Splice Operation

- Turning splicer ON
- Confirming splice, heater and operation modes
- Cleaning coating or sheath of fiber
- Placing protection sleeve over fiber
- Stripping fiber
- Cleaning fiber
- Cleaving fiber
- Loading fiber onto splicer
- Splicing start automatically
- Visual inspection on LCD during splice
- Removing spliced fiber
- Centering protection sleeve in tube heater
- Centering spliced point in tube heater
- Heating start automatically
- Completed

Note
- When splicing only standard SM fibers (ITU-T G.652), “SM AUTO” mode is recommended.
- When splicing different types of fibers, “AUTO” mode is recommended, but splice speed is slow.
- Splicing speed of “SM FAST” mode is fast, but periodical Arc calibration is required.

- Make sure the stripped fiber is free of coating debris or contamination.
- Use only 99% or better purity alcohol.
- Do not allow the cleaved fiber ends to touch anything or become contaminated.
- Place the fiber end between V-groove edge and Electrode center.

Note
- When splicer indicates following message, splice loss may be high
  “Arc discharge is not stable. Electrodes should be stabilized to reform the arc discharge.”
- Load prepared SM fibers onto splicer in order to stabilize electrodes. After completing it, re-splice fibers.
- When an altitude changes drastically, stabilizing electrodes must be executed before splicing.

Cleave Length

- 250μm: 5~16mm (1/5”~2/3”)
- 900μm: 5~16mm (1/5”~2/3”)

Marking
- *Hold the fiber at edge of splicer body
- **Gently pull the fiber

Pull

**Pull
How to use Keypad

- **ON/OFF Key**
  - Power ON/OFF

- **ARC Key**
  - Arc

- **X/Y Key**
  - Switch X/Y images

- **HEAT Key**
  - Heat Cancel
  - Operation of a lid

- **RESET Key**
  - Stop and back to Ready

- **SET Key**
  - Execute Splice

- **ESCAPE Key**
  - Return to previous screen

- **MENU Key**
  - Open Main Menu
  - Go to next page

- **UP/DOWN Key**
  - Move cursor
  - Change value

- **ENTER Key**
  - Enter
  - Go to next page
  - Open Main Menu

- **LED**
  - Turning ON
    - Press key until green LED turns on.
  - Turning OFF
    - Press key until red LED turns on.

Power Supply

**AC Adapter**

- **AC operation**
  - Input power: AC100-240V, 50-60Hz
  - Use only supplied AC power cord.
  - Connect to ground with ground terminal of AC power cord.
  - When using an AC power generator, check output voltage periodically with a circuit tester.

- **DC operation**
  - Input power: DC12V
  - Use only supplied DC power cord.

**Battery Pack**

- **How to recharge Battery Pack**
  - Connect AC adapter (ADC-18) and battery pack (BTR-09) with battery recharge cord (DCC-18).
  - Do not stack battery pack on top of AC adapter while recharging.
  - Recharging temperature: 0 ~ 40°C (32 ~ 104°F)

- **Note**
  - Confirm power saving function is working when using battery

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*Images and illustrations of the keypad and battery pack are not available in this text. Additional details can be found in the full manual.*
Cleaning before Splice Operation

**V-grooves**
- Clean bottom of V-groove with a thin cotton swab moistened with alcohol.
- Remove excess alcohol from V-grooves with a clean dry swab.
- Use a cleaved fiber end-face to dislodge.

**Fiber Clamp Chips**

**Fiber Cleaver**
- Clean rubber pads.
- Clean rubber anvil.
- Clean blade.

**Objective Lens**
- When lens is dirty, clean it.

**Caution of cleaning**
- Do not contact the electrode tips.
- Use only 99% or better purity of alcohol.

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**Replace Electrodes**

**Electrodes**
- When “Replace electrodes” message appears, or when the tip is damaged, replace electrodes.
- Execute [Replace Electrodes] in Maintenance Menu.
- Exchange for a new electrode the old electrode currently attached to equipment.

**Replace Electrodes**

- Remove the electrode cover
- Loosen screws
- Remove the old electrode
- Place the electrode cover
- Tighten screws
- Install new electrode

- Load prepared fibers onto the splicer.
- Execute [Stabilized Electrodes]
- [Arc Calibration] is executed.
## Ways of solution of an Error

<table>
<thead>
<tr>
<th>Error Message</th>
<th>Reason</th>
<th>Solution</th>
</tr>
</thead>
</table>
| Too Long Fiber      | • The fiber end-face is placed on the electrode centerline, or beyond it.  
                      • The cleave length (bare fiber part) is too long.  
                      • Dust or dirt is on the objective lens.             | • Press [RESET] and set the fiber end-face between the electrode centerline and the V-groove edge.  
                      • Confirm the setting position of the stripped fiber end on the fiber cleaver. Check the cleave length.  
                      • Execute the [Dust Check]. Clean the lens when dust or dirt exists. |
| Too Dusty Fiber     | • Dust or dirt is on the fiber surface.  
                      • [Cleaning Arc] time is too short or “OFF.”  
                      • Splicing indistinct core fibers with the SM or DS modes.  
                      • [Align] is set to “Core” to splice indistinct core fibers when using other splice modes.  
                      • [Focus] is incorrectly set when using other splice modes. The fiber end-face is placed on the electrode centerline, or beyond it. | • Completely prepare the fiber again (strip, clean and cleave).  
                      • Execute the [Dust Check]. Clean the lens if dust or dirt exists.  
                      • Set the [Cleaning Arc] time to “150ms.” When splicing carbon coated fibers, set to “200ms.”  
                      • Use the MM mode to splice indistinct core fibers (i.e. MM fiber).  
                      • Set [Align] to “Clad” to splice indistinct core fibers (i.e. MM fiber).  
                      • Set [Focus] to “Edge” to splice indistinct core fibers (i.e. MM fiber). To splice distinct core fibers, “Auto” or the correct focus value should be entered. |
| ZL/ZR Motor Overrun | • The fiber is set too far back and does not reach the splice point.  
                      • The fiber is not set correctly at the bottom of the V-groove. The fiber is not located in the Camera’s field of view.  
                      • The cleave length (bare fiber part) is too short. | • Press [RESET], re-position the fiber again with the end-face closer to the electrodes.  
                      • Press [RESET], and set the fiber again to seat it correctly at the bottom of the V-groove.  
                      • Confirm the setting position of the stripped fiber end on the fiber cleaver. Check the cleave length. |
| Large Cleave Angle  | • Bad fiber end-face.  
                      • [Cleave Limit] is set too low | • Check the condition of the fiber cleaver. If the blade is worn, rotate the blade to a new position.  
                      • Increase the [Cleave Limit] to an adequate limit. |
| Cleave Shape NG     | • Bad fiber end-face. | • Check the condition of the fiber cleaver. If the blade is worn, rotate the blade to a new position. |

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