

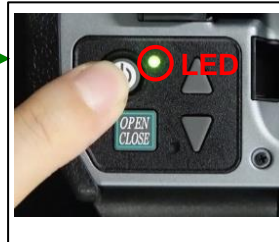
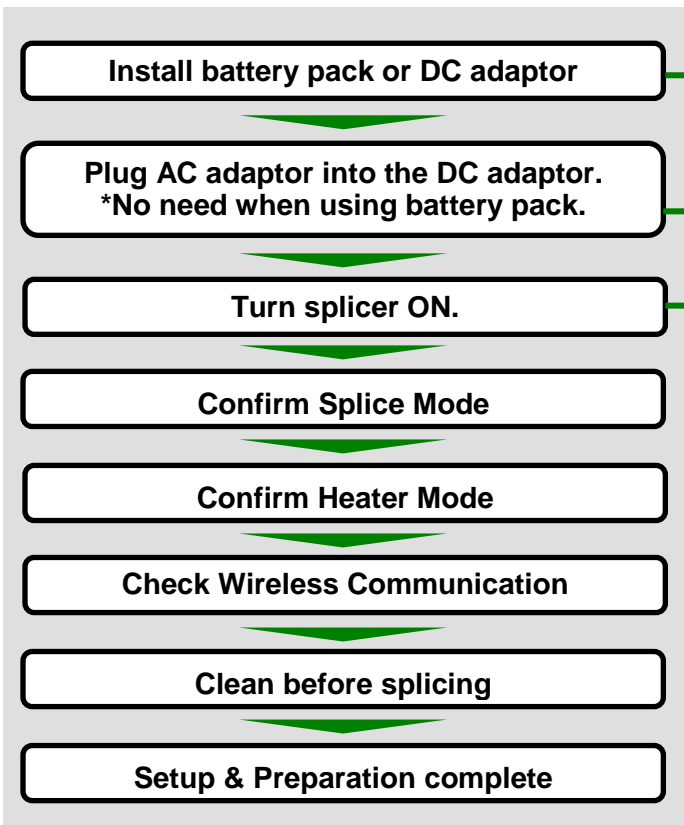
Tools for Splicing Operation



Consumables for cleaning

- Cotton
- Cotton swab
- Alcohol

Setup & Preparation Before Splicing



- **Turning ON**
Press key until **green** LED turns on.
- **Turning OFF**
Press key until **red** LED turns on.

Splice Mode

- Select "**SM AUTO**" to splice standard SM fibers (ITU-T G.652).

Heater Mode

- Select the adequate heater mode according to the sleeve. The [READY] screen shows the current heater mode.
- When using a protection sleeve which is not made by Fujikura, please set parameters based on the specific sleeve.

Wireless communication with accessories

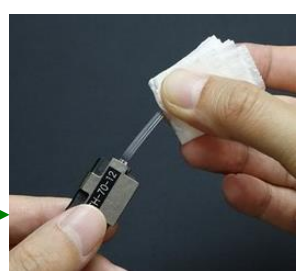
- Splicer can connect to the CT50 cleaver and RS02/03 ribbon stripper.
- When wireless communication is established, the splicer monitors the condition of these tools. If the splicer sees that the tool has an issue, it alerts the operator with an on-screen alarm.
- After initial pairing, the devices are always paired. Communication between splicer, cleaver and stripper resumes automatically even after power cycling.
- Refer to the setting guide "SG-03" or instruction manual for wireless communication function details.



*Basic operations can be performed from the touch screen after the power is turned on.

Splice Operation

- Clean fiber coating/Place protection sleeve
- Set the fiber into fiber holder
- Strip fiber
- Clean fiber
- Cleave fiber
- Load fiber into splicer
- Splicing starts automatically
- Visually inspect monitor during splice
- After splicing, wind protector open
- Grab the fiber at the position marked ◆
- Slide the splice joint to the center of the sleeve.
- Place sleeve in center of tube heater
- Heating starts automatically
- Heater lid opens after finishing heating
- Check shrunk sleeve
- Completed



- Press the holder lid
- Clean the fiber coating as well as the bare fiber.
- Use pure ethyl alcohol, >99%.

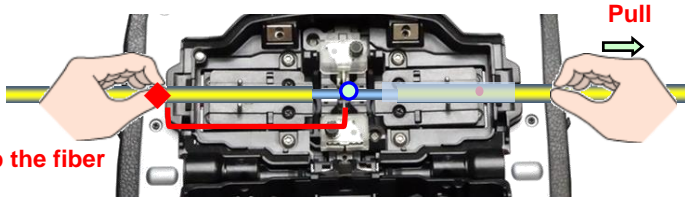


- Press firmly at the points indicated above



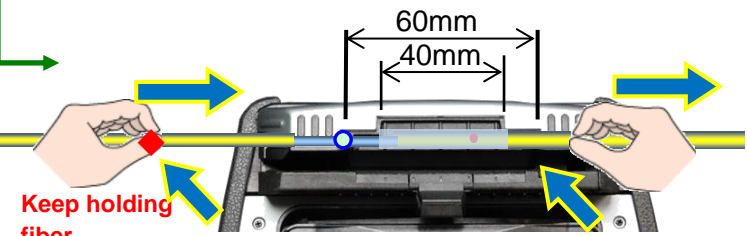
Note

- Place fiber holders in the splicer so that the model number reads left to right. If reversed, you may mismatch fibers.



