

**FIBER GRIP
SMA CONNECTOR
ASSEMBLY INSTRUCTIONS
949-1591**

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Important: Connector to Fiber/Buffer Verification

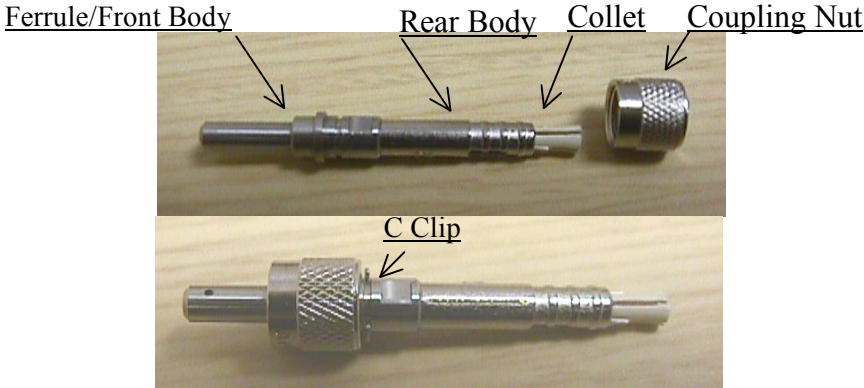
Fiber Grip SMA Part Number: 905-40XXX-XXXX

Check front of bag for connector part number.

905-40XXX-XXXX Highlighted numbers are the connector fiber hole sizes

905-40XXX-XXXX Highlighted digits are the optical fiber buffer sizes

Fiber Grip SMA Connector Parts



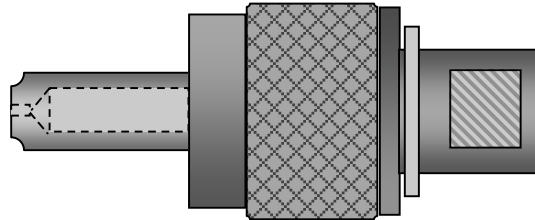
Strain Relief: Medical Grade Available in Black, Red and White

Fiber Grip Materials List: All Materials meet FDA Class VI

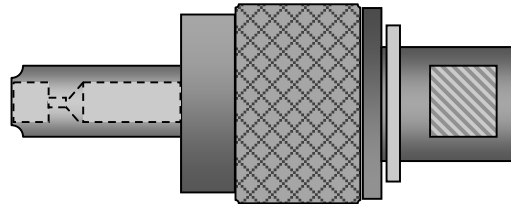
	Description	Material	Plating
1	Front body/Ferrule	303 Stainless Steel	N/A
2	Coupling Nut	Brass	Nickel
	(Optional)		
3	Rear Body	Stainless Steel	N/A
4	Collet	Zinc Die Cast	Nickel
5	Dust Cap/Lanyard	Liquid Crystal Polymer	N/A
	(Optional)		
6	C Clip	Santoprene FDA Class VI	
7	Strain Relief:	Beryllium Copper (Bu)	Nickel
		Santoprene FDA Class VI	

Fiber Grip types:

905-40XXX- SMA Fiber Grip with Standard SMA Interface



905-20XXX- SMA Damage resistant Ferrule: Counterbored Ferrule End face



Fiber Grip Tools

Tools to be used for termination are:

Description	Part Number	Manufacturer
Fiber Grip Assembly Tool	927-1696	Amphenol
Scale		
Permanent Marker		
Buffer Stripper (Kit)	Micro-Strip MS-TK-1	Micro Electronics
Buffer Stripper (Individual)	Micro-Strip MS-1-XXX-XXX	Micro Electronics
Wrench 4mm ????		
Fiber Cutter	Tec-Cut N-59	Techni-Tool
"C" Clip Assembly Tool	P/N CR018	Truarc

1. Fiber Grip Assembly Tool (927-1969)



2. Fiber Cutter (Tec-Cut N-59)



2. Fiber Strip Tools:

Micro-Strip: Are used in the removal of ETFE, Nylon, PVC, Silicone, and FEP optical fiber buffers. Consult your fiber manufacturer for the proper blade and bushing sizes.



*Note: Not for use in the removal of polyimide coatings

Micro-Strip Tools can be purchased from our distributors:

Fiber Optic Center
23 Center St.
New Bedford, MA 02740
800-473-4237
www.focenter.com

The SMA FiberGrip Connector does not require the use of any bonding material to terminate.

