



Assembly Instruction for Fiber Optic Series  
FO2-4  
Fischer Connectors



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## 1 Introduction

This document covers :

- The application of Fischer FiberOptic Series electrical contacts and optical termini to electrical and fiber optic cables (singlemode and multimode fibers)
- The assembly of fiber optic cable with a cladding size of 125 µm and having the cable structure described in Fischer FiberOptic Series Cable Specifications
- The assembly of Fischer FiberOptic Series electrical contacts and optical termini and Rear Accessory sets (Wire, Cable Clamp and Potting sets) to Fischer FiberOptic Series 2/4 channel connectors (referred as FO2-4 in the present document)

Please read these instructions thoroughly before starting assembly.

## 2 Document history

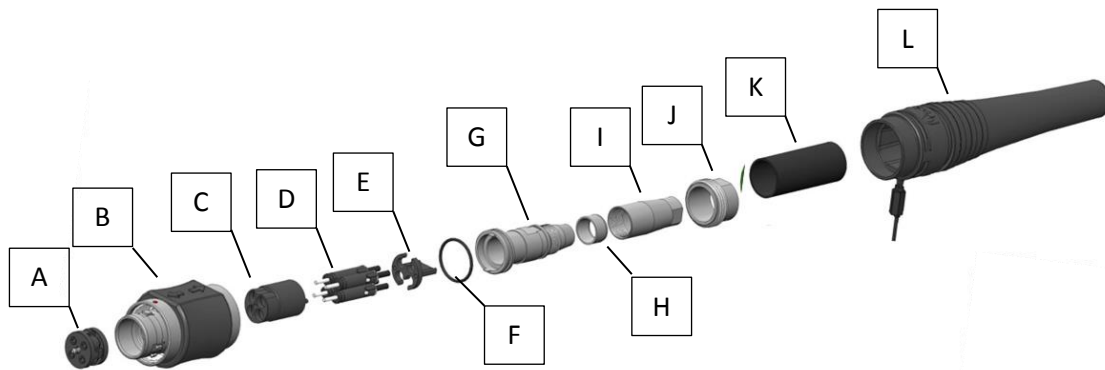
Date	Revision #	Author	Controller	Modification description
15.03.2017	6.0	JGY	SRH/CMI	New Document

## 3 Definitions and Acronyms

Text	Definition / Acronym
FO	Fischer FiberOptic
FO2/4	Fischer FiberOptic Series two channels or four channels-2/4 fiber
IEC	International Electrotechnical Commission

## 4 F02-4 Plugs & Receptacles with Cable Clamp Set

### Assembly steps



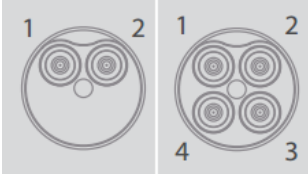
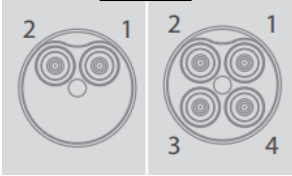
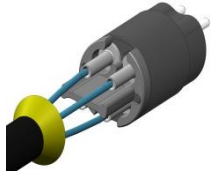
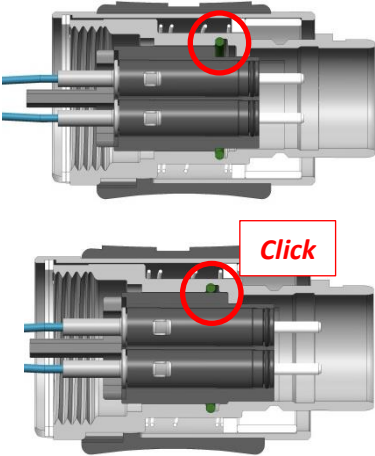
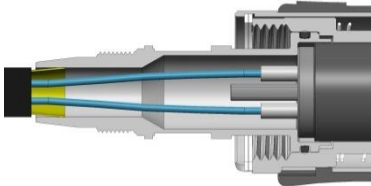
Components list :

- A – Sleeve Holder
- B – Connector Body
- C – Insulator
- D – Termini
- E – Support Washer
- F – O-ring Seal
- G – Clamp Set Body
- H – Conical Ring
- I – Clamp Nut
- J – Rear Nut
- K – Shrink Tube
- L – Bend Relief

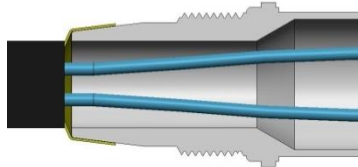
Note : the pictures shown in this section represent a P01 Plug.

The following assembly steps are valid for P01 plug, as well as R01, R03, R13 and R50 receptacles, except the final step (sleeve holder assembly).

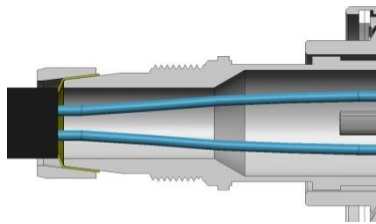
Picture	Process	Tools
	<p>Slide over the cable :</p> <ul style="list-style-type: none"> <li>- the Bend Relief "L"</li> <li>- the Shrink Tube "K"</li> <li>- the Rear Nut "J"</li> <li>- the Clamp Nut "I"</li> <li>- the Conical Ring "H"</li> <li>- the Clamp Set Body "G"</li> <li>- the O-Ring Seal "F"</li> </ul>	
	<p>Strip the cable to the dimensions as given on the picture.</p>	<p>Ruler, aramid shears, jacket stripper, and strip tool</p>
<b>Terminus assembly : See section 7</b>		
<b>Polishing: See section 8</b>		
	<p>Insert all the termini "D" into the insulator "C".</p> <p>When you insert the terminus "D", be careful to turn it during the insertion to not "bend" the contact O-ring.</p>	

<div style="text-align: center; border: 1px solid black; padding: 2px; width: fit-content; margin: 0 auto;">Receptacle</div>  <div style="text-align: center; border: 1px solid black; padding: 2px; width: fit-content; margin: 10px auto;">Plug</div> 	<p>Pin Layout front view.</p>	
	<p>Place the Support Washer "E" around the termini "D".</p>	
	<p>Push the contact bloc (termini "D" + insulator "C") with the Support Washer "E" until it clips.</p>	
	<p>Position the O-Ring Seal "F" on the Clamp Set Body "G" then slide the Clamp Set Body "G" into the Connector Body "B".</p>	

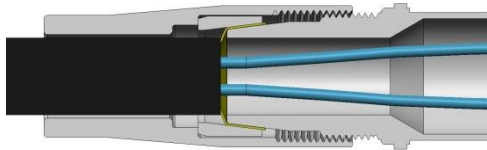
Assembly instructions Rev6.0



Screw by hand the Rear Nut "J" on the Connector Body "B", then uniformly distribute the cable strength members around the back of the Clamp Set Body "G".



