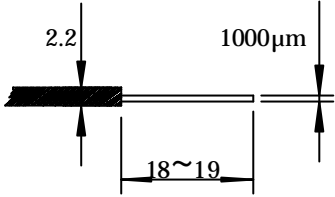

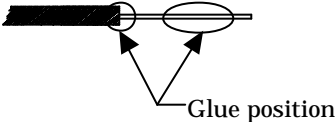
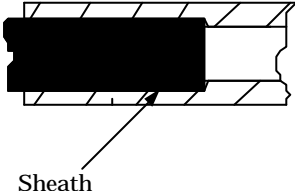
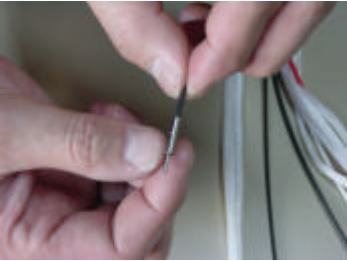
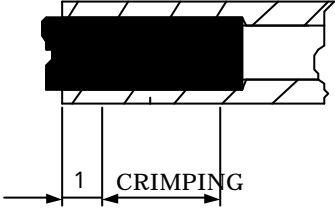

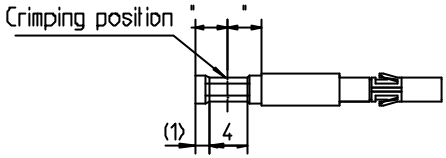
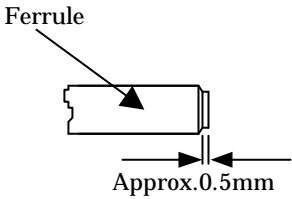


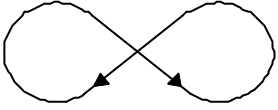
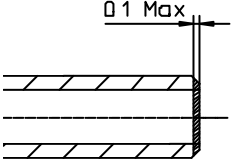

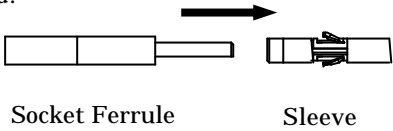


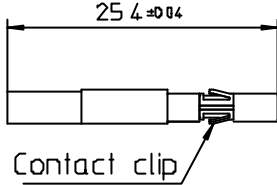


**Trim Trio Optical Contact  
Wiring Instruction Sheet for POF**

|   | Procedure  | Notes  |
|---|--|--|
| 1 | <p><b><u>STRIPPING THE 2.2mm DIA. EXTERNAL SHEATH</u></b></p> <p>1-1. Use Fiber stripping pliers Ref. 80WD-0006.<br/>Insert the cable in the pliers jaws(No.18) at the required length (approximately 18~19mm)</p> <p>1-2 . Tighten firmly and pull out the sheath.</p>   | <p>Be careful not to damage the fiber.</p>  <p align="center">External sheath stripping</p>   |
| 2 | <p><b><u>BONDING OF THE FIBER</u></b></p> <p>2-1. Put some glue on the fiber.<br/>glue: Ref. 45LV(80WG0014)</p>  <p>2-2. Install the fiber in the contact until the 2.2mm dia. external sheath butts against the rear of the contact.</p>  <p>2-3. Put the whole assembly in the oven Ref. 80WT-0008.<br/>Start the 10 minutes clock.<br/>After 10 minutes, remove the cable from the oven and let it cool down.</p> | <p>In addition to the glue recommended here, any other glue which can be used for optical fibers is acceptable.</p>  <p align="center">Install the fiber in the contact</p> <p>In addition to the oven recommended here, any other oven which can be used for optical fibers is acceptable.</p> <p>Be careful not to break the tip of optical fiber which comes out of the contact ferrule.</p> <p>If necessary, protect the tip of ferrule by using the rubber support Ref. 80WT0005</p> |

|   | Procedure   | Notes  |
|---|---|--|
| 3 | <p><b><u>CRIMPING THE CABLE IN THE CONTACT</u></b></p> <p>3-3. Insert the fiber in the contact until the 2.2 mm dia. external sheath butts against the rear of the contact.</p> <p>3-4. Use crimping pliers Ref. 80WS-0002 (hexagonal jaws).<br/>Make sure the pliers jaws are fully open by performing sham crimping.</p> <p>3-3. Install the socket to be crimped in the position A of the pliers jaws at approximately 1 mm from the rear of the contact.</p>  <p>3-4. Crimp the contact socket while exerting a pressure on the cable.</p> <p>3-5. Release the pliers jaws and remove the contact.</p> |  <p>Crimping the contact socket</p>  |
| 4 | <p><b><u>CUTTING THE FIBER</u></b></p> <p>4-1. If the step No.1 has been performed correctly, -i.e. the sheath stripping length is 18~19mm-, the fiber does not need to be cut..<br/>(This means that sheath stripping length is)</p> <p>4-2. In the contrary, if the fiber goes out of the ferrule long, use fiber cutting pliers Ref. 80WD-0006.<br/>Snap the fiber off at approximately 0.5 mm from the end piece.</p>   |    |

