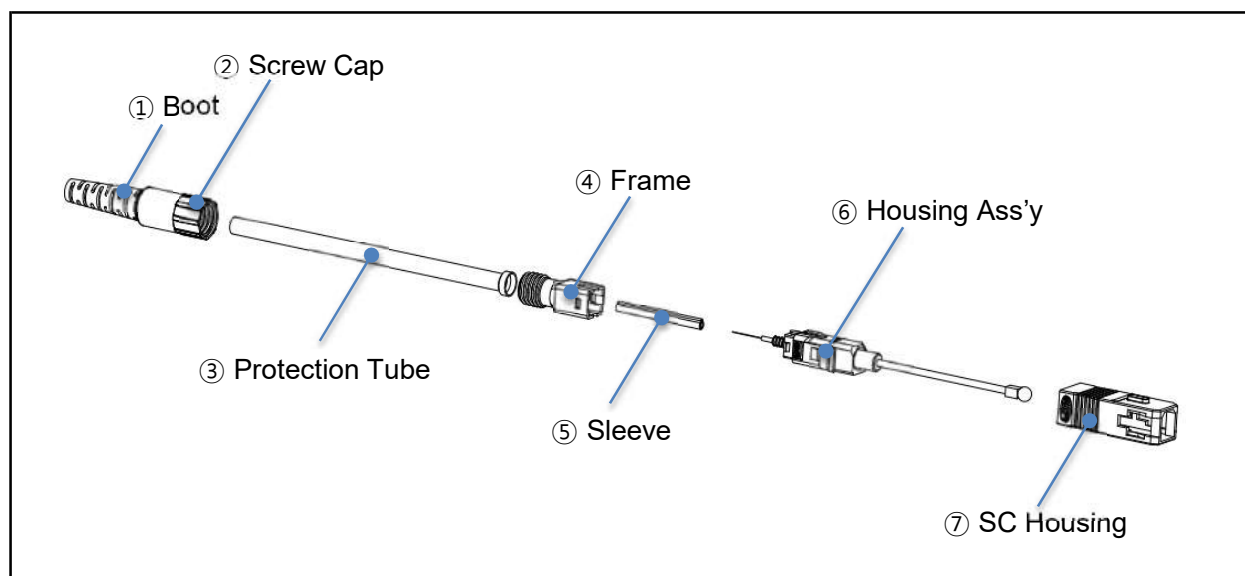## Contents

1. General
2. FSOC-D0-SC/UPC-25-30B Configuration
3. Assembly Tools
4. KF4A(Fusion Splicer) Setting
5. Installation

1. General

This installation guide provides procedures for assembling for FSOC-D0-SC/UPC-25-30B to 3.0mm indoor cable with KF4A All-In-One Fusion Splicer. A basic understanding of fiber handling, stripping, cleaning and splicing will be helpful.

2. FSOC-D0-SC/UPC-25-30B Configuration

3. Installation Tools

3.1 Tools for Cable Preparation

Cable Slitter (2.0/3.0mm)	Kevlar Shears (IDEAL 45-344)	Clothespin	Ruler
Marker		Cleaning Wipes	

3.2 Tools for Fusion Splicing (Stripping & Cleaving & Heating)

KF4A	Holder Left (HS-900)	Holder Right (HF4-SC/FC)

4. KF4A Setting

Depending on your cable, choose the appropriate settings for splice mode, stripper mode, and heater mode. When working with the FSOC-D0-SC/UPC-25-30B you may need to adjust settings depending on the machine's environmental conditions.

4.1 Splice Mode
- G.657.A2 to G.657.A2 : Setting – 12. G657 A2B2
- G.652.D to G.652.D : Setting – 1. SM ITU-T G652
- G.652.D to G.657.A2 : Setting – 18. G652-G657 A2B2

