

# **SLCS-P1UA, SLCS-PN1UA**

## **Series**

### **Ø0.9mm LC Universal Splice-On Connector**

## **ASSEMBLY MANUAL**



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## PREFACE

This manual describes the assembly of ø0.9mm LC Universal Splice-On Connector.

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1 PREPARATION

The tools and equipments required for ø0.9mm LC Universal Splice-On Connector assembly are as follows.

Assembly tools:

- Fiber stripper
- Fiber cleaver
- Assembly tool for LC Splice-On Connector



Figure 1-1 Fiber cleaver



Figure 1-2 Assembly tool

Assembly equipment:

- Fusion splicer
- Fiber holder for LC Splice-On Connector



Figure 1-3 Fusion splicer



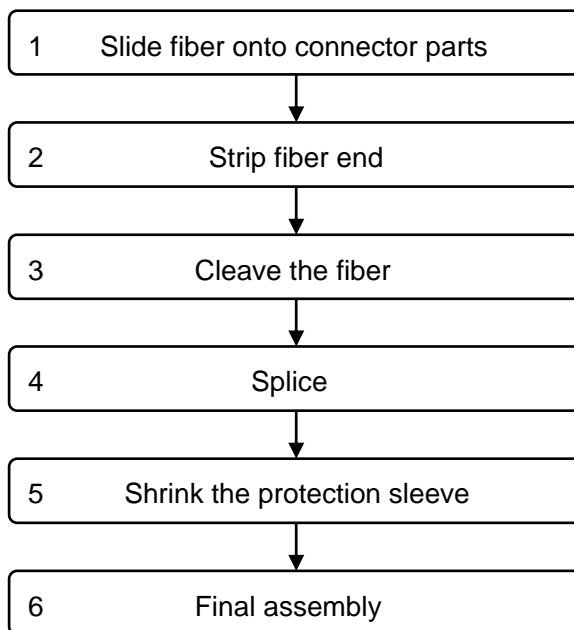
Figure 1-4 Fiber holder

Other supplies:

- Scale
- Marker: oil-based
- Cleaning paper
- Ethanol

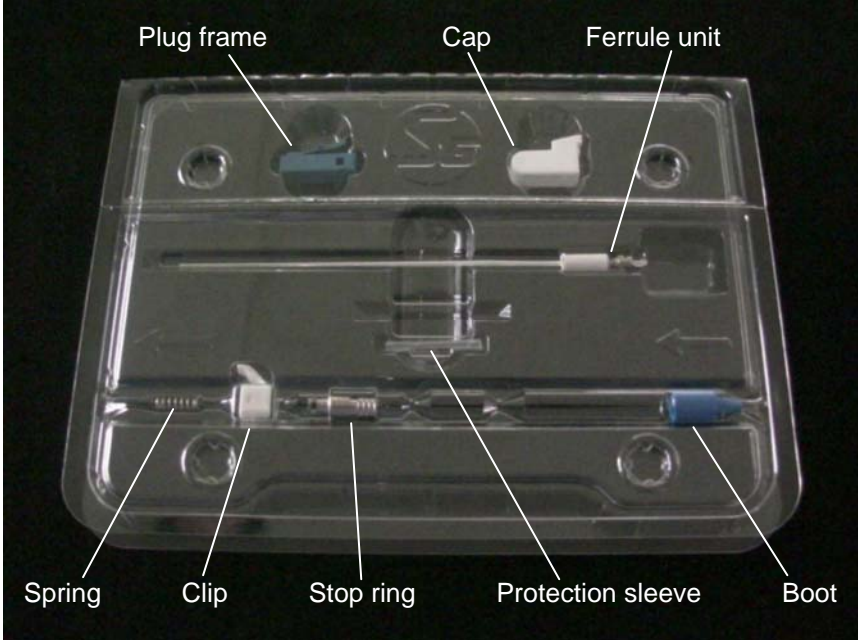
## 2 ASSEMBLY PROCEDURE

The Universal operational procedure for assembling  $\varnothing 0.9\text{mm}$  LC Universal Splice-On Connector is shown below.

