

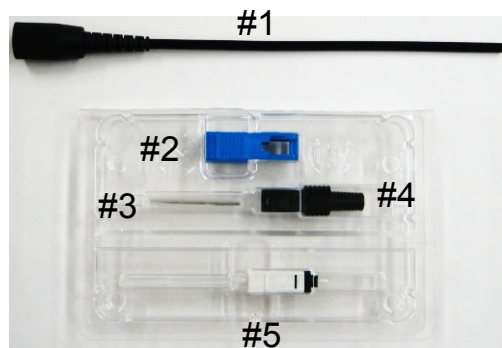
TOUCH Plus SC Splice-On Connector for Cordage Assembly Instructions

Standard assembly procedure of TOUCH Plus SC Splice-On Connector is as below.

Caution : Wear eye protection glasses when handling optical fibers.

1. Preparation

(1) Package



No.	Parts
1	Nut + Boot Assembly
2	Grip
3	Splice Protection Sleeve
4	Stopper
5	Plug Frame Unit

(2) Recommended Assembly Tools

No.	Tool	Vendor	P/N
1-1	Fusion Splicer	Furukawa FITEL	S123C, S153A, S178A
1-2	Holder for 900 μm coating diameter fiber	Furukawa FITEL	S712S-900
1-3	Holder for TOUCH Plus SC SOC	Furukawa FITEL	S712C-SGCH9-R
2	Fiber Cleaver	Furukawa FITEL	S325A, S326A
3	Jacket Slitter	Furukawa FITEL	S240A
4	3-Hole Fiber Stripper	Furukawa FITEL	S211B
5	Kevlar Scissors	Furukawa FITEL	SS-01
6	Scale	any	any
7	Marker (oil-based)	any	any
8	Cleaning paper	any	any
9	Ethanol	any	any

(3) Heating Parameter

Parameter for heater program on FITEL S123C, S153A or S178A for TOUCH Plus SC SOC splice protection sleeve

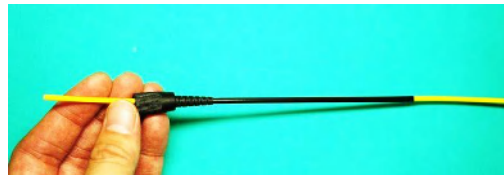
Heat Temp	180 deg C
Heat Time	60 sec.

2. Assembly Procedure

(1) Pick up Plug Frame Unit from package and put onto holder.



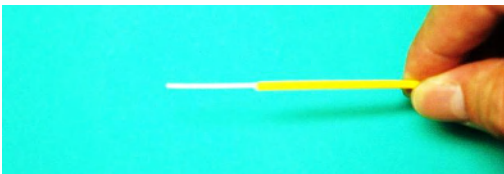
(2) Slide Nut and Boot Assembly onto cable.



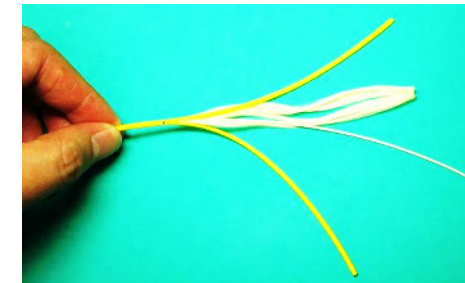
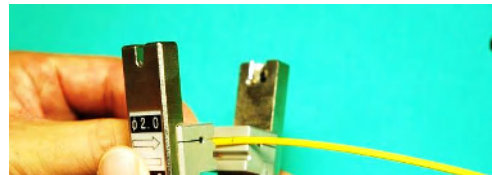
(3) Measure length of jacket to be stripped and mark at 25mm and 130mm.



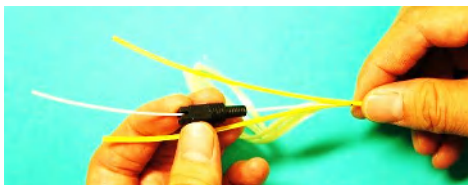
(4) Strip jacket and kevlar at 25mm.



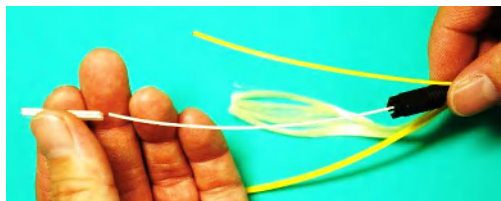
(5) Split jacket lengthways at 130mm.



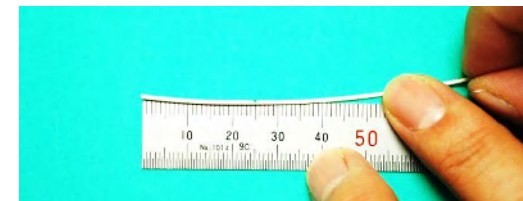
(6) Slide Stopper onto buffer cord.