Position the Conical Ring "H" against the strength members.



Screw by hand the clamp nut "I" on the back body clamp "G".



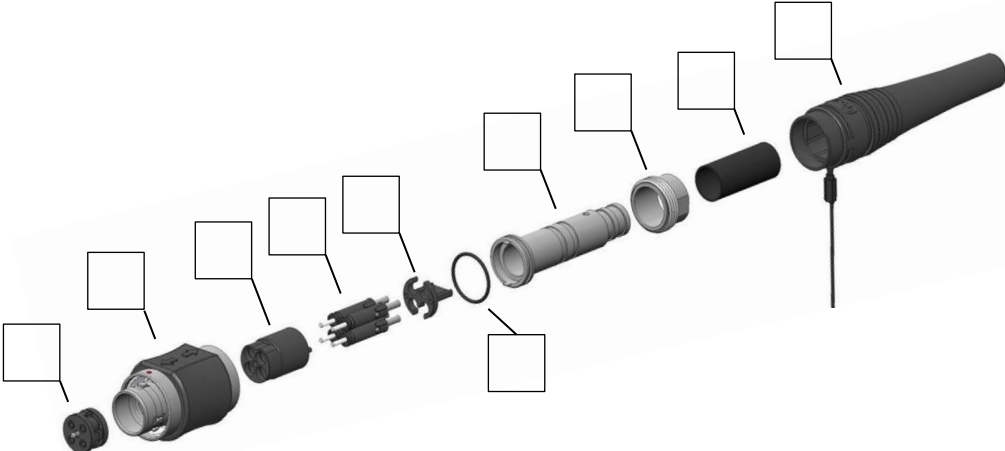
Screw the Rear Nut "J"  
Recommended torque : 5.0 Nm

Torque wrench [5Nm]  
**Size 13**  
Counter piece:  
receptacle FO2/4

Assembly instructions Rev6.0


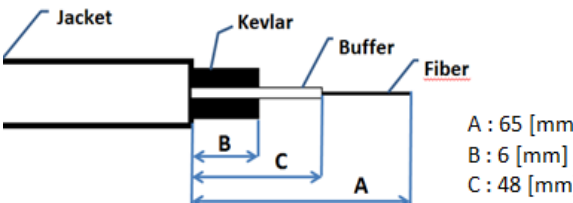
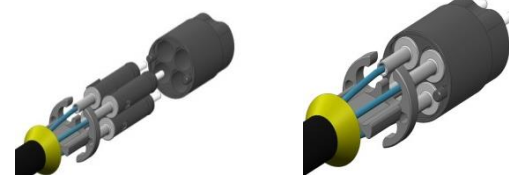
	<p>Screw the Clamp Nut "I".</p> <p>Recommended torque : 5.0 Nm</p> <p>Note : hold the Clamp Set Body with a wrench while screwing the Clamp Nut "I".</p>	<p><b>Torque wrench [3Nm]</b> Size 9</p> <p>Wrench size 10!</p>
	<p>Slide the Shrink Tube "K" until the end of the shrink tube bottoms against the Back Nut "J" and heat it.</p>	<p>Heat gun</p> <p>Shrink tube operating temperature Range : -55°C to 110°C.</p>
	<p>Apply epoxy on the Shrink Tube "K" and slide the Bend Relief "L" until the end of the bend relief bottoms against the Back Nut "J".</p>	<p>Epoxy: RT-355 Resintech</p>
	<p>Insert Sleeve Holder "A" in the Connector Body "B".</p> <p>Note : there is no sleeve holder for R01, R03,R13 and R50 receptacles. Thus, this final assembly step is valid only for P01 plug.</p>	

## 5 F02-4 Plugs & Receptacles with Potting Set

Assembly steps	
	<p>Components list :</p> <ul style="list-style-type: none"> <li>A – Sleeve Holder</li> <li>B – Connector Body</li> <li>C – Insulator</li> <li>D – Terminus</li> <li>E – Support Washer</li> <li>F – O-ring Seal</li> <li>G – Potting Set Body</li> <li>H – Rear Nut</li> <li>I – Shrink Tube</li> <li>J – Bend Relief</li> </ul>

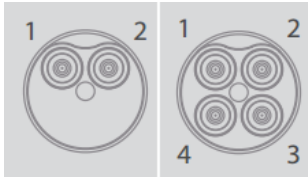
Note : the pictures shown in this section represent a P01 Plug.

The following assembly steps are valid for P01 plug, as well as R01, R03, R13 and R50 receptacles, except the final step (sleeve holder assembly).

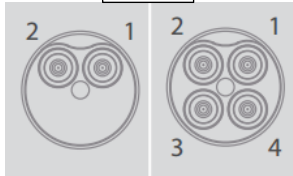
Picture	Process	Tools
	<p>Slide over the cable :</p> <ul style="list-style-type: none"> <li>- the Bend Relief "J"</li> <li>- the Shrink Tube "I"</li> <li>- the Rear Nut "H"</li> <li>- the Potting Set Body "G"</li> <li>- the O-Ring Seal "F"</li> </ul>	
 <p>A : 65 [mm] B : 6 [mm] C : 48 [mm]</p>	<p>Strip the cable to the dimensions as given on the picture.</p>	<p>Ruler, aramid shears, jacket stripper, and strip tool</p>
<b>Terminus assembly : See section 7</b>		
<b>Polishing: See section 8</b>		
	<p>Insert all the termini "D" into the insulator "C".</p> <p>When you insert the terminus "D", be careful to turn it during the insertion to not "bend" the contact O-ring.</p>	



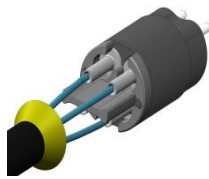
Receptacle



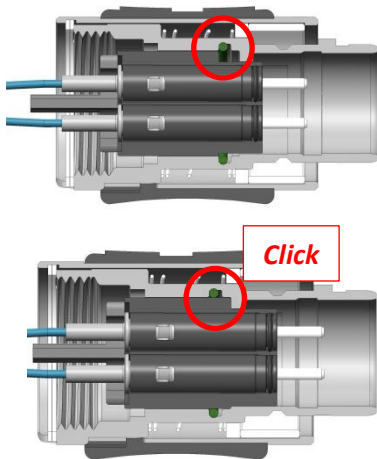
Plug



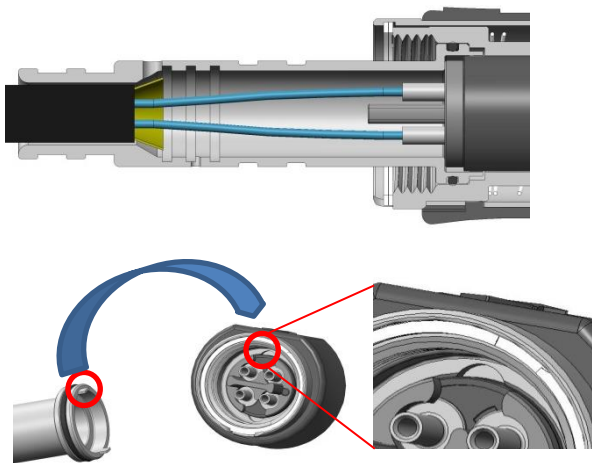
Pin Layout front view.