4.2 Heater Mode for HFSOC with 21mm Sleeve
- Setting – 10. S09-C 22x1.6x2.9
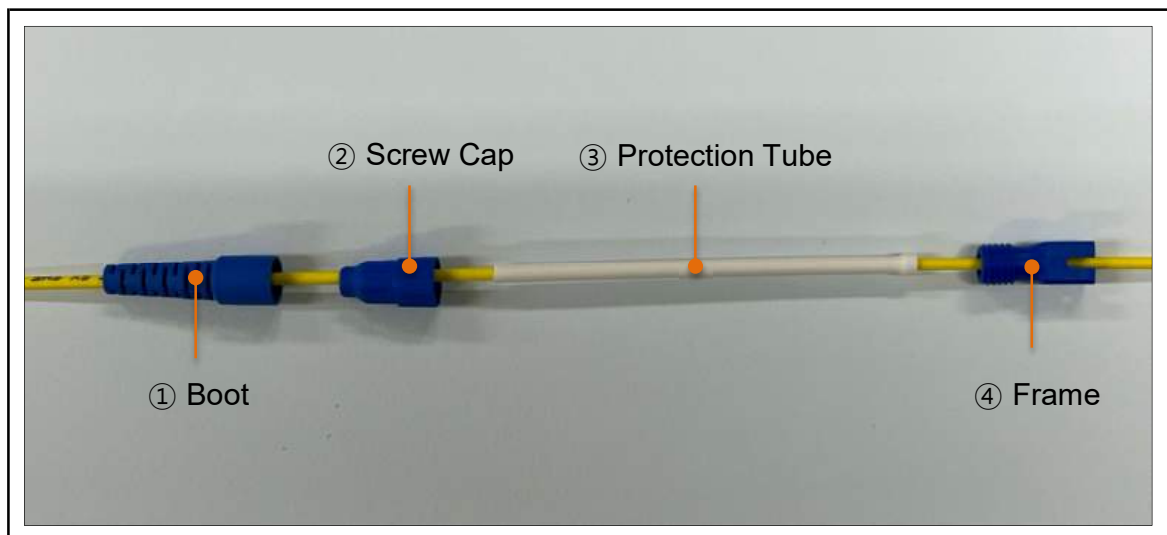- Detail - Heating Time : 40~60 seconds / Heat Temp. : 180~190 Degree

4.3 Stripper Mode
- Setting – 2. 0.9
- Detail - Stripping Time : 2 seconds / Stripping Temp. : 135 Degree

5. Installation Procedure
5.1 Cable(3.0mm) Preparation.
5.1.1 Insert components in order. First boot, screw cap, cable protection tube and frame.
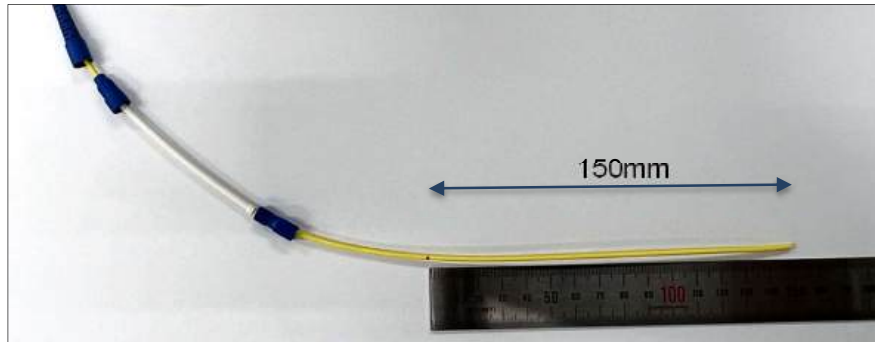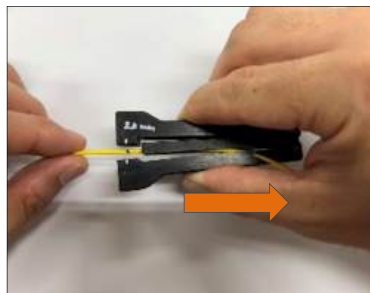

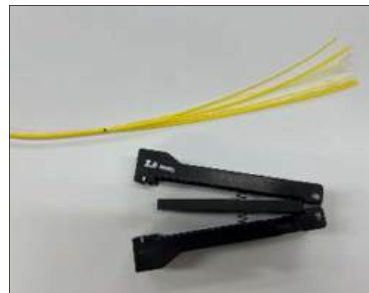② Screw Cap   ③ Protection Tube

① Boot   ④ Frame

5.1.2 Measure and mark 150mm from the end of the fiber cable using a ruler. Then use a cable slitter to separate the jacket from 150mm.
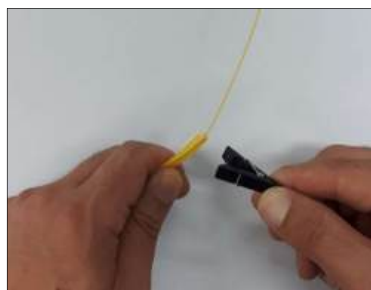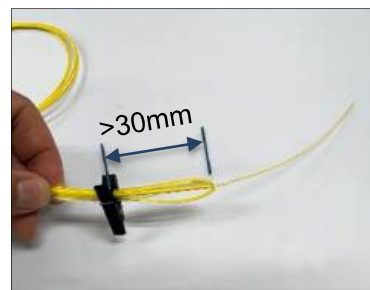

5.1.2a

5.1.2b

5.1.2c

5.1.3 Fix the split jacket and Kevlar using a clothespin as shown below.

[Tip] The fixed interval should be at least 30mm.

