

Quick Guide for IMT ST, SC & SP Connectors Mounting Procedures

rev.20060721

(For preparation of 250 μ buffer fiber mounting - insert into fan-out tubing and cut fiber even with the tubing)

STEP # 1

Slide appropriate boot/s (and Kevlar crimp sleeve for Kevlar cable mounting) onto the fiber (or 3mm patchcord cable.)

STEP # 2

(Buffer stripping)

Strip buffer = 1/4" min. to 3/8" max.

- For 900 μ & 250 μ buffer fiber in fan-out tubing.
- Or
- For cable mounting, **PRIOR** to stripping buffer -
 - **First strip cable jacket** as follows:
1 5/8" for ST & 1 1/2" for SC
 - Cut Kevlar strength members to 1/2" in length.

STEP # 3

Thread fiber through connector as far as it will go. Clean any residue on fiber to facilitate threading.

STEP # 4

(Buffer crimping)

Crimp the back of the connector to the buffer using appropriate die hole marked for 900 μ or 250 μ buffer fiber in fan-out tubing respectively.

STEP # 5

(Impact Mounting)

- Using the Hand Tool, place the **ST, SC or SP Insert** onto the rails (use a screwdriver to secure **Insert**).
- Lay the connector firmly on top of the insert,
- Slide the alignment block forward to the connector ferrule.
- Impact mount using the handle. (A "click" sound will be heard.)

STEP # 6

(Hand cleaving)

Place the blade parallel to the surface of the connector tip and cleave at the very base of the fiber. Then bend the fiber with the blade for a clean break-off.

Caution!

Dispose all fibers safely. Glass fibers are harmful to your health.

STEP # 7

(For Kevlar mounting only)

Pull Kevlar strength members and crimp sleeve up towards the back of the connector.

STEP # 8

(For Kevlar crimping only)

Using the Kevlar crimp tool, crimp Kevlar sleeve to the back of the connector using #ST or #SC die hole. Then crimp the sleeve to the cable jacket using #JJ die hole.

STEP # 9

Slide strain relief boot/s in place over the back of connector.

STEP # 10

(For SC connector only)

Install SC component parts together with correct alignment.

STEP # 11

(Hand polishing)

- First remove any rough edges by hand polish in the air with 12 μ paper 2 to 3+ times.
- Then using a polishing puck (ST or SC/SP), polish fiber surface with a 3 μ paper about 10 times. First polish gently, then **gradually increase pressure**.
- Finish gently with 0.3 μ paper for another 10 times.

Repolish a little more if necessary to achieve desirable result.

Use a figure 8 motion and a diameter of 4" for all polishing for best results.

DO NOT overpolish: too much polishing will remove the impacted connector tip and fiber will loosen up.

Additional Tips

- * **STEP # 1** - It is recommended to use both small and big strain relief boots for buffer fiber mounting for additional support.
- * **STEP # 2** - Make sure the transparent buffer is completely stripped to avoid threading problem.
- * **STEP # 4 & 8** - Make sure to squeeze handles of crimp tool to close completely for full force. (This may go beyond the ratchet release.)
- * **STEP # 5** - **Clean driver cone** frequently for proper function.
- * For **250 μ buffer fiber** – **fan-out tubing is required.**

SEE PICTURE NEXT PAGE

IMT HAND TOOL

INSERT



CONNECTOR

SCREW

ALIGNMENT
BLOCK

HANDLE