Place the Support Washer "E" around the termini "D".



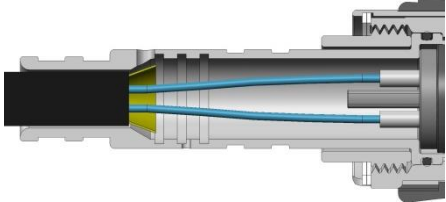

Push the contact bloc (termini "D" + insulator "C") with the Support Washer "E" until it clips.



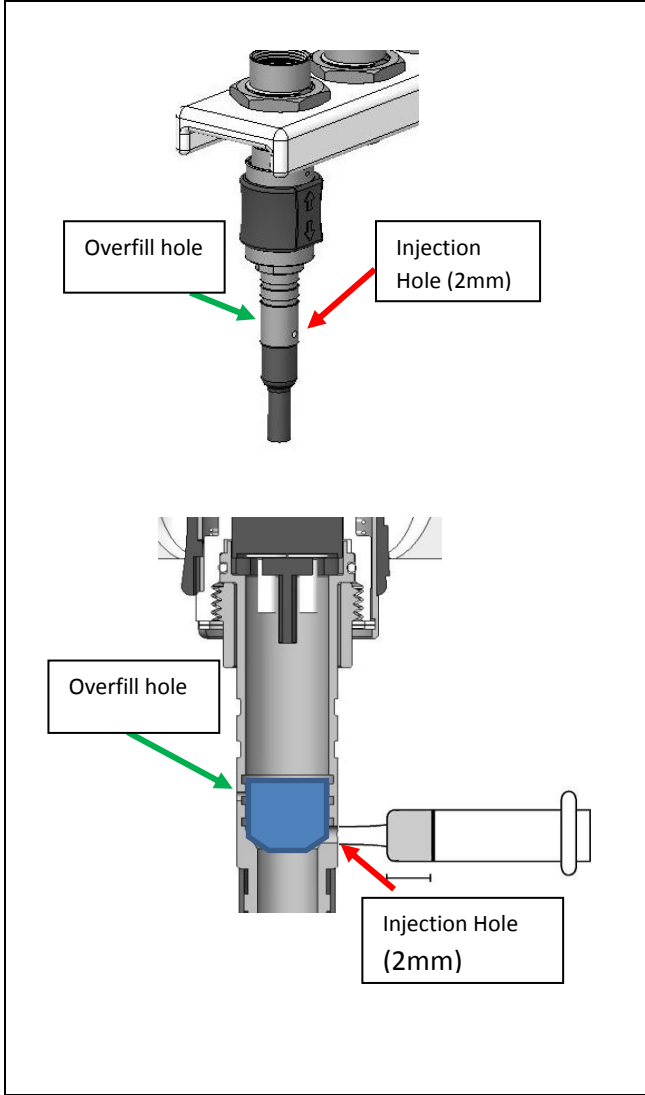
Position the O-Ring Seal "F" on the Potting Set Body "G" then slide the Potting Set Body "G" into the Connector Body "B".

Be careful to the orientation of the back body.

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	<p>Screw by hand the Rear Nut "H" on the Connector Body "B".</p>	
	<p>Screw the Rear Nut "G". Recommended torque : 5.0 Nm</p>	<p>Torque wrench [5Nm] <b>Size 13</b> Counter piece: receptacle FO2/4</p>
	<p>Slide the Shrink Tube "I" until the end of the shrink tube bottoms against the Potting Set Body "G" as shown on the left picture and heat it.</p>	<p>Heat gun  Shrink tube operating temperature Range : -55°C to 110°C..</p>

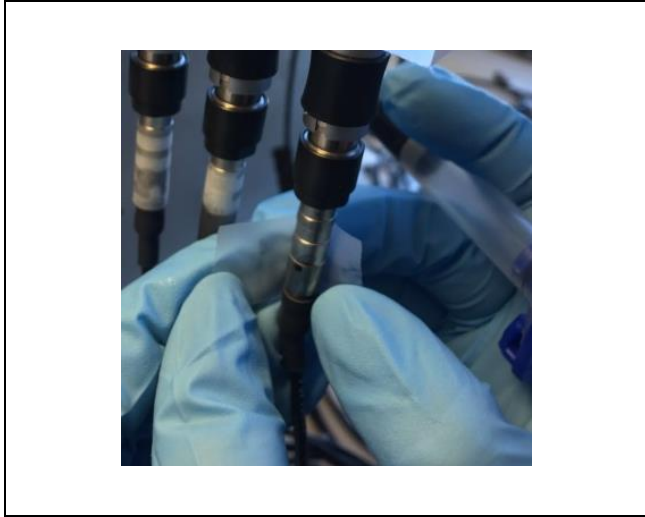
Assembly instructions Rev6.0



Slowly inject the epoxy inside the Potting Set Body "G" using the filling hole located at the bottom of the Potting Set Body "G".

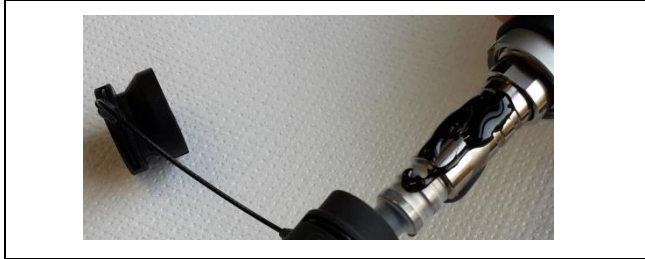
Note : the second hole, smaller and located above the filling hole, is an overfilling hole. Stop injecting epoxy when epoxy starts to flow from this overfilling hole.

Resin Epoxy RS 851-044 Black



Remove any excess epoxy from the assembly (if any), apply tape on both filling and overfilling holes and place the assembly onto the curing oven block.

