Termination Instructions   multicomp PRO

I Introduction

This termination procedure is for ST Connectors. Please read this procedure thoroughly.

II Description

Fig.1   Shows basic parts of a ST fiber connector. Actual parts may vary depends on fiber cable diameter, basic termination procedure should remain the same.
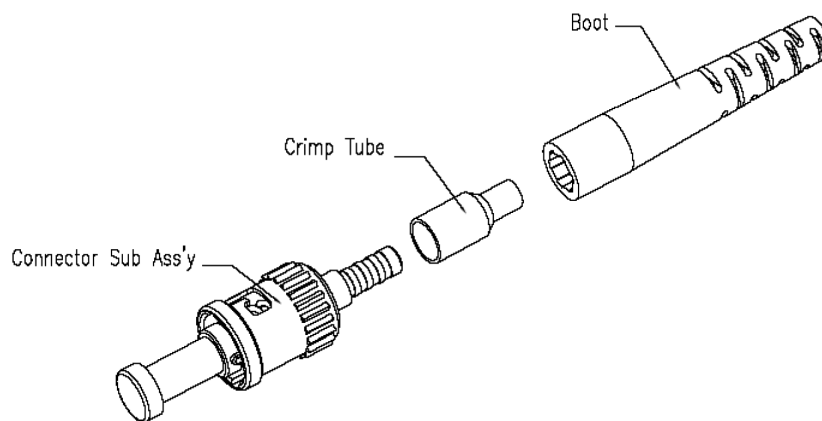

Fig. 1

Step 1   Insert boot and crimp tube onto cable per Fig 2.

Fig. 2

Step 2   Use jacket stripper and Kevlar cutter to prep cable per Fig 3. Us buffer stripper to remove the require length of buffer per Fig 3.
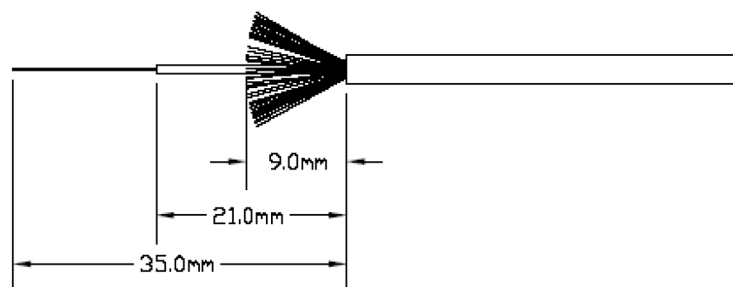

Fig. 3

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Step 3   Use alcohol and lens wiper to clean the bare fiber. Bare fiber must be properly cleaned before connector insertion.
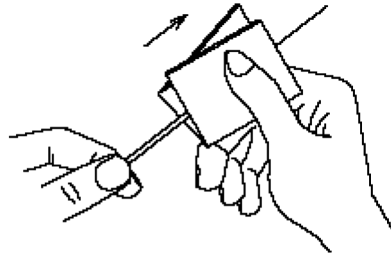

Fig. 4

Step 4   Apply a few drops of epoxy into connector body. Carefully insert prepared bare fiber into the epoxy filled connector. Slide the fiber gently in and out of ferrule to form the epoxy bead on the end of ferrule. Set connector with fully inserted cable.

Step 5   Cure epoxy fully based on epoxy manufacturer's recommendation. Use a fiber scriber to score the protruded fiber at the edge of epoxy bead. Gently pull the tip of fiber to separate protruded fiber. Perform polishing procedures per polishing equipment manufacturer's recommendation.

Step 6   Cut approx 8mm of jacket open with scissor and prep the drawn out Kevlar per Fig 5.
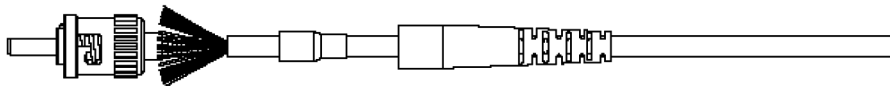

Fig. 5

Step 7   Slide the pre-inserted crimp tube against connector with Kevlar evenly distributed. Fix crimp tube on connector with crimping tool per Fig 6.
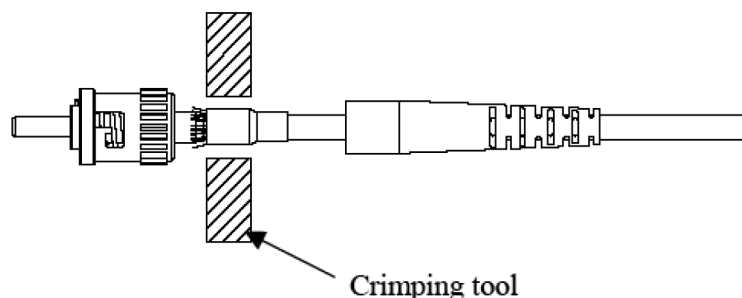

Crimping tool

Fig. 6

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Crimp Tool Recommendation

	Crimp Tube
ST 2.0mm	4.0mm
ST 3.0mm	4.0mm
Actual requirement may vary.	

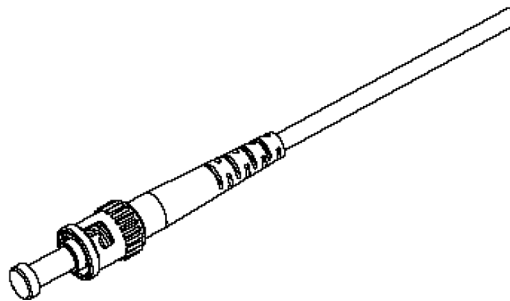Step 8   Slide the pre-inserted boot against crimped connector and protect end ferrule with dust cap.

Fig. 7

Part Number
SPC23254

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