THE SB01 SPLICE ENCLOSURE NOW INCLUDES A LID GASKET THAT DOES NOT REQUIRE RTV APPLICATION.

DO NOT APPLY RTV TO THE GASKET WHEN SEALING THE SB01 SPLICE ENCLOSURE.

SEE SEALING THE SPLICE BOX (SECTION 18) FOR UPDATED INSTRUCTIONS.

Instructions for Preparing

AFL HEXACORE, CENTRACORE AND MINICORE

OPTICAL GROUND WIRE

IN THE SB01 SPLICE ENCLOSURE

(STAINLESS STEEL TUBE CABLE DESIGNS)

ATTENTION:

The SB01 Splice Enclosure now includes a lid gasket that does not require RTV application. Do not apply RTV to the gasket when sealing the SB01 Splice Enclosure. See Section 18 for updated instructions.

NOTE:

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TABLE OF CONTENTS

List of Materials

ITEM	DESCRIPTION	QTY
1	Splice Box (consisting of the following):	
	Splice Box Body	1
	CSM Termination Eye Bolt	2 or 4
	Center Shaft	1
	Cover Gasket	1
	Connector Assemblies (consisting of the following items for 1 connector):	2 or 4
	Connector Body	1
	Cable Retainer	1
	Nut Retainer	1
	Entry Bushing	1
	Set Screw – 5/16 – 18 UNC	2
	O-Ring	1
2	Organizer Tray Assembly (consisting of the following items for 1 tray):	2 to 8
	Tray	1
	Cover	1
	Splice Protector Holders (6 Splices / Holder)	2
	Manifold (MCI Tray Only)	1
3	Splice Box Cover	1
4	RTV – 108 Adhesive	1
5	Spanner Nut or Hex Nut	1
6	O-Ring or Self-Sealing Washer	1
7	Retaining Rings	2
8	Tension Screw	0 to 4
9	Tension Nut	0 to 4
10	Humi – Sorb	1
11	Range-Taking Flanged Sleeve (used with FRP strength member)	0 to 4
12	Mounting Plate	1
13	Slotted Sleeve (used with OPT/GW FRP strength member)	0 to 4
14	Spacer	1
15	Splice Protector Sleeves	10 to 56

Remove all loose parts, top retaining ring, spacer, mounting plate with tray assemblies from the box. Confirm all parts are present (see List of Materials above), then place in a convenient location.

Please see supplemental instruction sheet for ST1-72 Tray installation instructions.

Items Supplied by Customer:

- Lag screws and washers (1/2 in. dia.) or hardware for attachment of assembly to pole or tower
- Silicone sealant for splice protection
- Splicer equipment

Please see supplemental instruction sheet for ST1-72 Tray installation instructions.

1.0 Purpose of Installation

The purpose of installing optical cables into a splice enclosure is to connect the individual fibers of the cables providing a continuous light path while protecting the connection in a sealed enclosure.

2.0 Scope

This document describes and illustrates the installation of the HFC stainless steel tube Optical Ground Wire (OPGW) into the AFL SBO1 splice enclosure.

3.0 Precautions

3.1 Health
Optical fibers are very thin, fragile and sharp. Therefore, careful handling is required to avoid either damage to the delicate glass fibers, or more importantly, injury to the technician or bystander. Small fiber scraps should be deposited on strips of adhesive tape, placed in a bottle or vinyl bag and properly disposed. Do not eat or drink when working with optical fibers as small pieces of glass may inadvertently be ingested. Never look directly at the end of a fiber unless certain that no laser light is being transmitted through the fiber.

3.2 Work Environment
Handle optical fiber and cable carefully, taking care to impose no damage by physical shock or sharp bends. During the actual splicing, care must be taken to keep hands and work area clean in order that the fibers may be kept clean. Keep all tools and equipment in their proper cases or storage pouches when not in use. Consideration should be given to the work area in which the enclosure will be organized. A clean, snag-free horizontal surface protected from the wind is necessary.

4.0 Cable Preparation at Towers

4.1 After the stringing procedure, a minimum of 75 feet (per 7.0 install) of OPGW should remain at the base of the structure for prepping and splicing purposes. If a service loop is required, calculate the excess cable that will be needed for this procedure prior to the time of installation.

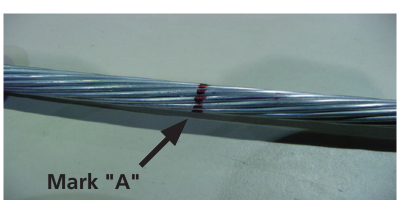
Note: If the cable at the structure was located on the pulling end, remove the first 10 feet due to potential damage.

4.2 Prior to installing the OPGW into the AFL splice enclosure, the mounting location of the splice enclosure needs to be determined. This will determine the amount of cable that will be needed to reach the prepping and splicing area.

4.3 Determine which of the two cables will be permanently mounted closest to the outside of the tower. Mark this cable with tape for identification purposes.

4.4 Measure both cables back 10.5 feet on the SB01 enclosure and the ST1-72 Tray.. This length allows for the furcation of the tubes and 6.5 feet of fiber in the splice trays. At this point, place a mark on the cable that will be permanently mounted closest to the inside of the tower. After marking the cable, measure approximately 6 to 8 inches toward the free end of the cable and mark the remaining cable. The outside cable will always need to be the longer of the two cables in order to provide proper routing of the cables onto the tower. Each cable mark should be a straight and continuous circle around the cable strands (see Fig. 1). These Marks will be referenced as Mark "A". Mark "A" is eventually where the outer strands of the OPGW cables will enter the splice enclosure.

Fig. 1



Note: Mark "A" is the actual measured length of the cable to the bottom of the connector body as if the enclosure were mounted at the final structure location.

5.0 Preparation of the Splice Enclosure

This section will explain the necessary adjustments and accessories that need to be performed prior to the actual installation of the optical units into the enclosure.

5.1 With the use of a wrench, turn the termination eyebolts by 90 degrees in a counter clockwise direction as shown in Fig. 2. After this procedure, the eyebolts should be oriented as shown in Fig. 3.

Fig. 2

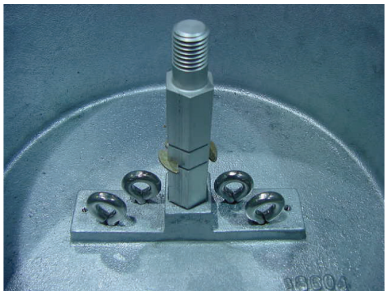
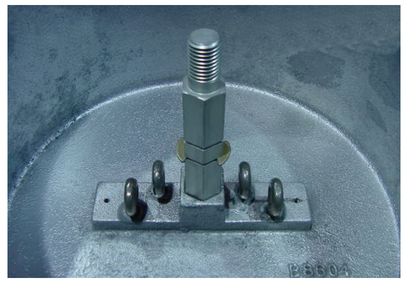
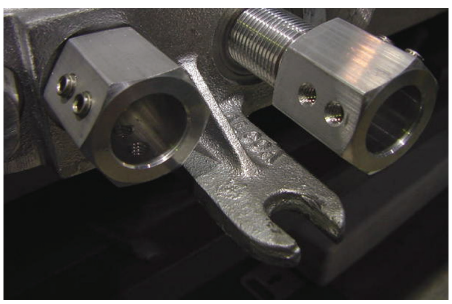


Fig. 3



5.2

Fig. 4



1. Remove the cable retainers (wire retainer) from each connector body.
2. Check the side of each cable reatiner to compare the cable range to the actual diameter of the cable.
3. Remove the set screws from the connector body.
4. Be sure that the Red O-ring is clean and is properly in position prior to tightening the connector Body.
5. Place and tighten the connector bodies into the two center splice enclosure ports (see Fig. 4)
6. Re-enter the set screws into the connector bodies

6.0 Securing the Optical Ground Wire Samples

6.1 Place a hose clamp or tie wrap around the cable approximately 2 feet behind Mark A (see Fig. 5). This secures the outer strands from unlaying during subsequent handling of the cable. Secure both cables to a workbench or table so that they are held rigidly in place (see Fig. 6). The use of a range taking tower guide clamp attached to a workbench is an adequate means of stabilizing the cable.

