

# Installation Instructions

## FITEL Splice-On Connectors

**1. Open and remove the contents of the vial. Each kit consists of one each of the following (FIT-SCOM3SOC shown):**

- A. Universal dust cap with extension handle (to aid in transfer into SOC holder, use optional)
- B. Outer housing (SC style shown, all versions may not contain a separate outer housing)
- C. Splice-On Connector (SOC) pigtail with cleave protector (may include fiber alignment sleeve)
- D. 25mm mini splice sleeve
- E. Strain relief boot

(Note: The SC & LC version may contain clear Fiber Alignment Sleeve for packaging and to alleviate typical 900 $\mu$ m fiber curl. If fiber alignment sleeve has become separated from the Splice on Connector body during transit do not attempt to re-install, disregard and continue the process)



**2. Remove the factory dust cap from the connector.**

(Note: The extended dust cap may be placed on at this time, if so desired, to aid in the transfer of the connector into SOC holder. **DO NOT USE THE EXTENDED DUST CAP WITH LC CONNECTORS WHEN PLACING IN SOC HOLDER AS IT MAY AFFECT FIBER ALIGNMENT.** Remove extended dust cap once connector is placed in splicer.)

**3. While holding the connector firmly, pull down on the cleave protector to remove it from the connector (Figure 1).**

(Note: Do not touch the cleaved fiber stub with the protector or your fingers as this may damage the pre-cleaved end.)

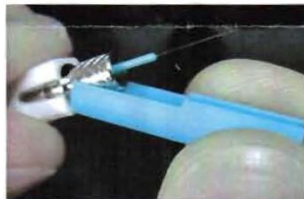


Figure 1

**4. Insert the connector into the Universal Splice-On Connector Holder (P/N S712C-FITSOC) so that the back end of the connector is flush with the end of the holder (Figure 2-5). Once aligned properly, the connector should fit into the holder with no force required.**

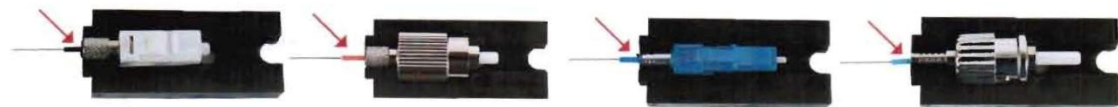


Figure 2 (SC)

Figure 3 (FC)

Figure 4 (LC)

Figure 5 (ST)

**5. Insert the holder into the right hand side of the splicer (Figure 6), being sure that the fiber stub lays properly into the v-groove block of the splicer (Figure 7). (Note: Do not touch the cleaved fiber stub with the protector or your fingers as this may damage the pre-cleaved end.)**

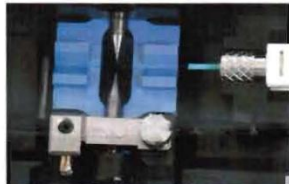


Figure 6



Figure 7

**6. Slide the 900 $\mu$ m strain relief boot and the 25mm mini splice sleeve onto the 900 $\mu$ m field fiber. Strip, clean, and cleave the field fiber to a 10mm cleave length and insert into the left hand side of the fusion splicer.**

7. Perform the fusion splice as described in the splicer instructions.

8. Once the fusion splicing cycle is completed, remove the connector from the splicer and slide up the splice protection sleeve to cover the splice. An equal amount of the sleeve should cover the buffer on either side of the splice.

**9. Transfer the splice to the heat oven**

(Note: After splice is complete remove connector and SOC holder (P/N s712-FITSOC) together. Gently slide the 25mm mini splice sleeve over the exposed bare fiber/splice area and place in the OFS SOC specified splice sleeve oven. Close door over splice protection sleeve and push heat cycle button (See directions on SOC heat oven for further instructions.)



Figure 9: Splice Sleeve Aligned in Oven

10. After the heat cycle is completed, remove the assembly from the oven. Verify splice protection sleeve is completely shrunk onto fiber to avoid the end catching while installing on the strain relief boot. (Warning: The connector body may be hot, use proper handling techniques) If not completely shrunk place back in oven for another heat cycle. Make sure that the splice sleeve has fully cooled before sliding the strain relief boot into place. For SC connectors, install the outer housing onto the connector, being sure to align the angled corners of the inner housing with those of the outer housing (Figure 11).



SC Connector



Figure 11