

## For P2020C-C-125 and P2020F-Z-125 Connectors With 0.9 mm Buffered or Strength Buffered Jacket (SBJ) Fibers

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### ⇒ NOTE:

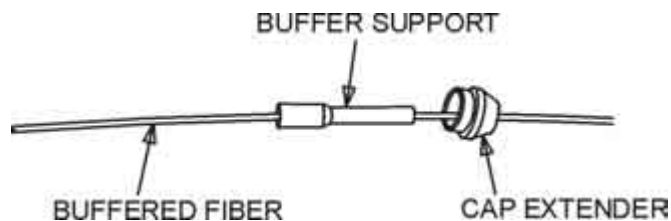
#### Recommended Usage Temperatures for Adhesive:

Storage: -5 C to 30 C (23 F to 86 F)

Installation: 0 C to 38 C (32 F to 100 F)

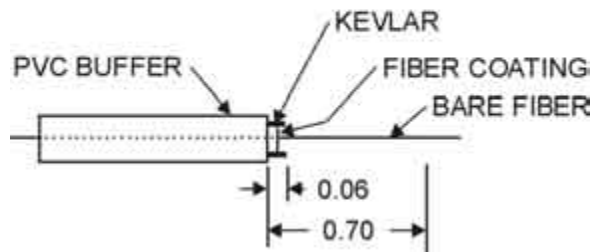
Operating: -40 C to 75 C (-40 F to 167 F)

1. Shake the bottle of adhesive and primer vigorously. Remove the cap from the bottle of adhesive. If the adhesive has not been opened, poke a hole in the tip of the nozzle with a straight pin. Remove the plunger and cap from a syringe and load the adhesive into the syringe. Replace the plunger and twist a syringe tip into place. As a second option, simply twist a syringe tip onto the nozzle of the adhesive bottle making sure that it fits snugly. Also, place a syringe tip onto a 3 cc syringe and twist to lock it in place. Remove the top from the bottle of primer and draw 0.5 cc of primer into the syringe (**Note:** Once the installation procedure has been completed, any extra primer in the syringe may be returned to the original bottle; however, the syringe tip should be removed to avoid getting adhesive which may be on the tip mixed in with the primer).
2. Slip the buffer cap (cap extender) and the buffer support onto the buffered fiber to be terminated.



3. Prepare the buffered fiber as shown below using the appropriate tools. The outer jacket may be removed with the 700A Stripping Tool. Clean the stripped fiber with a wipe dampened with isopropyl alcohol to remove any residual coating.

### BUFFERED or SBJ



4. Using the syringe with the primer in it, apply primer to 0.25 inches of the buffer. Avoid getting the primer on the fiber. If several connectors are being terminated, it is recommended that all of the buffers be primed before moving on to the next step.
5. Make sure that the hole in the connector tip is clear of any foreign matter. Use music wire to clear the hole if necessary. Place a wipe on the work table. Using the syringe, place a drop of primer on the wipe. Wipe the end of the connector through the primer on the wipe one time.
6. Gently insert the syringe tip on the adhesive into the back of the connector until it bottoms and inject the adhesive into the connector until a bead of adhesive forms on the tip of the ferrule. The adhesive bead should cover at least 1/2 of the ferrule end face. Withdraw the syringe tip from the connector but maintain pressure on the bottle or syringe to fill the back end of the connector with the adhesive.
7. **IMMEDIATELY** insert the fiber through the connector, carefully feeling for the ferrule capillary. Rotate the connector as the fiber is inserted to allow the fiber to pass through the connector without hanging up. Once the fiber has been fully inserted, use the syringe to place a drop of primer over the bead of adhesive on the ferrule end face. Be careful not to break the fiber. Seat the fiber into the connector making sure the buffer is completely seated against the ceramic inside the connector. Slip the buffer support onto the connector barrel and rotate the support to allow for proper adhesive distribution. Apply a drop of Loctite Super Bonder to the threads of the buffer cap (cap extender). Slip the cap extender over the buffer support and screw the extender into the connector body. Again, make sure that the fiber is fully seated into the connector and place a micro clip (1043A Tool) on the buffer support to make sure the fiber is not inadvertently pulled out of the connector. Place the installed connector in a 600A or 600B Connector Holder to protect the exposed fiber. Place the assembly in the 971A-1 Holder Block. Allow the adhesive to cure at least one (1) minute.