NOTE: The remaining cable preparation instructions will be as follows:
HexaCore–Stranded Stainless Steel Design: section 7.0 - 7.4
CentraCore–Stainless Steel Tube in Pipe Design: section 8.0 - 8.5

Fig. 5

Fig. 6

7.0 HexaCore: Removal of Outer / Inner Strands – Stranded Stainless Steel Tube Design

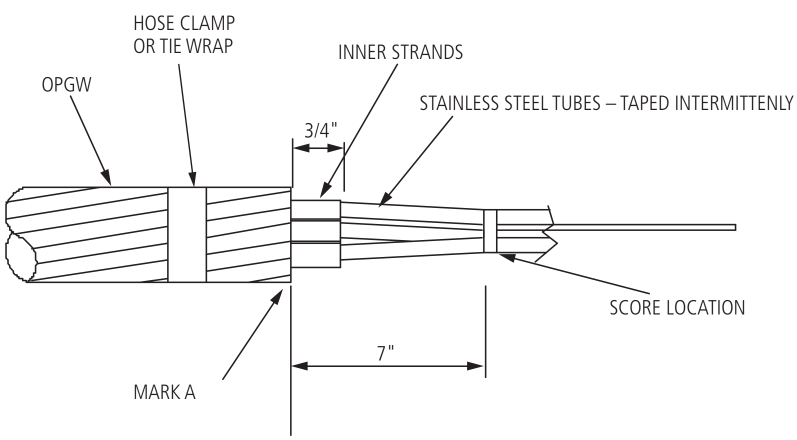
7.1 Unlay the outer strands from the free end past the Mark "A." Evenly cut each individual wire strand at Mark "A" (see Figs. 7 and 8). Be careful not to nick, cut or pry against the stainless steel tubes when unlaying and cutting the outer strands. After all outer wires have been cut at Mark A, fan the remaining length of outer wires back to the hose clamp or tie wrap located 2 feet behind Mark A. This will allow access to the inner layer of strands and stainless steel tubes. Approximately 10 inches back from Mark A, temporarily wrap electrical tape around the inner layer of strands. Replace outer strands to their original lay around the inner strands.

Fig. 7

Fig. 8

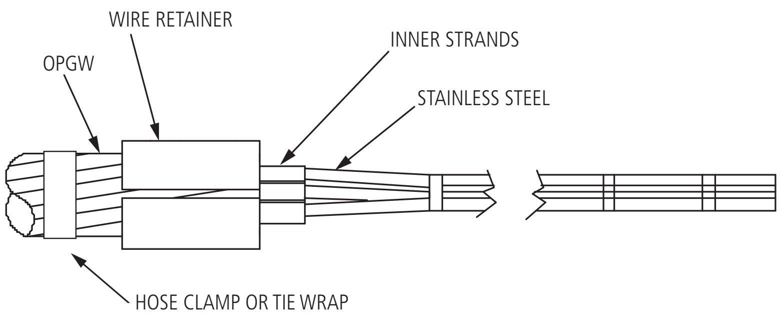
7.2 Measuring from the ends of the outer strands toward the free end, mark the inner wires at 3/4 inch, then mark each of the stainless steel tubes at 7 inches. After marking the cut location, uncoil both the outer and inner wire strands several inches past the 3/4 inch mark. Cut the inner layer of the wire strand at the 3/4 inch mark. Remove the black electrical tape that was placed on the cable in section 7.1. Reform both layers of wire strands back together and move the hose clamp or tie wrap closer to the end s of the wire strands as shown in Fig.9. If using an AFL tube straightener, refer to Appendix A.

Fig. 9



7.3 Slide the proper size wire retainer over the outer strands. Position flush with the cut ends of the outer layer (see Fig. 10).

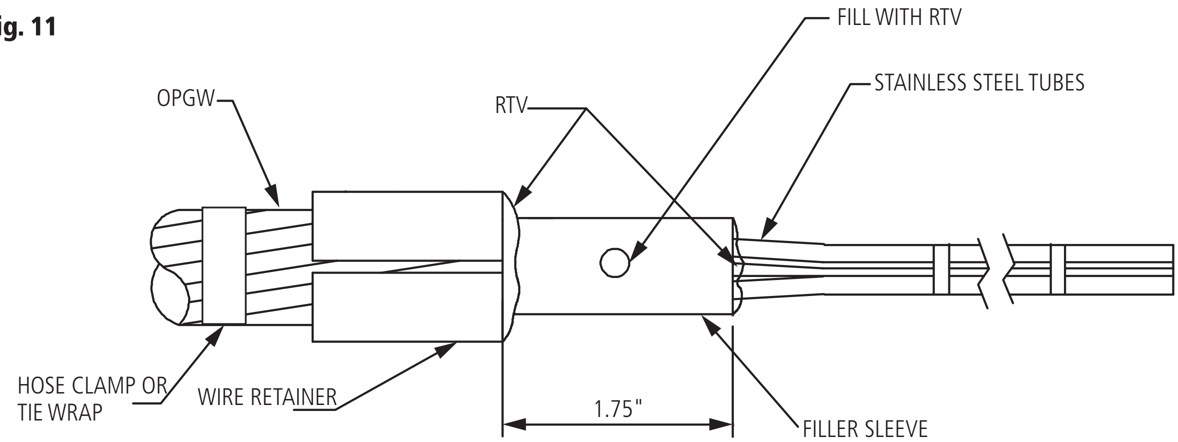
Fig. 10



Note: The hose clamp or tie wrap can be removed after the wire retainer has been applied

7.4 Place a bead of silicone on the outer layer wire tips and around the inner strands to fill all voids. Slide the filler sleeve over the stainless steel tubes and inner strands. While holding sleeve in place, insert silicone into the filler sleeve hole until silicone comes out of the end of the sleeve (see Fig. 11). Rotate the sleeve 180° and again insert silicone until it extrudes out end of sleeve. This will ensure more complete filling of the space within the sleeve.

Fig. 11



8.0 CentraCore: Removal of Outer Strands / Aluminum Pipe – Stainless Steel Tube in Aluminum Pipe Design

8.1 Unlay the outer strands from the free end back to Mark "A" and cut (see Figs. 12 and 13).

Fig. 12

Fig. 13

8.2 After all outer wires have been cut at Mark A; slide the proper wire retainer over the aluminum pipe and onto the outer wire strands. Position the retainer flush with the cut ends of the outer layer.

8.3 With the use of tubing cutter, score and remove approximately 1 3/4 inches of aluminum pipe from around the stainless steel tube. This procedure will provide a clean cut for the movement of the remaining aluminum tube (see Figs. 14 and 15).

Fig. 14

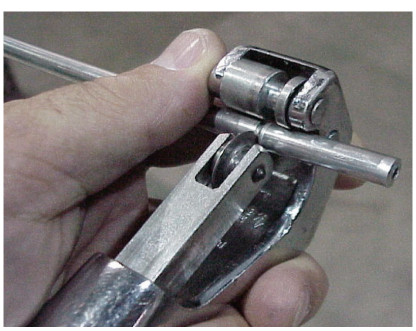
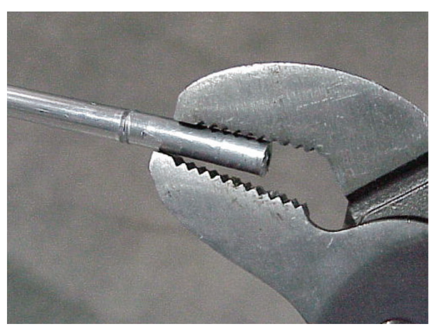


Fig. 15



8.4 Two procedures can be used to perform this process:
1. Using a tubing cutter, score the aluminum pipe in 6 to 10 inch sections. Lightly flex the aluminum pipe back and forth until the bond between the two sections is broken. slide or remove the aluminum pipe down or off.