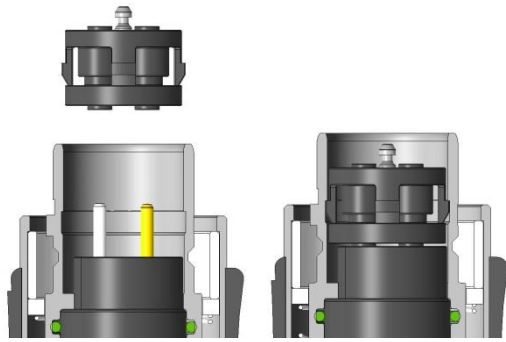
Curing time : 12 hours @ approx. 23°C.



Apply epoxy on the Shrink Tube "I" and slide the Bend Relief "J" until the end of the Bend Relief "J" bottoms against the Back Nut "H".

Epoxy: RT-355 Resintech

## Assembly instructions Rev6.0

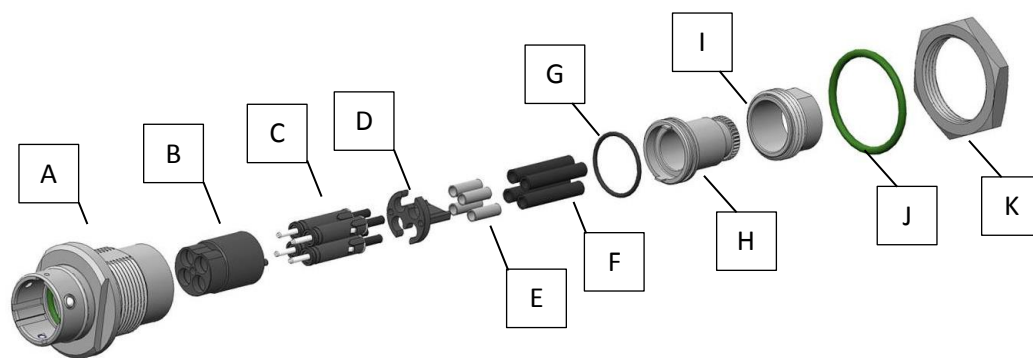


Insert Sleeve Holder "A" in the Connector Body "B".

Note : there is no sleeve holder for R01, R03,R13 and R50 receptacles. Thus, this final assembly step is valid only for P01 plug.

## 6 F02-4 R01, R03 & R13 Receptacles with Wire Set

### Assembly steps




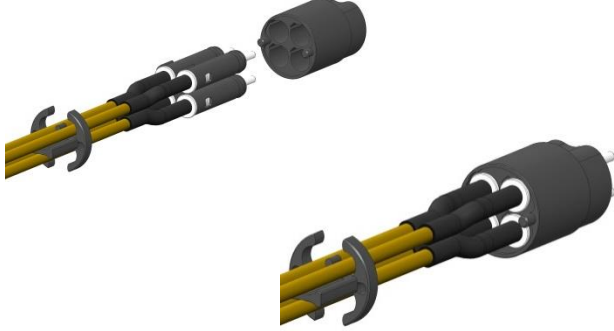
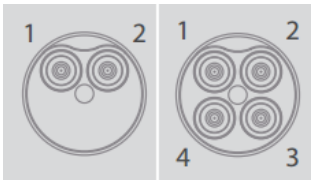
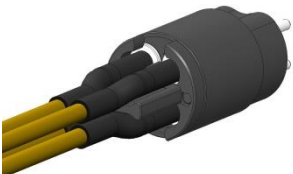
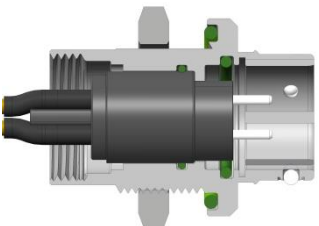
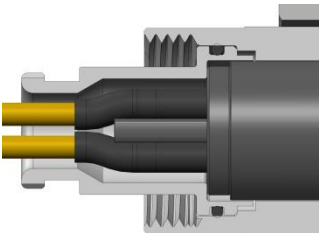
#### Components list :

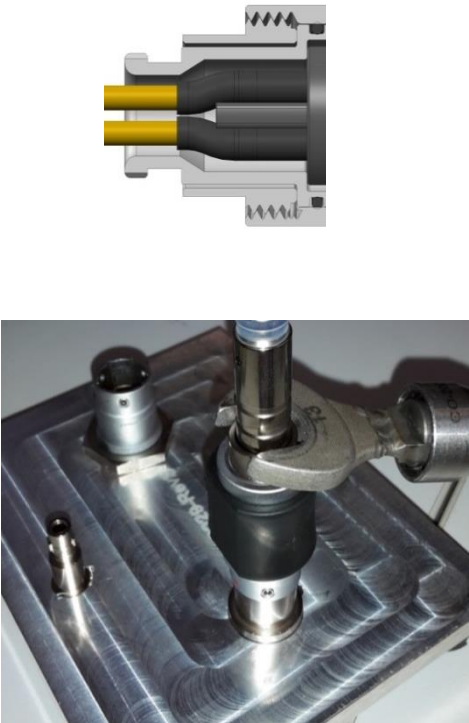
- A – Connector Body
- B – Insulator
- C – Terminus
- D – Support Washer
- E – Crimp Sleeve
- F – Shrink Tube
- G – O-ring
- H – Wire Set Body
- I – Wire Set Nut
- J – Connector Panel Seal
- K – Connector Nut

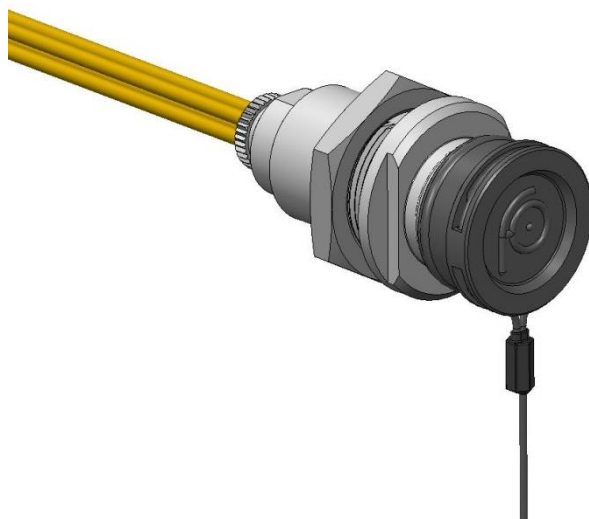
Note : the pictures shown in this section represent a R03 receptacle.

The following assembly steps are valid for R01 & R13 receptacles as well.

Picture	Process	Tools
	Slide over the cable : <ul style="list-style-type: none"> <li>- the Wire Set Nut "I"</li> <li>- the Wire Set Body "H"</li> <li>- The O-ring "G"</li> <li>- the Shrink Tube "F"</li> <li>- the Crimp Sleeve "E"</li> </ul>	
	Strip the cable to the dimensions as given on the picture.	Ruler, aramid shears, jacket stripper, and strip tool
<b>Terminus assembly : See section 7</b>		
	Uniformly distribute the cable strength members around the back of the Terminus "B".	
	Slide the Crimp Sleeve "E" over the cable strength members until the end of the crimp sleeve bottoms against the Terminus "B".	Find tools drawing in annexes.

