

SEL-C804/C814 ST Connector Assembly Instructions

Black or Clear-Jacketed Fiber, 1.0 mm Core, 2.2 mm Outside Diameter

Parts Required	SEL Part Number
1.0 mm Plastic Optical Fiber (POF) Black-Jacketed Fiber, Zipcord Duplex	915900154
ST [®] Connector With Sleeve (1.0 mm POF)	915900150
1.0 mm Plastic Optical Fiber (POF) Clear-Jacketed Fiber	915900234

Note: Order parts from the SEL-C804 and SEL-C814 MOTs at www.selinc.com/onlinemot/.

1. Using the precision stripper, remove 12.00 mm (0.47 in) of the jacket off the end of the selected channel.
2. Slide the ST fiber sleeve on first, then the ST connector. Roughly 2.54 mm (0.1 in) of fiber should protrude from the end of the ST connector. Excess will be polished off in the final stage of the process.



3. Place the ST connector into the swage crimp of the FiberFin crimp tool. Ensure the cable is fully inserted in the ST connector. Holding the end of the fiber in place, crimp the front edge of the ST connector.



4. Slide the ST sleeve back far enough that the end of the ST connector can be placed in the jaws of the crimp tool without damaging the sleeve. Using the front hexagonal slot of the tool, crimp the end of the ST connector to the jacket of the fiber.



5. Slide the sleeve up to the base of the ST connector past the ribs on the barrel to ensure proper seating.



6. Polish the fiber until it is flush with the metal barrel end of the ST connector.
 - a) Place the 2000-grit sandpaper rough side up on the glass plate provided in the polishing kit.
 - b) If excess fiber is protruding from the ST connector, carefully cut 1 to 2 mm from the end of the unpolished termination with the disposable fiber cutter.
 - c) Place the ST connector into the 2.5 mm (0.1 in) guide hole of the 38.1 mm (1.5 in) diameter plastic guide puck.
 - d) Maintaining a 90° angle with the surface of the sandpaper, polish the end of the fiber by moving the termination in a “figure 8” pattern.
 - e) After roughly 10 strokes, inspect the end of the fiber for scratches, cloudy appearance in the fiber, or a slanted, irregular cut; repeat as necessary.
7. Repeat steps 1 through 6 for the second end of the zipcord duplex fiber cable.