

CORNING

SC/APC Connectors Termination Procedure

Series: 728

C	Update address and fax number	10/26/18
B	Initial Release	11/2/09
Version	Revision History Summary	Issue Date

**SERIES 728
SC/APC CONNECTORS
TERMINATION PROCEDURE**

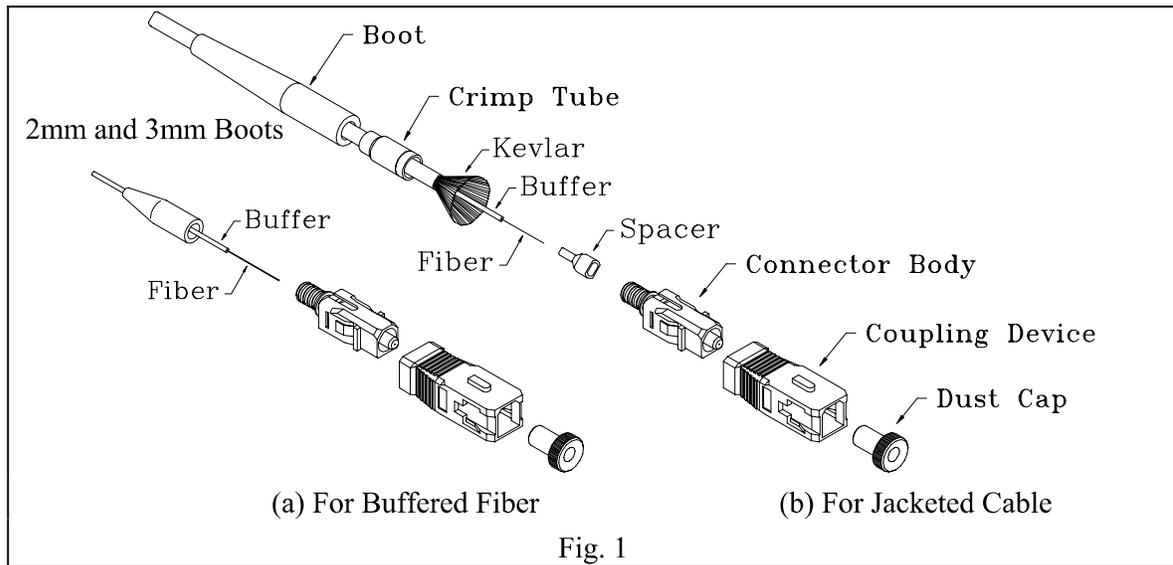


I INTRODUCTION

This termination procedure is for SC/APC 728 Connectors. Please read this procedure thoroughly before starting assembly.

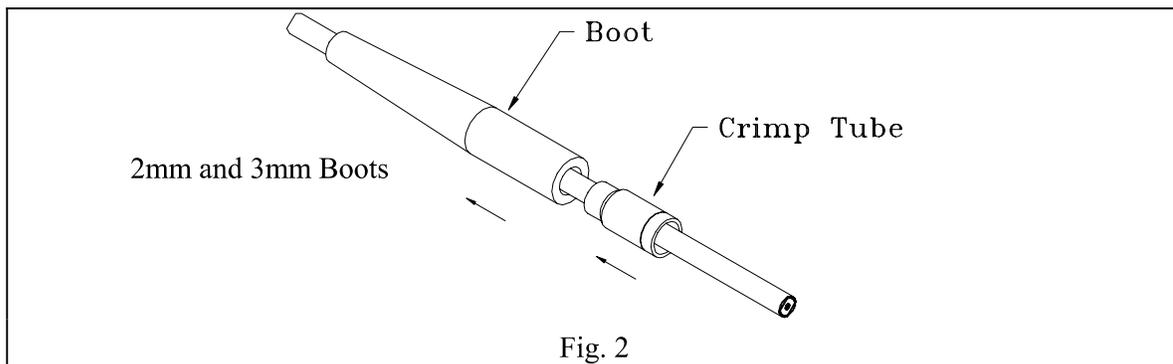
II DESCRIPTION

Fig. 1 shows the structure of Series 728 SC/APC connector, which consists of Coupling Device, Connector Body, Crimp Tube, Boot, Dust Cap, Ferrule Body and Spacer. Follow the following steps to make cable assembly.