5.1.3a

5.1.3b

5.1.4 Place a mark on the cable jacket at 80 mm from the end. And Place a mark at 50mm and at 30mm. Then use the Kevlar shear to cut the 0.9mm fiber cable as shown below.
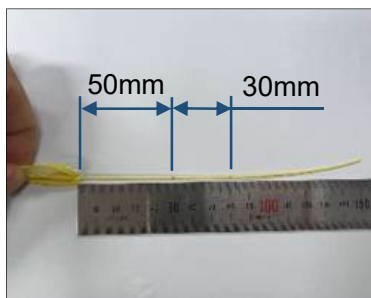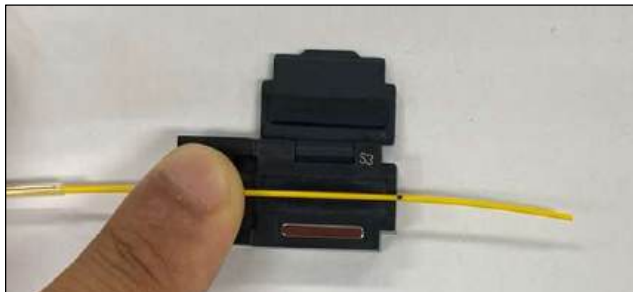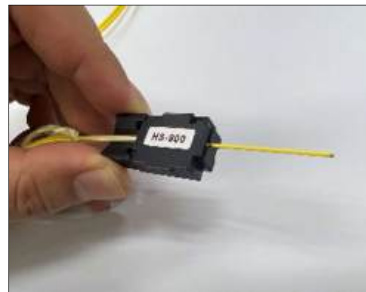

5.1.4a
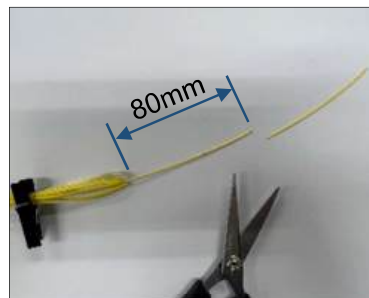
5.1.4b

5.1.5 Insert the sleeve and place the 0.9mm fiber in the holder (HS-900) as follows.

5.1.5a

5.1.5b

5.2 Fusion Splicing (Include Stripping and Cleaving)

5.2.1 Stripping

a. Turn on the power of stripper.

b. Mount the fiber holder to the auto-stripper. Make sure 0.9mm fiber should be placed on the center of heater.

c. Close left cover first then right cover. On closing right cover, stripping process is activated automatically.

d. After Stripping is completed, open the left cover.

e. Remove the holder sliding back not lift it up to avoid damage on the fiber.

f. When the right cover is opened, the left part returns to its original position. Use a brush to clean the blade and hot plate area.

5.2.2 Cleaving

a. Clean the optical fiber using an alcohol-soaked fiber wipe. Open the cover of the cleaver and trash bin. Mount the holder on the cleaver slot.

b. Close the covers and press the actuation button, and carefully remove the holder with sliding it back.
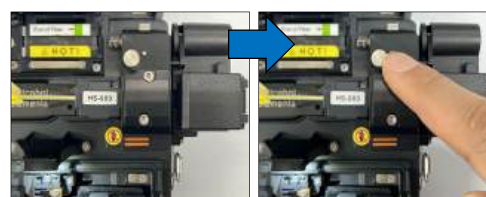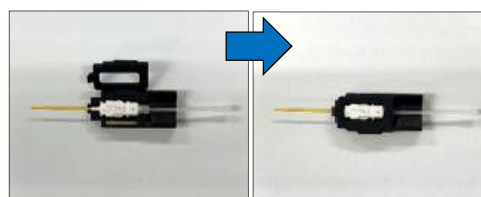
[Caution]
Lifting the holder after cleaving may damage the fiber.

c. Mount the fiber holder into the splicer. Fiber should be in the v-groove and fix the cable on the cable guide. (Close the left cover)

d. Please go through the same process for the subassembly. (Stripping to Cleaving)

e. Mount the subassembly holder into the splicer.