2. Using a tubing cutter, score the aluminum pipe at 6 to 10 inch sections. Using two pairs of plyers, place one on each side of the scored area. Move the plyers slightly in opposite directions several times until the bond between the two sections is broken. Slide or remove the aluminijm pipe down or off.

Fig. 16A

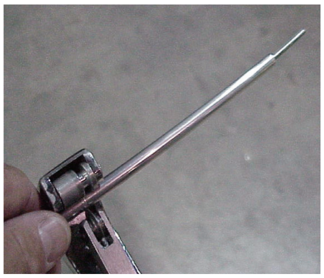
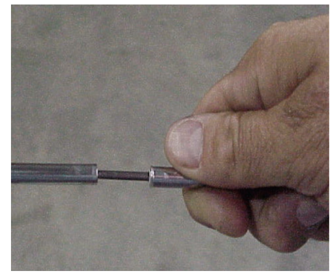


Fig. 16B

Fig. 16C



8.5 All remaining aluminum pipe sections except for a 2" portion shall be ring cut and slid to the end/or removed from the stainless steel tube in 6 to 10 inch sections (see Figs. 17and 18). Always maintain control of the sample to prevent kinking of the stainless steel tube.

Fig. 17

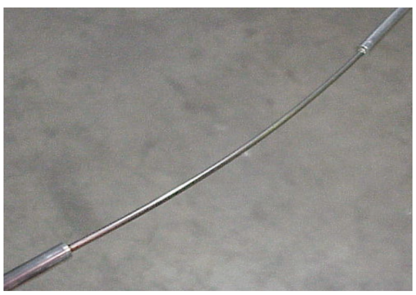
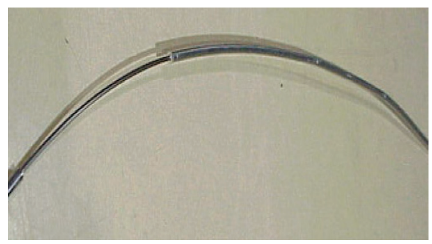


Fig. 18



8.6 Place a mark on the stainless steel tube that represents the removal location.

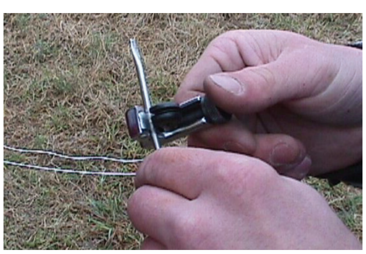
9.0 Removal of Stainless Steel Tube(s)

NOTE: Certain required components listed in these instructions, such as transition tubing and labels, are available and sold separately in AFL part number OGF01 Furcation Kit.

9.1 This step involves scoring the stainless steel tube(s). Practice scoring, flexing, and snapping the stainless steel tube on a scrap piece of cable. Practicing this procedure helps ensure that the optical fibers are not damaged during tube removal (see Fig. 20).

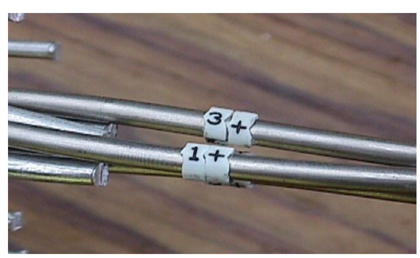
9.2 From the scored location (7") on the stainless steel tube(s), mark each tube at approximately 4-foot increments. Always label each tube with some form of identification (i.e., wire markers, colored pen marks, etc). Before removing see Fig. 21.

Fig. 20 CentraCore:



Final scoring location:

Fig. 21 HexaCore:



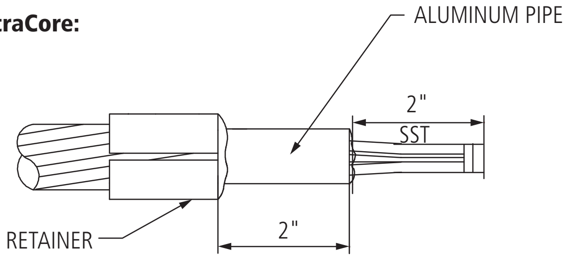
Note: AFL sells number stickers and not snap on numbers.

9.3 Choose a stainless steel tube and carefully score it at the mark closest to the free end. Flex the tube at the scored location in order to snap and separate the tube. Continue to score and remove each 4-foot piece of tube until the tube is removed.

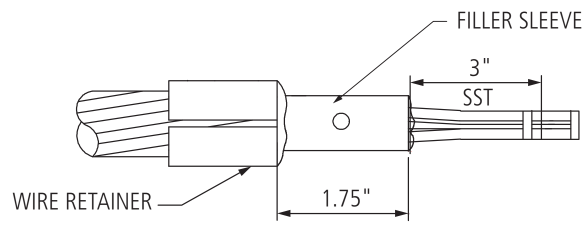
NOTE: Special care should be taken to ensure that the fibers do not scrape against the ends of the tubes during the removal process.

9.4 Cut a 2" length of the heat shrink tubing for each stainless steel tube. Slide the heat shrink tubing over the fibers and 1" of the stainless steel tube (see Fig. 22). If the pipe can be completely removed, slide the heat shrink tubing over the stainless steel tube prior to being removed.

CentraCore:

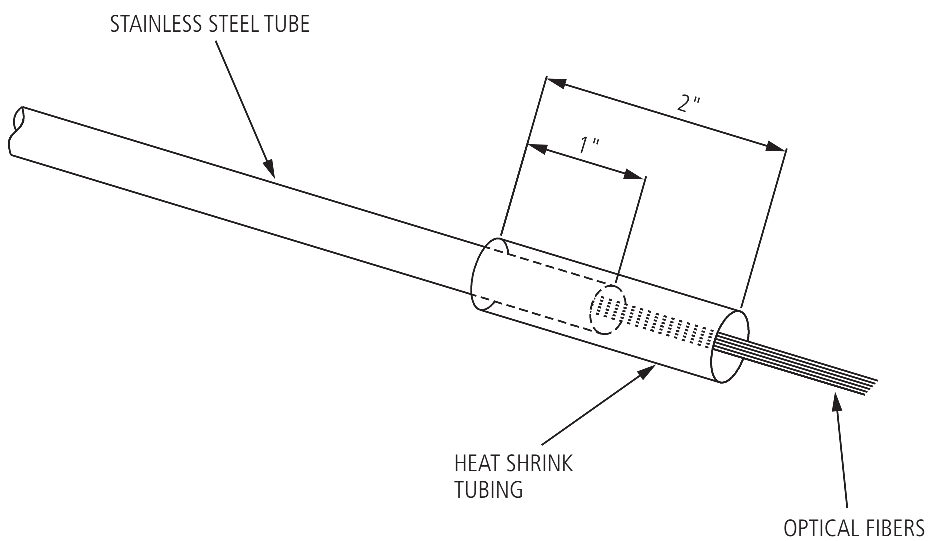


HexaCore:



9.5 Using a heat gun, evenly shrink the tubing around the stainless steel tube and fibers. The heat shrink tube will not shrink onto the fibers. Special care should be taken to ensure that the hot air blast does not remain on the optical fibers for an extended period. Allow the tubing to cool for approximately 5 minutes.

Fig. 22



10.0 Placement of the Transition Tubing

In order to protect the fiber as it is routed from the end of the stainless steel tube to a splice or transition tray, an approximate 6.5-foot (ST01-72 Tray) length of primary transition tubing should be used. Cut and slide this primary transition tubing over the fibers, fitting it snugly around the heat shrink tubing at the mouth of the stainless steel tube (see the FRP/transition tubing procedure).

