SC and FC3 Epoxy Connectors

Instructions for 6202, 6306, 8202, 8203, 8204, 8305, 8306, 8307

Mounting – Jacketed

1. Slide boot and crimp ring onto cable.
   - Use black crimp ring for 3.0 mm cable.
   - Use red crimp ring for 2.4 mm cable.
2. Cut and remove 1-3/16" (30 mm) of jacket.
3. Cut Kevlar™ fibers to 5/16" (8 mm) length, flare and fold back.
4. Seat stripping collar (round, blue) with large opening over jacket.
5. Strip fiber with modified No-Nik tool.
6. Clean with isopropyl alcohol** and lint-free cloth.
7. Install load adapter (SC or FC) onto connector.
8. Epoxy (8692): mix, load, wipe, inject with mint green tip to form bead.
9. Insert fiber into connector.

Note: ***When the buffer bottoms, the jacket end is 1/16" (1.6 mm) from connector.***

10. Kevlar extends forward over ribbed back end.
11. Slide crimp ring over ribs, capturing Kevlar fibers.
12. Crimp crimp ring to connector and cable.
    - Use .190 cavity for Kevlar fibers and connector.
    - Use .137 cavity for 3.0 mm cable.
    - Use .120 cavity for 2.4 mm cable.
13. Apply thin band of epoxy to **smaller section** of crimp ring.
14. Slide boot forward and rotate.
15. For SC, align boot with key side to smooth side.
16. Place connector and load adapter in oven for 20 minutes.
17. Cool in rack for 5 minutes.

Mounting – 900 µm Buffer

1. Mark strain relief tube 3/16" (5 mm) from end.
2. Crimp black crimp ring at mark using .137 cavity.
3. Slide boot and strain relief tube with crimp ring onto cable.
4. Strip off 5/8" (16 mm) of buffer.
5. Clean with isopropyl alcohol** and lint-free cloth.
6. Install load adapter (SC or FC) onto connector.
7. Epoxy (8692)**: mix, load, wipe, inject with mint green tip to form bead.
8. Insert fiber into connector.
9. Crimp crimp ring to connector with .190 cavity.
10. Apply thin band of epoxy to **smaller section** of crimp ring.
11. Slide boot forward and rotate.
12. For SC, align boot with key side to smooth side.
13. Place connector and load adapter in oven for 20 minutes.
14. Cool in rack for 5 minutes.

Note:** ***Carefully follow safety, health and environmental information on container label or Material Safety Data Sheet for isopropyl alcohol and 8692 Epoxy being used.

Polishing

1. Remove load adapter, score fiber with flat carbide blade and pull fiber straight up to detach. Shorten fiber by hand polishing with brown polishing film if necessary.
2. Perform 5 µm polish (brown film) using soft rubber pad. **Do not** remove all epoxy.
3. Place 1 µm green film on top of 5 µm film. Add water and polish to remove all epoxy.
4. Clean connector and inspect. For SC, install housing.

Note: ***For complete details on connector terminating and polishing process for -40 dB reflections, refer to the instruction manual Epoxy SC and FC/PC3 Connectors.***

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