5.2.3 Splicing

a. Close the wind cover after ensuring
   that both holders are in place.
   When wind cover is closed,
   the splice will be executed automatically.

b. Splicer will pause for viewing of
   the splice parameters.

c. After successfully splicing, the splicer
   automatically performs a tensile test
   when the door of the splicer is opened.
   Please DO NOT interrupt this test.

d. Carefully open the holder cover,
   hold both sides and lift it up carefully.

   [Tip]
   **To prevent damage to the spliced
   fiber, open the left side covers while
   pressing(holding) the cable, and hold
   the ferrule cap while opening the
   right side holder cover.**

e. Slide sleeve over the splice carefully to
   the end of the subassembly.
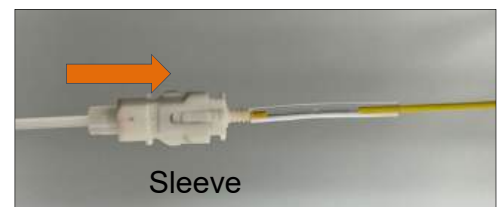
Sleeve

f. Open the heater cover. Locate the connector and sleeve area and place the sleeve within appropriate heating area. Close the right heater cover first, then the main heater cover.
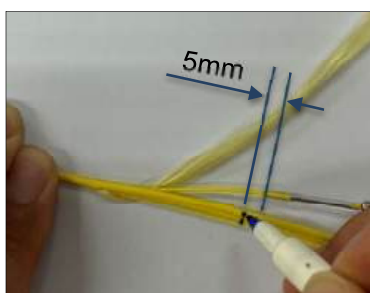If the auto heater function is on, it will run automatically. If not, press the heater button to run it.
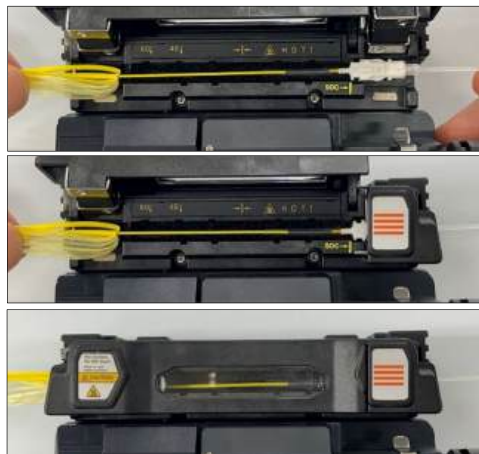
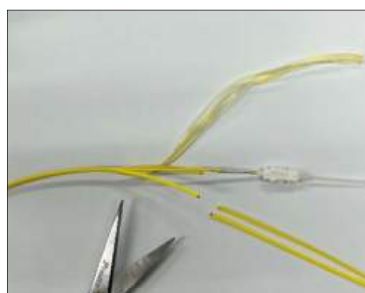g. Open the heater cover, hold both ends and lift straight off the heater.

5.3 Assembly with housing kit

5.3.1 Place a mark on the jacket at 5 mm from sleeve. Remove the jacket using Kevlar scissors.

5.3.1a

5.3.1b

5.3.2 Frame Assembly

: Slide the frame up to the housing ass'y with pulling out the 2mm jacket and kevlar carefully. Then assemble the frame with the housing ass'y.
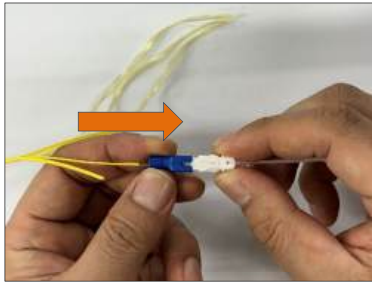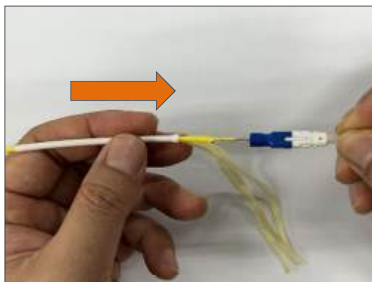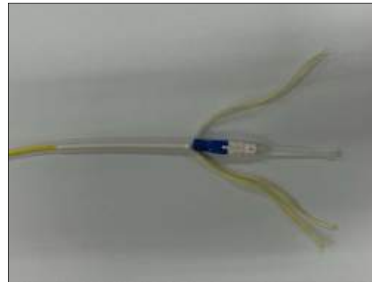

