

3M™ Hot Melt Fiber Optic Connectors ST, SC and FC

Instructions

June 2011
78-8073-7873-8-E

3M

Contents

1.0 Safety and Helpful Hints 3

2.0 3M™ Field Termination Kit Contents 4

3.0 3M™ Hot Melt ST Connector 900 µm Buffered Fiber 6

4.0 3M™ Hot Melt ST Connector 3 mm Jacketed Cable 8

5.0 3M™ Hot Melt SC Connector 900 µm Buffered Fiber 10

6.0 3M™ Hot Melt SC Connector 3 mm Jacketed Cable 12

7.0 3M™ Hot Melt FC Connector 900 µm Buffered Fiber 14

8.0 3M™ Hot Melt FC Connector 3 mm Jacketed Cable 16

9.0 Scribing 18

10.0 Multimode Polishing: Hot Melt 19

11.0 Singlemode Polishing: Hot Melt 21

13.0 Finishing 24

14.0 Field Termination Kit Replacement Part Numbers 25

1.0 Safety and Helpful Hints

Use reagent grade isopropyl alcohol that is 99% pure to clean the fibers and other components. When terminating connectors on any cable containing grease, ensure that all grease is wiped away and the buffer, coating, and fiber are thoroughly cleaned with isopropyl alcohol. Isopropyl alcohol is not shipped with the 3M™ Field Termination Kits; however, a bottle for the alcohol is included.

Note: Carefully follow safety, health and environmental information given on the container label or the Material Safety Data Sheet for the isopropyl alcohol and 3M™ Pronto™ Instant Adhesive, CA-8.

⚠ CAUTION

Hot Surface. The metal block in the Hot Melt Oven is heated to approximately 482°F (250°C). Do not touch. Do not cover. Use only with original 3M™ accessories.

Note: Flashpoint of the Hot Melt glue is 520°F (271°C).

⚠ WARNING

- Safety glasses should be worn when working with optical fibers.
- Do not view fiber ends if they are illuminated with a laser.
- Keep oven clear from flammable material.
- Disconnect power supply when cleaning.

3M™ Hot Melt Oven Safety

Safety Information

This hot melt connector oven is intended for melting hot melt adhesive in 3M™ Hot Melt Connectors. It has been designed and tested for use only with the 3M™ Fiber Optic Connectors System. Other uses of this product may lead to poor performance or an unsafe condition.

⚠ WARNING

1. Power cord must be grounded and plugged into a grounded outlet.
2. Eye hazard. Do not view fiber ends if they are laser illuminated as eye damage may result. Illuminate fiber ends with white light only.
3. Wear safety glasses.
4. No serviceable parts - return unit to the manufacturer for servicing.
5. For indoor use only.
6. To avoid possible environmental contamination, dispose of the unit in accordance with applicable governmental regulations.
7. Avoid touching hot surfaces.
8. Avoid using unit near flammable materials.
9. When in use locate the unit where it can easily be unplugged.
10. The unit shall be cool before cleaning, and there shall be no flammable cleaning fluids used.

Cooling and Cleaning

The device shall be cooled down before cleaned and there shall be no easily flammable cleansing liquids used.

Explanation of symbols:

⚠ Warning - Refer to accompanying documents.

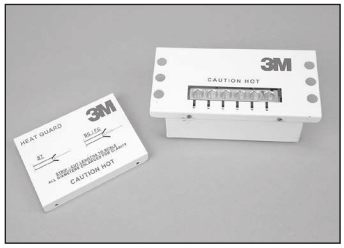
⚠ Caution - Risk of electric shock. Refer all servicing to manufacturer.

⚠ Caution - Hot Surface. The metal block in the Hot Melt Oven is heated to approximately 482°F (250°C). Do not touch. Do not cover. Use only with original 3M™ Accessories. ***Note: Flashpoint of the Hot Melt glue is 520°F (271°C).***

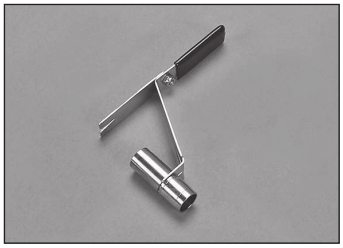
2.0 3M™ Field Termination Kit Contents



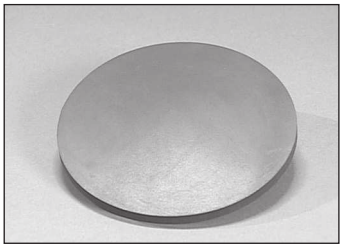
2.1 Carrying Case, 1 ea.



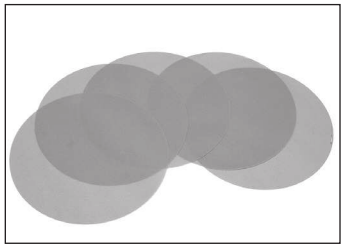
2.2 3M™ Hot Melt Oven 6312 (120 V) or 6323 (230 V) with heat guard, 1 ea.



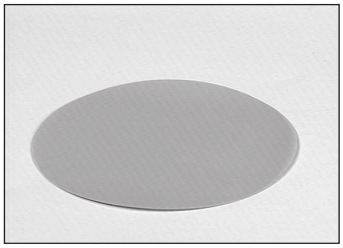
2.3 3M™ Universal Connector Holder 6365-HH, 6 ea.



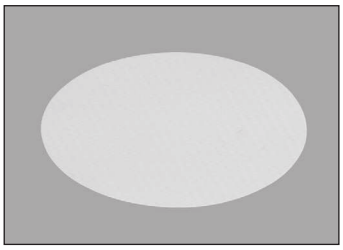
2.4 3M™ Polishing Pad 6365-PP, 2 ea



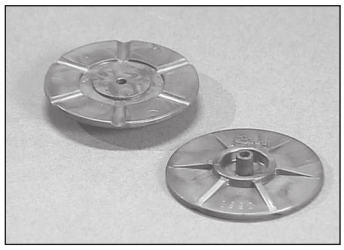
2.5 3M™ Lapping Film 9 µm (gray), 10 sheets.



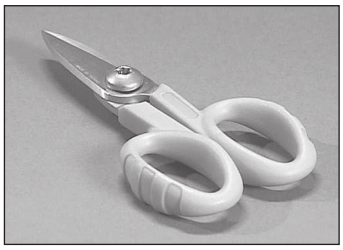
2.6 3M™ Lapping Film 2µm (pale green), 50 sheets



2.7 3M™ Final Polish Film 0.05µm (frost white), 20 sheets



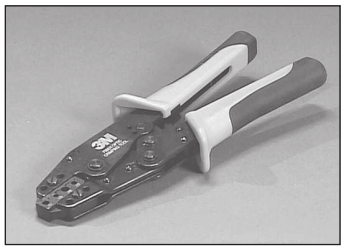
2.8 3M™ Polishing Jig 8892, 2 ea.



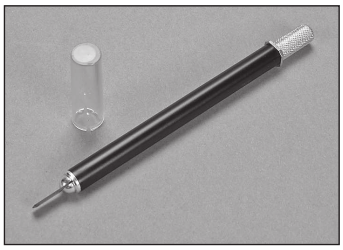
2.9 3M™ Aramid Yarn Snips 6365-KS, 1 ea.



2.10 3M™ Stripping Tool 6362-TH, 1 ea.



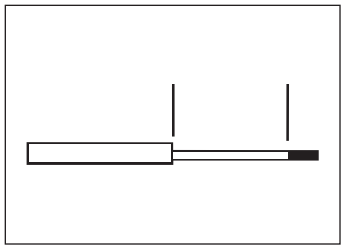
2.11 3M™ Crimp Tool 6365-CT, 1 ea.



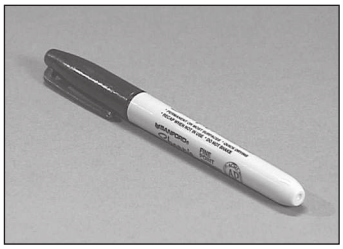
2.12 3M™ Fiber Scribe 6365-FS, 1 ea.



2.13 3M™ View Scope 6365-VS, 1 ea.



2.14 Strip Templates, 1 ea.



2.15 Fiber Marking Pen, 1 ea.



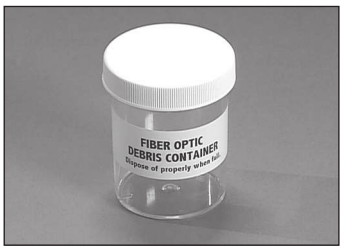
2.16 3M™ Pronto™ Instant Adhesive, CA-8, 1 ea.



2.17 3M™ Lint-Free Cloths 6366-CW, 100 pcs.



2.18 Alcohol and Water Bottles (shipped empty), 1 ea.

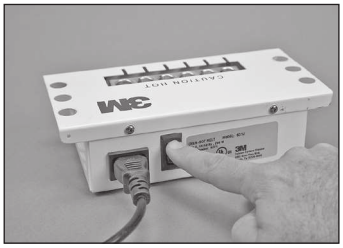


2.19 Fiber Scrap Can, 1 ea.

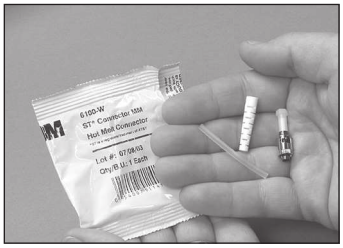


2.20 Training CD Rom, 1 ea.

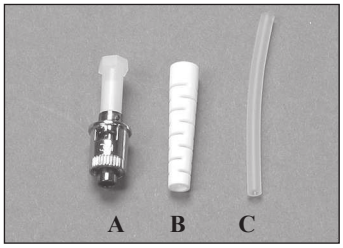
3.0 3M™ Hot Melt ST Connector 900 µm Buffered Fiber



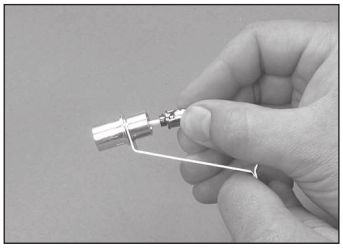
3.1 Plug in the 120V or 230V power cord. Turn on the 3M™ Hot Melt Oven. The oven requires six minutes to warm up.