1.0 Fiber Grip Termination Procedure

- 1.1. Coupling Nut Assembly: Insert the coupling nut over the rear of the SMA connector, large hole first. With the coupling nut pushed as far as it can go, take the retaining ring and press it onto the groove around the connector body immediately next to the nut to hold it in place.

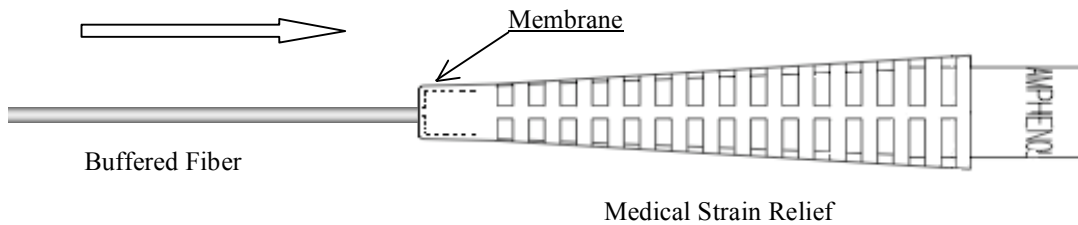


- 1.2. Cut Fiber to Length: Measure fiber and cut to length using Fiber Cutter (Tec-Cut N-59)

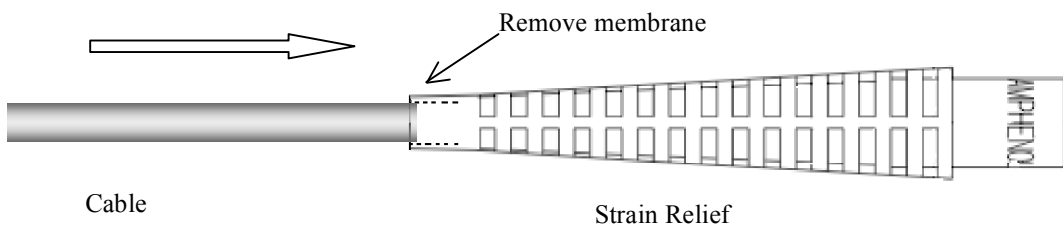


1.3 Strain Relief:

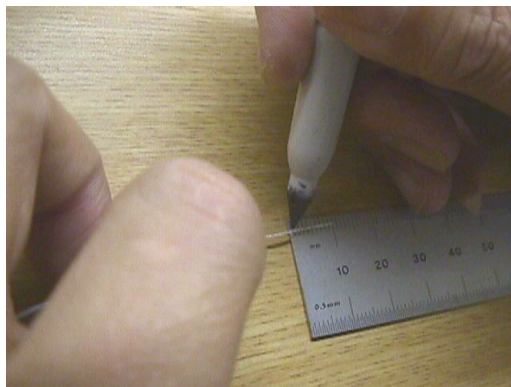
- 1.3.1 (Fiber) Assemble boot onto fiber by Inserting fiber through membrane at rear.
Part number: 905-5195 (Optional)



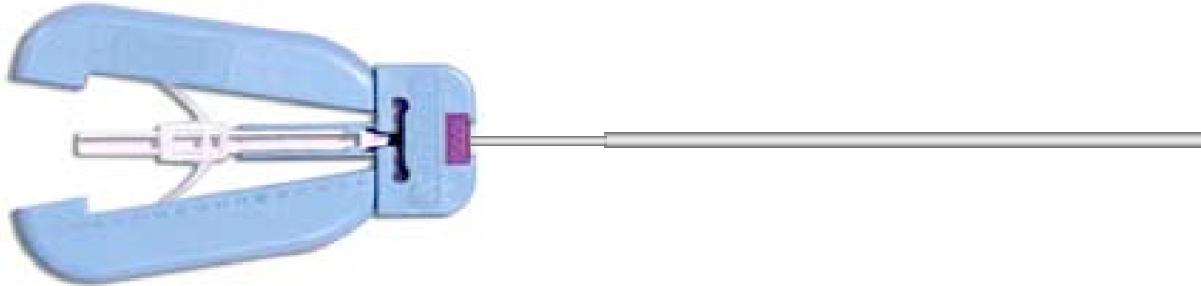
- 1.3.2 (Cable) Assemble boot onto cable by inserting at rear of rear. For use on cable diameters up to 3.0mm (.118"). Part Number 905-5217



