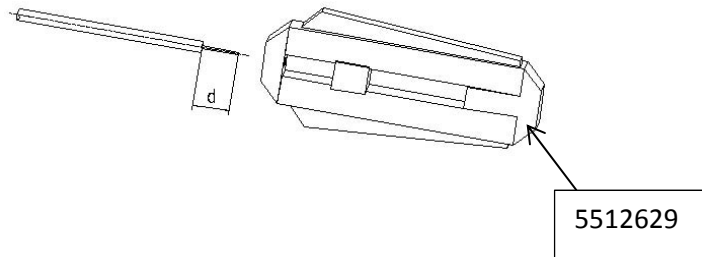
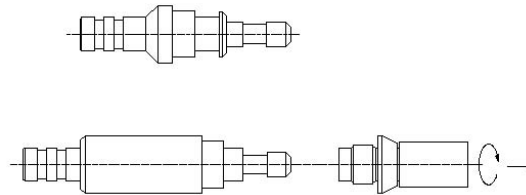


POF Contact Assembly

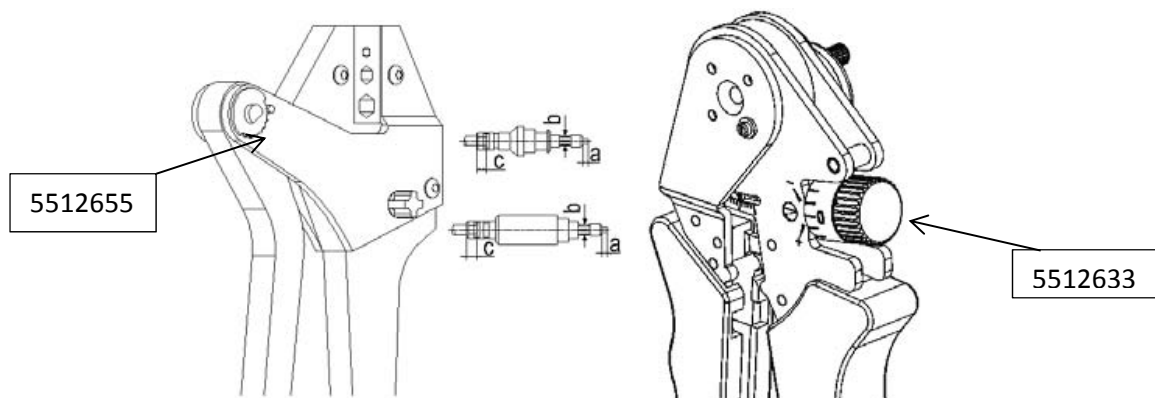
1. Strip the outer jacket of the POF cable to min. 9 mm (d) for the male contact and min. 13 mm (d) for the female contact.



2. Insert the stripped POF cable into the proper contact. Make sure the fiber protrudes 1 mm (a) out of the contact. For the female contact the barrel has to be screwed off in beforehand.

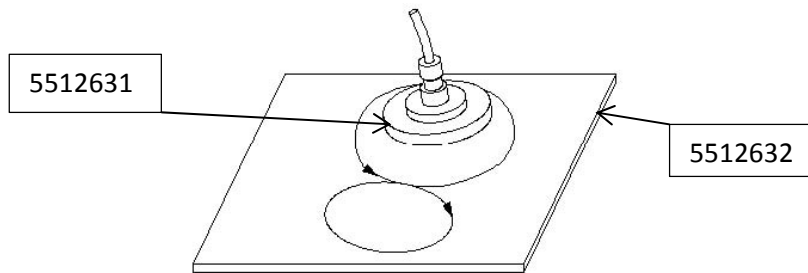


3. Crimp the mating side of the contact using the four point concentric crimping tool. Make sure the four point concentric crimping tool is calibrated properly using \varnothing 1.8 mm pin gauge (b) and locator position 3. (Please respect the manufacturer's instruction sheet).



4. Crimp the strain relief part of the contact, approximately 4 mm (c) long from the cable jacket, using the FO crimping tool. When crimping the strain relief, make sure the contact is positioned in SW 3 mm cavity.

5. The protruding fibre is polished by means of a polishing block (7 mm depth) with grain size 1000. Make sure polishing is performed on a flat and solid surface. The very tip of the contact can be polished with a 9 μ grain size polishing paper.



6. The barrel has to be screwed onto the female contact. Make sure that the snap ring has the correct position.