(7) Slide Splice Protection Sleeve onto buffer cord.

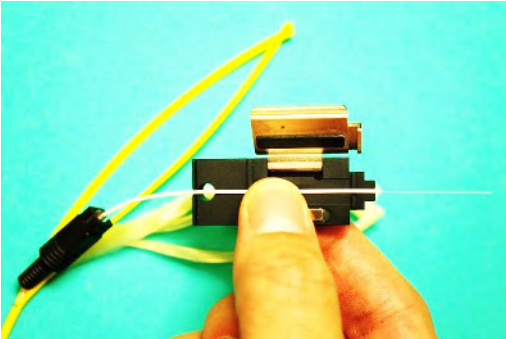


(8) Measure length of buffer coating to be stripped and mark at 25mm.

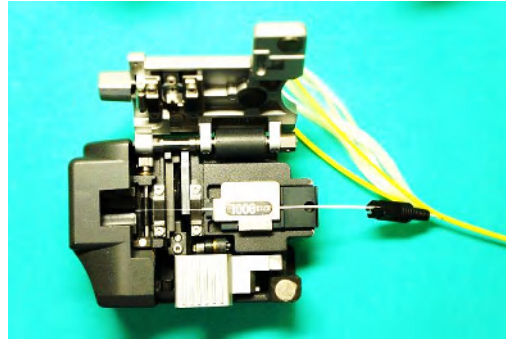


TOUCH Plus SC Splice-On Connector for Cordage Assembly Instructions

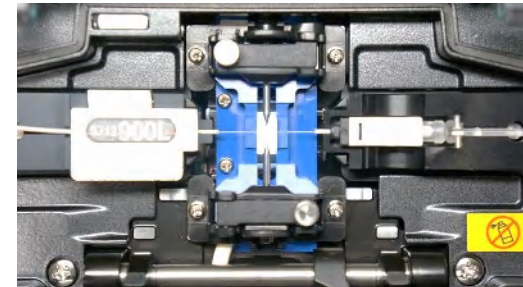
(9) Strip buffer coating at 25m, and put it onto holder.



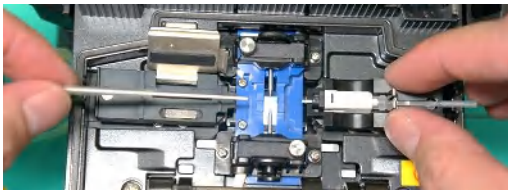
(10) Cleave fiber.



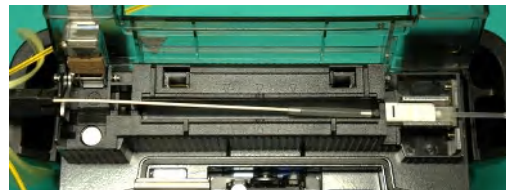
(11) Set holders on splice machine, and splice fibers.



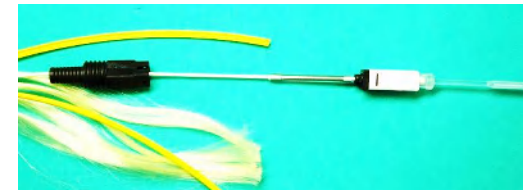
(12) Slide Splice Protection Sleeve toward holder, and pick up spliced fiber cord.



(13) Put spliced fiber cord onto heating stage. * Note



(14) Confirm heating of Splice Protection Sleeve properly made.



(15) Slide Stopper to Plug Frame Unit and twist it 90 degree to be assembled.



(16) Spread kevlar over the tail of Stopper.



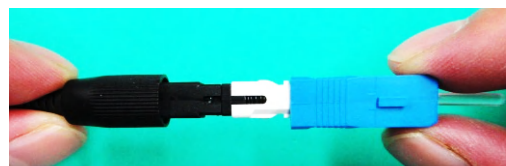
(17) Slide Nut and Boot Assembly over kevlar, and screw.



(18) Screw Nut and Boot Assembly until it stops.



(19) Assemble Grip onto Plug Frame Unit.



(20) Assembly completed !



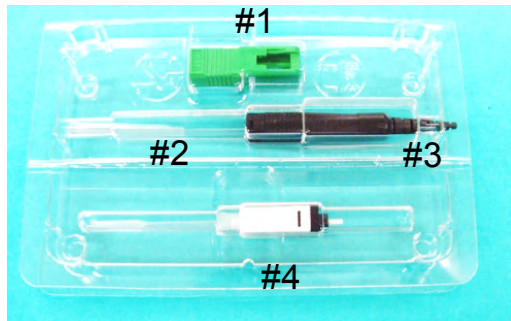
TOUCH Plus SC Splice-On Connector for $\phi 900\mu\text{m}$ Buffer Cord Assembly Instructions

Standard assembly procedure of TOUCH Plus SC Splice-On Connector is as below.

