FuseConnect™ ST
Assembly manual

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

1. Components
Fuseconnect-ST Cord is assembled with parts shown below.

- Boot unit
- Coupling unit
- Connector holder
- Fusion splice sleeve

2. Assembly & Fiber preparation tools

- Fusion splicer (FSM-60R)
- Fiber cleaver (CT-30)
- 4.09 Fiber stripper
- Fiber holder (FH-60-900)

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

3. Operation procedure

3.1 Preparation
Set the fiber holder and connector holder on fusion splicer.

3.2 Fiber Processing
3.2.1 Stripping fiber
Strip the fiber jacket about 35mm

3.2.2 Cleaning and Screening
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.

3.2.3 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
Insert boot unit & Fusion splice sleeve through the fiber.

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.

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-60S/FSM-18S</td>
<td>FP-03 (L=40)</td>
<td>5 0</td>
<td>2 10</td>
<td></td>
</tr>
<tr>
<td>FSM-60R/FSM-18R</td>
<td>FP-05</td>
<td>5 0</td>
<td>2 30</td>
<td></td>
</tr>
<tr>
<td>FSM-17S-FH</td>
<td>FPS-01-900-25</td>
<td>5 0</td>
<td>2 00</td>
<td></td>
</tr>
<tr>
<td>FSM-50R/FSM-17R</td>
<td>FP-05</td>
<td>5 0</td>
<td>2 30</td>
<td></td>
</tr>
<tr>
<td>FSM-11S/FSM-11R</td>
<td>FP-04 (S)</td>
<td>4 0</td>
<td>2 00</td>
<td></td>
</tr>
<tr>
<td>FSM-30R/FSM-16R</td>
<td>40 mm</td>
<td>8 5</td>
<td>2 40</td>
<td></td>
</tr>
</tbody>
</table>

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

Insert boot unit & Fusion splice sleeve through the fiber.

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.

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.

Set the fiber holder and connector holder on fusion splicer.

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

Strip the fiber jacket about 35mm.
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.

3.4.3 Heater setting

Start heating by pushing the heat button.

3.5 Housing assembly

Pull out the tube that is protecting the ferrule.

Set the stopring unit in ferrule by aligning the key.

Assemble coupling unit to stopring unit.

Completed