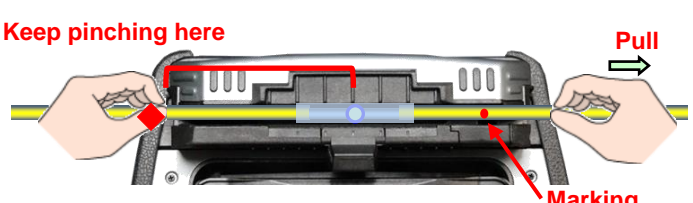
Grab the fiber

Apply proper tension to the fiber during transition to the tube heater to avoid bending of the fiber.



Keep holding fiber

There are two slots, one for 40mm and one for 60mm. Use the appropriate slot according to sleeve size.



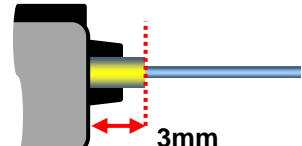
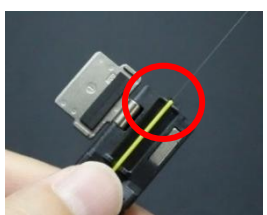
Keep pinching here

Marking

Keep applying tension to the fiber until the heater clamps hold it.

In case of single fiber

When setting a single fiber in the fiber holder, adjust the fiber so 3mm of coating protrudes from the flat front surface of the fiber holder.



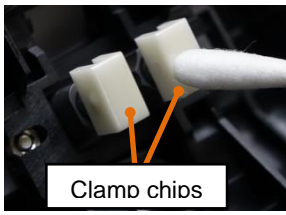
3mm

Tips for single fiber

Marking the fiber coating is convenient to avoid "twisting fiber" during transfer to the heater.

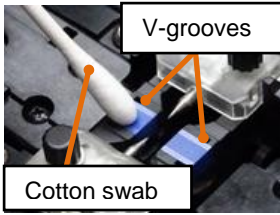
Cleaning before Splice Operation

V-groove Clamps

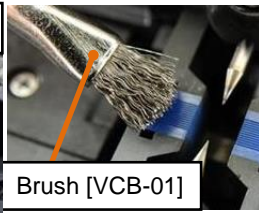


Clamp chips

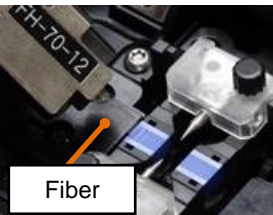
V-grooves



V-grooves
Cotton swab



Brush [VCB-01]



Fiber

Tools

Optical fiber cleaver

- Clean rubber pads.
- Clean rubber anvil.
- Clean cleaving blade.

Ribbon fiber stripper

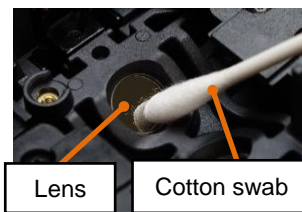
- Clean stripping blade

- Clean the clamp chips and bottom of the V-grooves with a thin lint-free cotton swab moistened with alcohol.
- Remove excess alcohol with a clean dry swab.
- Dislodge debris in the V-groove by using Brush [VCB-01] and/or the cleaved fiber end face if there is a remaining deposit in the bottom of the V-groove.-

Electrode Replacement

- When the “Replace electrodes” message appears, or when the tip is damaged, replace electrodes.
- If the electrodes appear heavily worn, it is recommended to replace the electrodes even if the alarm message hasn’t appeared.
- Execute [Replace Electrodes] in Maintenance Menu.

Objective Lens



Lens
Cotton swab

- When the lens is dirty, clean it with a thin cotton swab moistened with alcohol.
- Remove the electrodes or V groove inserts when cleaning the lenses.
- Take care not to damage the lens surface by using a rigid or hard object when cleaning.

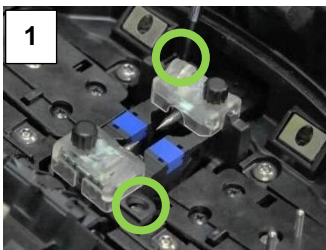
Cleaning Cautions

- Do not allow contact onto the electrode tips.
- Use only 99% or better purity of alcohol.
- Use new lint-free cotton swab every time you clean.

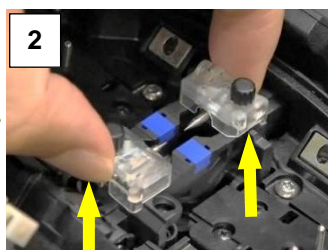
Replacing V-grooves

Using properly cleaned or new V-grooves simplifies fiber viewing and handling when loading ribbons into the splicer. After extended use or improper splicer care, excessive glass particles and debris will accumulate on the V-grooves, making them impossible to clean. This splicer has replaceable V-grooves to solve this problem. Instead of returning for maintenance, users can resume splicing within minutes by replacing the V-grooves.