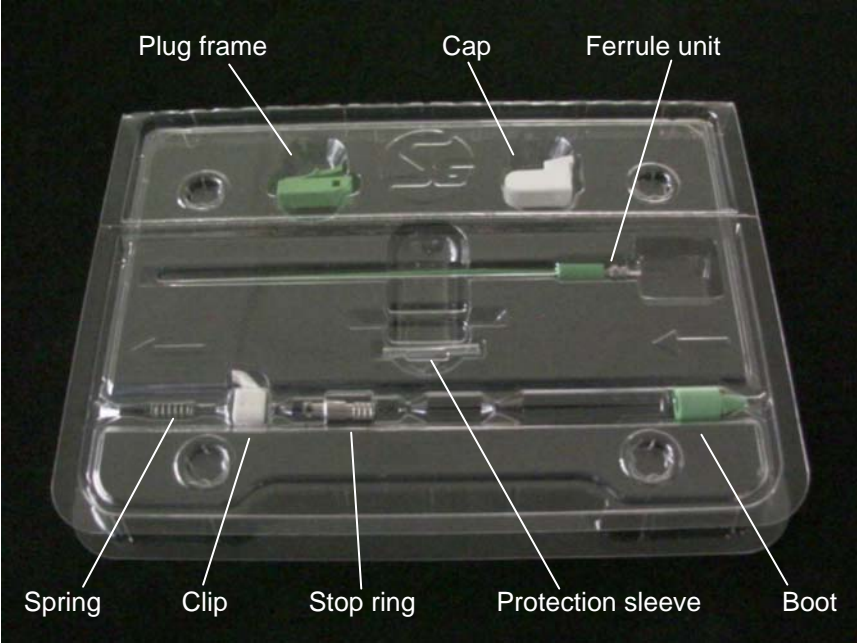


3 SLCS-P1UA, SLCS-PN1UA LC SOC PARTS

The components making up SLCS-P1UA or SLCS-PN1UA LC SOC are shown below.



For PC application (SLCS-P1UA)

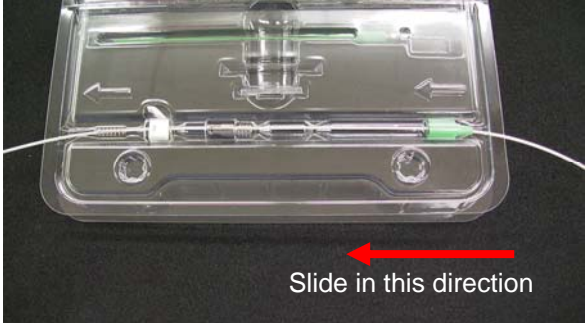


For Angled-PC application (SLCS-PN1UA)

Figure 3 SLCS-P1UA, SLCS-PN1UA LC SOC Parts

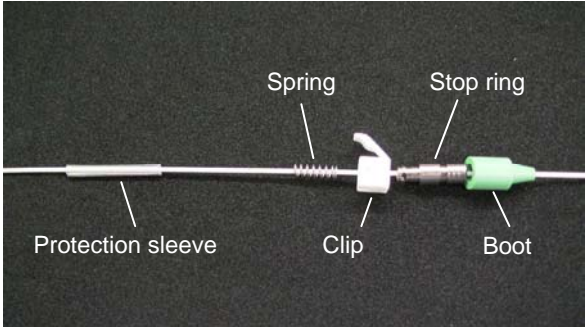
4 ASSEMBLY

4.1 SLIDING THE FIBER ONTO CONNECTOR PARTS



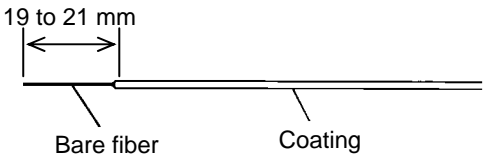
Step 1 Slide fiber onto connector parts inside packaging case.

Step 2 Pick up fiber with connector parts attached from packaging case.

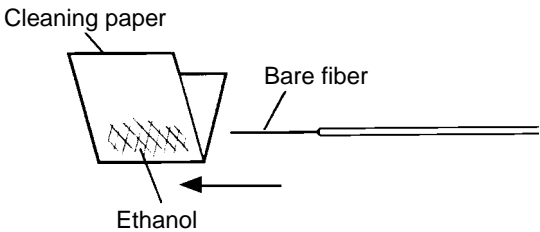


Step 3 Pick up protection sleeve from packaging case and slide it onto fiber.

4.2 STRIPPING THE FIBER END



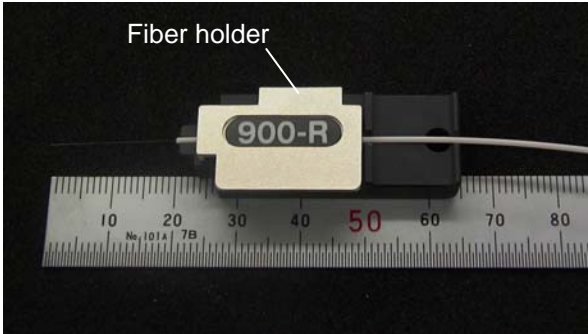
Step 1 Using the fiber stripper and a scale, remove 19 to 21 mm of the buffer coating from the end of the fiber as shown.