Step 1 Slide Boot, Crimp Tube onto the cable shown in Fig. 2.

Note: In case of Buffered Fiber, do not use Crimp Tube Spacer and Boot. Use Rubber Boot instead.



Step 2 Use Jacket Stripper to cut cable jacket and Kevlar. See Fig. 3 for correct dimensions.

Note: In case of Buffered Fiber termination, skip this step.

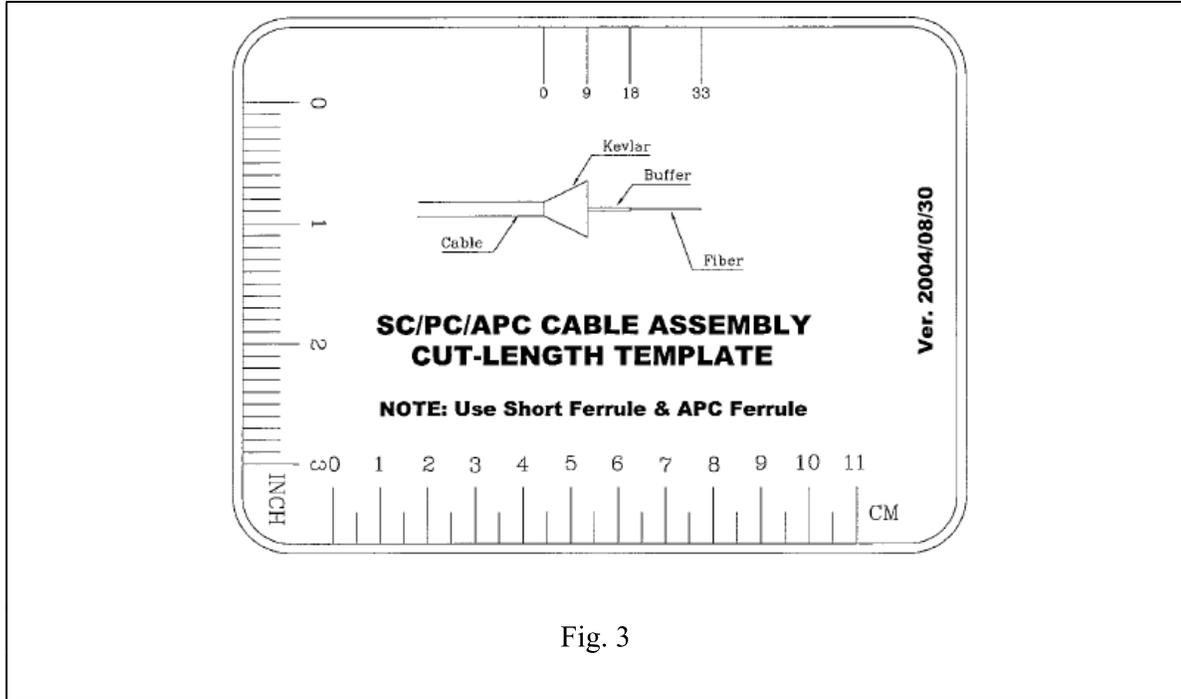


Fig. 3

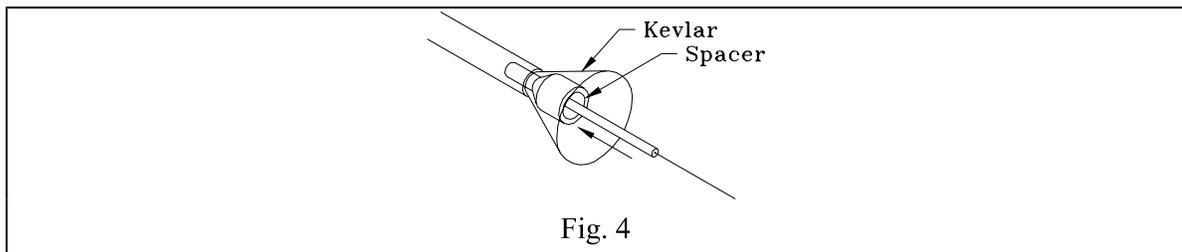


Fig. 4