|   | Procedure  | Notes  |
|---|--|--|
| 5 | <p><b><u>POLISHING THE OPTICAL FACE</u></b></p> <p>5-1. Use polishing plate Ref. 80WP-0005.<br/>                     This plexiglass polishing plate is maintained in place by six adhesive stops and is used as a plane support for the polishing disks. The plate should be clean, without splinters nor scratches disproportionate in size compared with the useful surface of the disk.</p> <p>Each time you want to use the polishing plate, clean it with paper and ethanol.</p> <p>5-2. Use polishing tool Ref. 80WP-0018<br/>                     This tool is used for polishing the face of the male and female contact end pieces.</p> <p>5-3. Use polishing disks<br/>                     -COARSE 30 μ m(green) Ref. 80WP-0019<br/>                     -FINE 9μ m(blue) Ref. 80WP-0014</p> <p>These disks can be used for coarse and fine polishing of approximately 10 contacts.</p> <p>5-4 . Polishing Operation<br/>                     Coarse polishing<br/>                     -Install the 30 μ m polishing disk on the polishing plate.<br/>                     -Install the contact to be polished in the polishing tool.<br/>                     -Place the contact and polishing tool assembly on the polishing disk.<br/>                     -Exert a slight pressure on the tool and the contact and polish with a figure of eight motion.<br/>                     -Stop this operation as soon as black traces of metal appear on the paper (traces of abrasion of the end piece) and check the end piece visually.</p> <p>Fine polishing<br/>                     -Install the 9 μ m polishing disk on the polishing plate.<br/>                     -Install the contact to be polished in the polishing tool.<br/>                     -Place the contact and polishing tool assembly on the polishing disk.<br/>                     -Exert a slight pressure on the tool and the contact and polish with a figure of eight motion (between 5 and 10 motions).<br/>                     -Remove the contact and clean the end piece.</p> <p>Polishing Limit<br/>                     - Polishing Limit : Max. 0.1</p> | <p>Remove the protective film from the plate front panel when first using after delivery.</p> <p>It is recommended not to replace the disk during finish polishing of a contact in order to keep its slightly finer grain.</p> <p>Cleaning the disk with ethanol after each use makes it possible to polish more contacts per disk.</p> <div data-bbox="890 775 1158 976" style="text-align: center;">  <p>Coarse polishing</p> </div> <div data-bbox="890 1039 1158 1240" style="text-align: center;">  <p>Fine polishing</p> </div> <div data-bbox="938 1303 1216 1411" style="text-align: center;">  <p>Figure of eight motion</p> </div> <div data-bbox="967 1608 1200 1769" style="text-align: center;">  <p>Polishing Limit</p> </div> |

|   | Procedure  | Notes   |
|---|--|---|
| 6 | <p><b><u>INSPECTION</u></b></p> <p>Check the condition of the optical face with a microscope.</p> <p>The fiber should be free from splinters or big scratches.</p> <p>Male contact wiring is finished.</p> <p>For a female contact, go ahead to next process No.7.</p>   | <p>Microscope</p>   |
| 7 | <p><b><u>ASSEMBLING THE FEMALE CONTACT</u></b></p> <p>7-1. Use press fit tool Ref. T-RCPF3H-01.<br/>See Tool Manual:IJM-T-RCPF3H02</p> <p>Install the socket ferrule in the sleeve slightly by hand.</p>  <p>Socket Ferrule                  Sleeve</p>  <p>7-2. Install the contact on the tool as following figure, and tighten firmly.</p>  <p>7-3. Release the tool and remove the contact.<br/>Female contact wiring is finished.</p> | <p>Be careful not to deform contact clip during assembly operation.</p> <p>After an assembly, Confirm length.</p>  |
| 8 | <p><b><u>OTHERS</u></b></p> <p>8-1. Avoid water, oil, and dust before mating connectors.</p> <p>8-2. If pin contact is bent or a foreign body is fitted over the inside of socket contact, it cannot mate correctly.</p> <p>8-3. Storage conditions</p> <p style="padding-left: 40px;">Temperature :Less than 30°C</p> <p style="padding-left: 40px;">Humidity :Less than 60%</p>  |   |