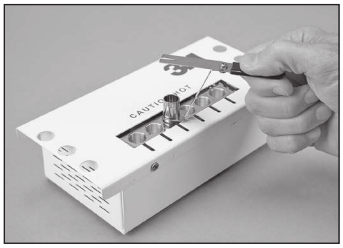
3.2 Open the connector package and remove components.



3.3 Each connector package contains a connector (A), strain relief boot (B), and clear strain relief tube (C).

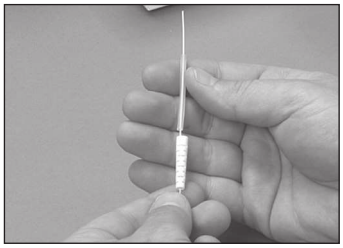


3.4 Load ST Connector into the shorter end of the 3M™ Universal Connector Holder.



3.5 Place the connector holder into an available port in the oven.

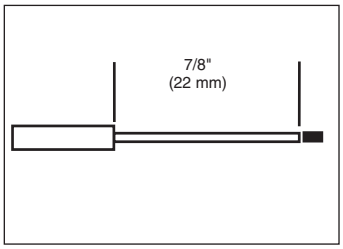
Note: The hot melt connector should be in the oven for at least 60 seconds. The connector should not be in the oven longer than five minutes.



3.6 Place the strain relief boot and clear strain relief tube on the buffered fiber, as shown.



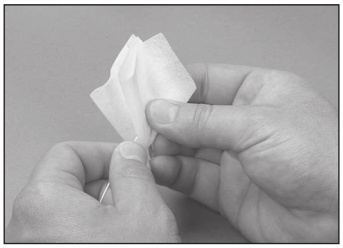
3.7 Place the buffered fiber on the strip template for “ST Hot Melt” and use the fiber marking pen to mark the location of the buffer cut.



3.8 Strip Template



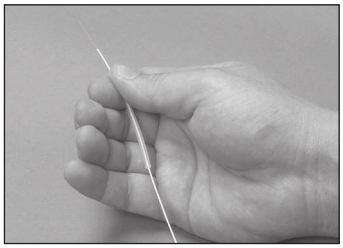
3.9 Using the 3M™ Stripping Tool 6362-TH, remove the buffer in small pieces until 7/8” (22 mm) of buffer has been removed.



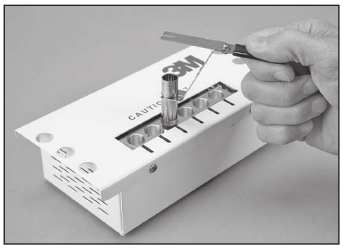
3.10 Using a lint free cloth moistened with Isopropyl alcohol, clean the bare fiber to remove any oils or Acrylate coating debris.



3.11 Check the final strip lengths and adjust if necessary.

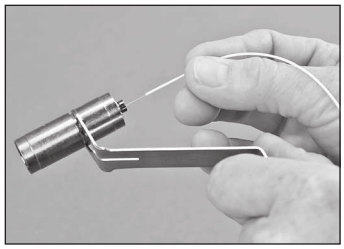


3.12 Position the clear strain relief tubing towards the end of the fiber where it will be easily accessible.

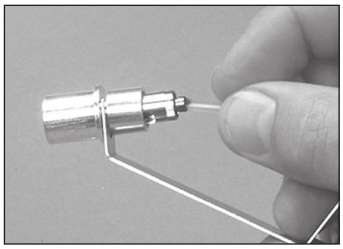


3.13 Remove the 3M™ Universal Connector Holder from the 3M Hot Melt Oven by grasping the cool-touch handle.

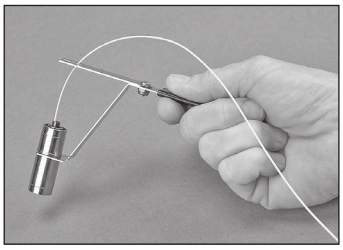
Caution: Do not touch the metal portion of the holder or connector, as it will be hot!



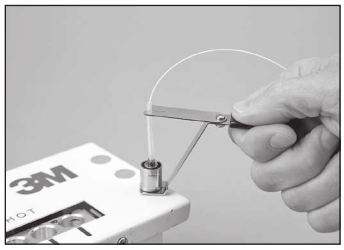
3.14 Feed the fiber into the back of the 3M Hot Melt ST Connector, until the buffer stops inside the connector.



3.15 Slide the clear strain relief tube into the connector until it stops.



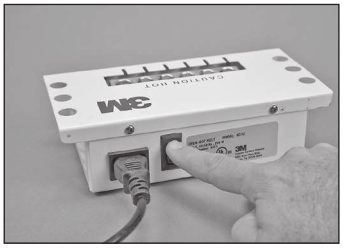
3.16 Push the buffered fiber into the cable retention feature until secure.



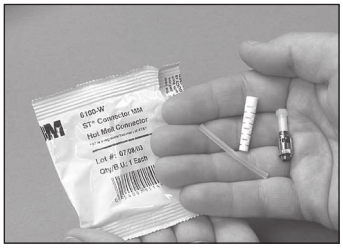
3.17 Rest the connector holder in one of the available cooling ports located on both sides of the oven. Let cool for three minutes.

Proceed to Section 9: Scribing, Page 18.

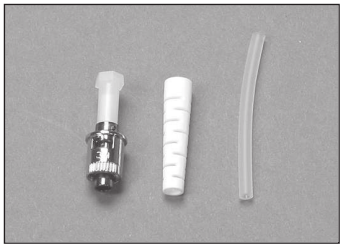
4.0 3M™ Hot Melt ST Connector 3 mm Jacketed Cable



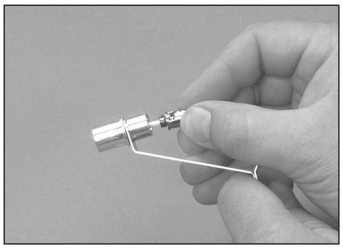
4.1 Plug in the 120V or 230V power cord. Turn on the 3M™ Hot Melt Oven. The oven requires six minutes to warm up.



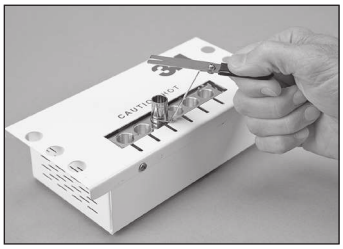
4.2 Open the connector package and remove components.



4.3 Each connector package contains a connector (A), strain relief boot (B), and clear strain relief tube (C).

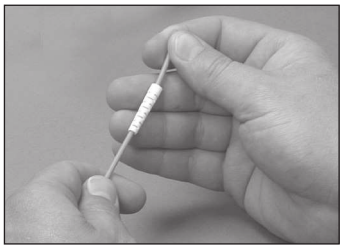


4.4 Load ST Connector into the shorter end of the 3M™ Universal Connector Holder.

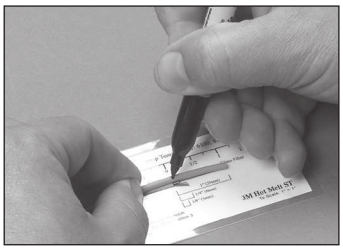


4.5 Place the connector holder into an available port in the oven.

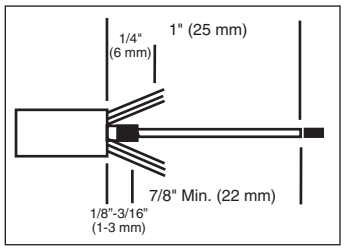
Note: The hot melt connector should be in the oven for at least 60 seconds. The connector should not be in the oven longer than five minutes.



4.6 Place the strain relief boot on the jacketed fiber, as shown.



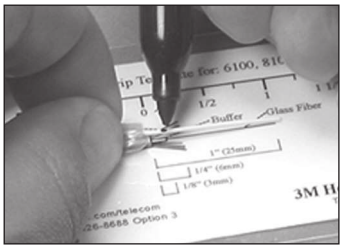
4.7 Place the jacketed fiber on the strip template for “ST Hot Melt” and use the fiber-marking pen to mark the location of the jacket cut, approximately 1" from the end.



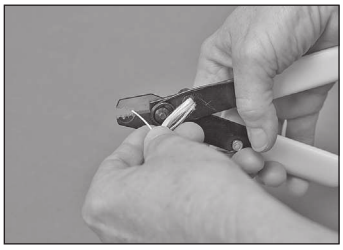
4.8 Strip Template



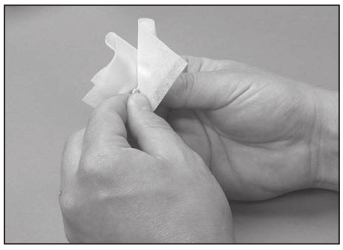
4.9 Using the 3M™ Stripping Tool 6362-TH, score the jacket and remove by hand.



