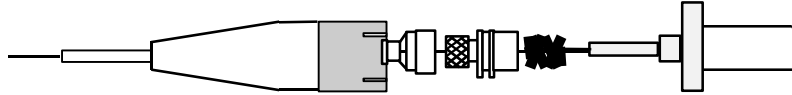


**FINAL SC CONNECTOR ASSEMBLY**  
**RISER ASSEMBLY MANUFACTURING INSTRUCTIONS**

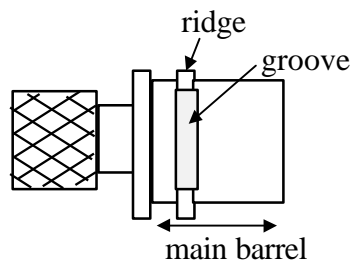
10 Tools: inner housing mounting vice, crimpers

Parts: boot with furcation tube, crimp, stopper, and spring installed on the fiber, as follows:

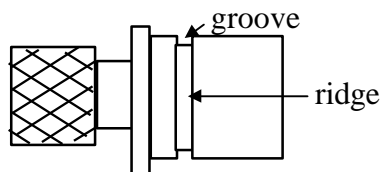


Check the TDR for correct final assembly, part number, and style of SC connector, followed by the latest parts listing for numbers for these needed parts: inner housing (part no. A2E00035-01), outer housing (A2E00036-01), and dust cap (A2E00037-01).

20 It is critical to note the stopper construction looking from the side with two different rotations. In the first view, a ridge appears sticking up above the main barrel of the stopper, and on the side at the same point of the barrel, there is a groove, as shown:

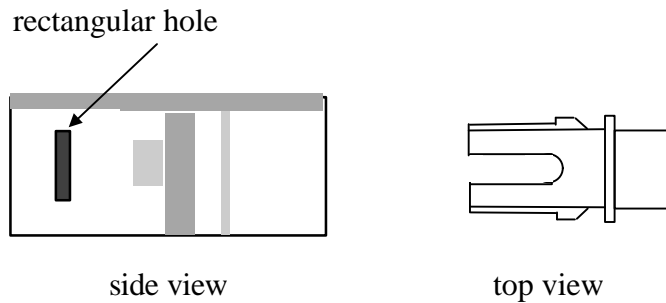


When the stopper is rotated 90 degrees, the groove will be seen dipping into the profile of the barrel, like the following:

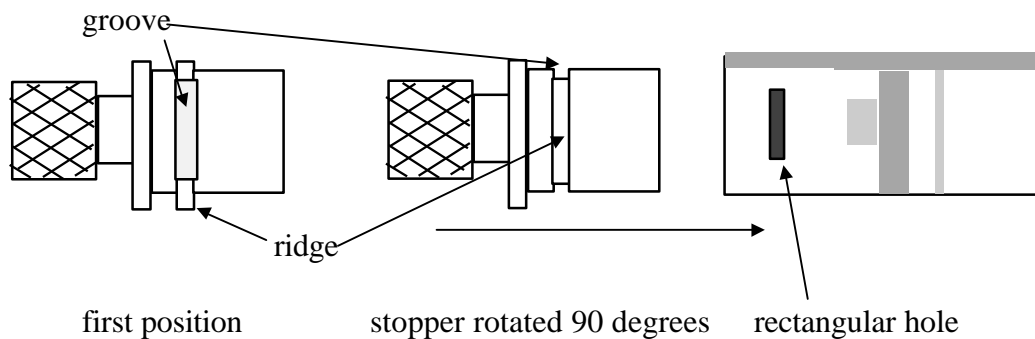


The groove is where the ridge was, and the ridge is where the groove was on the side.

