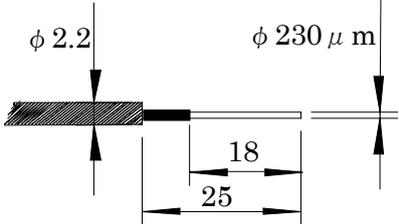
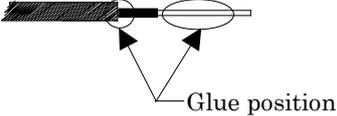
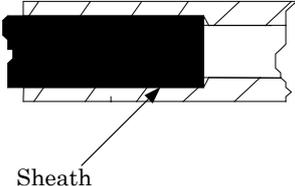
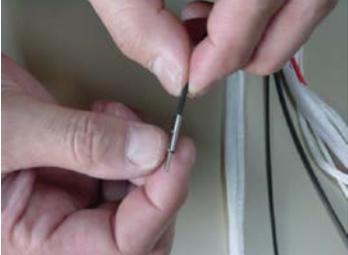
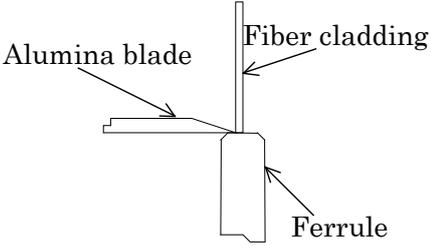
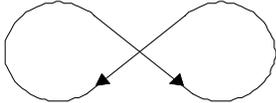
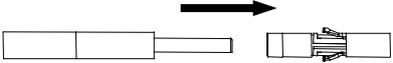
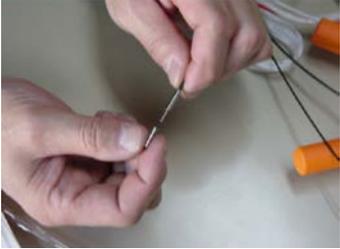


Trim Trio Optical Contact
Wiring Instruction Sheet for PCF

No.	Procedure	Notes
1	<p><u>STRIPPING THE FIBER CABLE</u></p> <p>1-1. Stripping the 2.2mm dia. external sheath Use fiber stripping pliers Ref. 80WD-0006. Insert the cable in the pliers jaws(No.16) at the required length (approximately 25mm) Tighten firmly and pull out the sheath.</p> <p>1-2. Cutting the kevlar After stripping the sheath, cut the kevlar with a cutter just where the external sheath was cut.</p> <p>1-3. Stripping the protective coating of the fiber Use stripping tool Ref. 80WD-0010 Adjust the stripping dia. 0.3mm and insert the cable in the tool jaws at the required length (approximately 18mm) Tighten firmly and pull out protective coating to strip the cable</p> 	<p>Be careful not to damage the fiber.</p>  <p>External sheath stripping</p>  <p>Cutting the kevlar</p>  <p>Protective coating stripping</p>

No.	Procedure	Notes
2	<p><u>BONDING OF THE FIBER</u></p> <p>2-1. Put some glue on the fiber. glue: Ref. 45LV(80WG0014)</p>  <p>2-2. Install the fiber in the contact until the 2.2mm dia. external sheath butts against the rear of the contact.</p>  <p>2-3. Put the whole assembly in the oven Ref. 80WT-0008. Start the 10 minutes clock. After 10 minutes, remove the cable from the oven and let it cool down.</p>	<p>In addition to the glue recommended here, any other glue which can be used for optical fibers is acceptable.</p>  <p>Install the fiber in the contact</p> <p>In addition to the oven recommended here, any other oven which can be used for optical fibers is acceptable.</p> <p>Be careful not to break the tip of optical fiber which comes out of the contact ferrule.</p> <p>If necessary, protect the tip of ferrule by using the rubber support Ref. 80WT0005</p>