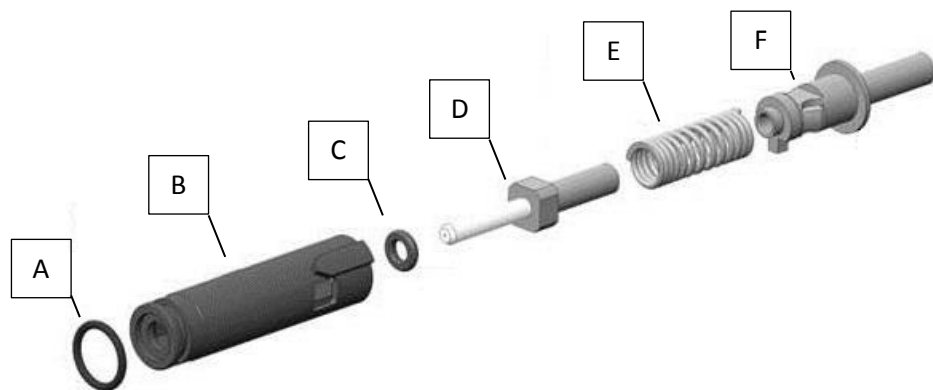
Picture	Process	Tools
	<p>Slide the Shrink Tube "F" over the Crimping Sleeve "E" and heat it.</p>	<p>Heat gun Shrink tube operating temperature Range : -55°C to 110°C.</p>
<b>Polishing: See section 8</b>		
	<p>Insert all the termini "C" into the insulator "B".</p> <p>When you insert the terminus "C", be careful to turn it during the insertion to not "bend" the contact O-ring.</p>	
<p style="text-align: center;">Receptacle</p> 	<p>Pin Layout front view.</p>	
	<p>Place the Support Washer "D" around the termini "C".</p>	
	<p>Push the contact bloc (termini "C" + insulator "B") with the Support Washer".</p>	
	<p>Insert the Wire Set Body "H" into the Connector Body "A".</p>	

Picture	Process	Tools
 <p>The 'Picture' column contains two images. The top image is a technical cross-section drawing of a connector assembly, showing two yellow wires inserted into a grey connector body. A nut is being tightened onto the back of the connector. The bottom image is a photograph showing a torque wrench being used to tighten a nut on a metal assembly mounted on a workbench.</p>	<p>Screw the Wire Set Nut "I" on the Connector Body "A".</p> <p>Recommended torque : 5.0 Nm</p>	<p>Torque wrench [5Nm] <b>Size 13</b></p>





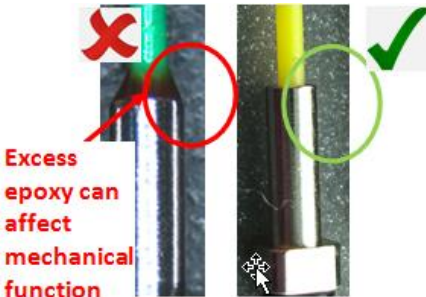

## 7 Terminus assembly

### Assembly steps

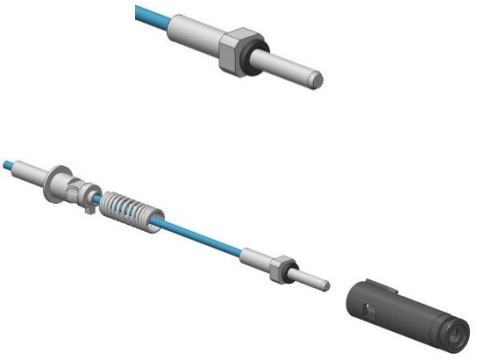
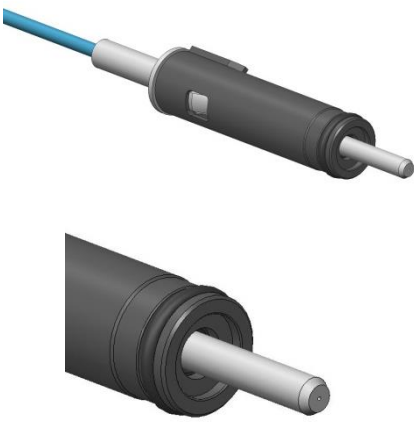


Components list :

- A – Housing O-Ring
- B – Termini Housing
- C – Ferrule O-Ring
- D – Ferrule
- E – Spring
- F – Termini Closure

Picture	Process	Tools
	Slide over the cable : <ul style="list-style-type: none"> <li>- the Termini Closure "F"</li> <li>- the Spring "E"</li> </ul>	
<b>Prepare the cable according to stripping dimension from the relevant section.</b>		
	Insert epoxy into the Ferrule "D" until a little drop appears at the ferrule end.  Carefully insert the fiber into the back of the Ferrule "D and make sure the buffer slides inside the ferrule the buffer bottoms on the ceramic.	Extended Working Life, 2-Part Epoxy, 2.5 Gram Packet Frs : FIBER OPTIC CENTER Ref : ET383ND-2.5G
	Remove any excess epoxy from the assembly	
	Cure the epoxy	120 +10/- 20[°C] during 20min.
	Cleave fiber	Scribe Tool

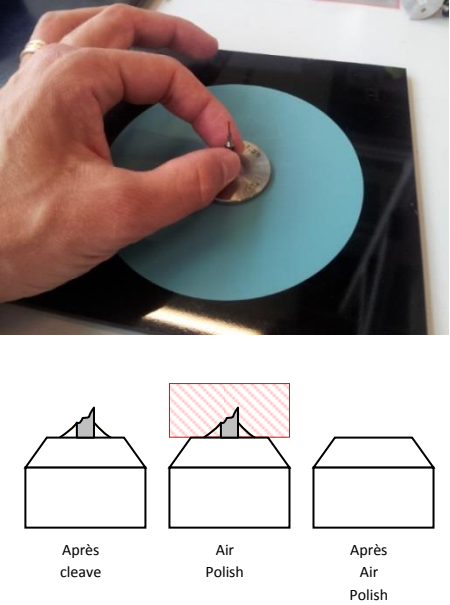



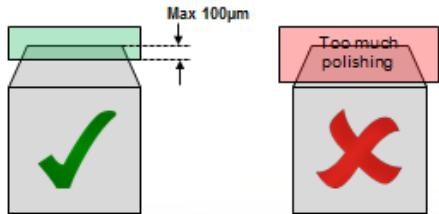
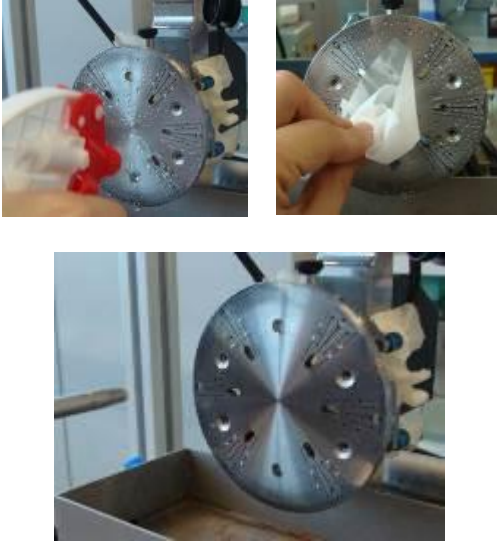