8. Remove the 600A or 600B Connector Holder(s). Carefully wipe any uncured adhesive from around the fiber where it protrudes from the adhesive bead using the edge of a wipe. Be careful not to break the exposed fiber. Using a light sawing motion with a cleaving tool (the 975A Cleaving Tool may be used), score the fiber at the crest of the adhesive bead. Using a gentle straight pull, remove the exposed fiber. **DO NOT BEND AND BREAK THE FIBER, A STRAIGHT PULL WILL YIELD A BETTER CLEAVE!** With the connector ferrule pointing upward, polish the cleaved fiber down flush with the adhesive bead by running the brown side of a sheet of Type A Paper over the fiber using light circular or figure-8 strokes. This will reduce the risk of breaking the fiber during the next polishing step.
9. Clean the polishing plate and the 400A, 400B, or 1510A Polishing Tool with a wipe moistened with isopropyl alcohol. Blow the plate and polishing tool dry with compressed air.
10. Place a sheet of Type A (brown foam-backed) Polishing Paper onto the glass plate, foam side down. Starting with extremely light pressure, polish the connector on the Type A Paper using figure-8 strokes. (**Note: EXTREMELY** light pressure should be used during the first few polishing strokes to avoid breaking the fiber.) Polish the connector until a shiny halo can be observed around a thin layer of adhesive remaining on the tip. Start with a fresh area of the polishing paper for each connector to be polished.
11. Place the Type C (gray mylar-backed) Polishing Paper onto the glass plate (glossy side down). One wipe can be used under the Type C polishing paper for the first few figure-8s, to protect the fiber. Using figure-8 strokes, polish the connector until all of the remaining adhesive is removed. Start with a fresh area of the paper for each connector being polished.
12. Remove the connector from the polishing tool and clean both the connector and tool with a wipe dampened with isopropyl alcohol. Then use canned air to dry the connector tip. Remove the 1043A Micro Clip if used.
13. Inspect the fiber end using the 300B Microscope. (**CAUTION: Do not use a laser or LED to illuminate the core area for viewing.**) An acceptable fiber end is free of cracks, chips, or scratches in the core area. If the fiber is unacceptable, the fiber must be reterminated.
14. If the fiber end is acceptable and the connector is not to be used immediately, cover the end with the protective cap.

## For P2020C-C-125 and P2020F-Z-125 Connectors With Jacketed Single-Fiber Cables

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### ⇒ NOTE:

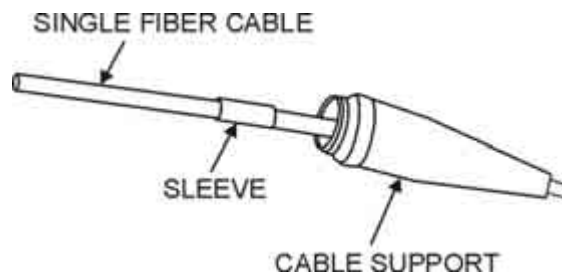
Recommended Usage Temperatures for Adhesive:

Storage: -5 C to 30 C (23 F to 86 F)

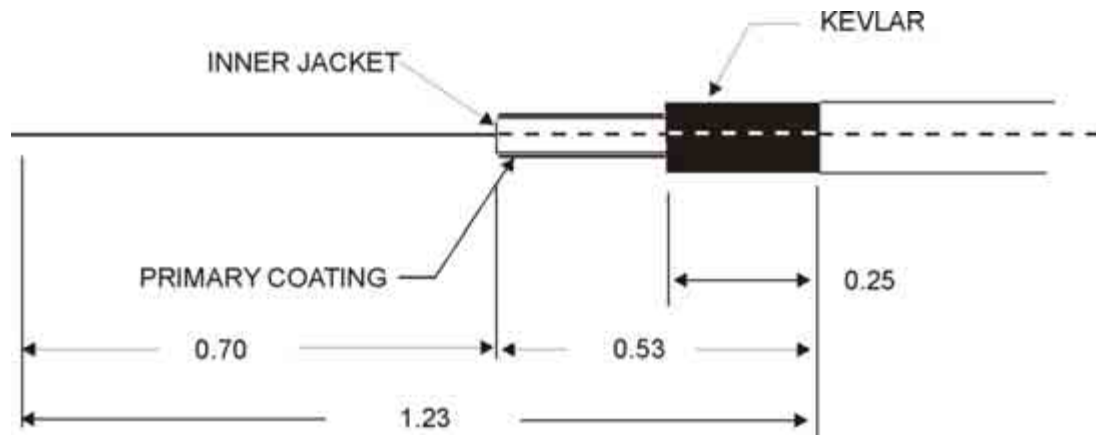
Installation: 0 C to 38 C (32 F to 100 F)