11.0 Identifying Fiber Groups

11.1 Lightly run a clean wipe over the surface of the fibers to remove the excess gel (see Fig. 23). Do not use a cleaner.

11.2 Starting at the end closest to the stainless steel tube, separate the fibers until you can identify the colored string binders (see Fig. 24).

NOTE: AFL optical ground wires use two colored thread binders to identify each group of twelve fibers in each stainless steel tube. This built-in redundancy makes for a fail-safe method to identify fiber groups in the unlikely event that any binders should break.

Fig. 23

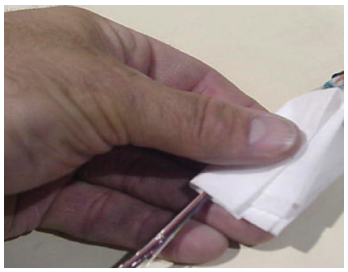
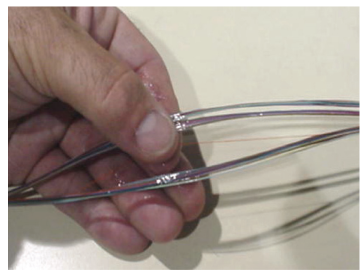


Fig. 24



11.3 Locate one of the colored string binders then lightly pull it until the bundle starts to separate from the other fibers (see Fig. 25 and 26).

11.4 Once a single bundle has been identified, inspect the bundle for the matching color prior to separating the fibers from the other bundles. Once you have identified that both binders are around the same fiber group, count and identify the number of fibers and confirm that they meet the standard color code (see Fig. 27). Separate the unit from the other fibers (see Fig. 28).

Fig. 25

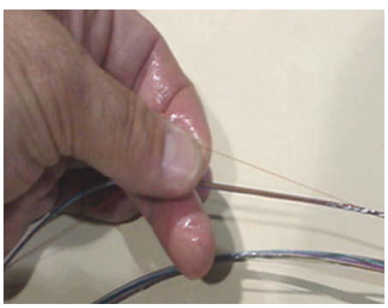
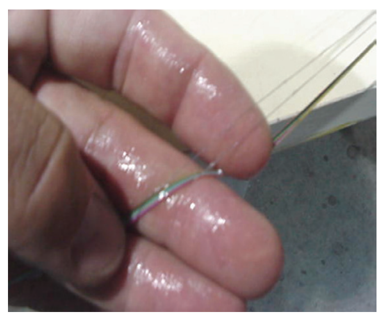


Fig. 26



11.5 Repeat steps 10.3 through 10.4 on each of the fiber bundles. Separate each group of bundled fibers to assure easy identification (see Fig. 27).

Fig. 27

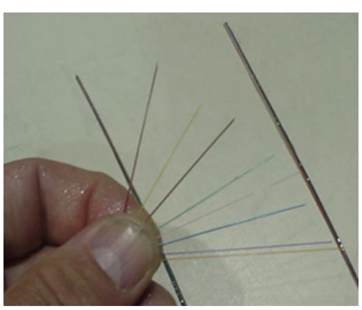
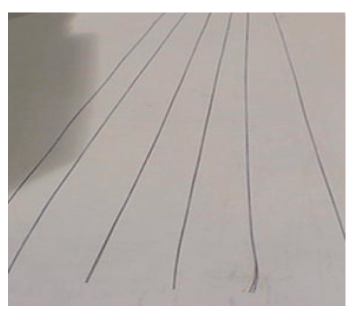


Fig. 28



11.6 The knot is used to identify the indivual units after cleaning. Once the fiber groups have been identified, cut the binders at approximately 4 inches from the stainless steel tub (1 group at a time). Place several half hitch knots around the fiber group for identification. Remove the remaining binders from the group (see Fig. 34 and 35).

12.0 Cleaning the Optical Units

Clean each fiber group with a qualified fiber cleaner.

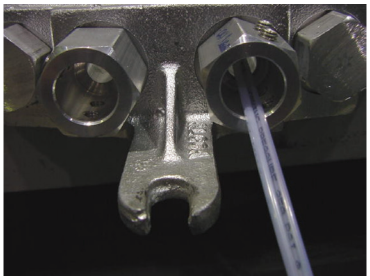
13.0 Placement of the Transition Tubing

13.1 Place a bead of RTV silicone on the wire tips located at the cable retainer (CentraCore Designer).

13.2 Verify which side of the enclosure the transition tubing will be placed in.

13.3 Feed the fiber, transition tubing and stainless steel tube through the connector body (see Fig. 29). Route the transition tubing so that the optical fibers don’t get damaged during the feeding process.

Fig. 29



13.4 After all of the unit(s) have been fed into the enclosure, insert the OPGW cable and cable retainer into the connector body of the splice box. Make sure that the cable retainer is aligned properly with the flat portion being inline with the set screws. Be sure the cable retainer is inserted completely. Firmly tighten each setscrew during the unit installation and again after the completion of the splicing (see Figs. 30A and 30B).

Fig. 30A

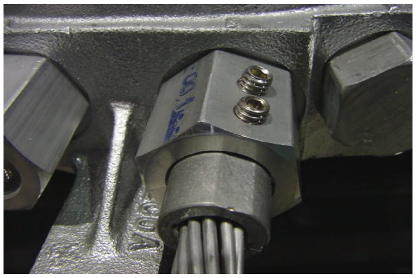
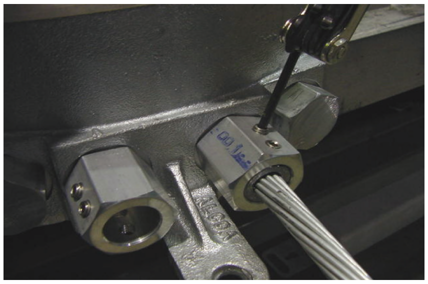
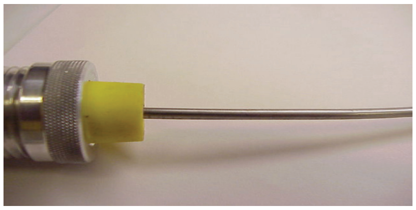


Fig. 30B



13.5 Slide the bushing and retaining nut over the fibers and transition tubing. Tighten the retaining nut so that the bushing is sealed around the pipe and or tube(s) (see Fig. 31).

Fig. 31



14.0 Placement of Optical Fibers in Transition Tubing / Trays (12F Tray Application)

14.1 Route the primary transition-tubing counter clockwise in the box to a splice / transition tray (see Figs. 32 and 33). Secure the tubing to the tray. In the case of two high fiber count optical ground wire cables being spliced together it is advisable to use the same transition tray for the two stainless steel tubes being spliced. Ensure that all tubing is clearly marked for ease of identification.

Fig. 32

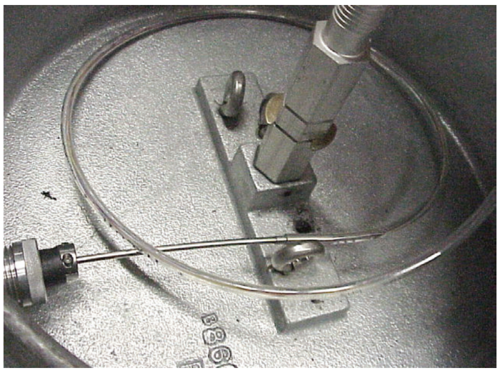
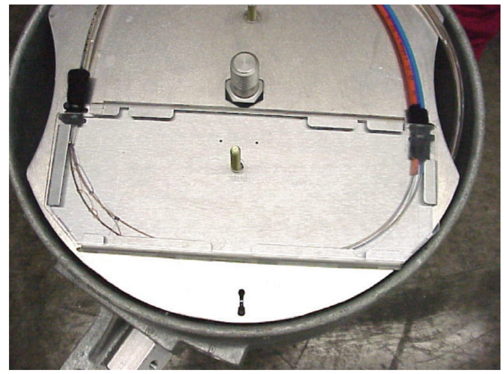


Fig. 33



14.2 If furcation (subdividing a large group of fibers into smaller groups) is required, use the transition tray to segregate the fibers into smaller bundles (see Fig. 33). A length of secondary transition tubing approximately 21 inches long is sufficient to route the fiber from the transition tray, into the actual splice tray. One tray will be needed for each sub-group of fibers.