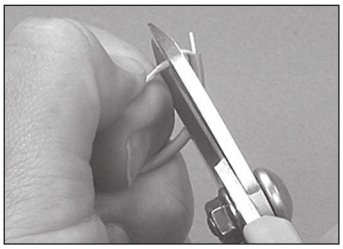
4.10 Fold back the Kevlar® fibers and mark where the buffer should be stripped.



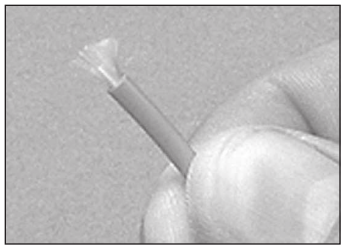
4.11 Using the 3M™ Stripping Tool, 6362-TH, remove the buffer in small pieces until 1/8" (3 mm) of buffer is protruding from the end of the jacket.



4.12 Using a lint free cloth moistened with Isopropyl alcohol, clean the bare fiber to remove any oils or Acrylate coating debris.



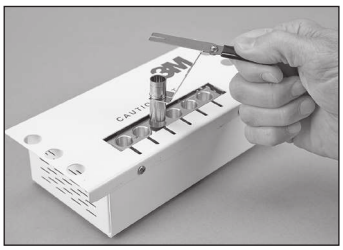
4.13 Gather the Kevlar® fibers to one side and cut to length, approximately 1/4".



4.14 Flare the Kevlar® fibers equally around the buffered fiber.

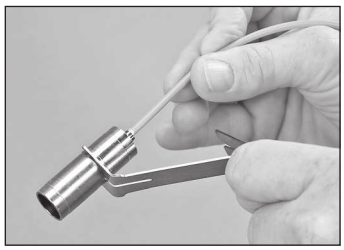


4.15 Check the final strip lengths and adjust if necessary.

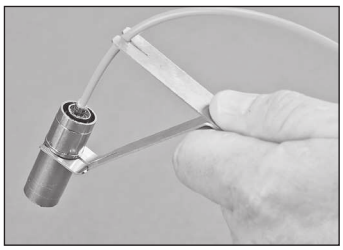


4.16 Remove the 3M™ Universal Connector Holder from the 3M Hot Melt Oven by grasping the cool-touch handle.

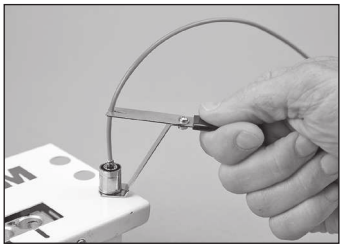
Caution: Do not touch the metal portion of the holder or connector, as it will be hot!



4.17 Feed the fiber into the back of the 3M Hot melt Connector, pushing until the Kevlar® fibers and jacket are secured inside the connector.



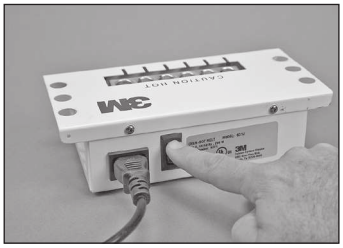
4.18 Push the jacketed fiber into the cable retention feature keeping the fiber as straight as possible.



4.19 Rest the connector holder in one of the available cooling ports located on both sides of the oven. Let cool for three minutes.

Proceed to Section 9: Scribing, Page 18.

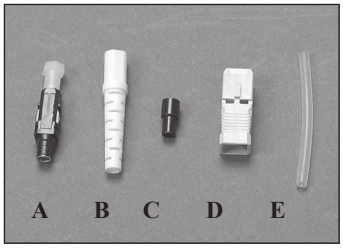
5.0 3M™ Hot Melt SC Connector 900 µm Buffered Fiber



5.1 Plug in the 120V or 230V power cord. Turn on the 3M™ Hot Melt Oven. The oven requires six minutes to warm up.



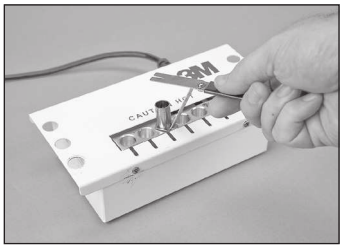
5.2 Open the connector package and remove components.



5.3 Each connector package contains a connector (A), strain relief boot (B), metal crimp ring (C), outer shell (D) and clear strain relief tube (E).

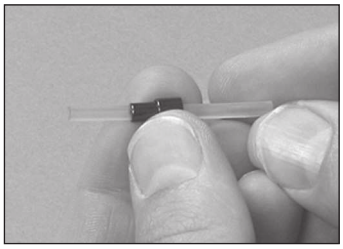


5.4 Load the SC Connector into the longer end of the 3M™ Universal Connector Holder.

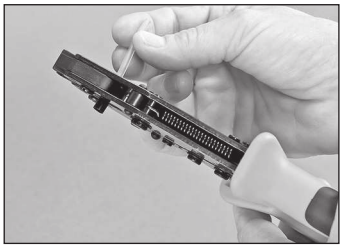


5.5 Place the connector holder into an available port in the oven.

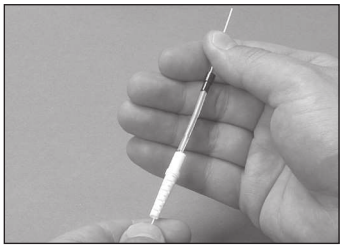
Note: The hot melt connector should be in the oven for at least 60 seconds. The connector should not be in the oven longer than five minutes.



5.6 Insert the clear strain relief tube into the metal crimp ring until the end of the tube is positioned in the small half of the crimp ring.

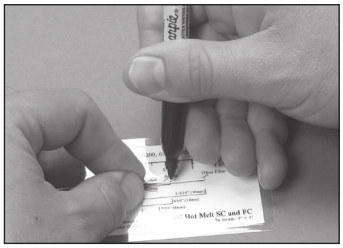


5.7 Using the die labeled .137, crimp the small half of the crimp ring onto the clear strain relief tubing.

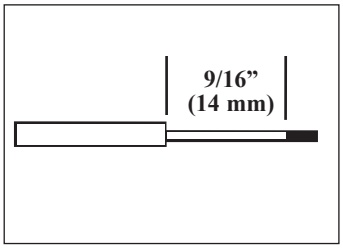


5.8 Place the strain relief boot, then the clear strain relief tube/crimp ring assembly on the buffered fiber.

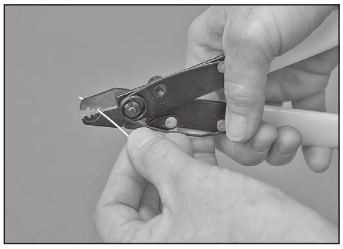
Note: SC-FC Crimp Rings for 2.4 mm jackets are available separately.



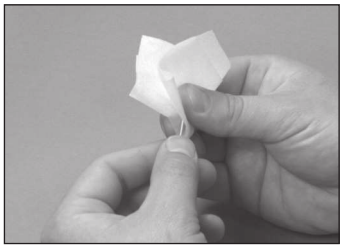
5.9 Place the buffered fiber on the strip template for “SC Hot Melt” and use the fiber marking pen to mark the location of the buffer cut.



5.10 Strip Template



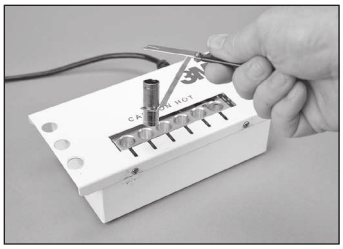
5.11 Using the 3M™ Stripping Tool 6362-TH, remove the buffer in small pieces until 9/16" (14 mm) of buffer has been removed.



5.12 Using a lint free cloth moistened with Isopropyl alcohol, clean the bare fiber to remove any oils or Acrylate coating debris.

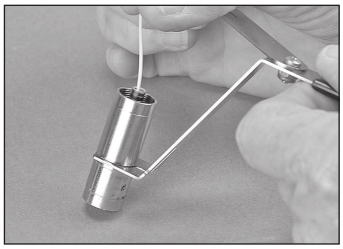


5.13 Check the final strip lengths and adjust if necessary.

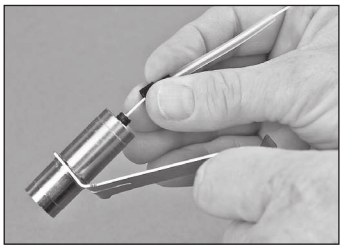


5.14 Remove the 3M™ Universal Connector Holder from the 3M Hot Melt Oven by grasping the cool-touch handle.

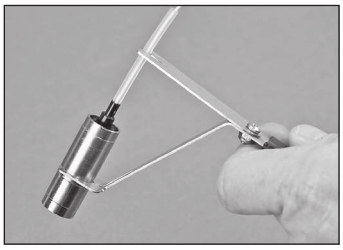
Caution: Do not touch the metal portion of the holder or connector, as it will be hot!



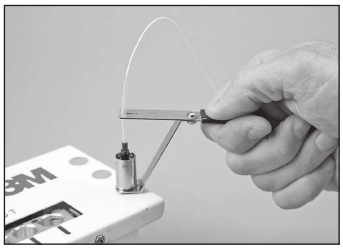
5.15 Feed the fiber into the back of the 3M Hot Melt Connector, until the buffer stops inside the connector.



5.16 Slide the metal crimp ring assembly onto the back of the connector.



5.17 Push the buffered fiber into the cable retention feature until secure.



5.18 Rest the connector holder in one of the available cooling ports located on both sides of the oven. Let cool for three minutes.