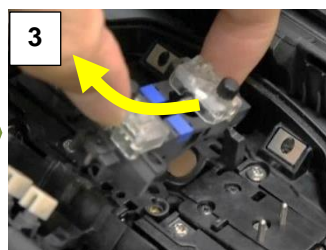
<How to replace>



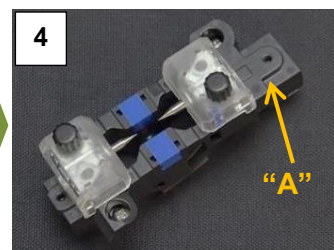
1 Remove two screws.



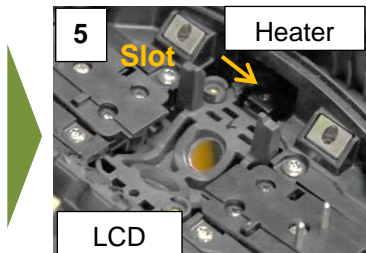
2 First, pull the V-grooves insert straight up



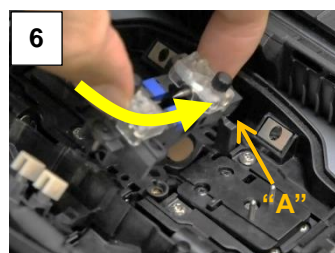
3 Second, rock the V-grooves towards you.



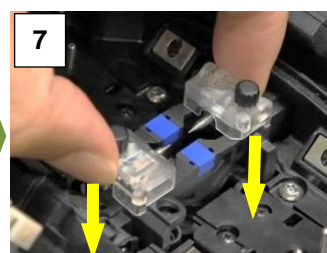
4 Note: V-grooves orientation, use side “A” as reference.



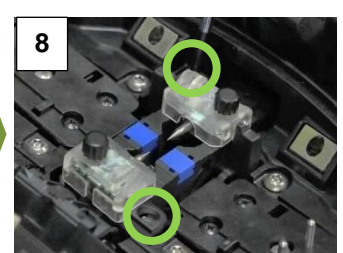
5 There is a slot on the heater side inside of the wind protector.



6 Install V-grooves in splicer such that side “A” is inserted in the slot.



7 Lower V-grooves straight down.



8 Tighten the screws to secure. Proper torque is 20cNm.

Solutions for Common Splicer Errors

Error Message	Reason	Solution
Too Long Fiber	<ul style="list-style-type: none"> The fiber end-face is placed on the electrode centerline, or beyond it The cleave length (bare fiber part) is too long Dust or dirt is on the objective lens 	<ul style="list-style-type: none"> Press RESET, and set the fiber end-face between the electrode centerline and the V-groove edge. Confirm the set position of the stripped fiber end on the fiber cleaver. Check the cleave length. Execute [Dust Check]. Clean the lens when dust or dirt exists.
Too Dusty Fiber	<ul style="list-style-type: none"> Dust or dirt is on the fiber surface Dust or dirt is on the objective lens. [Cleaning Arc] time is too short or "OFF." 	<ul style="list-style-type: none"> Completely prepare the fiber again (strip, clean and cleave). Execute the [Dust Check]. Clean the lens if dust or dirt exists. Increase the [Cleaning Arc] time in small increments.
ZL/ZR Motor Overrun	<ul style="list-style-type: none"> The bare fiber is too far back and does not reach the electrodes. The cleave length (bare fiber) is too short. 	<ul style="list-style-type: none"> Press RESET, re-position the fiber again with the end-face closer to the electrodes. Confirm the set position of the stripped fiber end on the fiber cleaver. Check the cleave length.
Large Cleave Angle	<ul style="list-style-type: none"> Bad fiber end-face [Cleave Limit] is set too low 	<ul style="list-style-type: none"> Check the condition of the fiber cleaver. If the blade is worn, rotate the blade to a new position. If dirty, clean clamp pads, anvil, or blade. Load the default value from the splice mode database.
Cleave Shape NG	<ul style="list-style-type: none"> Bad fiber end-face 	<ul style="list-style-type: none"> Clean and check the condition of the fiber cleaver. If the blade is worn, rotate the blade to a new position. If dirty, clean clamp pads, anvil, or blade.
High Estimated Loss	<ul style="list-style-type: none"> Dust or dirt is on the fiber surface Bad fiber end-face Unstable arc discharge 	<ul style="list-style-type: none"> Completely prepare the fiber again (strip, clean and cleave). Check the condition of the fiber cleaver. If the blade is worn, rotate the blade to a new position. Electrodes might be worn. Perform [Electrode Stabilization] or replace electrodes.

*This table only shows a few possible errors. Refer to the instruction manual for a more comprehensive list.



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