14.3 If furcation is required, the following method is used to segregate the fibers into individual bundles.

1. Remove the individual fiber group from within the transition tray.

2. Separate each bundle and cut both string binders approximately 4 inches from the stainless steel tube.

3. Remove and dispose of the excess binder from the optical fibers.

4. Take both remaining binders and loosely loop it through itself to form a small half hitch knot around the bundle they mark (see Figs. 34 and 35).

5. Cut the excess binder off approximately 1.0" above the new half hitch knot.

6. Repeat this method for each high fiber count stainless steel tube.

7. If further cleaning of the fibers is necessary, use a standard gel remover cleaner.

Fig. 34

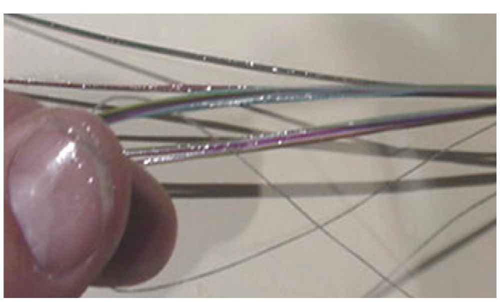
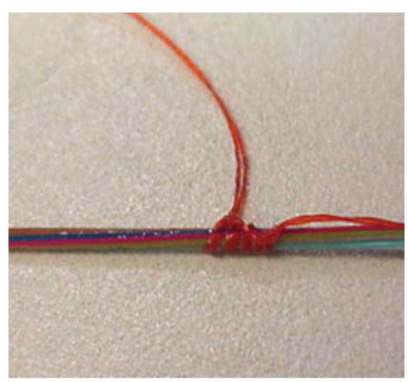


Fig. 35

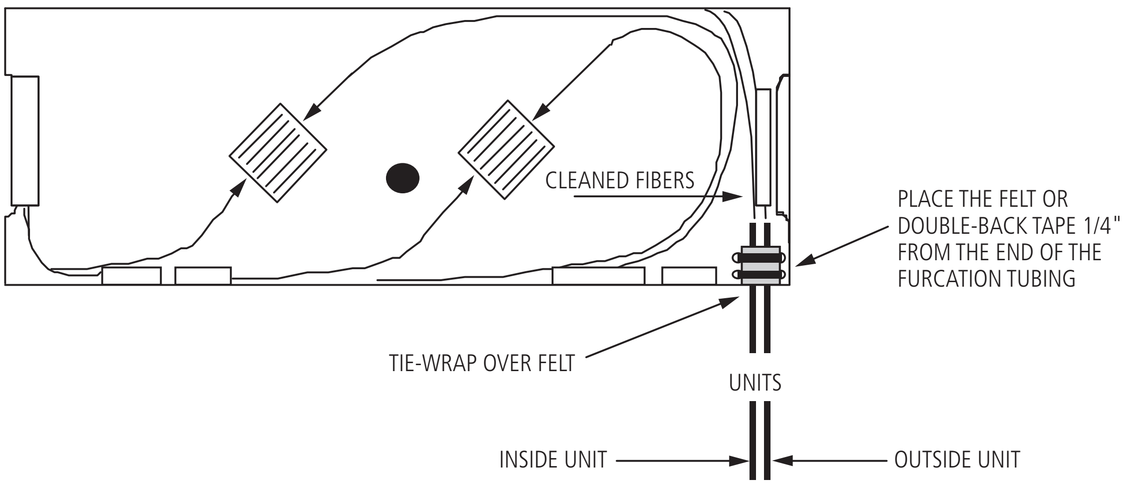


14.4 Slide the secondary transition tubing (approx. 21") over each sub-group of fibers. Identify each unit color and secure the tubing to the transition tray (see Fig. 33).

15.0 Optical Unit Preparation

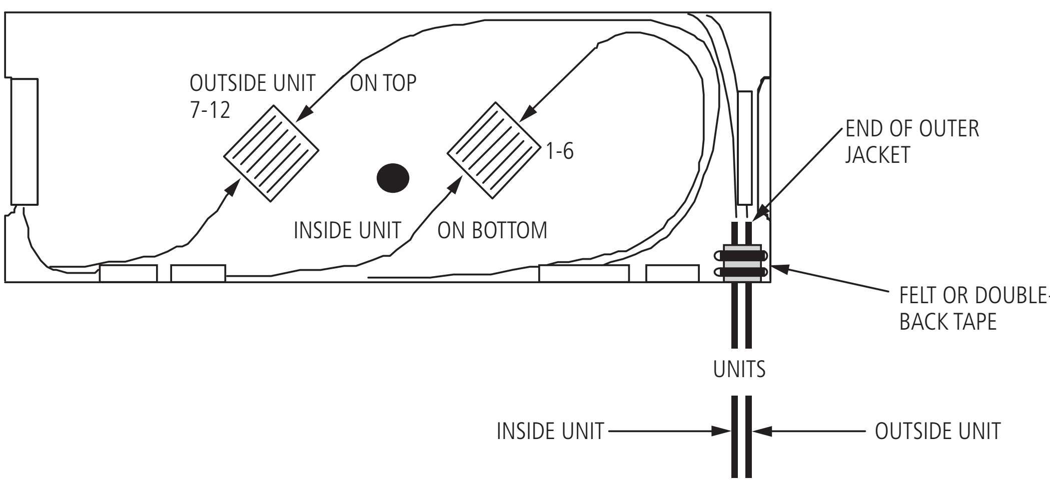
15.1 Tape the tubes marked "Blue" together by placing a piece of double-back tape or felt 1/4 inch back from the end of the furcation tubing. Place the bound section of the Blue units onto the splice tray and secure them to the splice tray with tie wraps (see Fig. 36). If multiple units exist, follow the same steps for the remainder of the like colored tubes. (Note: The double-back tape or felt serves to cushion the optical units from the tie-wraps to be applied).

Fig. 36



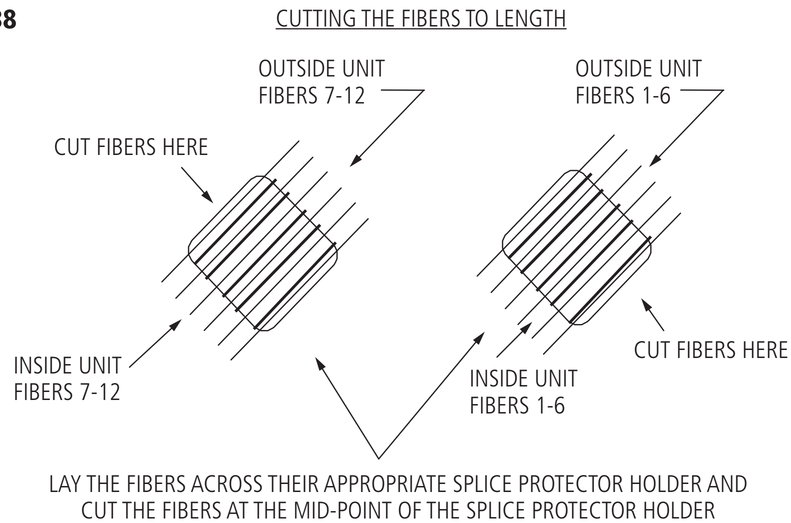
15.2 When cutting fibers to length, wrap the four plus feet of fibers of the inside unit around the tray in a counterclockwise direction. Cut the fibers so that the splice section will fit into the splice-protector-holders. Be sure that the fibers are cut and positioned in COLOR CODE ORDER. Prepare the outside unit in the same manner. The first six fibers will be shorter than the last six fibers in the outside unit (see Figs. 37 and 38). For the inside unit, the first six fibers will be longer than the last 6 fibers. (This figure is based on a 12-fiber unit design.) Place the splice tray cover onto the splice tray making sure that all of the fibers are wrapped inside of the splice tray.