Operating: -40 C to 75 C (-40 F to 167 F)

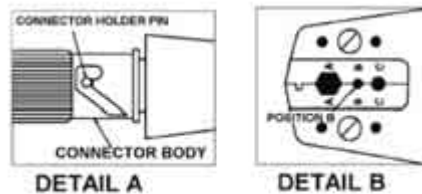
1. Shake the bottle of adhesive and primer vigorously. Remove the cap from the bottle of adhesive. If the adhesive has not been opened, poke a hole in the tip of the nozzle with a straight pin. Remove the plunger and cap from a syringe and load the adhesive into the syringe. Replace the plunger and twist a syringe tip into place. As a second option, simply twist a syringe tip onto the nozzle of the adhesive bottle making sure that it fits snugly. Also, place a syringe tip onto a 3 cc syringe and twist to lock it in place. Remove the top from the bottle of primer and draw 0.5 cc of primer into the syringe (Note: Once the installation procedure has been completed, any extra primer in the syringe may be returned to the original bottle; however, the syringe tip should be removed to avoid getting adhesive which may be on the tip mixed in with the primer).
2. Slip the cable support and the appropriate crimp sleeve onto the cable .



3. Prepare the single-fiber cable as shown using the appropriate tools. The outer jacket may be removed with the 700A Stripping Tool. If 1800 or 2000 Series Cordage is being terminated, the MS1-08N-5B5-FS40 Stripping Tool may be used to remove the buffer. If 9000 Series Cordage is being terminated, the 1026A Heat-Strip Tool (CC# 105514764) is recommended. Clean the stripped fiber with a wipe dampened with isopropyl alcohol to remove any residual coating.



4. Using the syringe with the primer in it, apply primer to 0.25 inches of the buffer. Avoid getting the primer on the fiber and the strengthening yarn. If several connectors are being terminated, it is recommended that all of the buffers be primed before moving on to the next step.
5. Make sure that the hole in the connector tip is clear of any foreign matter. Use music wire to clear the hole if necessary. Place a wipe on the work table. Using the syringe, place a drop of primer on the wipe. Wipe the end of the connector through the primer on the wipe one time.
6. Gently insert the syringe tip on the adhesive into the back of the connector until it bottoms and inject the adhesive into the connector until a bead of adhesive forms on the tip of the ferrule. The adhesive bead should cover at least 1/2 of the ferrule end face. Withdraw the syringe tip from the connector but maintain pressure on the bottle or syringe to fill the back end of the connector with the adhesive.
7. **IMMEDIATELY** insert the fiber through the connector, carefully feeling for the ferrule capillary. Rotate the connector as the fiber is inserted to allow the fiber to pass through the connector without hanging up. Once the fiber has been fully inserted, use the syringe to place a drop of primer over the bead of adhesive on the ferrule end face. Be careful not to break the fiber.
8. Slip the crimp sleeve over the outer jacket of the cable and strengthening yarn and onto the connector barrel. Place the installed connector in a 600A or 600B Connector Holder to protect the fiber. Position the 600A or 600B Connector Holder pins onto the connector body as shown in Detail A.



9. This will allow the sleeve to be fully exposed for crimping. Before crimping, make sure the sleeve is butted against the connector. Place position B (for 2.4 mm cable) of the 102A Crimping Tool over the sleeve so that the first two indentations on the sleeve will appear over the connector barrel and the third appears over the cable jacket. This will insure a good crimp and prevent cable rotation. Squeeze the crimping tool handles until they release. Rotate the connector 90 degrees and crimp again. (**Note:** Use position C on the crimping tool for 3 mm cable). Place a drop of Loctite Super Bonder on the threads of the cable support. Slip the support over the crimped sleeve and screw the support into the connector body. Place the assembly in the 971A-1 Holder Block. Allow the adhesive to cure for at least one (1) minute.
10. Remove the 600A or 600B Connector Holder(s). Carefully wipe any uncured adhesive from around the fiber where it protrudes from the adhesive bead using the edge of a wipe. Be careful not to break the exposed fiber. Using a light sawing motion with a cleaving tool (the 975A Cleaving Tool may be used), score the fiber at the crest of the adhesive bead. Using a gentle straight pull, remove the exposed fiber. **DO NOT BEND AND BREAK THE FIBER, A STRAIGHT PULL WILL YIELD A BETTER CLEAVE!** With the connector ferrule pointing upward, polish the cleaved fiber down flush with the adhesive bead by running the brown side of a sheet of Type A Paper over the fiber using light circular or figure-8 strokes. This will reduce the risk of breaking the fiber during the next polishing step.
11. Clean the polishing plate and the 400A, 400B, or 1510A Polishing Tool with a wipe moistened with isopropyl alcohol. Blow the plate and polishing tool dry with compressed air.
12. Place a sheet of Type A (brown foam-backed) Polishing Paper onto the glass plate, foam side down. Starting with extremely light pressure, polish the connector on the Type A Paper using figure-8 strokes. (**Note:** **EXTREMELY** light pressure should be used during the first few polishing strokes to avoid breaking the fiber.) Polish the connector until a shiny halo can be observed around a thin layer of adhesive remaining on the tip. Start with a fresh area of the polishing paper for each connector to be polished.