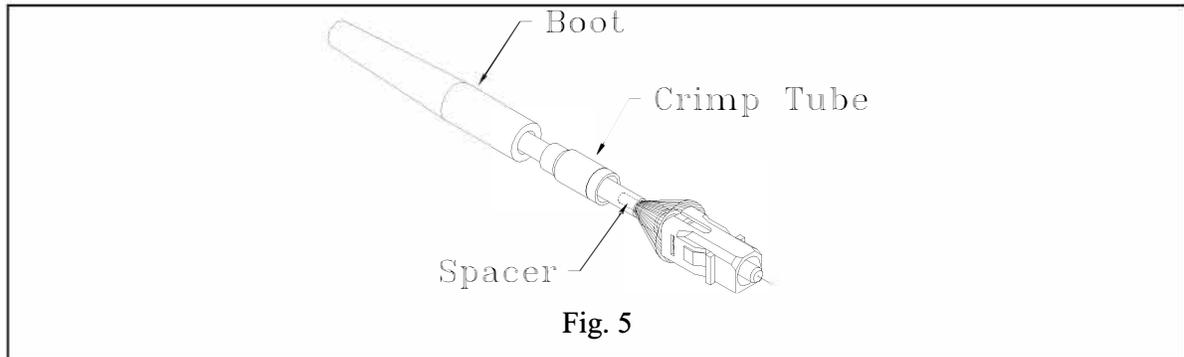
Step 3 Insert the Spacer carefully onto the buffer of cable and push the Spacer all the way until it is stopped by the jacket, shown in Fig. 4.

Note: In case of Buffered Fiber termination, skip this step.

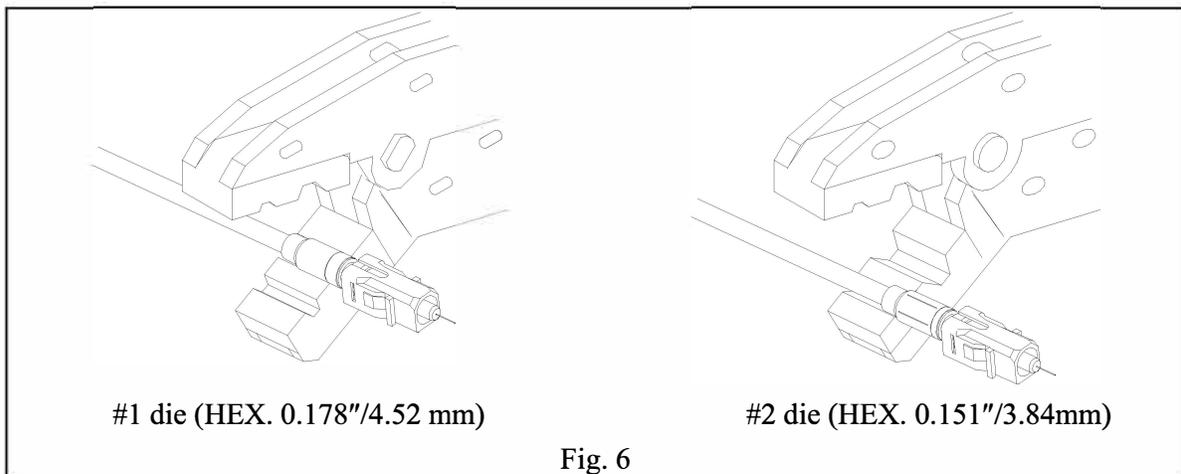
Step 4 Use Buffer Stripper to remove the require length of buffer and use alcohol and lens wiper to clean the bare fiber. See Fig. 3 for correct dimensions.