Fig. 37



15.3 Prep all trays in the same manner as detailed in Fig. 37 before any splicing is performed. (NOTE: The exact arrangement may vary due to fiber count configurations).

Fig. 38



16.0 Splicing Fibers

16.1 Splicing will be easier if the splice tray is level with the top of the splicer.

16.2 Lay out only enough fiber to cleave and place into the splicer.

16.3 Slide splice protector sleeve over one of the fibers BEFORE STRIPPING, CLEANING, CLEAVING AND LOADING INTO SPLICER.

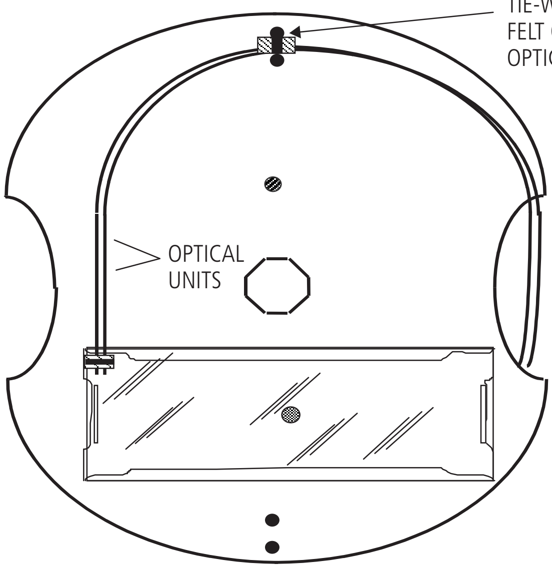
16.4 After the splicing is completed and the splicing technician has accepted the splice, slide the splice protector over the spliced area and place in the tube heater. Once the splice protector has cooled and has become rigid, place and center it into splice protector holder in the tray.

16.5 After all of the fibers have been spliced, protected and positioned, make sure that all fibers are stored on the inside of the splice tray. Place the splice tray cover onto the splice tray.

16.6 If multiple splice trays are required, work only with one splice tray at a time.

16.7 Place the splice tray(s) on the mounting plate bolt. If multiple splice trays are present, sure to stack all splice tray(s) on the same side of the mounting plate. Place the securing nut on the bolt and securely tighten it down snug. This will keep the splice tray(s) secured to the mounting plate (see Fig. 39).

Fig. 39

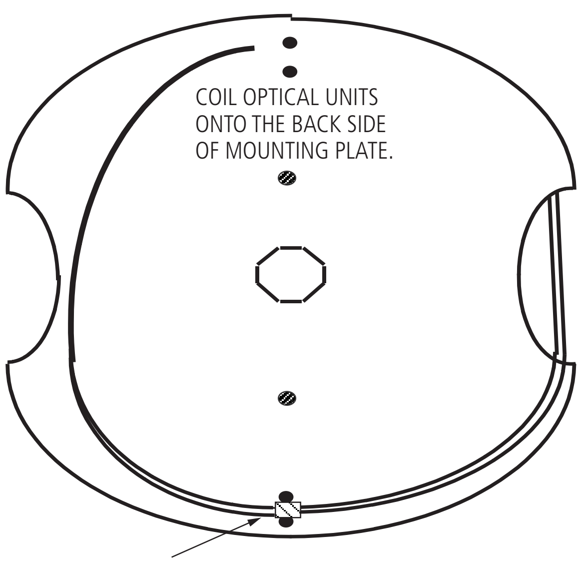


16.8 Place felt or double-back tape around all of the furcation units and tie wrap them together as shown in the above Fig. 39.

17.0 Installing Mounting Plate within the Splice Box

17.1 Using felt or double-back tape, secure and tie wrap the furcation tubes to the backside of the mounting plate (snug) as shown in Fig. 40.

Fig. 40



17.2 Proceed to coil the small section of furcated fibers in a counter-clockwise direction. Align and position the units within the enclosure.

NOTE: Coiling the furcated units should be done by rotating the mounting plate. This procedure will assist in preventing twist or stress to the optical fibers (see Fig. 39 and 40 on previous page).

17.3 When all of the slack is coiled and stored behind the mounting plate, align the mounting plate and secure it to the center shaft by placing the spacer on the center shaft, and installing the outside retaining "clip" ring. (See Fig. 41a below left.)

Fig. 41a

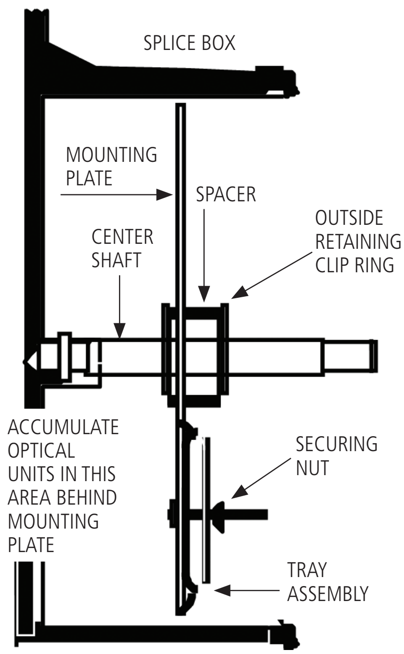
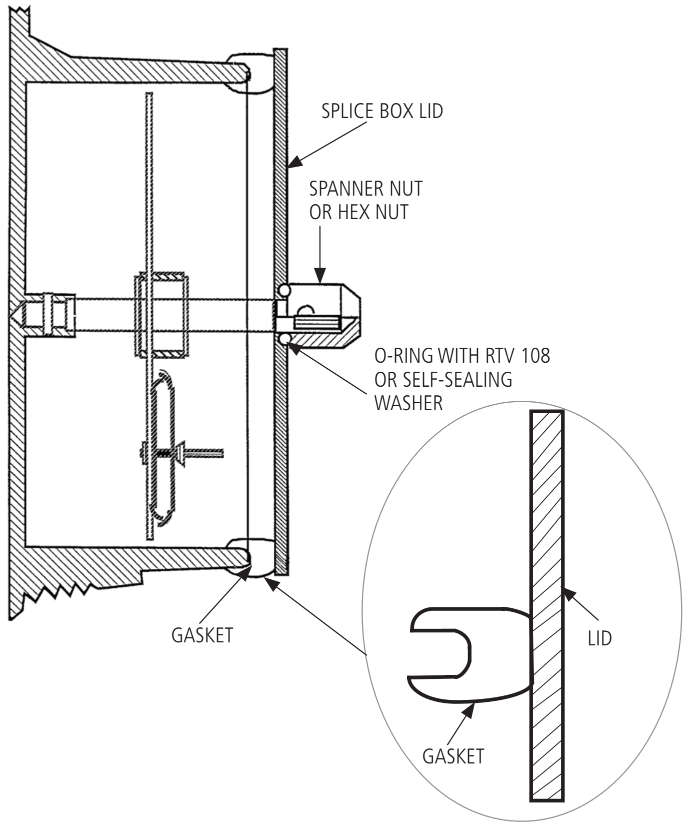


Fig. 41b



18.0 Sealing the Splice Box

18.1 Using alcohol ≥91% and a clean cloth, wipe down the inside groove (both sides) of the gasket and the inside of the splice box lid.