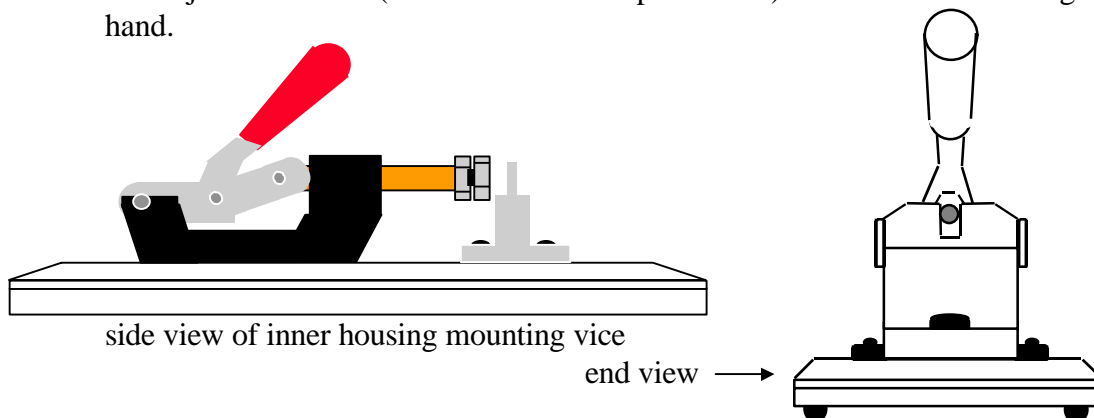
- 30 The following assembly procedure will mount the SC connector inner housing onto the existing assembly. Note the construction of the inner housing when it is rotated 90 degrees. The left view in the diagram shows a rectangular hole in the housing.



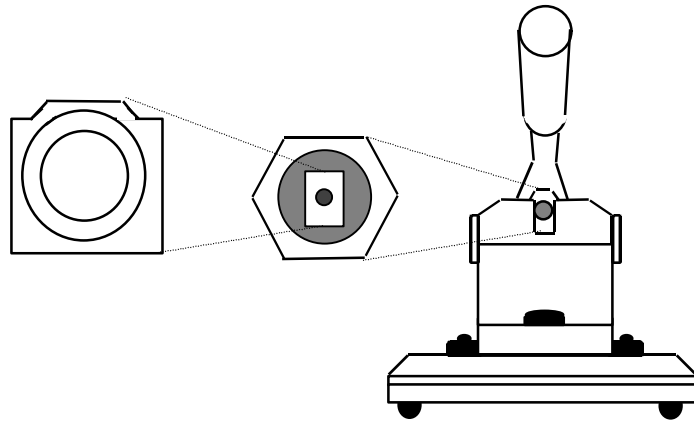
The ridge on the stopper is supposed to snap into the rectangular hole in the inner housing, as shown, here.



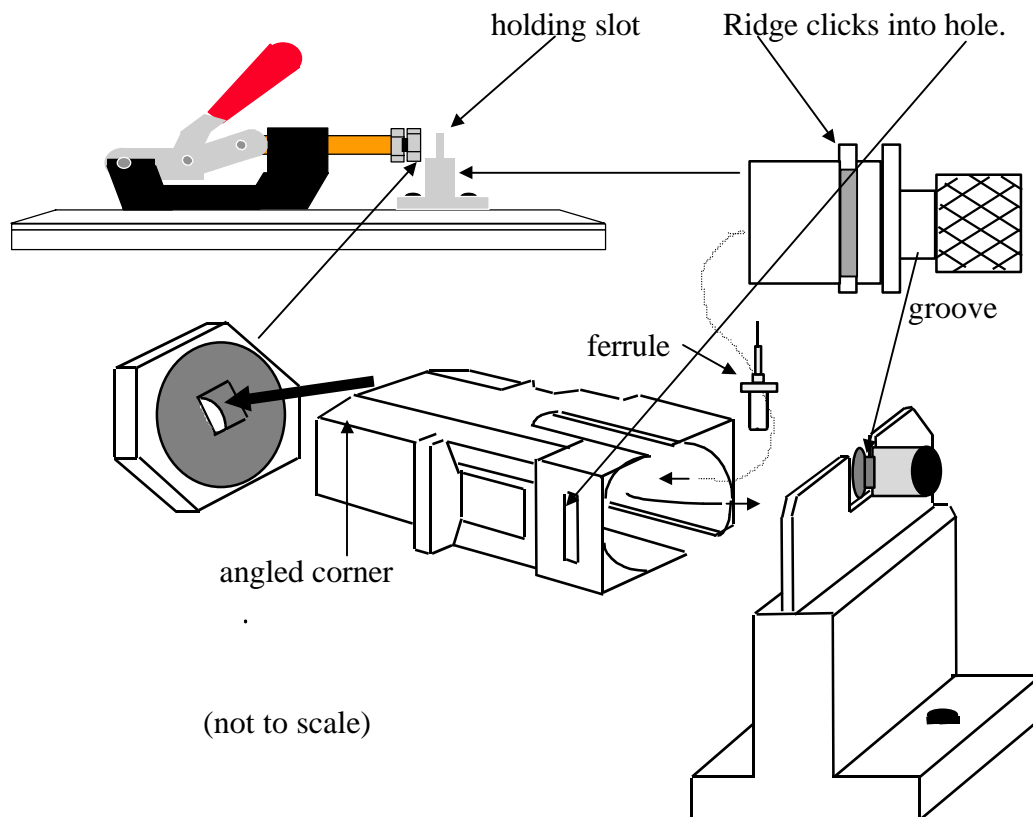
- 40 When new at mounting SC connector inner housings, use the inner housing mounting vice, illustrated below. For more experienced users, it may be sufficient to use just the holder (which exists as a separate tool) and install the housing by hand.



