

# Installation Instructions

## Clearfield's CraftSmart Splice-On Connector

**1. Open and remove the contents of the vial. Each kit consists of one each of the following (SC Style SOC Shown):**

- A. Universal dust cap with extension handle (to aid in transfer from holder to oven)
- B. Outer housing (SC style shown, all versions may not contain a separate outer housing)
- C. Splice-On Connector (SOC) pigtail with cleave protector
- D. 25mm mini splice sleeve
- E. Universal strain relief boot



**2. Remove the standard dust cap and replace it with the extended dust cap.**

(Note: Depending on the fusion splicer model used, it may not be possible to use the extended dust cap. This will be evident after the connector is placed into the holder and in the splicer. If during the alignment phase the fiber position is too high or too low, the operator may need to omit the extended dust cap during the splicing operation when using this splicer.)

**3. While holding the connector firmly, pull down on the cleave protector to remove it from the connector (Figure 1).**

Do not touch the cleaved fiber stub with the protector or your fingers as this may damage the pre-cleaved end.

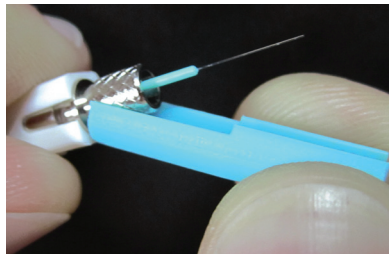


Figure 1

**4. Insert the connector into the Universal Splice-On Connector Holder so that the back end of the connector is flush with the end of the holder (Figure 2-5). Once aligned properly, the connector should fit freely into the holder with no force required.**

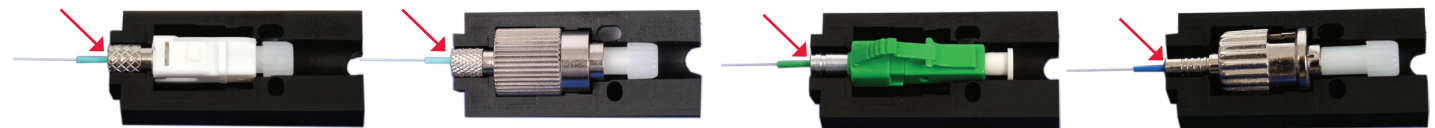


Figure 2 (SC)

Figure 3 (FC)

Figure 4 (LC)

Figure 5 (ST)

**5. Insert the holder into the right hand side of the splicer (Figure 6), being sure that the fiber stub lays properly into the v-groove block of the splicer (Figure 7).**

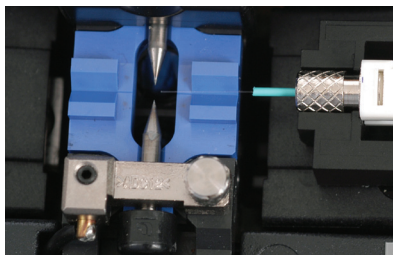


Figure 6

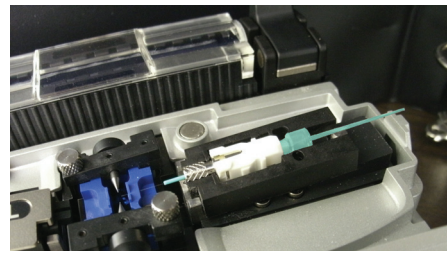


Figure 7

**6. Slide the 900 $\mu$ m strain relief boot and the 25mm mini splice sleeve onto the 900 $\mu$ m field fiber. Strip, clean, and cleave the field fiber to a 10mm cleave length and insert into the left hand side of the fusion splicer.**

**7. Perform the fusion splice as described in the splicer instructions.**

**8. Once the fusion splicing cycle is completed, remove the connector from the splicer and slide up the splice protection sleeve to cover the splice. An equal amount of the sleeve should cover the buffer on either side of the splice. If the extended cap was not used in the splicing process, it can be put in place now to aid in the transfer to the oven.**

**9. Transfer the splice to the heat oven (Figure 9).**

**(Note:** Depending on the model of splicer used and the style of connector, the operator may notice that the entire connector and splice do not fit into the splicers protection sleeve oven. In order to ensure a proper sleeve shrink, the connector must be placed on top of the oven and the oven heat settings should be changed to a recommended setting of 230 degrees C for a time of 70 seconds.

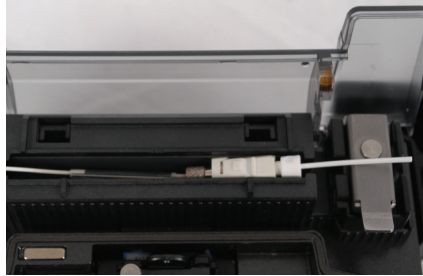


Figure 9: Connector in oven

**10. After the heat cycle is completed, remove the assembly from the oven. (Warning: The connector body may be hot, use proper handling techniques) Make sure that the splice sleeve has fully cooled before sliding the strain relief boot into place. For SC connectors, install the outer housing onto the connector, being sure to align the angled corners of the inner housing with those of the outer housing (Figure 11).**

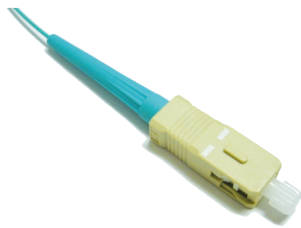
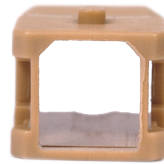


Figure 11



SC Connector