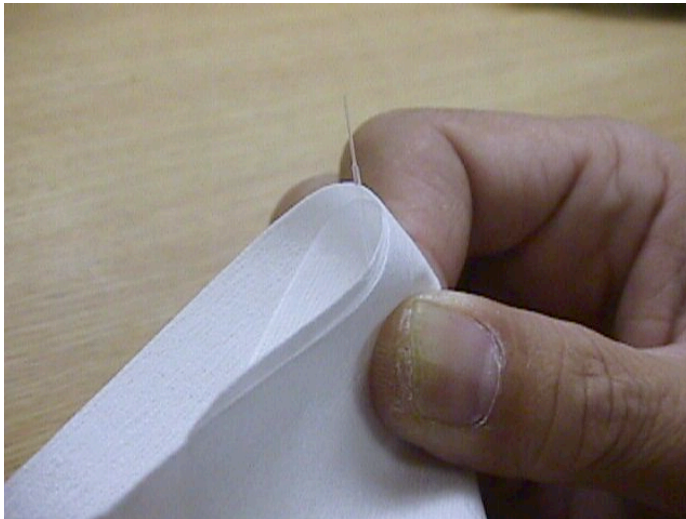
- 1.4 Mark Fiber: On the end to be terminated, measure back 1.75 & 2.75 inches making marks with permanent ink on buffer at both points.



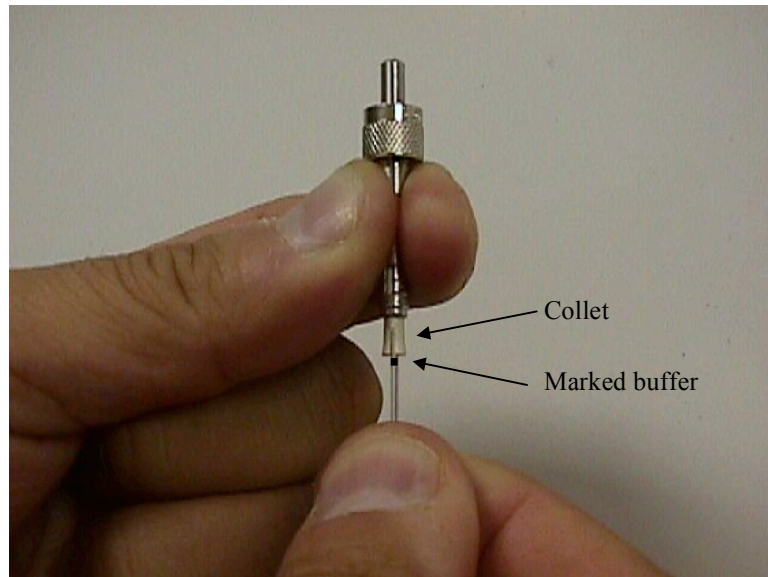
1.5 Strip Buffer: Strip 1.75 inches of buffer from the fiber using a Micro-Strip tool with properly matched bushing and blades. Be very careful not to damage or scratch the sides of the fiber. Please refer to fiber manufacturer's recommendations for the proper blade and bushing for MicroStrip tool.



1.6 Clean Fiber: Clean the end to be terminated with a soft cloth and isopropyl alcohol, while being careful not to damage the exposed fiber.

