



Supplemental Instructions For Terminating Panduit Fiber Optic Connectors onto 250 Micron Coated Fiber

Part Number: F250BT-C

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INSTALLATION INSTRUCTIONS

FS055

When terminating any Panduit fiber optic connector onto 250µm coated fiber, follow the 900µm Tight-Buffered Termination procedure in the appropriate connector installation instructions with the following modifications:

OptiCam Connectors: Refer to Stripping Template PN400* for LC and PN374* for SC and ST

1. After placing the 900µm boot onto the 250µm fiber, place one build-up tube (F250BT) onto the fiber and slide it back out of the way.
2. Place an insertion mark on the build-up tube 15mm for LC and 11mm for SC or ST from the end of the tube closest to the end of the fiber.
3. Use the buffer stripper to strip at least 30mm of coating and wipe the bare fiber clean with an alcohol soaked wipe.
4. Place an insertion mark on the coated fiber 15mm for LC and 11mm for SC or ST from the end of the stripped coating.
5. Cleave the fiber 7mm from the end of the coating and slide up the build-up tube so that the end is even with the cleaved fiber end.
6. While holding the fiber and build-up tube together behind the build-up tube, insert them into the back of the connector until the build-up tube bottoms out within the connector. The insertion mark on the build-up tube should be hidden within the back of the connector.
7. Slide just the fiber forward using constant light pressure until it bottoms out within the connector on the fiber stub. The insertion mark should be visible through the build-up tube and located near the back end of the connector.
8. Squeeze both clamp arms to open the clamp pads. Place the fiber between the open clamp pads and release the clamp arms while creating a slight bow in the fiber. The bow is intended to provide appropriate glass-to-glass mating pressure. **DO NOT** shuttle the cradle forward, as this may create an excessive bow behind the build-up tube.
9. Turn on the laser and complete the connector termination as described in the appropriate instruction sheet.

When terminating any Panduit fiber optic connector onto 250µm coated fiber, follow the 900µm Tight-Buffered Termination procedure in the appropriate connector installation instructions with the following modifications:

Opti-Crimp Connectors

1. After placing the 900µm boot onto the 250µm fiber, place one build-up tube (F250BT) onto the fiber and slide it back out of the way.
2. To obtain the correct fiber strip length, mark and strip the 250µm coating per the appropriate 900µm Buffered Stripping Dimensions.
3. After the fiber is inserted and crimped, slide up and insert the build-up tube until it bottoms out within the connector.
4. Crimp the buffer crimp area of the connector assembly using the 0.048" crimp pocket to secure the build-up tube.

Field Polish Connectors

1. After placing the 900µm boot onto the 250µm fiber, place one build-up tube (F250BT) onto the fiber and slide it back out of the way.
2. To obtain the correct fiber strip length, mark and strip the 250µm coating per the appropriate 900µm Buffered Stripping Dimensions.
3. After applying primer onto the bare fiber, apply primer onto the first 0.75" (19mm) of the build-up tube closest to the fiber end. This will help secure the tube inside the connector.
4. After the fiber is inserted into the adhesive filled ferrule, immediately slide up and insert the build-up tube until it bottoms out within the connector.
5. Allow 1 minute for the adhesive to harden before cleaving.