	<p>Position the Ferrule O-ring "C" on the Ferrule "D" as shown on the top left picture.</p> <p>Slide the Spring "E" and Termini Closure "F" at the back of the Ferrule "D" and assemble them into the Termini Housing "B".</p>	
	<p>Position the Housing O-ring "A" on the Termini Housing "B" as shown on the left picture.</p>	

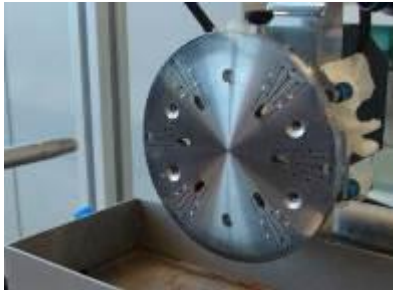
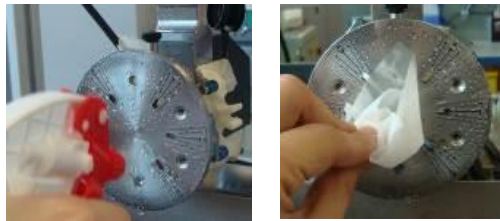
## 8 Polishing

It is recommended polishing the fiber using a polishing machine.

Polish the fiber according to the machine manufacturer's instructions.

Picture	Process	Tools
<b>PC termini</b>		
 <p style="text-align: center;">Après cleave      Air Polish      Après Air Polish</p>	<p><b>Step1 : Air polish</b></p> <p>Holding the polishing bushing and terminus, place the polishing bushing on the film. Using light pressure on the ferrule, polish the endface of the ferrule in a small circular motion.</p>	<ul style="list-style-type: none"> <li>▪ Polishing film: 9µm Silicon carbide</li> <li>▪ Polishing Pad : N/A</li> <li>▪ Lubricant: N/A</li> <li>▪ Tool: FO-10090</li> </ul>
	<p>Clean the polishing pad with demineralized water and lint-free cloth, from the center outwards.</p> <p>Spray some demineralized water on the polishing pad and place the polishing film, starting at edges of the polishing pad.</p> <p>Spray abundantly demineralized water on the polishing film.</p>	

	<p><b>Step 2 :</b></p> <p>Polish the termini with 5µm Silicon carbide polishing film, until no peripheral chips are visible.</p> <p><b>Do not remove more than 100 µm.</b></p>	<ul style="list-style-type: none"> <li>▪ Polishing film: 5µm Silicon carbide</li> <li>▪ Polishing Pad : 90 duro black</li> <li>▪ Lubricant: DI-water</li> <li>▪ Fixture tool: FO-10019</li> </ul>
	<p>Wipe abundantly the polishing tool holding the termini with demineralized water and clean it carefully with a lint-free cloth.</p> <p>Use an airpressure gun to remove residual water.</p>	
	<p>Clean the polishing pad with demineralized water and lint-free cloth, from the center outwards.</p> <p>Spray some demineralized water on the polishing pad and place the polishing film, starting at edges of the polishing pad.</p> <p>Spray abundantly demineralized water on the polishing film.</p>	
	<p><b>Step 3 :</b></p> <p>Polish the termini with 1µm Diamond polishing film in an 8 pattern motion (or pattern of the polishing machine).</p>	<ul style="list-style-type: none"> <li>▪ Polishing film: 1µm Diamond</li> <li>▪ Polishing Pad: 80 duro green</li> <li>▪ Lubricant: DI-water</li> <li>▪ Fixture tool: FO-10019</li> </ul>



Wipe abundantly the polishing tool holding the termini with demineralized water and clean it carefully with a lint-free cloth.

Use an airpressure gun to remove residual water.



Clean the polishing pad with demineralized water and lint-free cloth, from the center outwards.

Spray some demineralized water on the polishing pad and place the polishing film, starting at edges of the polishing pad.

Spray abundantly demineralized water on the polishing film.

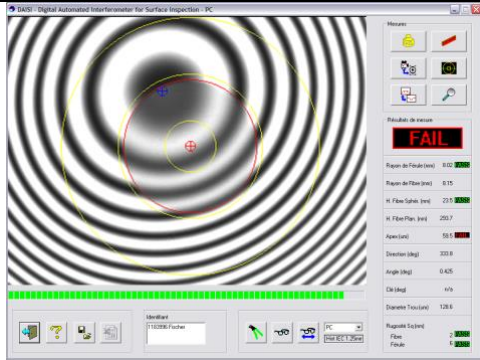
**Step 4 :**

Polish the termini with AngstromLap Final Polish SiO<sub>2</sub> in an 8 pattern motion.

**Do not clean the polishing tool after this step, to avoid creating scratches on the polished ferrule.**

- Polishing film: AngstromLap Final Polish SiO<sub>2</sub>
- Polishing Pad: 80 duro green
- Lubricant: DI-water
- Fixture tool: FO-10019

**Geometrical control :**



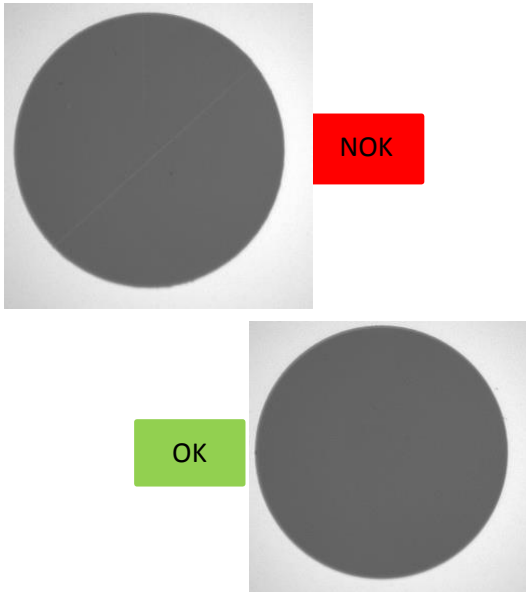
**Ferrule Radius[mm]:**

Min 5 - Max 12

**Apex Offset[um]:**

Min 0.0 – Max 50.0

If fail, repeat from step 3.