18.2 Place the gasket on the splice box with the beveled side on the lip of the splice box.

18.3 Place the splice box lid on the splice box.

WITH SPANNER NUT

10.4 Place the O-ring over shaft. Cover the O-ring with RTV. Screw the spanner nut on the shaft.

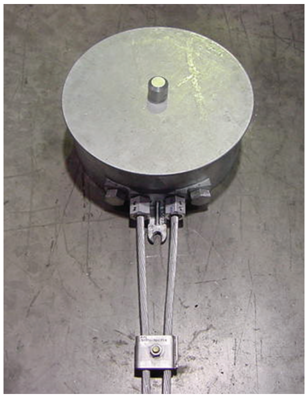
10.5 Tighten the spanner nut on the center shaft until the lid bottoms out (45 ft-lbs).

WITH JAM NUT

10.4 Place the self-sealing washer over the shaft. Screw the nut on the shaft.

10.5 Tighten the spanner nut on the center shaft until the lid bottoms out (45 ft-lbs).

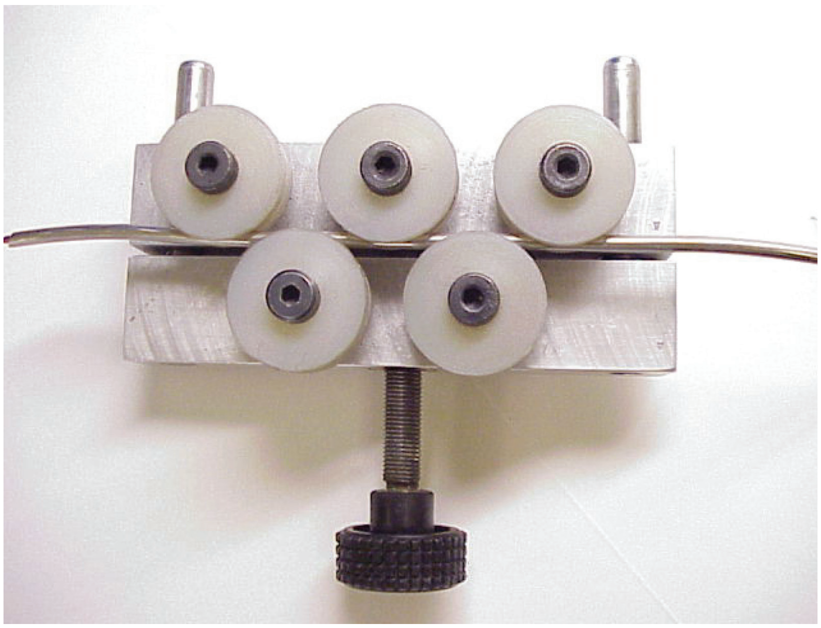
Fig. 42

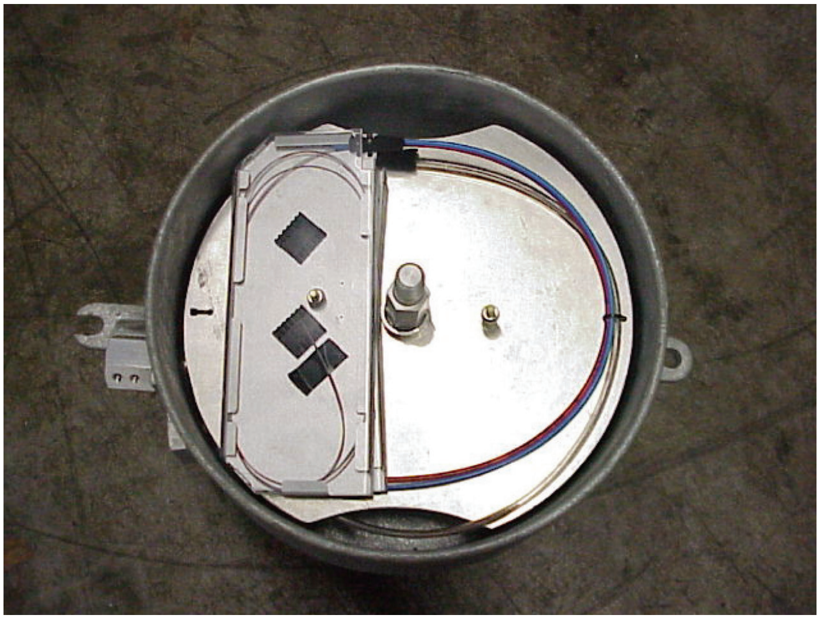


Appendix A

If using an AFL tube straightener, loosen the rollers to allow the stainless steel tube to pass through easily. Insert the free end of one tube into one end of the tool, between the rollers, and out the other end. Slide the tool along the stainless steel tube back to the 7- inch mark. Tighten the rollers together until all are contacting the tube. The purpose is to tighten the rollers to the point where they straighten the tube when it is pulled through them. You may want to practice this procedure on a scrap length of tubing to get an idea of how tight the rollers should be. Over-tightening may crush the tubes and/or damage the fibers. Once the rollers are tightened, use the handles on both sides of the tool to slide it toward the free end, thereby straightening the tubes for ease of tube removal (see Fig. 43).

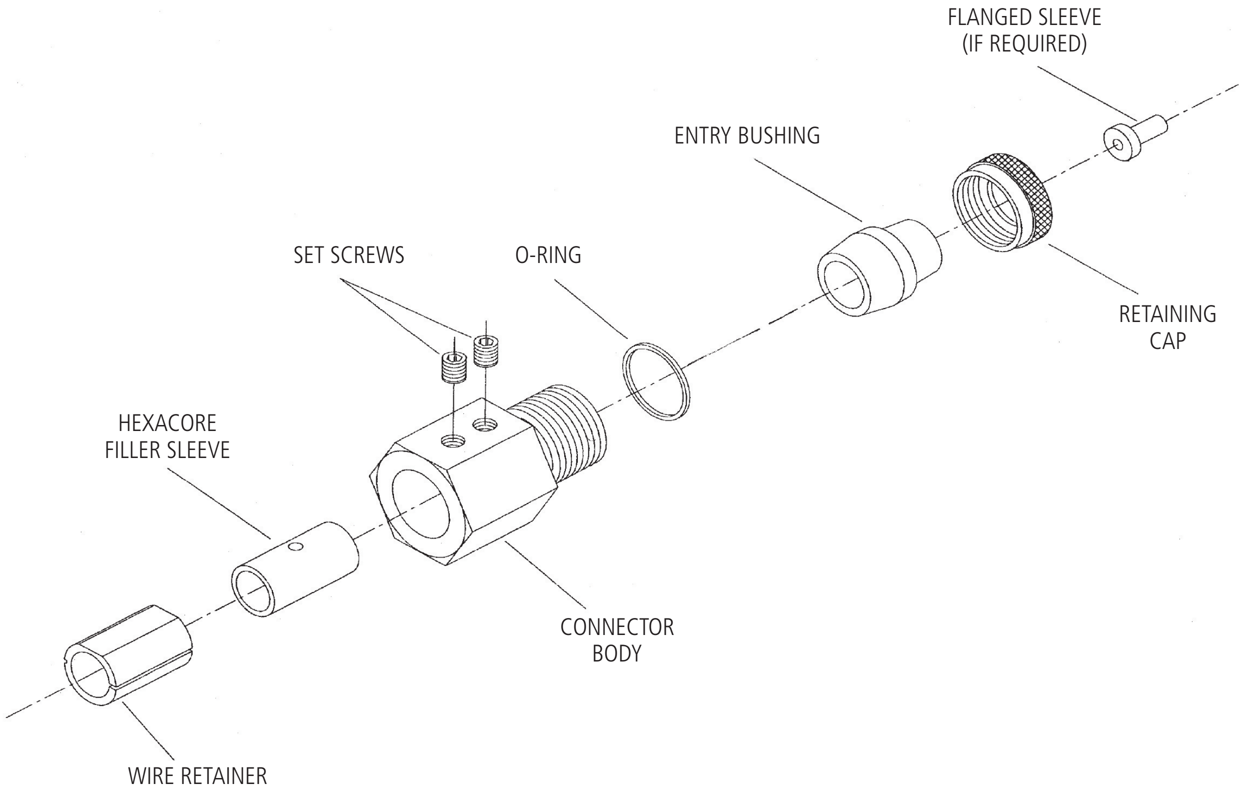
Fig. 43





AFL SB01 SPLICE ENCLOSURE

Connector Assembly



Instructions for Preparing

AFL ST1-72 FIBER SPLICE TRAY

INTO THE AFL SB01 SPLICE ENCLOSURE

NOTE:

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1.0 Tray Description

Fig. 1

1.1 The AFL ST1-72 Splice Tray is capable of holding up to 72 individual splices per tray. The circular tray is constructed of high impact resistant Lexan with a black base and a clear lid. Each tray assembly contains eight, twelve fiber manifolds. Of the eight manifolds, only six are used in the splicing process with the remaining two manifolds being placed in the top positions to help secure the fibers within the tray.

