

1 OBJECTIVE

This work instruction details the procedure for termination of the J-Tech 29504 contacts, styles 1 and 2

2 SCOPE

This work instruction applies to all parties in possession of J-Tech 29504 Termini.

3 MATERIAL & EQUIPMENT

- 3.1 Epoxy
- 3.2 Curing Oven
- 3.3 Fiber
- 3.4 Fiber Strippers

4 PROCEDURE

Style 1 Termination Steps

1. Install terminus heat shrink sleeve onto jacketed fiber.
2. Strip cable Jacket and cut strength member to specified length (See figures 1 and 2 for recommendations).
3. Strip buffer off fiber to specified length (see fig. 1 and 2).
4. Mix and fill syringe with epoxy or defrost frozen epoxy (Recommended EPO-TEK 353 ND see manufacturer's instructions).
5. Completely fill termini with epoxy ensuring epoxy fills the ceramic (look for small bead on end) as well as the termini body.
6. Clean fiber with isopropyl alcohol.
7. Slide fiber into termini. It may necessary to rotate termini slightly to get fiber into the ceramic.
8. Evenly dress the strength member over the thinner rear of termini.
9. Slide heat shrink sleeve into position and apply heat gun.
10. Place termini in curing unit until epoxy is fully cured (refer to manufacturer's epoxy data sheet).
11. Cleave the excess fiber from termini tip with fiber cleave.
12. Polish end-face per local standards.
13. Before installing hood assembly to the socket contacts place a small amount of Loctite (222 MS recommended) on the threads of socket terminus.



Style 1 Socket Termination

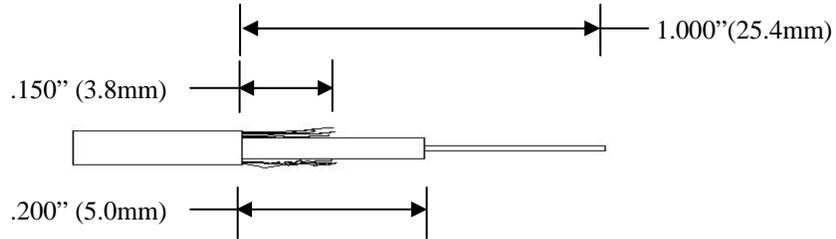


Figure 1: Style 1 Socket Terminus Strip Lengths

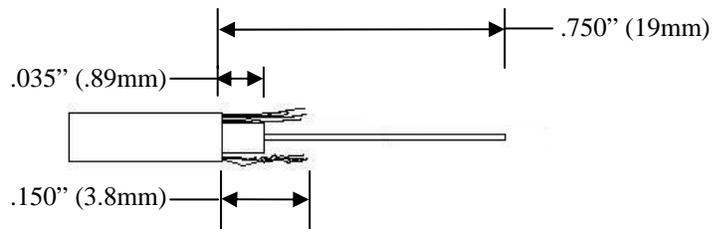


Figure 2: Style 1 Pin Terminus Strip Lengths

Style 2 Termination Steps

1. Strip cable Jacket and cut strength member to specified length (See figures 3 and 4 for recommendations).
2. Strip buffer off fiber
3. Mix and fill syringe with epoxy or defrost frozen epoxy (Recommended EPO-TEK 353 ND, see manufacturer's instructions).
4. Completely fill termini with epoxy ensuring epoxy fills the ceramic (look for bead on end) as well as the termini body.
5. Clean fiber with isopropyl alcohol.
6. Slide fiber into termini. It may necessary to rotate termini slight to get fiber into the ceramic.
7. Slide termini onto fiber, slightly rotate fiber if there some resistance.
8. Place termini in curing unit until epoxy is fully cured (refer to manufacturer's epoxy data sheet).
9. Cleave the excess fiber from termini tip with fiber cleave.
10. Polish end-face per local standards.
11. Before installing the hood assembly onto the socket contacts place a small amount of Loctite (222 MS recommended) on the threads of socket terminus.



Style 2 Socket Termination

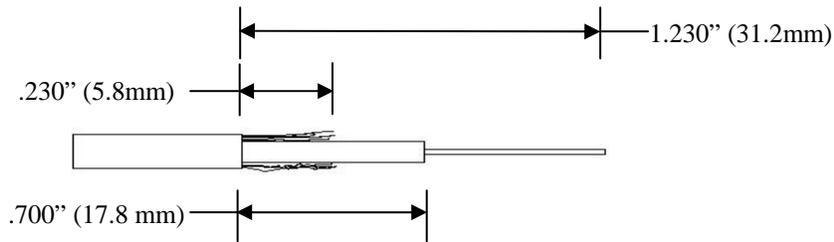


Figure 3: Style 2 Socket Terminus Strip Lengths

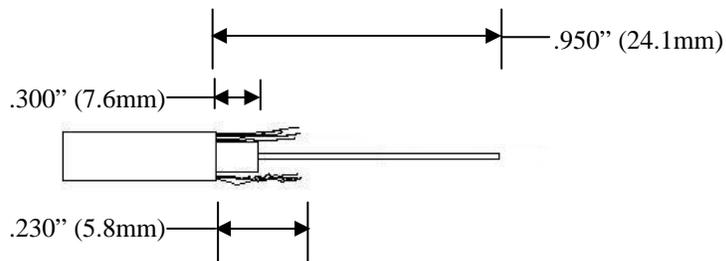


Figure 4: Style 2 Pin Terminus Strip Lengths

Quality Work Instruction

Work Instruction Name: 29504 Termination Procedure
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Work Instruction No.: QW75-310
 Revision: -

Revision History

Rev	Date	Description of Change	Approved Mfg Engineering	Approved Mfg Manager	Approved Engineering	Approved Quality Mgr.
-	5-22-07	Release	Chad Eichele	Randy Davidson	Chris Roe	Clair Seif
A	5-30-07	Modify strip length recommendations	Chad Eichele	Randy Davidson	Chris Roe	Clair Seif