**Fiber core inspection :**

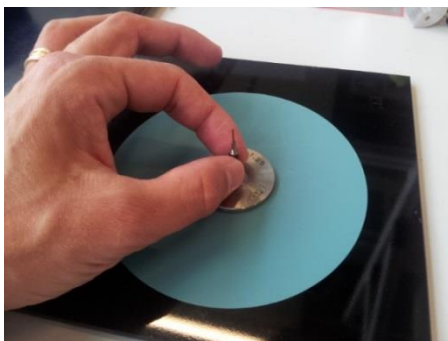
Examine the endface of the ferrule for scratches according to left pictures.

If fail, repeat from step 4.



If not installing the connector immediately, install a protective cover onto terminus to prevent contamination to the endface of the ferrule.

**8° APC termini**

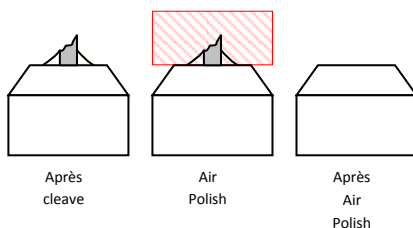







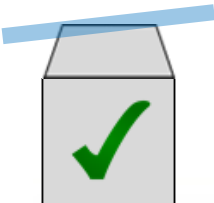



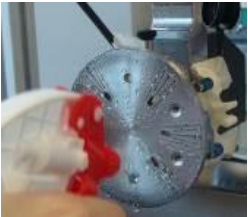

**Step1 : Air polish**

Holding the polishing bushing and terminus, place the polishing bushing on the film.

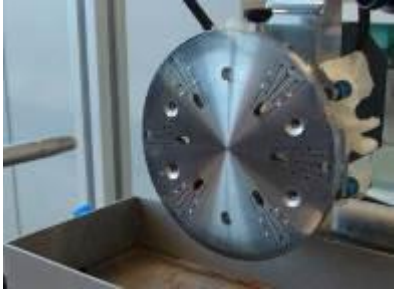


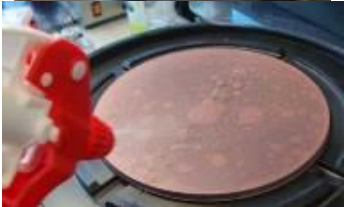
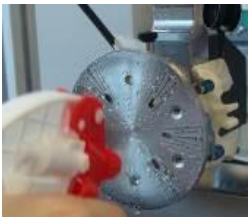
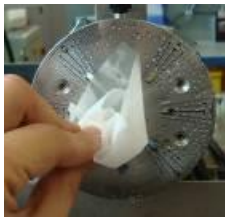
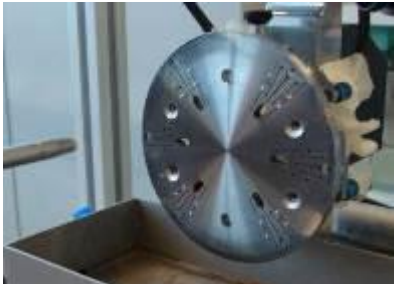
Using light pressure on the ferrule, polish the endface of the ferrule in a small circular motion.


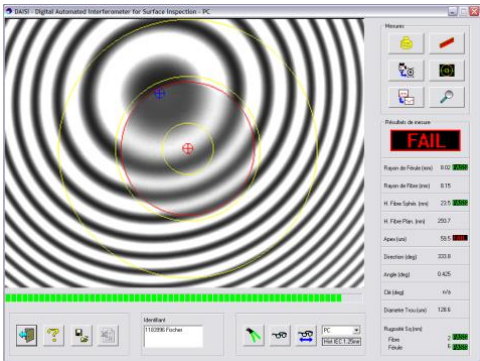
- Polishing film: 9µm Silicon carbide
- Polishing Pad : N/A
- Lubricant: N/A
- Tool: FO-10090



    	<p>Clean the polishing pad with demineralized water and lint-free cloth, from the center outwards.</p> <p>Spray some demineralized water on the polishing pad and place the polishing film, starting at edges of the polishing pad.</p> <p>Spray abundantly demineralized water on the polishing film.</p>	
   	<p><b>Step 2 :</b></p> <p>Polish the termini with 8° angle using the fixture tool.</p> <p>Make sure the endface of the ferrule is fully polished, as shown on the left pictures.</p> <p>If not, repeat from step 2.</p>	<ul style="list-style-type: none"> <li>▪ Polishing film: 5µm Diamond</li> <li>▪ Polishing Pad: Glass</li> <li>▪ Lubricant: DI-water</li> <li>▪ Fixture tool: TX00.285</li> </ul>
 	<p>Wipe abundantly the polishing tool holding the termini with demineralized water and clean it carefully with a lint-free cloth.</p> <p>Use an airpressure gun to remove residual water.</p>	

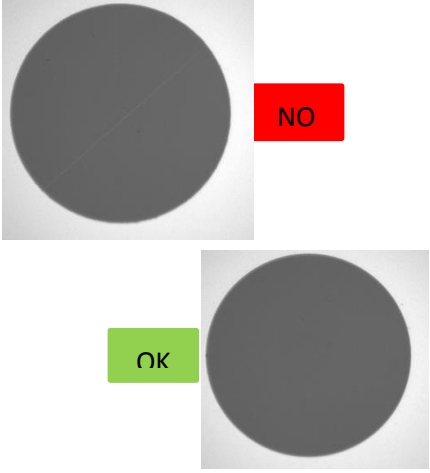



		
  	<p>Clean the polishing pad with demineralized water and lint-free cloth, from the center outwards.</p> <p>Spray some demineralized water on the polishing pad and place the polishing film, starting at edges of the polishing pad.</p> <p>Spray abundantly demineralized water on the polishing film.</p>	
	<p><b>Step 3 :</b></p> <p>Polish the termini with 1µm Diamond polishing film in an 8 pattern motion (or pattern of the polishing machine).</p>	<ul style="list-style-type: none"> <li>▪ Polishing film: 1µm Diamond</li> <li>▪ Polishing Pad: 80 duro green</li> <li>▪ Lubricant: DI-water</li> <li>▪ Fixture tool: TX00.285</li> </ul>
  	<p>Wipe abundantly the polishing tool holding the termini with demineralized water and clean it carefully with a lint-free cloth.</p> <p>Use an airpressure gun to remove residual water.</p>	