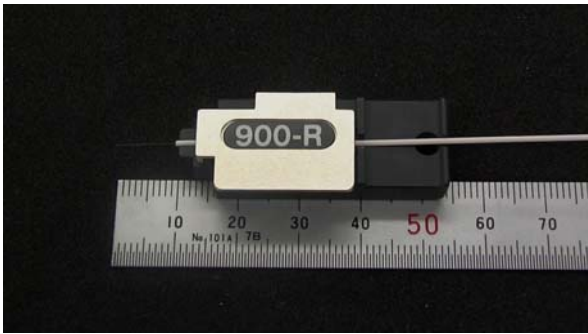
Step 2 Wipe off the residual coating with a piece of cleaning paper moistened with ethanol.



### 4.3 CLEAVING THE FIBER



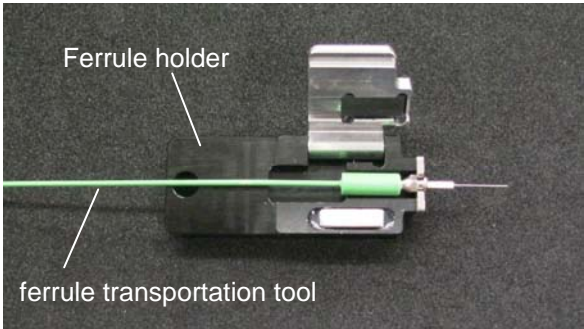
Step 1 Place fiber into fiber holder.



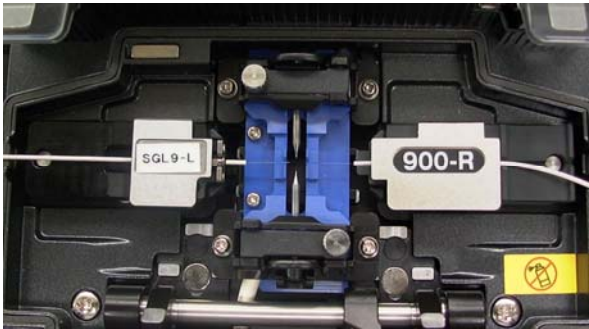
Step 2 Cleave the fiber.

### 4.4 SPLICING

Step 1 Select fusion-splicing program and heating program for SOC on Fusion splicer.



Step 2 Pick up ferrule unit from packaging case using ferrule transportation tool. Place ferrule unit in ferrule holder.



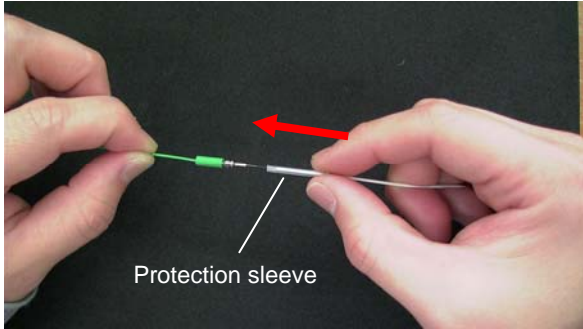
Step 3 Set the ferrule holder and the fiber holder onto the fusion splicer, and splice them.

### 4.5 SHRINKING THE PROTECTION SLEEVE

Step 1 After splicing, pick up the ferrule unit and fiber from holder.

**CAUTION**

Do not remove the ferrule holder and fiber holder from the splicer.



Step 2 The protection sleeve should be moved until its tip is inserted into the rear end of the ferrule unit.

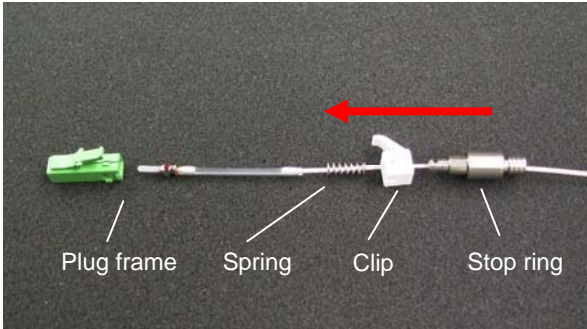


Step 3 Set the fiber on the heating stage, and shrink the protection sleeve.