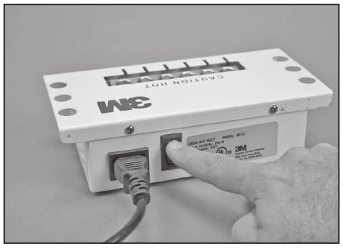


5.19 Once connector has cooled, remove from connector holder. Using the die labeled .190, crimp the large portion of the crimp ring onto the connector.

Note: If installing the SC-FC 2.4 mm red crimp ring, use the die labeled .120 to crimp the jacket.

Proceed to Section 9: Scribing, Page 18.

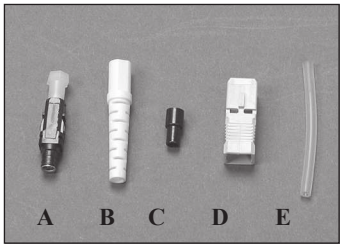
6.0 3M™ Hot Melt SC Connector 3 mm Jacketed Cable



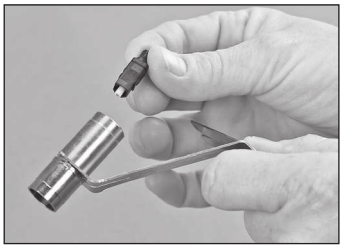
6.1 Plug in the 120V or 230V power cord. Turn on the 3M™ Hot Melt Oven. The oven requires six minutes to warm up.



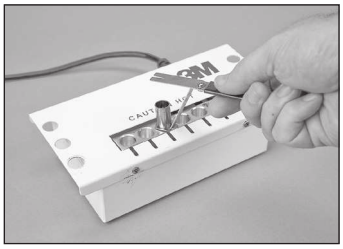
6.2 Open the connector package and remove components.



6.3 Each connector package contains a connector (A), strain relief boot (B), metal crimp ring (C), outer shell (D) and clear strain relief tube (E).

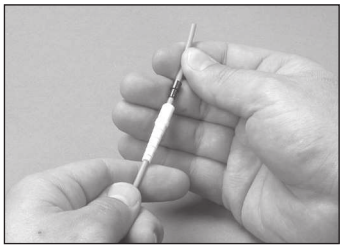


6.4 Load the SC Connector into the longer end of the 3M™ Universal Connector Holder.



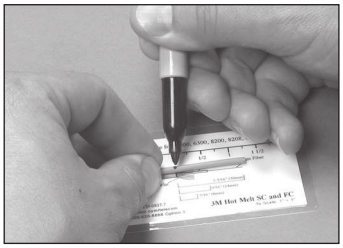
6.5 Place the connector holder into an available port in the oven.

Note: The hot melt connector should be in the oven for at least 60 seconds. The connector should not be in the oven longer than five minutes.

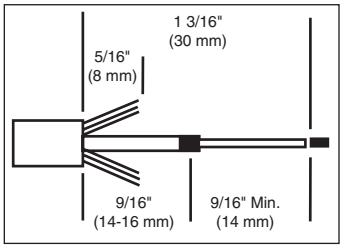


6.6 Place the strain relief boot, then the metal crimp ring on the jacketed fiber, as shown.

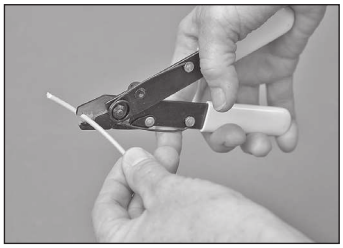
Note: SC-FC Crimp Rings for 2.4 mm jackets are available separately.



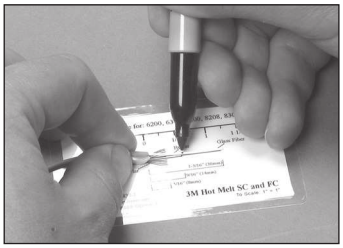
6.7 Place the jacketed fiber on the strip template for “SC Hot Melt” and use the fiber-marking pen to mark the location of the jacket cut, approximately 1-3/16" (30 mm) from the end.



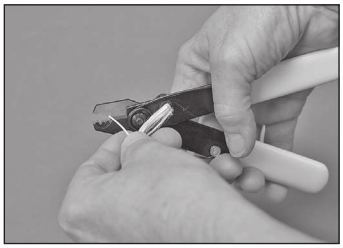
6.8 Strip Template



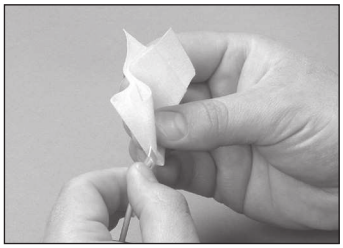
6.9 Using the 3M™ Stripping Tool 6362-TH score the jacket and remove by hand.



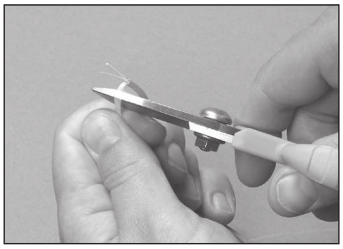
6.10 Fold back the Kevlar® fibers and mark where the buffer should be stripped.



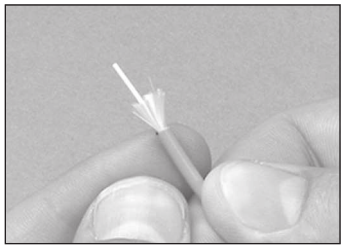
6.11 Using the 3M™ Stripping Tool 6362-TH, remove the buffer in small pieces until 9/16" (14 mm) of buffer is protruding from the end of the jacket.



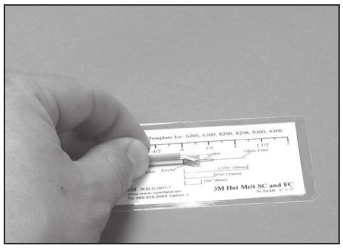
6.12 Using a lint free cloth moistened with Isopropyl alcohol, clean the bare fiber to remove any oils or Acrylate coating debris.



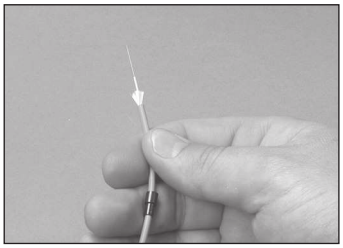
6.13 Gather the Kevlar® fibers to one side and cut to length, approximately 5/16".



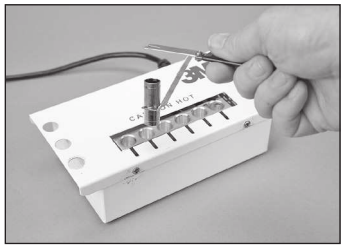
6.14 Flare the Kevlar® fibers equally around the buffered fiber.



6.15 Check the final strip lengths and adjust if necessary.

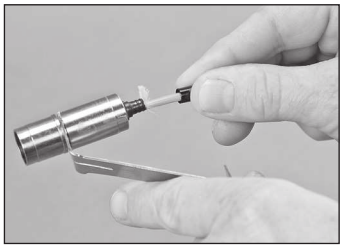


6.16 Position the metal crimp ring towards the end of the cable where it will be easily accessible.

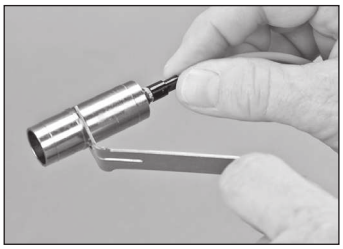


6.17 Remove the 3M™ Universal Connector Holder from the Hot Melt Oven by grasping the cool-touch handle.

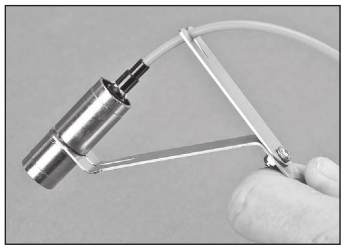
Caution: Do not touch the metal portion of the holder or connector, as it will be hot!



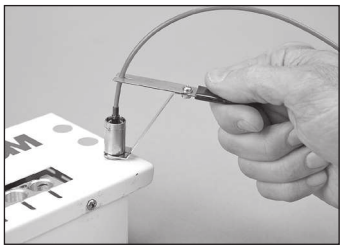
6.18 Feed the fiber into the back of the 3M Hot Melt Connector, pushing until the jacket stops on the connector. Flare the Kevlar® fibers equally around the buffered fiber.



6.19 Slide the metal crimp ring onto the back of the connector, capturing the Kevlar® fibers.



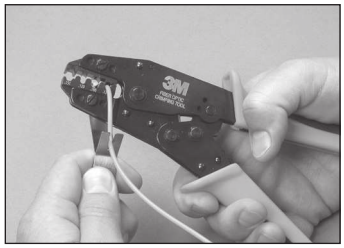
6.20 Push the jacketed fiber into the cable retention feature until secure



6.21 Rest the connector holder in one of the available cooling ports located on both sides of the oven. Let cool for three minutes.



6.22 Once connector has cooled, remove from connector holder. Using the die labeled .190, crimp the large portion of the crimp ring onto the connector.

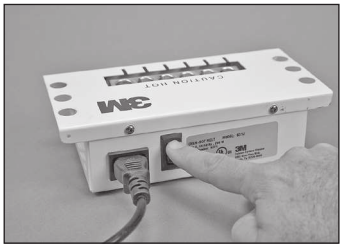


6.23 Secure the small portion of the crimp ring onto the jacket with the die labeled .137.

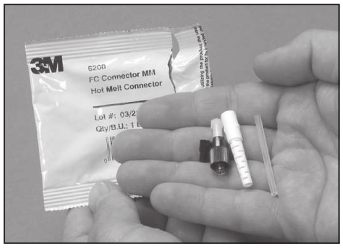
Note: If installing the SC-FC 2.4 mm red crimp ring, use the die labeled .120 to crimp the jacket.

