

**1. Glenair Recommended Fiber Strip Dimensions:**

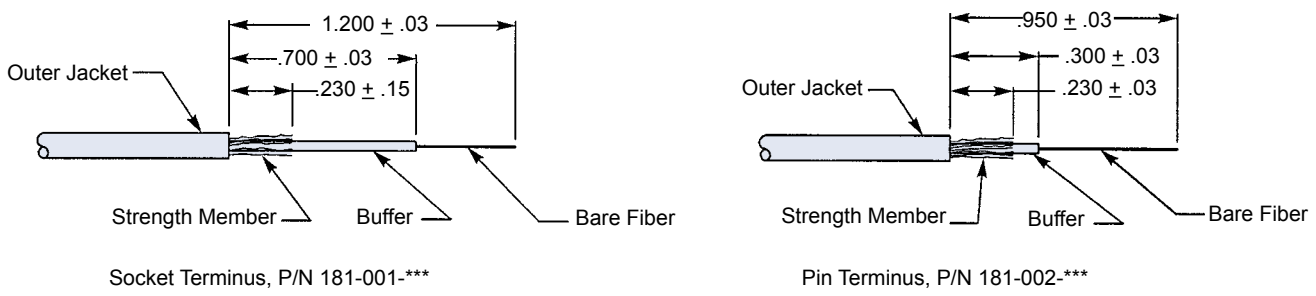


Figure 1

**2. Glenair Recommended Adhesives:**

- Tra-Bond, Tra-Con BAF 113SC (Heat Cure 1 Hr. @ 65°C or 24 Hr. Air Cure). For applications -55° to +150°C.
- EPO-TEC 353ND (Ramped Heat Cure: 30 Min. @ 80°C, 30 Min. @ 100°C, 10 Min. @ 150°C). For applications -65°C to +150°C.

**3. Termination Steps:**

- Install Terminus Shrink Sleeve
- Measure and Strip Fiber to Appropriate Length per Figure 1.
- Fill Syringe with Adhesive (No Air Bubble Should be Present).
- Completely Fill Terminus with Epoxy.
- Evenly Distribute Strength Member Over Rear of Terminus.
- Slide Sleeve to Base of Terminus and Heat Shrink using Heat Gun (Do Not Overheat the Fiber).
- Clean Terminus Body Using Isopropyl Alcohol.
- Add a Small Bead of Epoxy to the Tip of the Terminus (See Figure 2).

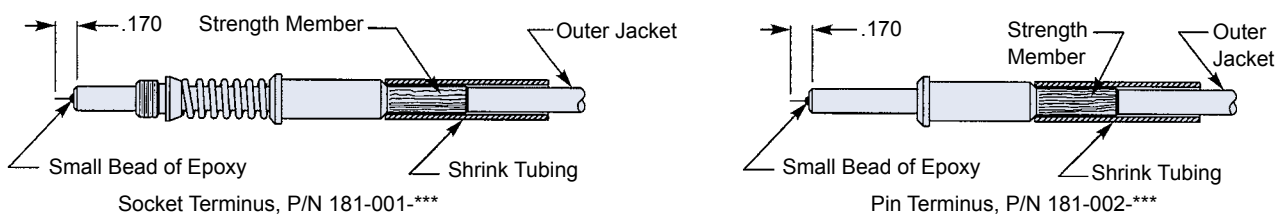


Figure 2

4. Cure Termination using Curing Oven.
5. Cleave Excess Fiber using Fiber Scribe.
6. Polishing Procedure:

- STEP 1: Use 9 Micron Diamond Film to Remove adhesive.
- STEP 2: Use 3 Micron Diamond Film to Polish.
- STEP 3: Use 1 Micron Diamond Film for Final Polish.
- STEP 4 (Singlemode Only): Polish using 65-70 Shore Rubber Pad and with .1 or .3 Micron Diamond Film.

7. Visually Inspect Fiber Termination at 200X Magnification. Core Area Must be Free of Epoxy, Scratches, Pits, and Cracks.

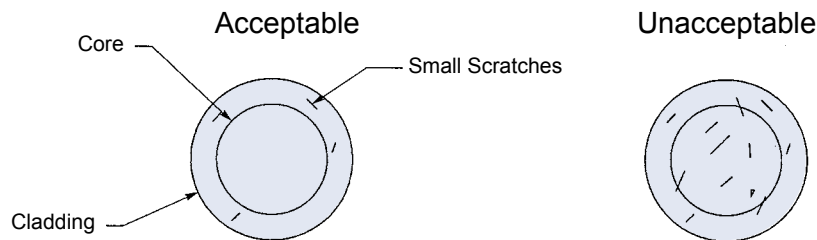


Figure 3

8. Socket Terminus Alignment Sleeve and Protective Cover Installation:

- Install Ceramic Sleeve.
- Apply "Loctite 222" on 3 Full Threads of the Terminus
- Screw Protective Cap onto Terminus Until Fully Seated.

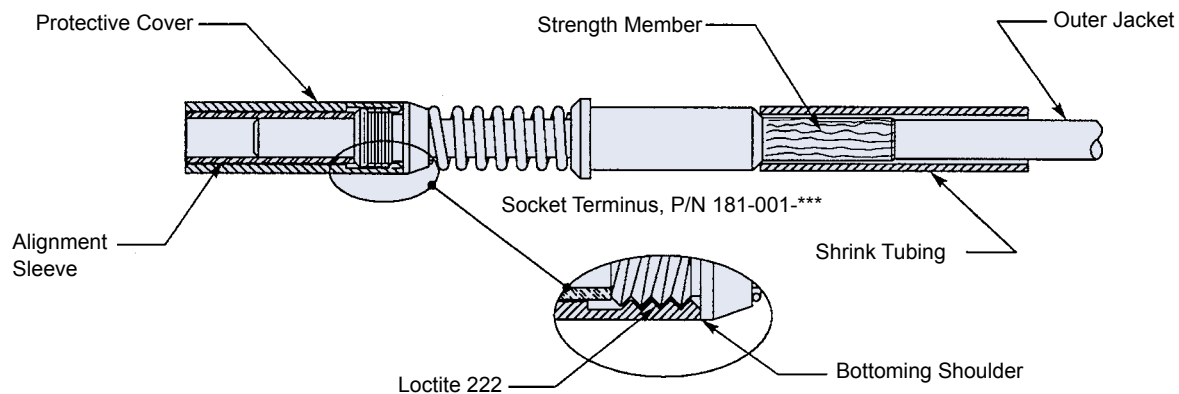


Figure 4