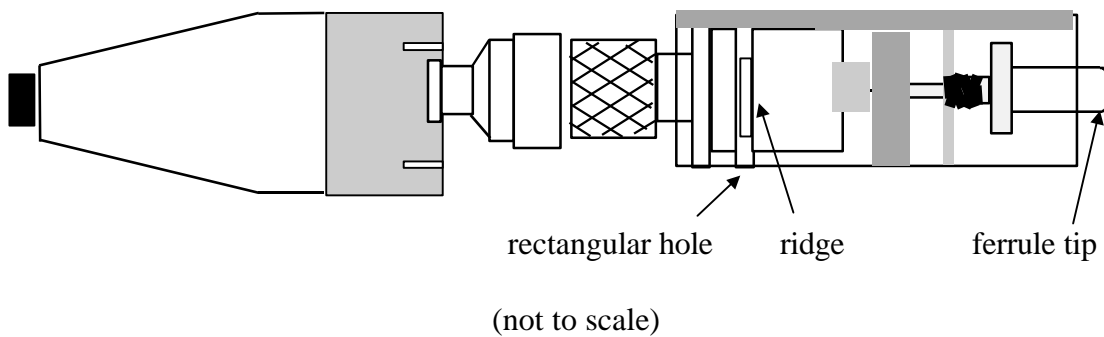
The end of the plunger has a recessed rectangle to receive the corresponding end of the inner housing. There is only one end capable of fitting into the plunger end. Go ahead and place the inner housing into the recessed rectangle.



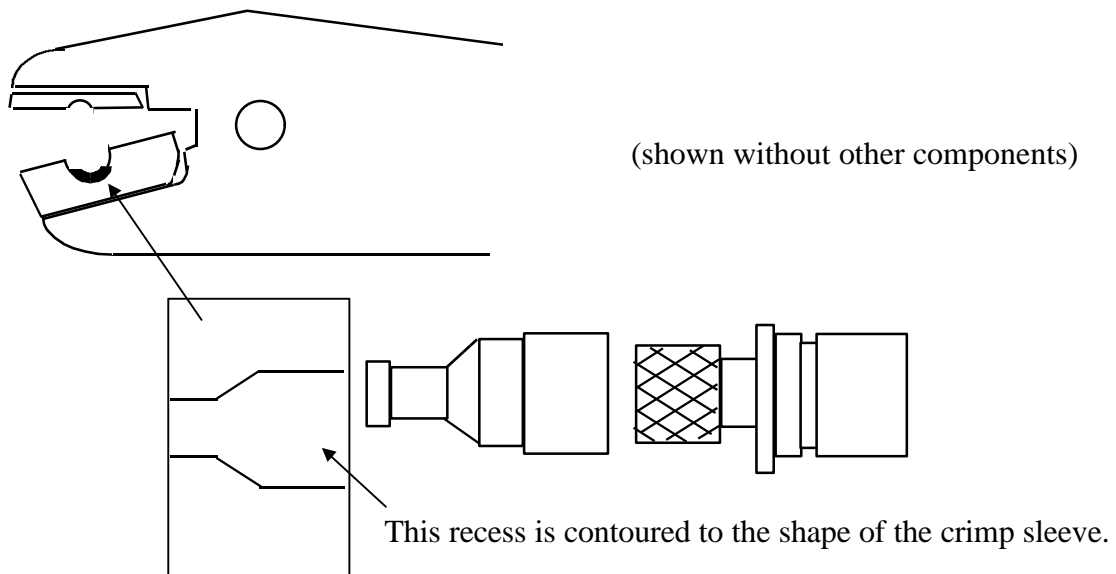
- 50 Just in front of the knurled part of the stopper assembly is a groove. This groove fits into the holding slot in the inner housing mounting vice. The ridges on the stopper are facing sideways. Make sure the angled corner on the end of the inner housing is facing up with the ferrule tip ready to be pushed in from the other end.