Step 5 Apply a couple drops of the prepared epoxy into the Connector Body with syringe or needle.

Step 6 Insert bare fiber carefully into the epoxy-filled connector. Slightly rotating the connector will help the fiber to get through the ferrule. Slide the fiber gently in and out of ferrule to form the epoxy bead at the end of ferrule. Or, apply a drop of epoxy on the tip of ferrule to form the epoxy bead.



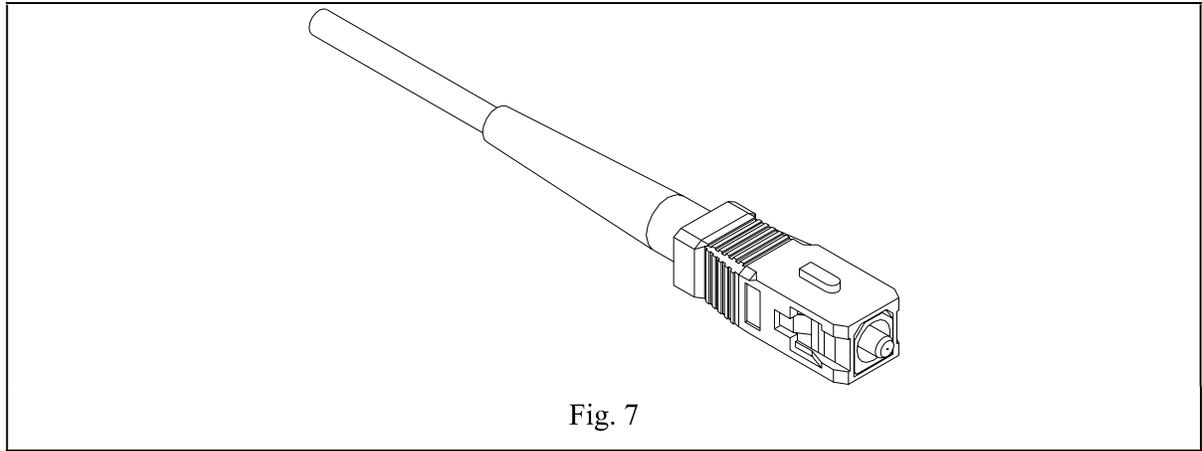
Step 7 Slide crimp tube over Kevlar and connector body. Crimp the tube twice with the crimping tool. (See Fig. 6) Crimp the large end tube with #1 die first and small end tube with #2 die later.



Note: (a) In case of Buffered Fiber termination, skip this step.

(b) #2 die is HEX 0.128"/3.25mm when a 2mm Crimp tube is applied.

Step 8 Slide the boot over the crimped tube as shown in Fig. 7.



Step 9 Carefully mount the connector onto the curing fixture. Place the connector into curing oven to cure epoxy.

Step 10 Remove the fixture from the connector after epoxy is fully cured. Use a fiber scribe to score the protruded fiber slightly at the point where the fiber and epoxy bead meet. Gently push the tip of fiber until the fiber separates.

Note: (a) Do not break the fiber directly when the fiber is scored.

(b) Fiber shall be scored again if fiber is not break by light push on the tip of fiber.

Step 11 Setup APC polishing machine. Then, (a) Remove epoxy, (b) Rough polishing, (c) Medium polishing, (d) Final polishing.

Note: Polishing Machine manufacturers offer different polishing procedures. Please refer to polishing machine manuals for proper polishing process.

Step 12 Clean connector and use microscope to inspect the end surface of the connector.