2358902-X Connector Assembly Receptacle, size 11, 1 mt cavity

2358904-X Connector Assembly, Plug, size 11, 1 mt cavity

2379928-X Connector Assembly, Jamnut Receptacle, size 11, 1 MT cavity

2358900-X Connector Assembly Receptacle, size 13, 2 mt cavity

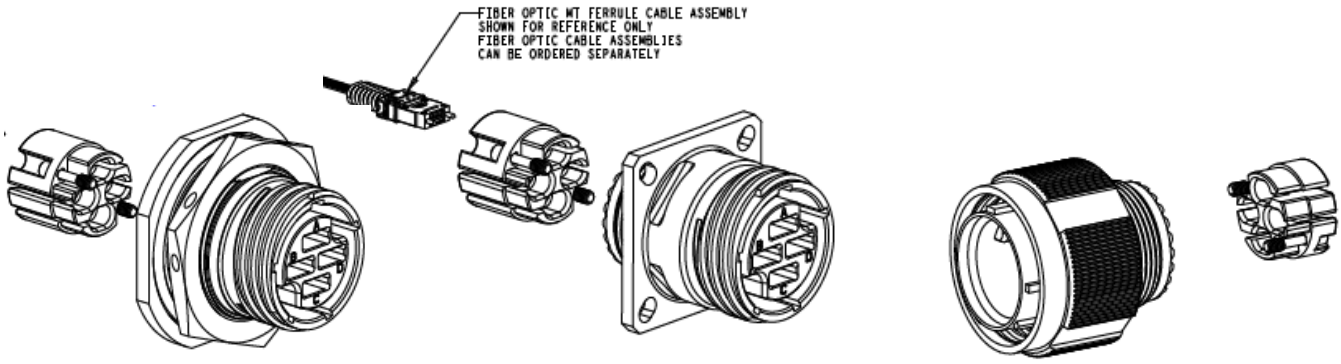
2358901-X Connector Assembly, Plug, size 13, 2 mt cavity

2379927-X Connector Assembly, Jamnut Receptacle, size 13, 2 MT cavity

2358897-X Connector Assembly, Receptacle, size 15, 4 MT cavity

2358899-X Connector Assembly, Plug, size 15, 4 MT cavity

2379812-X Connector Assembly, Jamnut Receptacle, size 15, 4 MT cavity



1. Introduction:

1.1. This instruction sheet covers the assembly of VITA87 Plug and Receptacle Connector kits. For specific part numbers see Figure 1.

Each connector kit is designed to receive pre terminated Lens MT (LMT) or Physical Contact MT (PCMT) ferrules as part of the final cable assembly process.

2. REQUIRED TOOLS AND MATERIALS

2.1. The following tools and materials are recommended for assembling VITA87 Plug and Receptacle Connector kits.

- Safety Glasses
- Torque wrench capable of achieving 4in-lb
- 1/16" Hex bit
- Ferrule Guide – 2389070-1
- Pre-terminated PCMT or LMT cable assembly / assemblies

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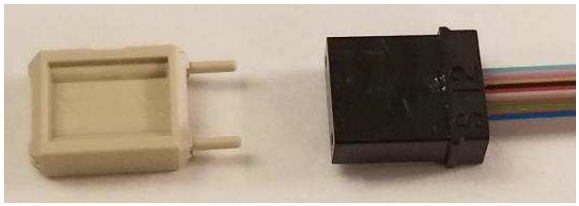
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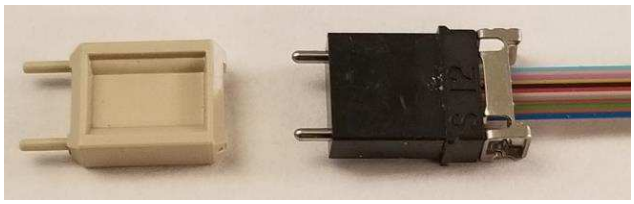
3. ASSEMBLY SEQUENCE

3.1. Install Ferrule Guide

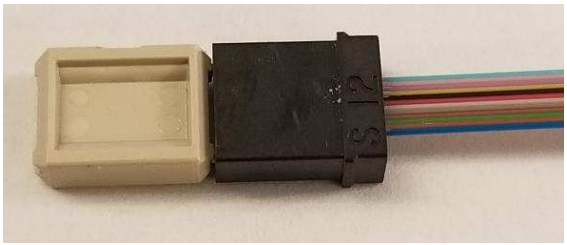
Ferrule guides installed on the ferrule will protect the polished endface during insertion. Note: figures show PCMT ferrules. Same process applies to LMT ferrules.

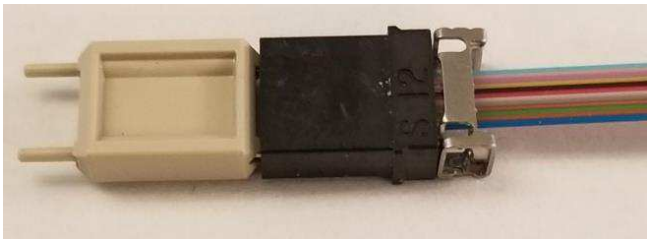
Select proper orientation of ferrule guide based on ferrule gender (Female / Male)





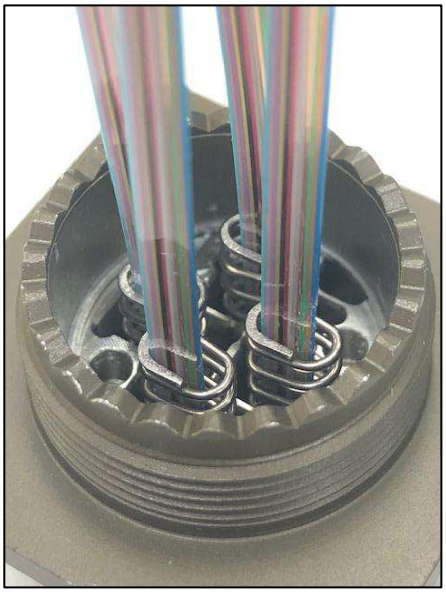
Assemble ferrule guide and ferrule so guide is bottomed against the ferrule endface.