13. Place the Type C (gray mylar-backed) Polishing Paper onto the glass plate (glossy side down). One wipe can be used under the Type C polishing paper for the first few figure-8s, to protect the fiber. Using figure-8 strokes, polish the connector until all of the remaining adhesive is removed. Start with a fresh area of the paper for each connector being polished.
14. Remove the connector from the polishing tool and clean both the connector and tool with a wipe dampened with isopropyl alcohol. Then use canned air to dry the connector tip. Remove the 1043A Micro Clip if used.
15. Inspect the fiber end using the 300B Microscope. (**Caution:** Do not use a laser or LED to illuminate the core area for viewing.) An acceptable fiber end is free of cracks, chips, or scratches in the core area. If the fiber is unacceptable, the fiber must be reterminated.

## Ordering Information

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### 1032F Tool Kit (Comcode 106736929)

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Kit Quantity	Description	Replacement CC#	Replacement Quantity
1	102A Crimping Tool	104389903	1 Tool
1	300B Microscope	104412077	1 Microscope
1	400B Polishing Tool	105246185	1 Tool
12	600A Connector Holders	104153937	12 Holders
1	700A Stripping Tool	104278478	1 Tool
1	MS1-08N-5B5-FS40 Strip Tool	105257414	1 Tool
2	971-A-1 Holder Blocks	104229398	1 Holder
1	975A Cleaving Tool	103808770	1 Tool
1	Scissors	105257364	2 Scissors
1	6-inch Scale	105257356	5 Scales
1	Alcohol Bottle	105257463	2 Bottles
1	Glass Plate	105075618	2 Plates
1	1 Stripping Tool (R4366)	105114581	1 Tool
1	Instruction Manual	105536718	1 Manual
15	Micro Clips (1043A)	106228455	15 Micro Clips
1	1039A Template (1039A)	106075146	5 Templates
1	Eye Loupe	N.A.	



**D-182668 Kit (Comcode 106731367)**

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The D-182668 Kit of Consumables contains consumables to install 50 multimode ST Connectors. The kit includes fifty (50) P2020C-C-125 Connectors.

<b>Kit Quantity</b>	<b>Description</b>	<b>Replacement CC#</b>	<b>Replacement Quantity</b>
2 Pkgs.	Wipes	105205678	250 Sheets
1 Vial	Music Wire	105071013	4 Vials
15 Syringes	Syringes	105257422	10 Syringes
25 Tips	Dispensing Tips	105157879	125 Tips
1 Bottle	Adhesive	106730856	1 Bottle
1 Bottle	Primer	106730849	1 Bottle
25 Sheets	Type A Polishing Paper	105488175	100 Sheets
25 Sheets	Type C Polishing Paper	105076798	100 Sheets
1 Copy	Instruction Sheet	106746647	1 Copy
1 Copy	Instruction Sheet (ST II+)	107107799	1 Copy
50	P2020C-C-125 Connectors	105143911	1 Connector

**640-252-044-01**  
**Instruction Sheet**

**D-182709 Kit (Comcode 106736937)**

The D-182709 Kit of Consumables contains consumables to install 500 multimode ST Connectors. The P2020C-C-125 Connectors are not included in this kit.

<b>Kit Quantity</b>	<b>Description</b>	<b>Replacement CC#</b>	<b>Replacement Quantity</b>
10 Pkgs.	Wipes	105205678	250 Sheets
5 Vial	Music Wire	105071013	4 Vials
75 Syringes	Syringes	105257422	10 Syringes
125 Tips	Dispensing Tips	105157879	125 Tips
2 Bottles	Adhesive	106730856	1 Bottle
2 Bottles	Primer	106730849	1 Bottle
125 Sheets	Type A Polishing Paper	105488175	100 Sheets
125 Sheets	Type C Polishing Paper	105076798	100 Sheets
2 Copies	Instruction Sheet	106746647	1 Copy