No.	Procedure	Notes
3	<p><u>CUTTING THE FIBER</u></p> <p>3-1. Cut the fiber at the top of the glue dome with the alumina blade Ref. 80WC-0004.</p> <p>First, slice the fiber cross-wise by applying a moderate pressure on the fiber. The fiber should not break in any case.</p> <p>Then, pinch slightly the fiber with 2 fingers, and pull rapidly in the contact axis.</p>	<p>Be careful not to break the fiber with the blade.</p>  <p>Alumina blade</p> <p>Fiber cladding</p> <p>Ferrule</p>
4	<p><u>POLISHING THE OPTICAL FACE</u></p> <p>4-1. Use polishing plate Ref. 80WP-0005.</p> <p>This plexiglass polishing plate is maintained in place by six adhesive stops and is used as a plane support for the polishing disks. The plate should be clean, without splinters nor scratches disproportionate in size compared with the useful surface of the disk.</p> <p>Each time you want to use the polishing plate, clean it with paper and ethanol.</p> <p>4-2. Use polishing tool Ref. 80WP-0018</p> <p>This tool is used for polishing the face of the male and female contact end pieces.</p> <p>4-3. Use polishing disks</p> <ul style="list-style-type: none"> -COARSE 9 μ m (blue) Ref. 80WP-0014 -FINE 0.3 μ m (white) Ref. 80WP-0015 <p>These disks can be used for coarse and fine polishing of approximately 10 contacts.</p> <p>4-4. Polishing Operation</p> <p>Coarse polishing</p> <ul style="list-style-type: none"> -Install the 9 μ m polishing disk on the polishing plate. -Install the contact to be polished in the polishing tool. -Place the contact and polishing tool assembly on the polishing disk. -Exert a slight pressure on the tool and the contact and polish with a figure of eight motion. -Stop this operation as soon as black traces of metal appear on the paper (traces of abrasion of the end piece) and check the end piece visually. <p>Fine polishing</p> <ul style="list-style-type: none"> -Install the 0.3 μ m polishing disk on the polishing plate. -Install the contact to be polished in the polishing tool. -Place the contact and polishing tool assembly on the polishing disk. -Exert a slight pressure on the tool and the contact and polish with a figure of eight motion (between 20 and 30 motions). -Remove the contact and clean the end piece. 	<p>Remove the protective film from the plate front panel when first using after delivery.</p> <p>It is recommended not to replace the disk during finish polishing of a contact in order to keep its slightly finer grain.</p> <p>Cleaning the disk with ethanol after each use makes it possible to polish more contacts per disk.</p>  <p>Coarse polishing</p>  <p>Fine polishing</p>  <p>Figure of eight motion</p>

No.	Procedure	Notes
5	<p><u>INSPECTION</u></p> <p>Check the condition of the optical face with a microscope.</p> <p>The fiber should be free from splinters or big scratches.</p> <p>Male contact wiring is finished.</p> <p>For a female contact, go ahead to next process No.6.</p>	<p>Microscope</p> 
6	<p><u>ASSEMBLING THE FEMALE CONTACT</u></p> <p>6-1. Use press fit tool Ref. T-RCPF3H-01. Install the socket ferrule in the sleeve slightly by hand.</p>  <p style="text-align: center;">Socket Ferrule Sleeve</p>  <p>6-2. Install the contact on the tool as following figure, and tighten firmly.</p>  <p>6-2. Release the tool and remove the contact. Female contact wiring is finished.</p>	<p>Be careful not to deform contact clip during assembly operation.</p>
7	<p><u>OTHERS</u></p> <p>7-1. Avoid water, oil, and dust before mating connectors.</p> <p>7-2. If pin contact is bent or a foreign body is fitted over the inside of socket contact, it cannot mate correctly.</p> <p>7-3. Storage conditions</p> <p style="padding-left: 40px;">Temperature :Less than 30°C</p> <p style="padding-left: 40px;">Humidity :Less than 60%</p>	