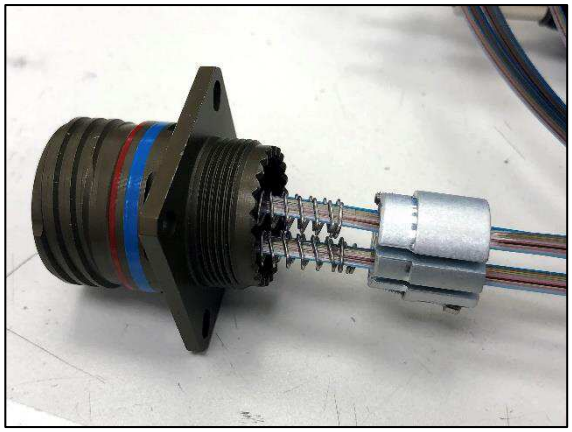
3.2. Insert Cable Assembly / Assemblies

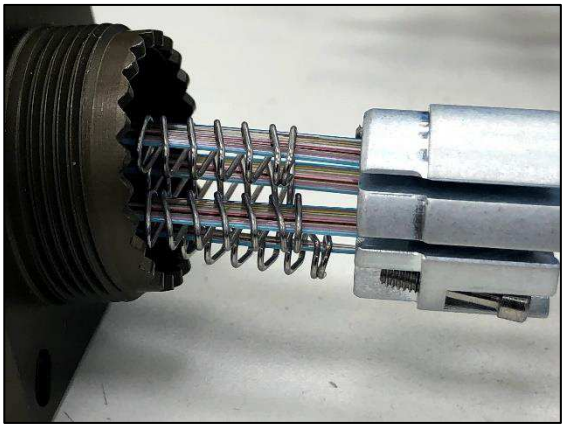
Install the cable assemblies into the VITA87 connector insert from the rear of the connector. Insert 1 cable assembly at a time into the designated cavity making sure that the ferrule is completely bottomed against the internal shoulder, and springs are resting against the rear of the ferrule. The ferrule guide can be removed after the ferrules have been inserted into the cavity.



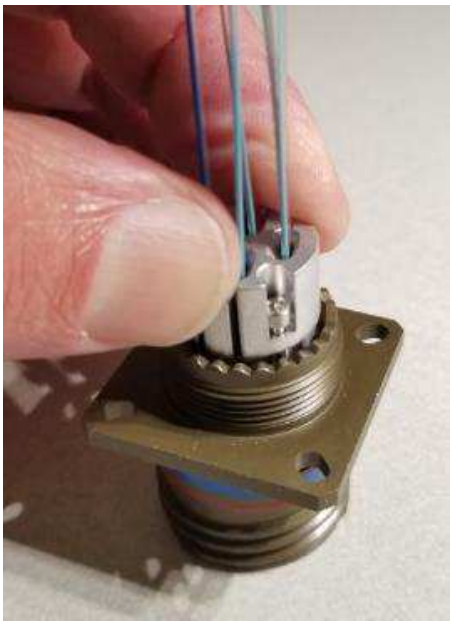
3.3. Position / Install Retainer

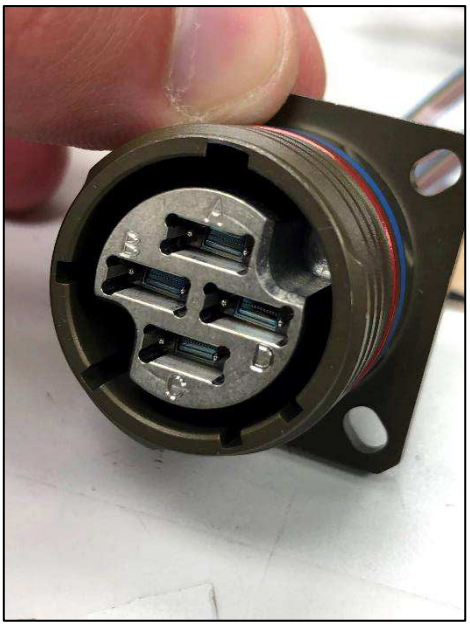
Install the ferrule retainer and attach to the VITA87 insert. Position the retainer approximately 50mm away from the rear of the connector shell. Place and weave the fibers into the corresponding slots on the retainer. Inspect the retainer to ensure that the captive screws align with the threaded holes in the insert. Inspect the fibers to ensure that they are inline with the intended insert cavity and are not twisted.





Slide the retainer forward so it starts to compress the springs and the screws engage with the treaded holes in the insert. While viewing the front of the connector ensure all ferrules are fully inserted and properly seated in the insert cavity. While holding light pressure on the retainer, begin tightening the screws.





It is critical to use an alternating pattern when tightening the screws. Alternate 5 turns on left screw / 5 turns on right screw, 3 turns left / 3 turns right, 2 turns left / 2 turns right until the 4 in lb torque limit is achieved. Ensure fibers are not damaged while tightening the screws.