	<p>Clean the polishing pad with demineralized water and lint-free cloth, from the center outwards.</p> <p>Spray some demineralized water on the polishing pad and place the polishing film, starting at edges of the polishing pad.</p> <p>Spray abundantly demineralized water on the polishing film.</p>	
	<p><b>Step 4 :</b></p> <p>Polish the termini with AngstromLap Final Polish SiO2 in an 8 pattern motion.</p> <p><b>Do not clean the polishing tool after this step, to avoid creating scratches on the polished ferrule.</b></p>	<ul style="list-style-type: none"> <li>▪ Polishing film: AngstromLap Final Polish</li> <li>▪ Polishing Pad:80 duro green</li> <li>▪ Lubricant: DI-water</li> <li>▪ Fixture tool: TX00.285</li> </ul>
	<p><b>Geometrical control :</b></p> <p><b>Ferrule Radius[mm]:</b> Min 5 - Max 12</p> <p><b>Apex Offset[um]:</b> Min 0.0 – Max 50.0</p> <p>If fail, repeat from step 3.</p>	
	<p>Fiber core inspection :</p> <p>Examine the endface of the ferrule for scratches according to</p>	

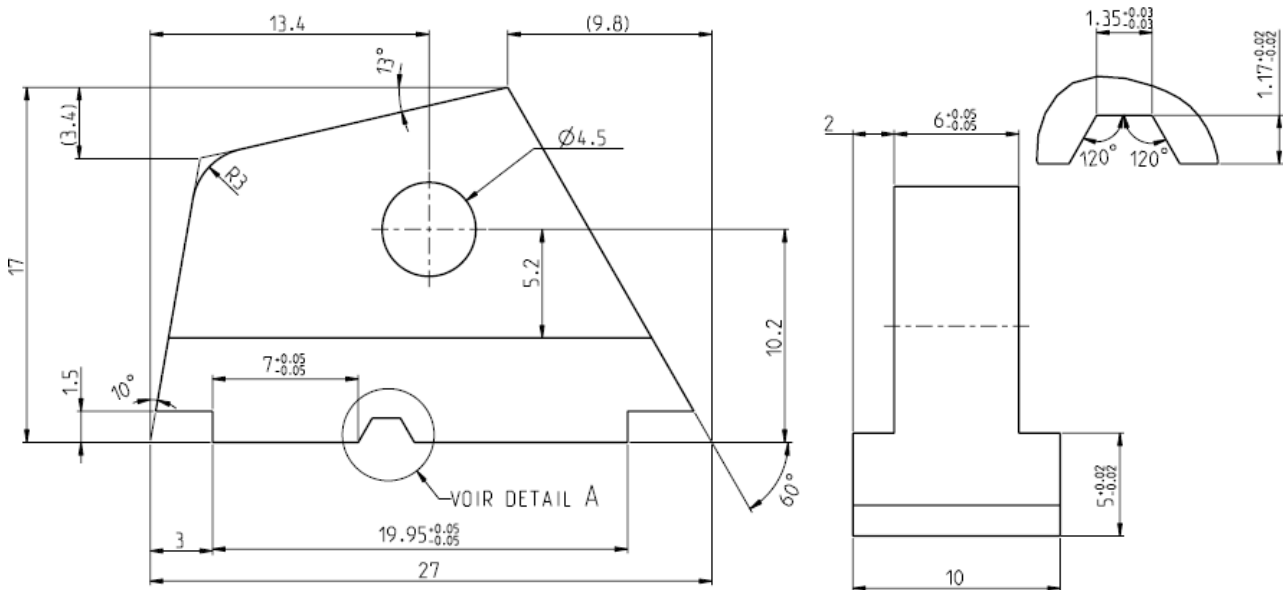
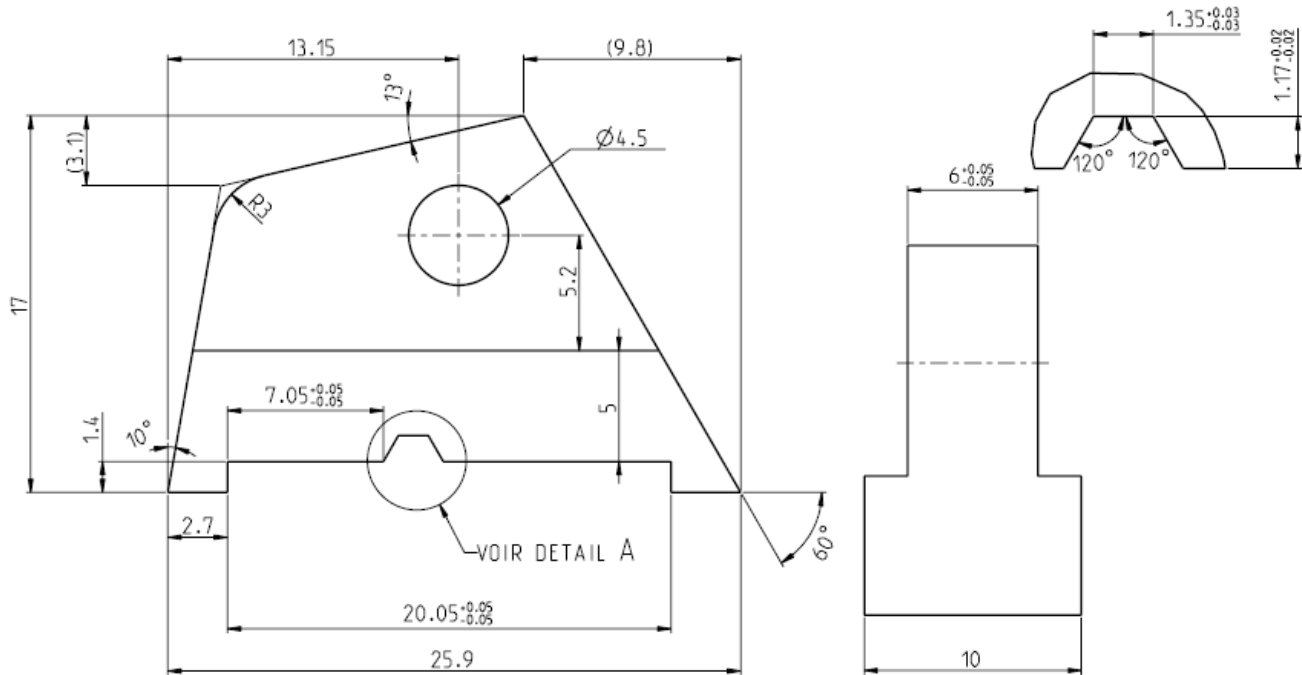


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	<p>left pictures. If fail, repeat from step 4.</p>	
	<p>If not installing the connector immediately, install a protective cover onto terminus to prevent contamination to the endface of the ferrule.</p>	

## 9 Appendix

### Tool drawing for crimping the sleeve to the contact



### Tool drawing for crimping the ground contact to the rear body (FOH)

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