



A Furukawa Company

OFS Recommendations for splicing 3 MM OFNR (Blue) Cordage and Cordage installed in Duct

The following should be used when splicers encounter difficulties splicing OFS fiber due to incorrect fiber movement of ZR stage preventing the fibers to move to correct orientation.

1. This document describes the recommended procedure for splicing 3 MM OFNR cordage to 250 micron fiber or splice-on-connectors. These recommendations include the process to prevent fiber movement within the 3 mm cordage and/or 900 micron buffered fiber.
2. OFS recommends using a locking coil when splicing 3 MM cordage if problems have occurred due to low adhesion between the fiber and the 900 micron buffer fiber. The locking coil should be used only if the operator is experiencing splicing problems.
3. Before splicing, place a three-inch diameter coil in the 900 micron buffered fiber and secure it with a piece of tape (Figure 1). The coil will allow the stripped fiber and 900 micron buffer tube to move as one unit.

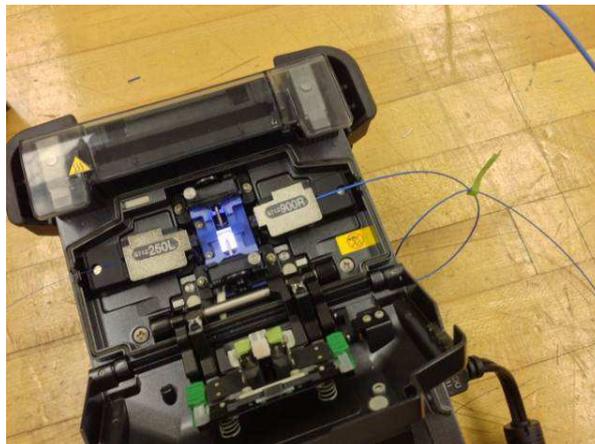


Figure 1 – Three-inch diameter coil in 900 micron fiber.

4. Close the lid and complete the fusion splice (Figure 2).



Figure 2 - Close the lid and splice the fibers.

5. After making the splice remove the tape and release the coil before opening the lid on the splicer. **This step is important to relieve tension on the fibers!**
6. Slide the heat shrink sleeve over the splice (Figure 3) and place in the heater (Figure 4). Shrink the sleeve over the splice to complete the splicing operation.

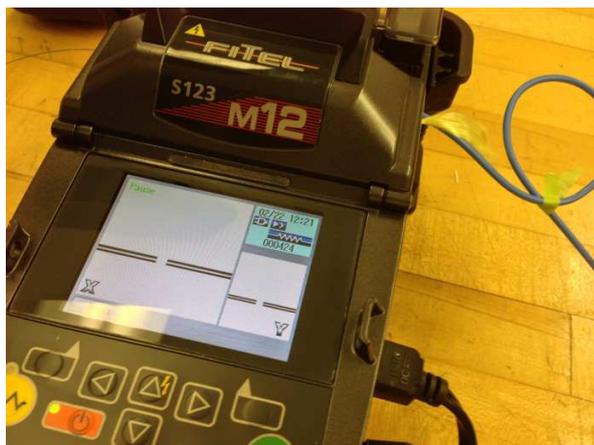


Figure 3 – Slide the heat shrink over the splice.



Figure 4 – Place the splice and heat shrink sleeve in the heater.

7. When splicing a splice-on-connector onto 3 MM cordage, place the three-inch diameter coil in the 3 mm cordage (Figure 5). **Remove the coil before opening the splicer lid!** Complete the splice by installing the heat shrink sleeve as described above.



For additional information please contact your sales representative. You can also visit our website at www.ofsoptics.com or call 1-888-FIBER-HELP (1-888-342-3743) from inside the USA or 1-770-798-5555 from outside the USA.

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