Proceed to Section 9: Scribing, Page 18.

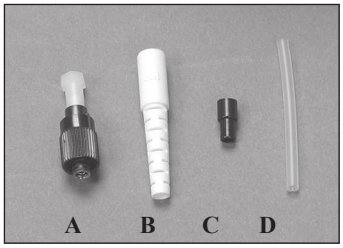
7.0 3M™ Hot Melt FC Connector 900 µm Buffered Fiber



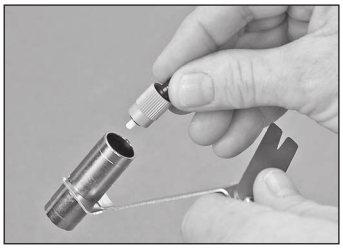
7.1 Plug in the 120V or 230V power cord. Turn on the 3M™ Hot Melt Oven. The oven requires six minutes to warm up.



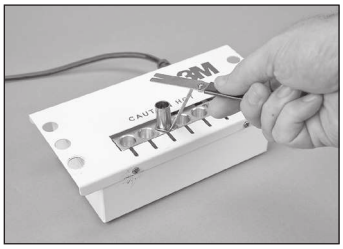
7.2 Open the connector package and remove components.



7.3 Each connector package contains a connector (A), strain relief boot (B), metal crimp ring (C) and clear strain relief tube (D).

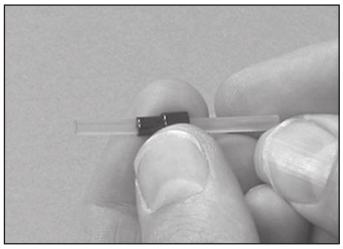


7.4 Load the FC Connector into the longer end of the 3M™ Universal Connector Holder.

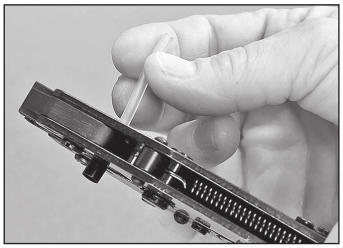


7.5 Place the connector holder into an available port in the oven.

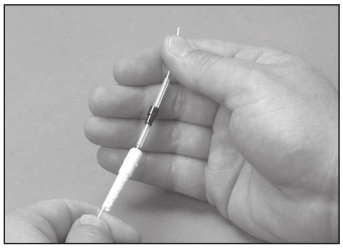
Note: The hot melt connector should be in the oven for at least 60 seconds. The connector should not be in the oven longer than five minutes.



7.6 Insert the clear strain relief tube into the metal crimp ring until the end of the tube is positioned in the small half of the crimp ring.

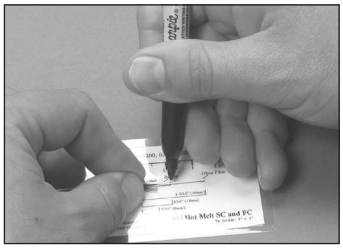


7.7 Using the die labeled .137, crimp the small half of the crimp ring to the clear strain relief tubing.

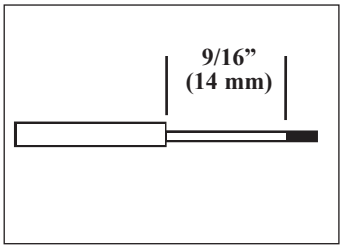


7.8 Place the strain relief boot and clear strain relief tube/crimp ring assembly on the buffered fiber.

Note: SC-FC Crimp Rings for 2.4 mm jackets are available separately.



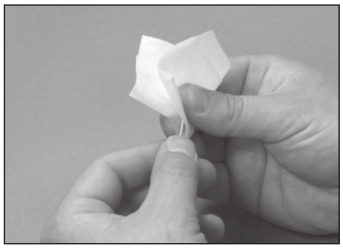
7.9 Place the buffered fiber on the strip template for “FC Hot Melt” and use the fiber marking pen to mark the location of the buffer cut.



7.10 Strip Template



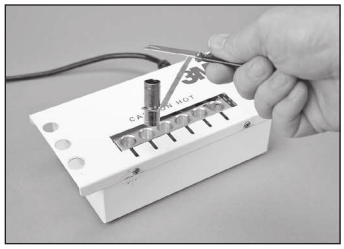
7.11 Using the 3M™ Stripping Tool 6362-TH, remove the buffer in small pieces until 9/16” (14 mm) of buffer has been removed.



7.12 Using a lint free cloth moistened with Isopropyl alcohol, clean the bare fiber to remove any oils or Acrylate coating debris.

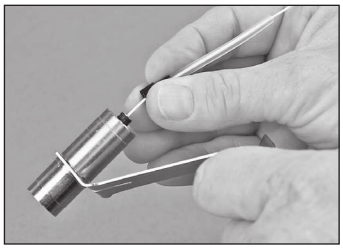


7.13 Check the final strip lengths and adjust if necessary.

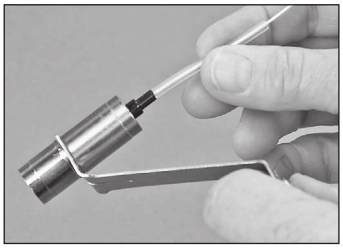


7.14 Remove the 3M™ Universal Connector Holder from the Hot Melt Oven by grasping the cool-touch handle.

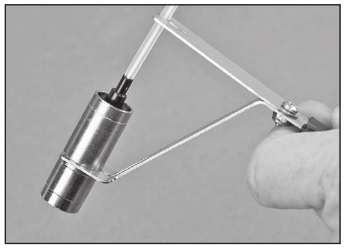
Caution: Do not touch the metal portion of the holder or connector, as it will be hot!



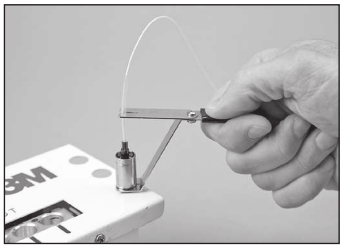
7.15 Feed the fiber into the back of the 3M Hot Melt Connector, until the buffer stops inside the connector.



7.16 Slide the clear strain relief tube/crimping assembly to the connector until it stops.



7.17 Push the buffered fiber into the cable retention feature until secure.



7.18 Rest the connector holder in one of the available cooling ports located on both sides of the oven. Let cool for three minutes.

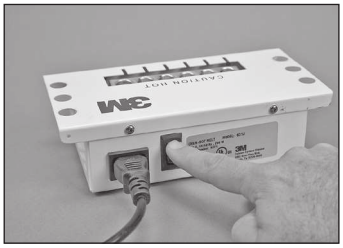


7.19 Once connector has cooled, remove from connector holder. Using the die labeled .190, crimp the large portion of the crimp ring onto the connector.

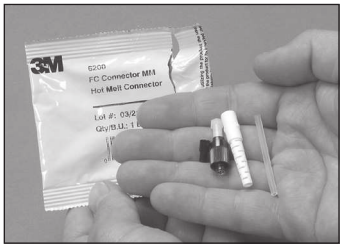
Note: If installing the SC-FC 2.4 mm red crimp ring, use the die labeled .120 to secure the crimp ring to the strain relief tube.

Proceed to Section 9: Scribing, Page 18.

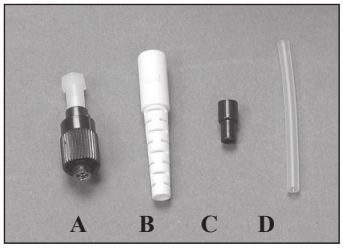
8.0 3M™ Hot Melt FC Connector 3 mm Jacketed Cable



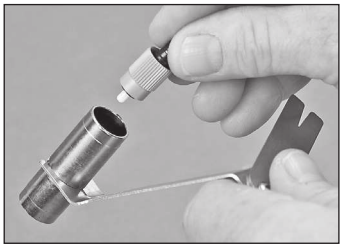
8.1 Plug in the 120V or 230V power cord. Turn on the 3M™ Hot Melt Oven. The oven requires six minutes to warm up.



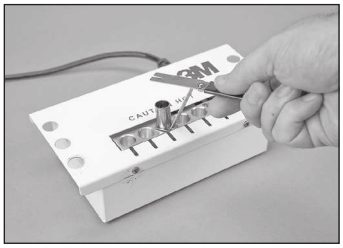
8.2 Open the connector package and remove components.



8.3 Each connector package contains a connector (A), strain relief boot (B), metal crimp ring (C) and clear strain relief tube (D).

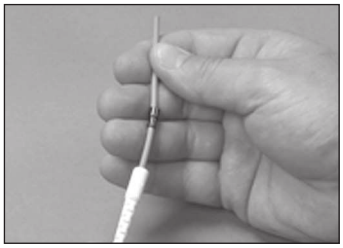


8.4 Load the FC Connector into the longer end of the 3M™ Universal Connector Holder.



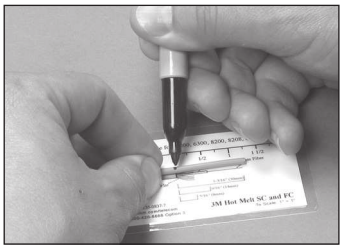
8.5 Place the connector holder into an available port in the oven.