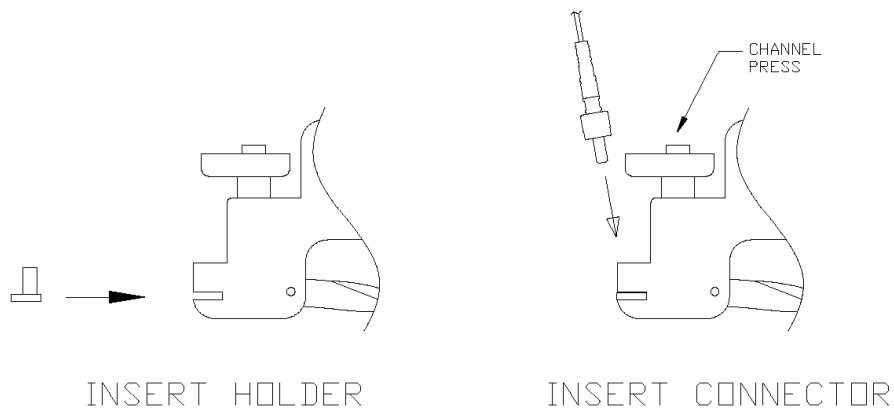


1.7 Insert Fiber: Carefully insert the fiber into the rear of the connector aligning the marked buffer with the rear of the collet. Do not push too hard because this may cause the fiber to break within the connector.

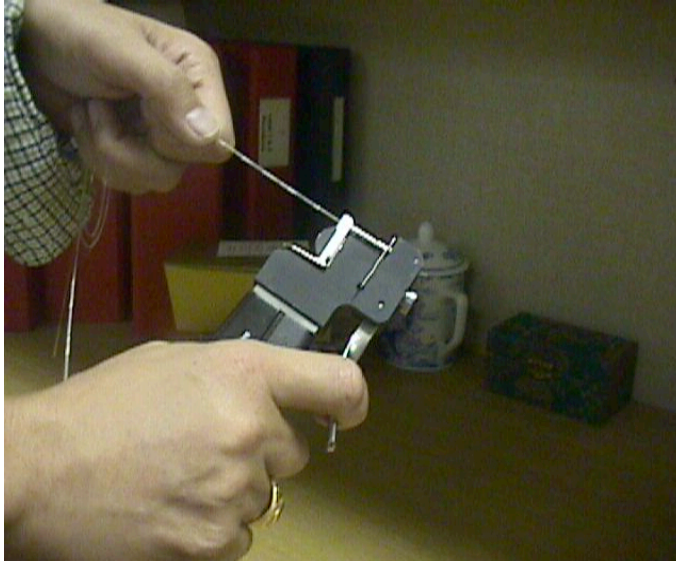


1.8 Collet Insertion: Use the fiber grip tool to press the collets in place and hold the fiber.

1.8.1 If it is not already in place, insert the connector holder in the front of the FiberGrip tool by sliding it into the front slot. Insert the connector into the connector holder of the FiberGrip tool per the figure below. Pull the fiber into the slot in the channel press to ensure that it is not damaged while pressing the collets into place.



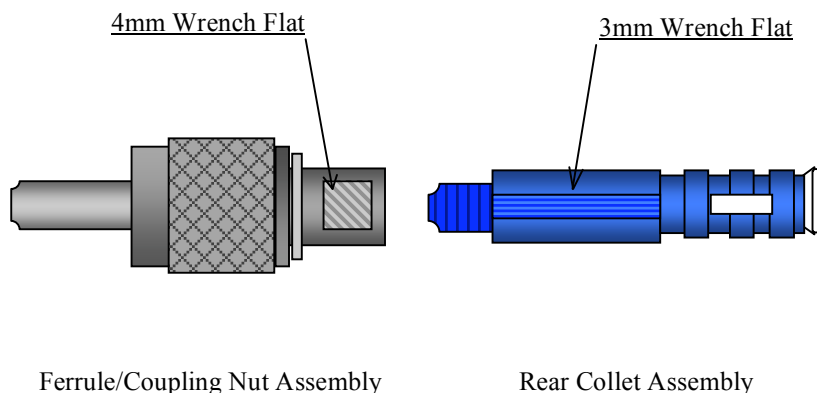
- 1.8.2 Pull firmly and completely on the trigger of the Fiber-Grip assembly tool to press down on the collets and terminate the connector. Take care to make sure that the fiber does not pull out from the connector while doing this.



- 1.9 Final Assembly: The connector is now ready for cleaving, polishing or any other subsequent processing.

- 1.10 Fiber Processing: Due to the various processes used in fiber end face finishing, Amphenol can not document all

2.0 Connector Repair: Incase of a bad cleave or polish of the fiber end face, the ferrule/coupling nut assembly can be removed and the rear collet assembly can be replaced. Using 4mm open end wrenches, insert them on the wrench flats and disassemble.



REVISIONS				
REV.	DESCRIPTION	DATE	ECO #	APPROVED
A	New Procedure			