5.3.2a
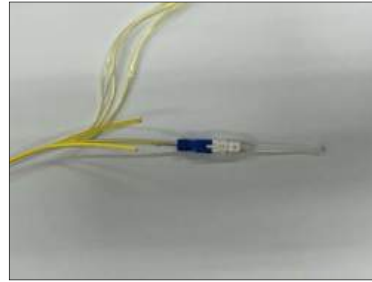
5.3.2b

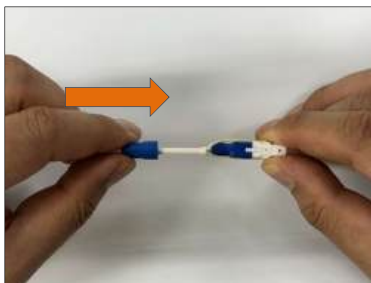### 5.3.3 Protection Tube Assembly
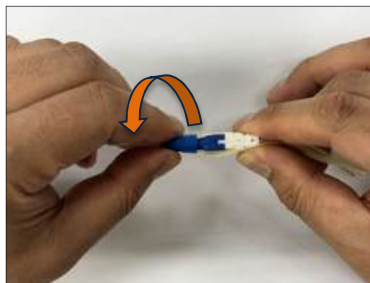
: Carefully Insert the protection tube.
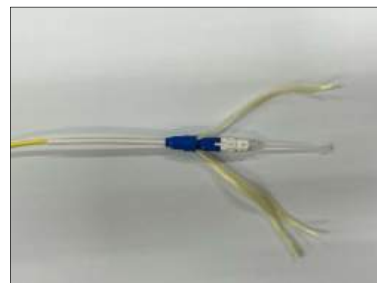

5.3.3a

5.3.3b

5.3.4 Housing Assembly

: Push up the screw cap and secure it firmly to the Housing ass'y.
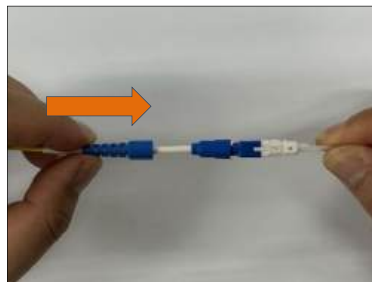

5.3.4a

5.3.4b

5.3.4c

: Finally, remove the aramid yarn using the Kevlar scissors.
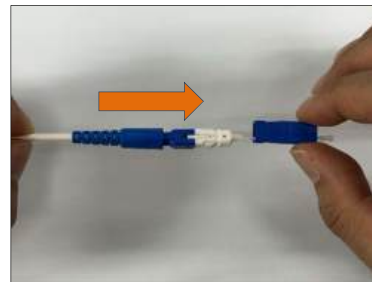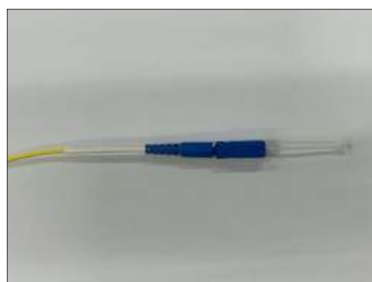Then assemble the boot and housing
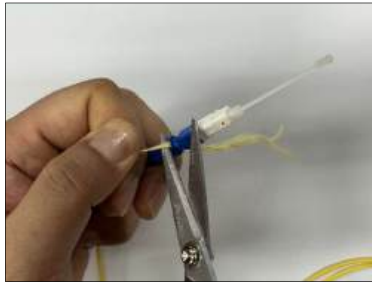
5.3.4d
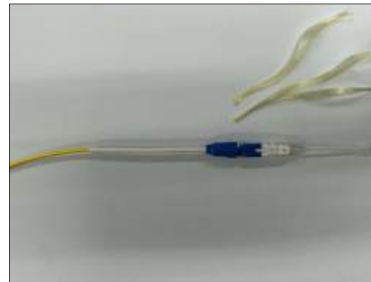
5.3.4e

5.3.4f

5.3.4g

5.3.4h

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