Note: The hot melt connector should be in the oven for at least 60 seconds. The connector should not be in the oven longer than five minutes.

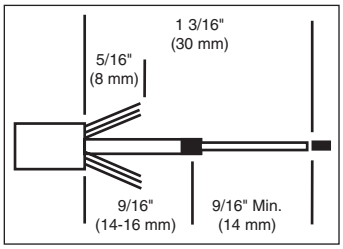


8.6 Place the strain relief boot, then the metal crimp ring on the jacketed fiber, as shown.

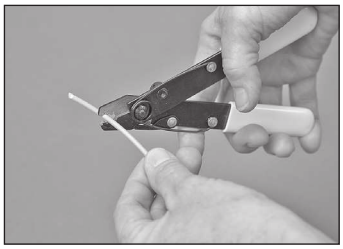
Note: SC-FC Crimp Rings for 2.4 mm jackets are available separately.



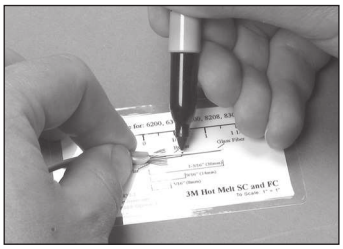
8.7 Place the jacketed fiber on the strip template for “FC Hot Melt” and use the fiber-marking pen to mark the location of the jacket cut, approximately 1-3/16" (30 mm) from the end.



8.8 Strip Template



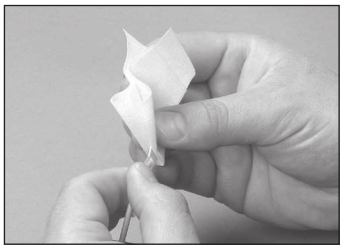
8.9 Using the 3M™ Stripping Tool 6362-TH, score the jacket and remove by hand.



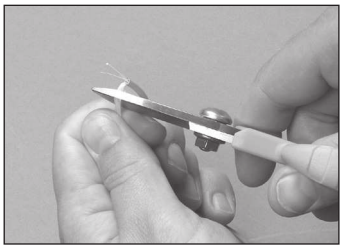
8.10 Fold back the Kevlar® fibers and mark where the buffer should be stripped.



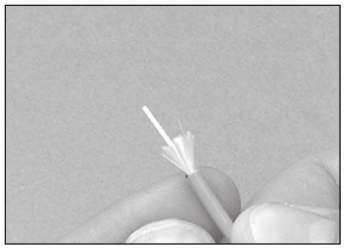
8.11 Using the 3M™ Stripping Tool, 6362-TH, remove the buffer in small pieces until 9/16”” (14 mm) of buffer is protruding from the end of the jacket.



8.12 Using a lint free cloth moistened with Isopropyl alcohol, clean the bare fiber to remove any oils or Acrylate coating debris.



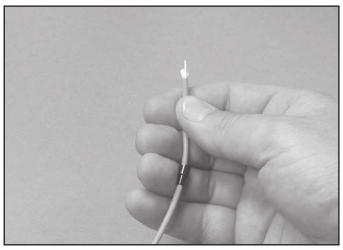
8.13 Gather the Kevlar® fibers to one side and cut to length, approximately 5/16".



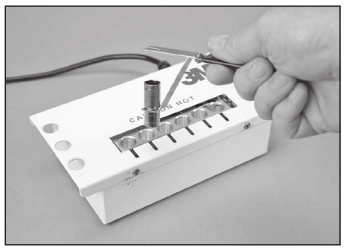
8.14 Flare the Kevlar® fibers equally around the buffered fiber.



8.15 Check the final strip lengths and adjust if necessary.

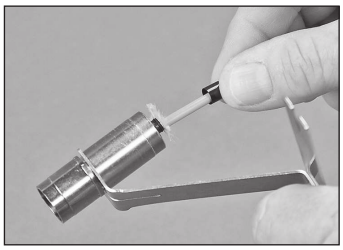


8.16 Position the metal crimp ring towards the end of the cable where it will be easily accessible.

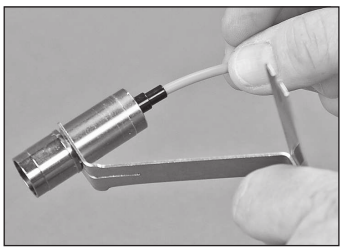


8.17 Remove the 3M™ Universal Connector Holder from the 3M Hot Melt Oven by grasping the cool-touch handle.

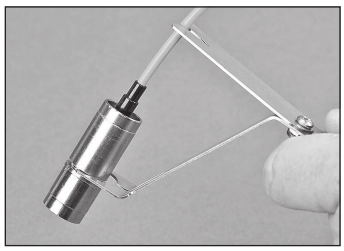
Caution: Do not touch the metal portion of the holder or connector, as it will be hot!



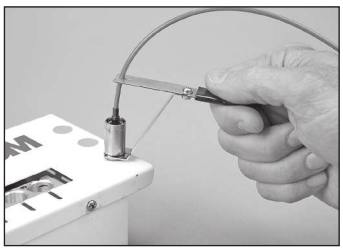
8.18 Feed the fiber into the back of the 3M Hot Melt Connector, pushing until the jacket stops on the connector. Flare the Kevlar® fibers equally around the buffered fiber.



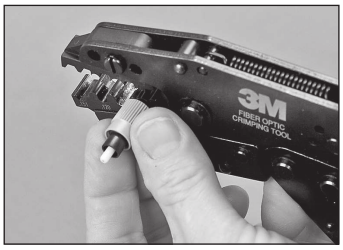
8.19 Slide the metal crimp ring onto the back of the connector, capturing the Kevlar.® fibers



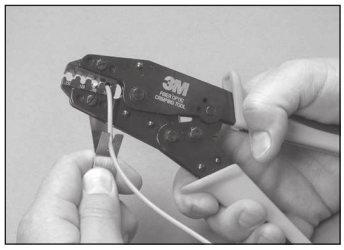
8.20 Push the jacketed fiber into the cable retention feature until secure.



8.21 Rest the connector holder in one of the available cooling ports located on both sides of the oven. Let cool for three minutes.



8.22 Once connector has cooled, remove from connector holder. Using the die labeled .190, crimp the large portion of the crimp ring onto the connector.

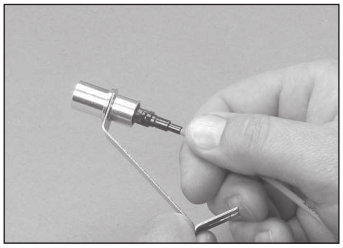


8.23 Secure the small portion of the crimp ring onto the jacket with the die labeled .137.

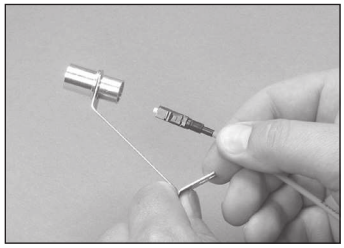
Note: If installing the SC-FC 2.4 mm red crimp ring, use the die labeled .120 to crimp the jacket.

Proceed to Section 9: Scribing, Page 18.

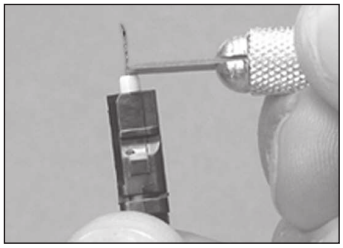
9.0 Scribing



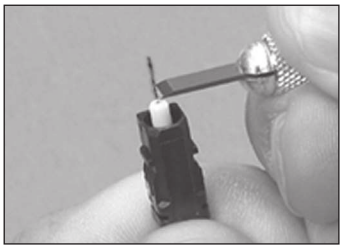
9.1 Remove the 3M™ Hot Melt Connector from the 3M™ Universal Connector Holder if necessary.



9.2 Caution - Be careful so that you do not break the protruding fiber.

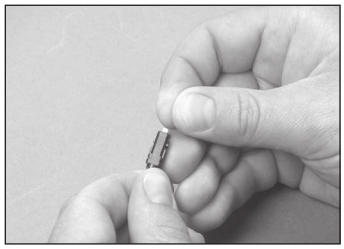


9.3 Position the scribe blade so the flat side of the blade is resting on the bead of adhesive and the blade is perpendicular to the fiber.



9.4 Score the fiber by gently sliding the blade across the fiber just above the bead of adhesive. Scoring means that you are making a small scratch on the outside of the fiber.

Caution: The fiber should not break during this step.

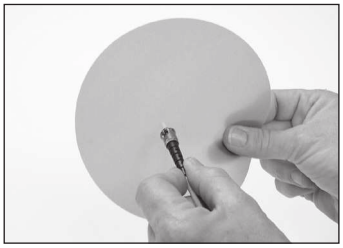


9.5 Pull the fiber away from the connector. Pull along the axis of the fiber, not to one side or the other. If the fiber does not break away, score the fiber again.



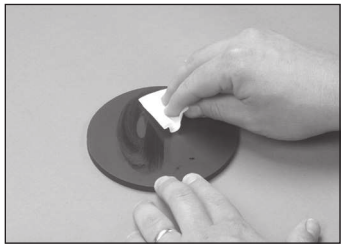
9.6 Dispose of the scrap fiber in the designated container.

10.0 Multimode Polishing: Hot Melt

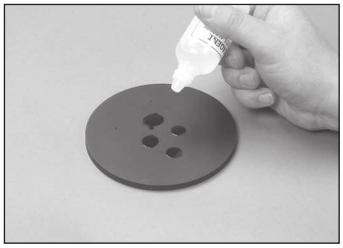


10.1 Perform an air polish by gently moving the 3M™ Hot Melt Connector in a circular motion on the gray, 9-micron 3M Lapping Film, for approximately 10 rotations.

