Fusion splicer (FSM-60R)
- Yarn cutter
- 0.9 Fiber stripper (FH-60-900)
- Fiber holder
- Cable clamp
- Jacket stripper
- Jacket splitter

*Please use the heating condition described in Table 1 during the assembly of this connector.

Table 1: Heating condition

<table>
<thead>
<tr>
<th>SPlicer Model</th>
<th>Default MODE</th>
<th>Change Parameter</th>
<th>Heat Time(S)</th>
<th>Heat Temp(℃)</th>
</tr>
</thead>
<tbody>
<tr>
<td>FSM-60R/FSM-18S</td>
<td>FP-03 L=40</td>
<td>5 0</td>
<td>210</td>
<td></td>
</tr>
<tr>
<td>FSM-60R/FSM-18R</td>
<td>FP-05</td>
<td>5 0</td>
<td>230</td>
<td></td>
</tr>
<tr>
<td>FSM-17S-FH</td>
<td>FPS-01-900-25</td>
<td>5 0</td>
<td>200</td>
<td></td>
</tr>
<tr>
<td>FSM-50R/FSM-17R</td>
<td>FP-05</td>
<td>5 0</td>
<td>230</td>
<td></td>
</tr>
<tr>
<td>FSM-11S/FSM-11R</td>
<td>FP-04 S</td>
<td>4 0</td>
<td>200</td>
<td></td>
</tr>
<tr>
<td>FSM-30R/FSM-16R</td>
<td>40 mm</td>
<td>8 5</td>
<td>240</td>
<td></td>
</tr>
</tbody>
</table>

3. Operation procedure
3.1 Preparation
- Fix the cord on cable clamp about 300mm from the cord edge.
- Insert boot unit & Stopring through the cable.

3.2 Cord Processing
3.2.1 Cord jacket marking, removal and splitting
- Mark the cord jacket at 35mm and 90mm from the cord edge.
- Remove the cord jacket from 35mm marking until cord edge.
- Mark the tight buffered fiber at 3mm from the cord edge.
- Split the cord jacket from 90mm marking until cord edge.

3.2.2 Fusion splice sleeve insertion and Fiber stripping
- Insert fusion splice sleeve through 900um fiber.
- Strip the fiber jacket from 3mm marking.

3.2.3 Cleaning and Screening
- Be sure to wear eye protection when handling optical fibers.
- Dispose of any fiber cut and cleaved fiber ends properly.
- Mark the cord jacket at 35mm and 90mm from the cord edge.
- Fix the cord on cable clamp about 300mm from the cord edge.
- Insert boot unit & Stopring through the cable.
- Clean the fiber surface after the coating was removed with cotton dipped in alcohol. Bend the fiber up and down as well as left and right 3 times slowly with the finger (about 60° angle) to verify that it does not break.
3.2.4 Fiber cleaving

Set the fiber on the fiber holder so that the fiber coating protrudes about 3mm from the fiber holder edge. Then, cleave the fiber.

Note: Ensure there is no gap at this point.

3.3 Splicing

3.3.1 Preparation

Set the fiber holder and connector holder on fusion splicer.

Note: Ensure the yarn and cord jacket are outside the fusion splicer.

3.3.2 Splicing cable to connector.

3.4 Heating

3.4.1 Removing cord from the fiber holder and connector holder

Before removing the cord, apply slight tension on the cord. Open the cover of the fiber holder and connector holder.

3.4.2 Putting the fusion splice sleeve

Slide the fusion splice sleeve in order to cover the bare fiber.

Note: Ensure there is no gap between tube edge and ferrule edge. Ensure the yarn and cord jacket are outside the heater.

3.4.3 Heater setting

Start heating by pushing the heat button.

3.5 Housing assembly

Slide stopring unit to the connector, then pull the yarn out from stopring unit.

3.6 Yarn termination

Divide the yarn into 2 equal position, Fix the yarn onto the coupling unit, then slide boot unit to the back of connector.

Screw the boot unit into the back of connector to fix the yarn firmly, while maintaining tension on the yarn and cord.

Trim away the excess yarn using a yarn cutter.

Completed!