- 60 With the inner housing mounted in the rectangular hole at the end of the plunger, and the stopper side ridge properly aligned sideways and the groove down in the slot on the holder, bring the handle of the plunger forward so that the inner housing flares out a bit and slips over the stopper. The ferrule tip should be pushing through the hole at the bevel end of the inner housing. As the housing slides over the stopper, the ridges will engage the rectangular holes on the sides of the housing with a small “click.” The assembly should look like the following when removed from the vice:

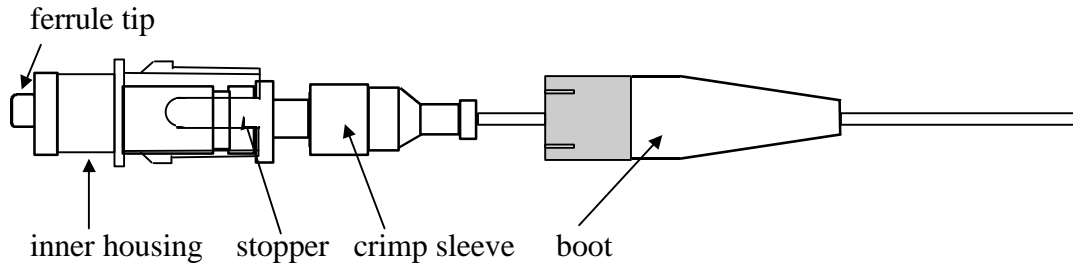


- 70 Crimping the sleeve over the knurled part of the stopper is next. Examine the crimping pliers and see how the crimp sleeve fits into the groove in the pliers' bottom jaw.

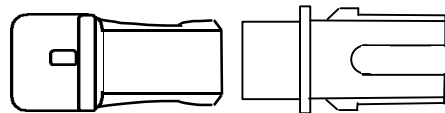


- 80 Making sure that the clear furcation tubing is inserted properly into the boot, the crimp sleeve is all the way up the knurled stem of the stopper, clamp down on the sleeve until the pliers stop clicking. Release the handles and remove the assembly.

At this point, the assembly should look like parts overlaid onto each other to show placement):

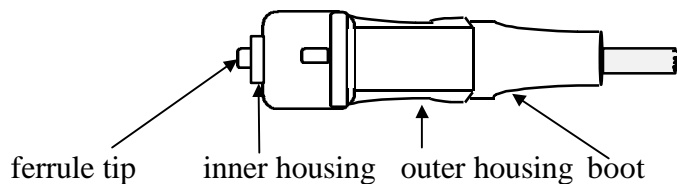


- 90 Slide the boot up onto the end of the crimp sleeve until the ears of the inner housing snap into the slots of the outer housing. Make sure that the inner housing is oriented correctly before insertion. The ferrule tip goes in first.



(shown without other components for clarity)

If everything has been done correctly, the final connector assembly will look like the following:



- 100 Fill out TDR according to the following figure:

Key/Assy:	Your initials	<div style="border: 1px solid black; padding: 5px; display: inline-block;">TDR</div>
Date:	Date work was done	
Inspect:	Inspect for: correct assembly of parts	