

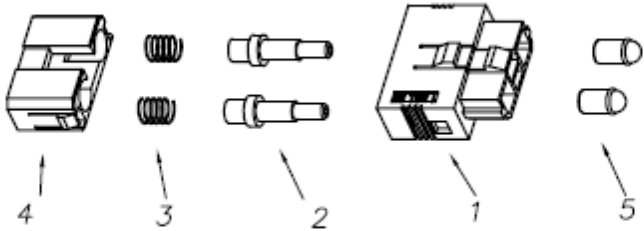
Tools Required

- IF FC1
- 37 0075
- IF 370042
- 37 0006 or IF 370012
- IF CPK
- IF 830090
- IF 370060
- IF 370045 or IF 370049 (0.128 Hex)

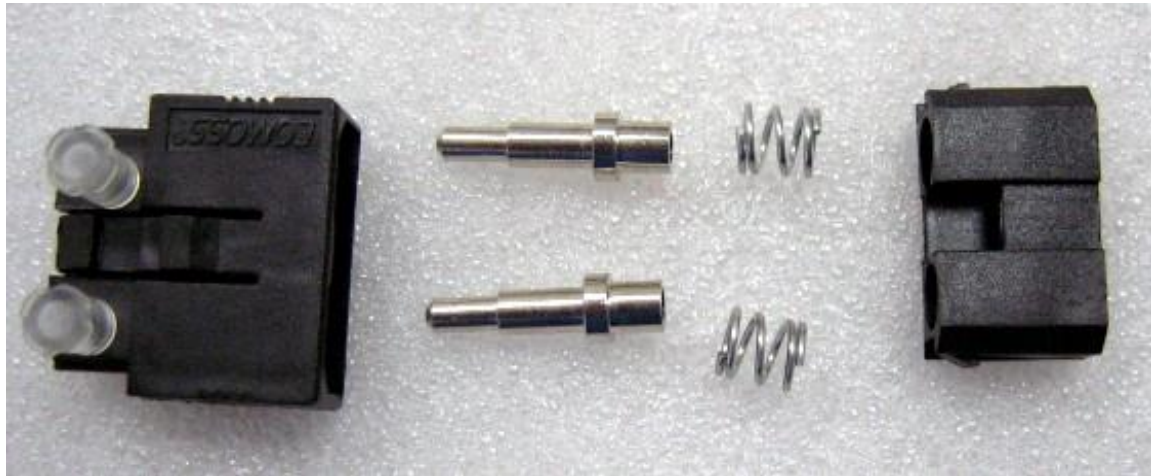
Fiber Prep

1. Cut fiber to length.
2. Split fiber 70 mm, using **IF FC1**.
3. Strip all fiber ends 10 mm, using **37 0075**.

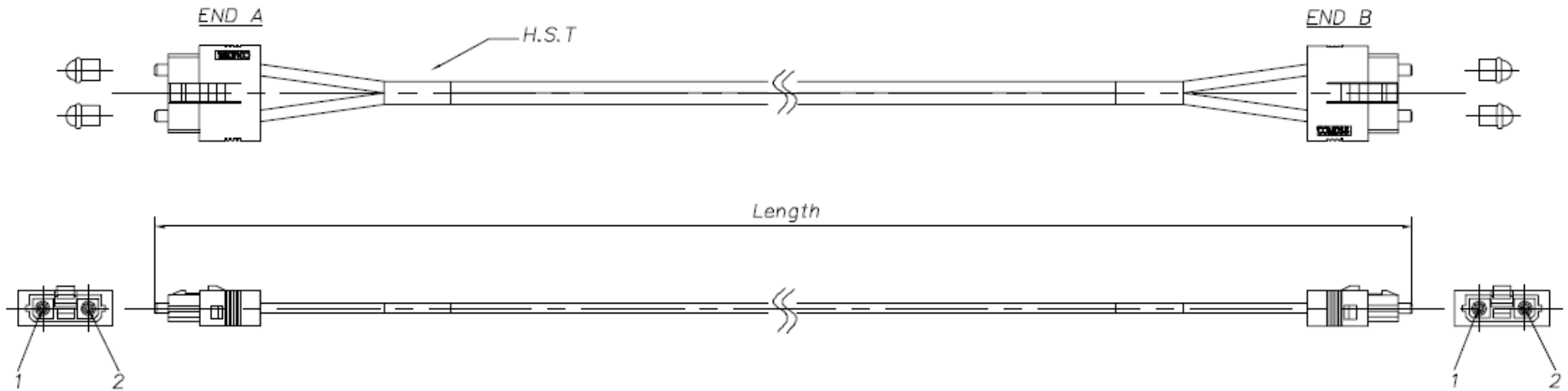
Install Connectors



NO	PART NAME	Material	QTY/Set
1	Front Housing	PBT+15%GF	1
2	Ferrule	Brass	2
3	Spring	SWP-A	2
4	Rear Housing	PBT+15%GF	1
5	Dust Cap	PVC	2



51 0165 (F07) connector consists of 5 separate parts for a total of 8 pieces



Fiber Path

End A	End B
1	2
2	1

1. Install the rear housing first.
2. Install a spring on each fiber and slide it back onto the fiber to the separation point.
3. Insert the fiber into a ferrule.
4. Insert the back of the ferrule, up to the raised ring, into the 0.128 hex opening on the crimper. Crimp the ferrule to the fiber.
5. Repeat steps 3 & 4 until all the ferrules have been installed. **Do Not Install Front Housing at this Step.**

Ferrule Prep & Polish

1. Plug **37 0006** or **IF 370012** and allow to heat up.
2. Insert ferrule into **IF 370042** and use Hot Knife to remove excess fiber.
3. Use **IF CPK** and **IF 830090** for polishing.
4. Follow IF CPK instructions for polishing.

Final Assembly

1. Slide Front Housing over the Rear Housing of the connector assembly.
2. The Inner & Outer pieces should snap/lock together. The Front Housing should be flush with the Rear Housing.
3. Repeat Steps 1 - 2 for the other end of the cable.
4. Repeat Steps 1 - 3 for the remaining cables.
5. Finished product pictured on the right.