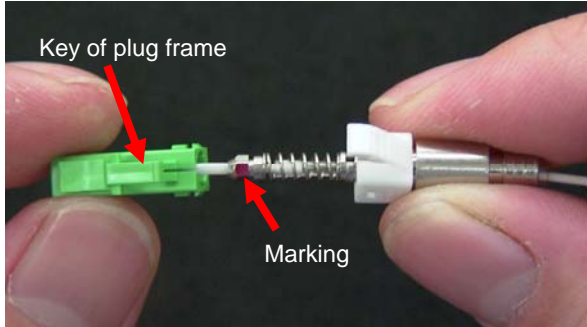


Step 4 Pick up the fiber from the heating stage.

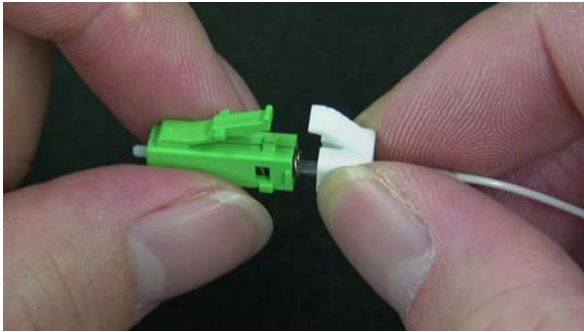
4.6 FINAL ASSEMBLY



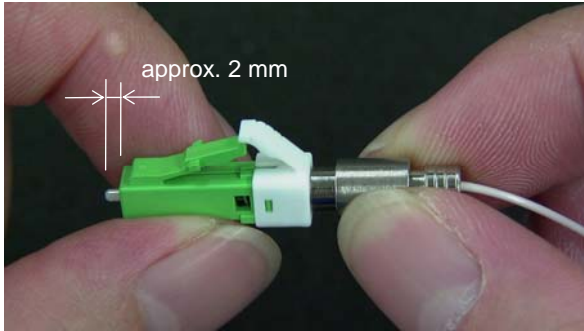
Step 1 Move the spring, the clip and the stop ring to the end of fiber.



Step 2 Insert the ferrule into the plug frame.  
In case of LC/APC, the tuned mark on the ferrule flange should be oriented to the key of the plug frame.

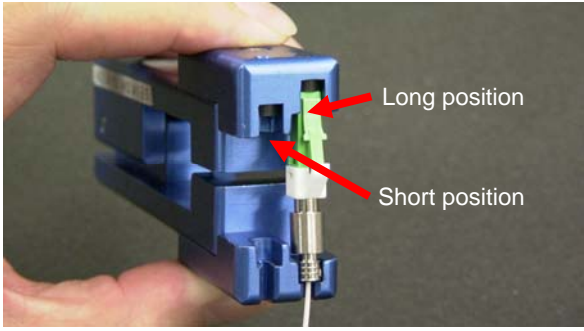


Step 3 Insert the clip into the plug frame.

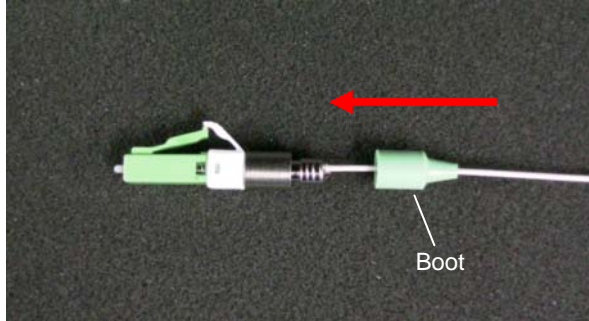


Step 4 Insert the stopper into the plug frame.  
Please confirm that the ferrule is protruded approx. 2mm from the top of the plug frame before inserting the stopper.

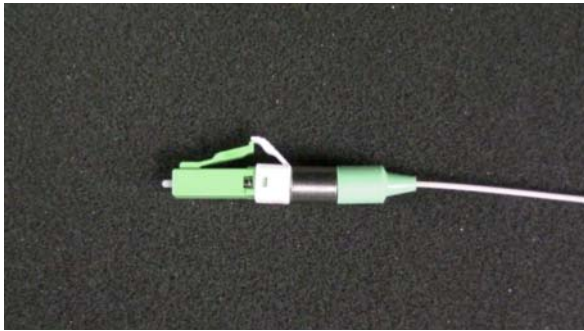
———— CAUTION ————  
To avoid the possible fiber breakage, do not hold the fiber cord, but hold only the stop ring, to insert into the plug frame.



———— NOTE ————  
When the assembly tool is used, set the connector at long position on the tool as shown.



Step 5 Slide the boot onto the stop ring.



Step 6 Assembly is completed.

## 5 INSTRUCTION FOR USE

It is good safety practice to never look directly into the end of a fiber or bulkhead adaptor. Otherwise, the optical laser beam may get into the eye and cause the blurred vision.