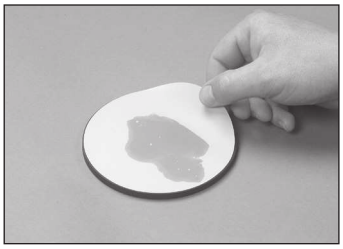
Note: Each sheet of 9 micron lapping film can be used for up to 20 connectors.



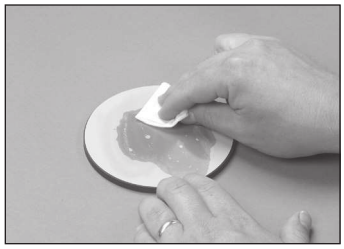
10.2 Clean the round 3M Polishing Pad with a lint free cloth moistened with Isopropyl alcohol.



10.3 Place several drops of alcohol onto the round rubber pad.

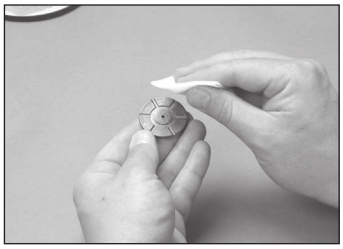


10.4 Before the alcohol evaporates, place a sheet of the pale green, 2-micron 3M Lapping Film, shiny side down on the pad. The alcohol creates suction on the lapping film and helps hold it in place.

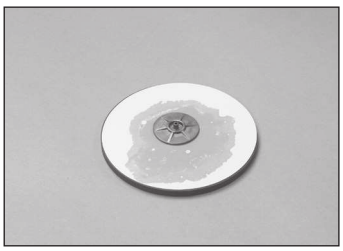


10.5 Clean the lapping film with a lint free cloth moistened with Isopropyl alcohol.

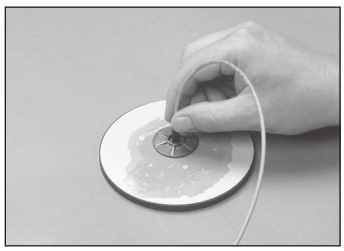
Note: The 2-micron lapping film can be used for up to two connectors.



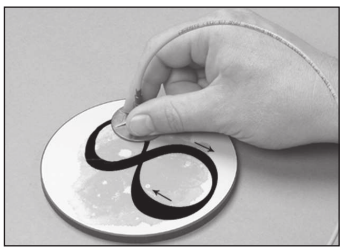
10.6 Clean the flat side of the 3M Polishing Jig with a lint free cloth moistened with Isopropyl alcohol.



10.7 Place the jig on the lapping film.



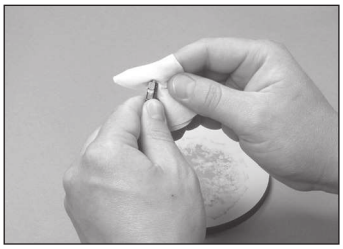
10.8 Place the ferrule in the jig until it stops.



10.9 Holding the connector and jig as shown, move the jig in a figure eight pattern with light pressure. The speed of your figure eights should be one to two per second.

After you have performed five figure eights, increase to a medium pressure and polish until all of the adhesive has been removed. Then, polish an additional three figure eights.

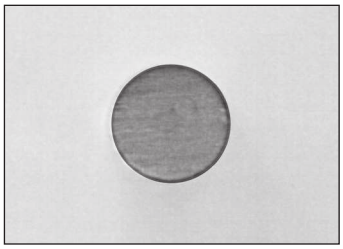
NOTE: The jig will feel much easier to push immediately after the adhesive has been removed.



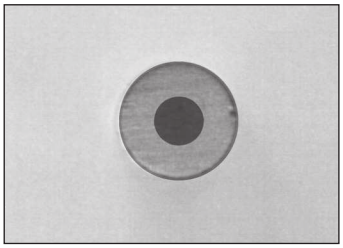
10.10 Clean the 3M™ Hot Melt Connector endface with a lint free cloth moistened with Isopropyl alcohol.



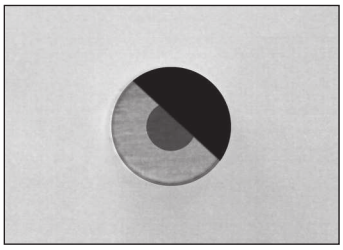
10.11 Inspect the connector endface with the fiber through coaxial and oblique views by changing the view with the thumbswitch on the body of the 3M View Scope.



10.12 Good Polish (coaxial)

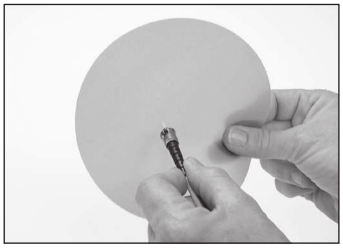


10.13 Good Polish (oblique)



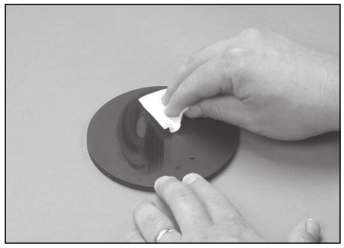
10.14 Bad Polish - requires re-termination

11.0 Singlemode Polishing: Hot Melt

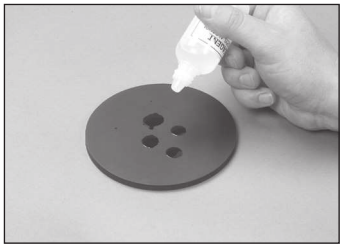


11.1 Perform an air polish by gently moving the connector in a circular motion on the gray, 9-micron lapping film, for approximately 10 rotations.

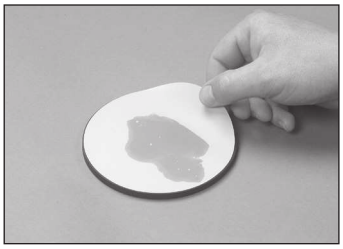
Note: Each sheet of 9 micron lapping film can be used for up to 20 connectors.



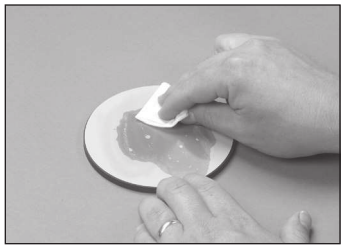
11.2 Clean the round polishing pad with a lint free cloth moistened with Isopropyl alcohol.



11.3 Place several drops of alcohol onto the round rubber pad.

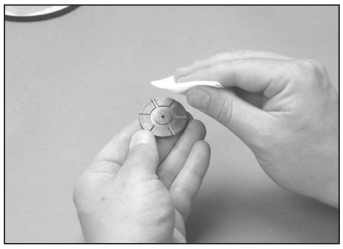


11.4 Before the alcohol evaporates, place a sheet of the pale green, 2-micron lapping film, shiny side down on the pad. The alcohol creates suction on the lapping film and helps hold it in place.

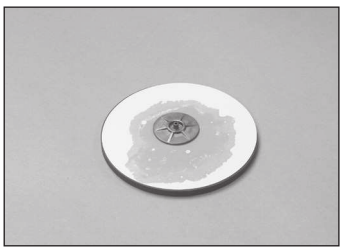


11.5 Clean the lapping film with a lint free cloth moistened with Isopropyl alcohol.

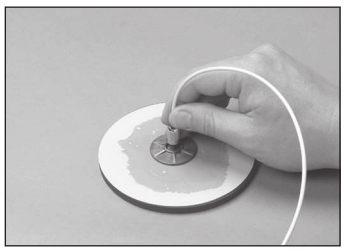
Note: The 2-micron lapping film can be used for up to two connectors.



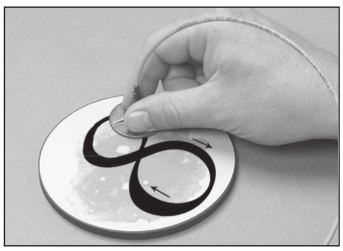
11.6 Clean the flat side of the polishing jig with a lint free cloth moistened with Isopropyl alcohol.



11.7 Place the jig on the lapping film.



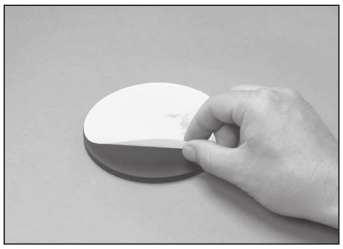
11.8 Place the ferrule in the jig until it stops.



11.9 Holding the connector and jig as shown, move the jig in a figure eight pattern with light pressure. The speed of your figure eights should be one to two per second.

After you have performed five figure eights, increase to a medium pressure and polish until all of the adhesive has been removed. Then, polish one additional figure eight only.

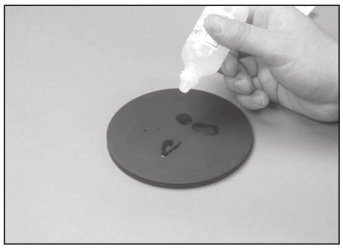
NOTE: The jig will feel much easier to push immediately after the adhesive has been removed.



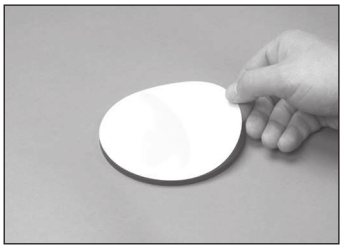
11.10 Remove the pale green, 2-micron 3M Lapping Film from the round polishing pad.