Caution : Wear eye protection glasses, when handling optical fibers.

1. Preparation

(1) Package



No.	Parts
1	Grip
2	Splice Protection Sleeve
3	Boot Assembly
4	Plug Frame Unit

(2) Recommended Assembly Tools

No.	Tool	Vendor	P/N
1-1	Fusion Splicer	Furukawa FITEL	S123C, S153A, S178A
1-2	Holder for 900 μm coating diameter fiber	Furukawa FITEL	S712S-900
1-3	Holder for TOUCH Plus SC SOC	Furukawa FITEL	S712C-SGCH9-R
2	Fiber Cleaver	Furukawa FITEL	S325A, S326A
3	3-Hole Fiber Stripper	Furukawa FITEL	S211B
4	Scale	any	any
5	Marker (oil-based)	any	any
6	Cleaning paper	any	any
7	Ethanol	any	any

(3) Heating Parameter

Parameter for heater program on
 FITEL S123C, S153A or S178A for
 TOUCH Plus SC SOC splice
 protection sleeve

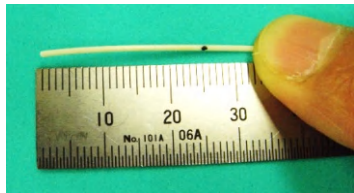
Heat Temp	180 deg C
Heat Time	60 sec.

2. Assembly Procedure

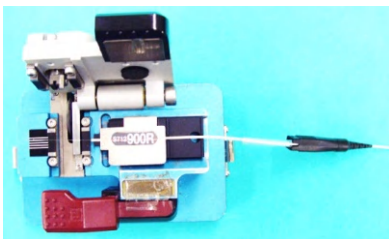
(1) Pick up Plug Frame Unit from package and put onto splice holder.



(4) Measure the length of buffer coating to be stripped and mark at 25mm.



(7) Cleave the fiber.



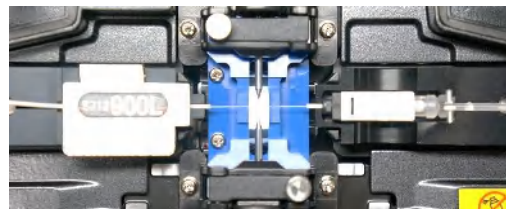
(2) Slide Boot Assembly onto buffer cord.



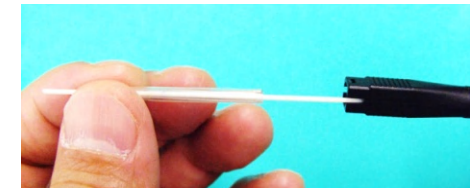
(5) Strip the coating of the buffer cord.



(8) Set holders on splice machine, and splice fibers.



(3) Slide Splice Protection Sleeve onto buffer cord.



(6) Put stripped buffer cord onto splice holder.



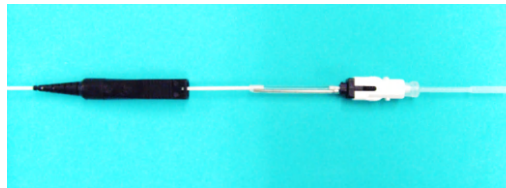
(9) Slide Splice Protection Sleeve to tail of Plug Frame Unit, and pick up spliced fiber cord.



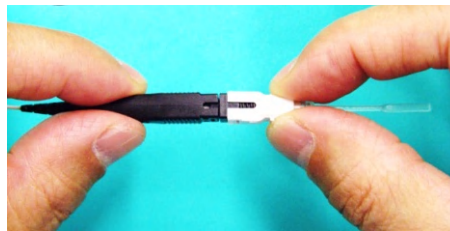
(10) Put spliced fiber cord onto heating stage. * Note



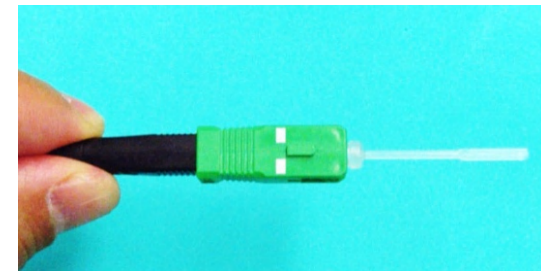
(11) Confirm heating of Splice Protection Sleeve was properly made.



(12) Slide Boot Assembly to Plug Frame Unit and twist it 90 degree to be fixed.



(13) Assembly completed !



*** Note : Please contact to Furukawa Electric/FITEL and their representatives for modification of heater on FITEL splice machine.**