**FUSECONNECT - SC - SF**

Assembly manual

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

1. **Components**

Fuseconnect-SC-SF is assembled with parts shown below.

2. **Assembly & Fiber cable preparation tools**

   - Fusion splicer (60R)
   - 60.9 Fiber stripper
   - Connector Holder (FH-60-900)
   - Fiber cleaver (CT-30)

3. **Operation procedure**

3.1 **Preparation**

Insert boot unit and fusion splice sleeve through the fiber.

3.2 **Cable Processing**

3.2.1 **Fiber stripping and cleaning, screening**

Remove approximately 35mm of fiber coating.

Clean the fiber surface after the coating is removed with cotton dipped in alcohol. Bend the fiber up and down, left and right 3 times slowly with the finger (about 60°) to verify that it does not break.

3.2.2 **Cleave fiber**

- Make a marking at 3mm form edge of fiber jacket. Set fiber on the fiber holder according to marking.
- Clear fiber
  - Note: There is no gap between cleaver and fiber holder.

3.3 **Fiber termination**

3.3.1 **Preparation**

Set fiber holder and connector holder on fusion splicer.

3.3.2 **Fusion splice**

Splice cable to connector.

3.4 **Heating**

3.4.1 **Remove completed splice**

- Release the cover of Fiber holder and connector holder. Applying slight tension on fiber, remove completed splice.

3.4.2 **Slide fusion splice sleeve; Set heater**

- Slide fusion splice sleeve
  - Note: There is no gap between tube edge and ferrule edge.
3.5 housing assembly

3.5.1 Fix coupling to Stopring

Set on the heater then start heating
Note: Refer to Table 1 (Heating condition)

<table>
<thead>
<tr>
<th>Splicer model</th>
<th>Existing heater mode to use</th>
<th>Parameters to be changed</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>Heat time(S)</td>
</tr>
<tr>
<td>FSM-60S/FSM-18S</td>
<td>FP-03 (L=40mm)</td>
<td>50</td>
</tr>
<tr>
<td>FSM-60R/FSM-18R</td>
<td>FP-05</td>
<td>50</td>
</tr>
<tr>
<td>FSM-17S-FH</td>
<td>FPS-01-000-25</td>
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<tr>
<td>FSM-50R/FSM-17R</td>
<td>FP-06</td>
<td>50</td>
</tr>
<tr>
<td>FSM-11S/FSM-11R</td>
<td>FP-04 (S)</td>
<td>40</td>
</tr>
<tr>
<td>FSM-30R/FSM-16R</td>
<td>40 mm</td>
<td>80</td>
</tr>
</tbody>
</table>

Table 1 Heating condition

Finish