11.11 Clean the round 3M Polishing Pad with a lint free cloth moistened with Isopropyl alcohol.



11.12 Place several drops of alcohol onto the round rubber pad.



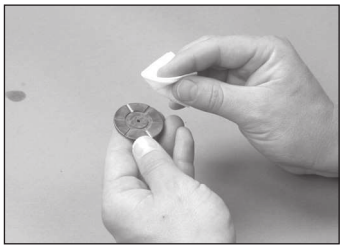
11.13 Before the alcohol evaporates, place a sheet of the frosted white final polish 3M Lapping Film, shiny side down on the pad.

Note: Each sheet of frosted white final polish lapping film can be used for up to five connectors

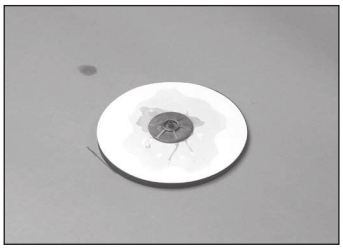


11.14 Final Polish: Clean the lapping film with a lint free cloth and distilled water. Add several drops of distilled water onto the lapping film.

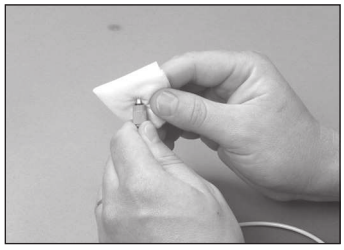
Note: Do not use alcohol on the final polish film as it will remove the grit on the film.



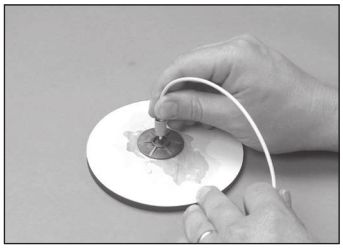
11.15 Clean the flat side of the 3M Polishing Jig with a lint free cloth moistened with Isopropyl alcohol.



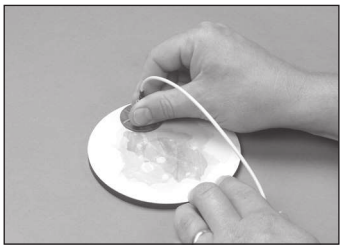
11.16 Place the jig on the lapping film.



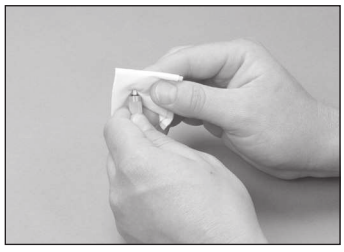
11.17 Clean the 3M Hot Melt Connector endface with a lint free cloth moistened with Isopropyl alcohol.



11.18 Place the ferrule in the jig until it stops.



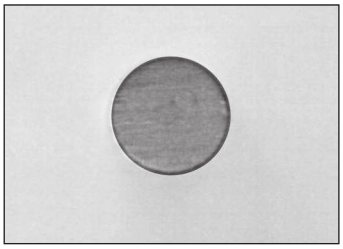
11.19 Polish the connector for four to eight figure eights only.



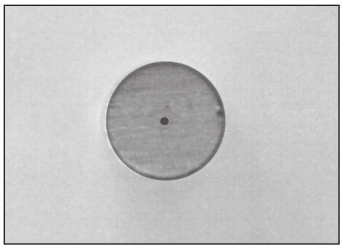
11.20 Clean the connector endface with a lint free cloth moistened with Isopropyl alcohol.



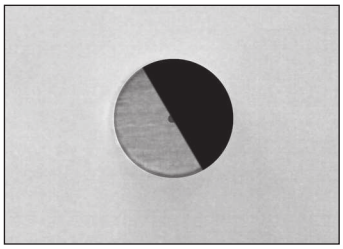
11.21 Inspect the connector endface with the fiber through coaxial and oblique views by changing the view with the thumbswitch on the body of the 3M View Scope.



11.22 Good Polish (coaxial)

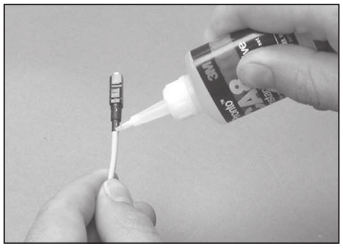


11.23 Good Polish (oblique)

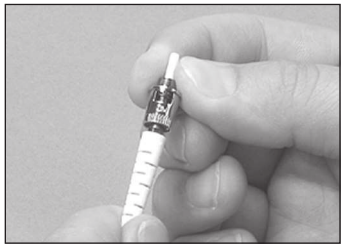


11.24 Bad Polish - requires re-termination

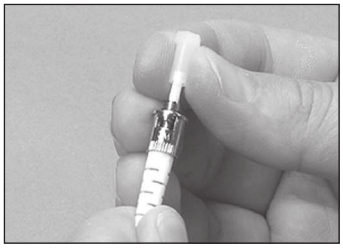
12.0 Finishing



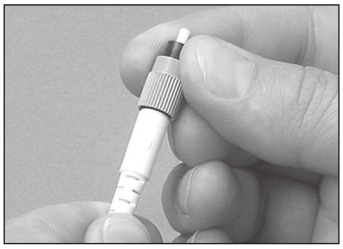
12.1 *Optional Step:* For high stress situations, you may wish to apply a small amount of the 3M™ Pronto™ Instant Adhesive, CA-8 around the cable directly past the crimp ring, and at the end of the body of the ST Connector. Immediately install the strain relief boot.



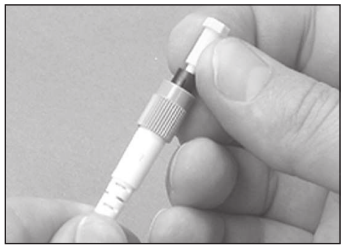
12.2 3M™ Hot Melt ST Connector - Slide the strain relief boot onto the back of the connector.



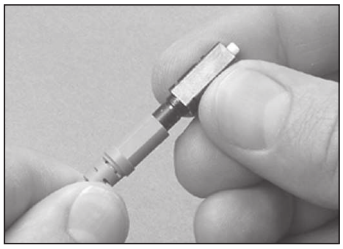
12.3 3M™ Hot Melt ST Connector - If the connector is not to be immediately put into service, install the protective dust cap.



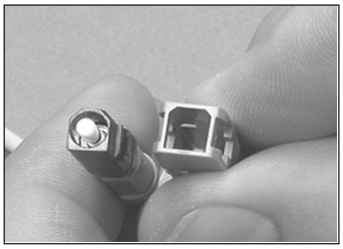
12.4 3M™ Hot Melt FC Connector - Slide the strain relief boot onto the back of the connector.



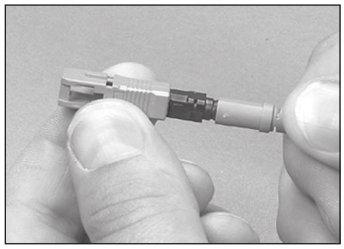
12.5 3M™ Hot Melt FC Connector - If the connector is not to be immediately put into service, install the protective dust cap.



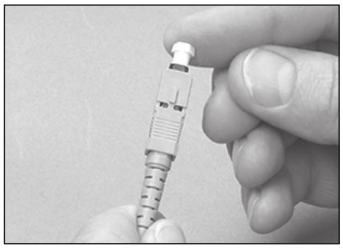
12.6 3M™ Hot Melt SC Connector - Slide the strain relief boot onto the back of the connector, ensuring the flat sides of the boot are in line with the flat sides of the connector.



12.7 3M™ Hot Melt SC Connector - Install the outer shell of the connector by aligning the profile of the connector's outer shell, with the connector body.



12.8 3M™ Hot Melt SC Connector - Slide the connector into the backside of the outer shell. The shell will snap into place.



12.9 3M™ Hot Melt SC Connector - If the connector is not to be immediately put into service, install the protective dust cap.

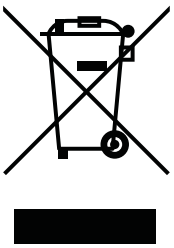
13.0 3M™ Field Termination Kit Replacement Part Numbers

3M™ Hot Melt Universal Termination Kit

Product Number	Description	Packaging
6366	Hot Melt Termination Kit 120 V	1 kit
6362	Hot Melt Termination Kit 230 V	1 kit

Replacements for 3M™ Hot Melt Universal Termination Kit

Product Number	Description	Packaging
6365-CC	Hot Melt Consumable Kit 254X 2-µm One Step Lapping Film 863X Final Polish Lapping Film Lint Free Cloths 8892 Universal Polishing Jig Pronto Adhesive	1 ea. 200 sheets 80 sheets 200 Sheets 1 ea. 1 ea.
6365-CT	Universal Crimp Tool	1 ea.
6365-HH	Universal Connector Holder	4 ea.
6365-PP	Polishing Pad, One Step	1 ea.
8892	Universal Polishing Jig	1 ea.
6365-FS	Carbide Fiber Scribe	1 ea.
6365-VS	200x View Scope	1 ea.
6362-TH	Tri-Hole Fiber Stripping Tool	1 ea.
6365-KS	3M™ Aramid Yarn Snips 6365-KS	1 ea.
6366-CW	Lints Free Cloths	100 shts
6312	Hot Melt Oven (6 port) 120 V	1
6323	Hot Melt Oven (6 port) 230 V	1
6851-E	Autopolisher	1
SC-FC	Crimp Ring 2.4 mm Red	60 ea.



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