NOTE: All eight manifolds must remain within the tray

2.0 Maximum Fiber Capacity

2.1 A maximum fiber count of 144 splices (two ST1-72 trays) can be stored within the AFL SB01 Splice Enclosure.

NOTE: Prior to installing any cable combination, be sure to verify that the required splice lay out can be contained within each of the two 72 fiber trays without the need to furcate the fibers from one tray to the other. If the customer requires more than the AFL recommended unit storage, confirm that the storage area is adequate prior to splicing the cable.

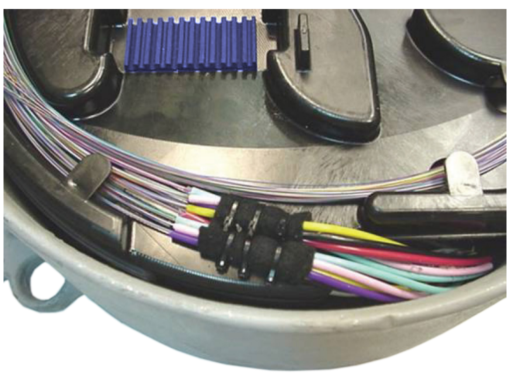
3.0 ADSS or Loose Tube Installation

Fig. 2

3.1 When installing an ADSS or Loose Tube cable into the SB01 enclosure and ST1-72 tray, it requires a minimum of 10.5 feet of optical unit. A minimum of 4 feet (48 inches) of optical unit is stored within the enclosure with an additional 6.5 feet (78 inches) of open fiber being placed within the splice tray. The aramid yarn or central strength member shall be secured within the enclosure with the optical units being routed in a clockwise direction.

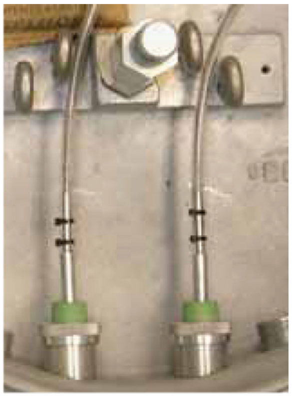
NOTE: Fig. 2 above shows an AFL 144 fiber ADSS design. Storage of Loose Tube or ADSS cables can be increased in length (over 4 feet) depending on the customer's required cable design. If the customer requires more than the AFL recommended unit storage, confirm that the storage area is adequate prior to splicing the cable.

Fig. 3



3.2 Each bundle of optical units shall be wrapped with an adhesive backed felt tape and secured within the tray with black UV cable ties. Once the excess has been cut from the cable tie, move the connection point away from the fibers and towards the edge of the enclosure.

4.0 Stainless Steel Tube Installation



4.1 When installing a Stainless Steel Tube cable design (CentraCore design shown) into the AFL SB01 enclosure and ST1-72 tray, it requires a minimum of 10.5 feet of optical fiber. A minimum of 4 feet (48 inches) of transition tubing (with fiber) is stored within the enclosure with an additional 6.5 feet (78 inches) of open fiber being placed within the splice tray. The transition tubing (with fiber) shall be routed within the enclosure in a clockwise direction.

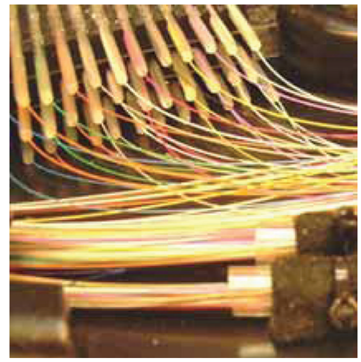
Fig. 5

4.2 Each transition tube containing optical fibers shall be wrapped with an adhesive backed felt and then secured within the tray with black UV cable ties. (**NOTE:** Once the excess has been cut from the cable tie, move the connection point away from the fibers and towards the edge of the enclosure.)

5.0 Routing of Optical Fibers

Fig. 6a

Fig. 6b



5.1 Route all of the fibers into the tray by using the following procedure:
(36F on Left / 36F on Right)

5.1.1 A length of 6.5 feet of fiber is used in order to complete two full wraps within the splice tray.

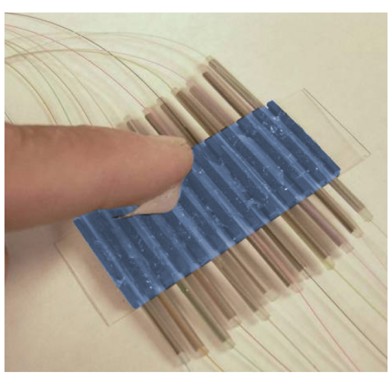
5.1.2 Each set of optical fibers should be separated by unit and individually measured and cut to length.

EXAMPLE: If cutting the fibers to length within the blue units, one of the two units would be measured from the top left side of the manifold facing down with the other unit being measure from the bottom left side facing up. All fibers should be stacked in sequence with the lowest number being placed on the bottom. Fibers 1-36 are to be placed on the left hand side of the tray with fibers 37-72 being placed on the right.

NOTE: Each tray assembly contains eight, twelve fiber manifolds. Of the eight manifolds, only six are used in the splicing process with the remaining two manifolds being placed in the top positions to help secure the fibers within the tray.

6.0 Fiber Splice Sleeves

Fig. 7



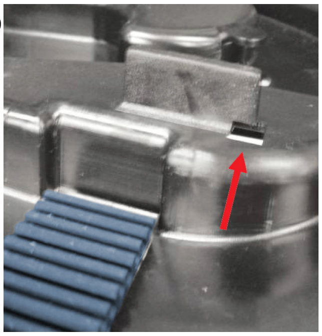
6.1 AFL recommends using the Fujikura 60 mm (#500065) splice sleeves for this application.

6.1 **NOTE:** To ensure that the recommended sleeves are being used, all contractors should check the tightness of their splice sleeves within each of the manifolds used. If necessary, a small bead of RTV can be placed and spread evenly over the splice sleeves to help secure them in place. If this method is used, allow a few minutes for the RTV to begin curing so that the manifolds will not stick together within the tray.

7.0 Closing the ST1-72 Tray

Fig. 8a

Fig. 8b



7.1 After splicing, ensure that all of the fibers are located under the tabs and are free of any pinch points that may be caused from securing the lid. Insert one foam plug on each side of the tray to help secure the fibers in place.

7.2 Apply the lid as follows:

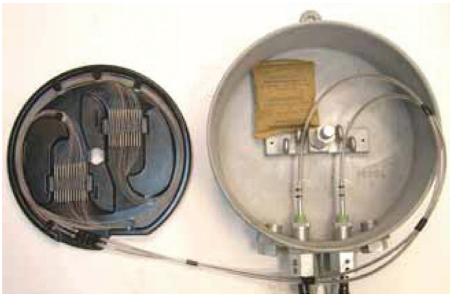
- **7.2.1** Align the open portion of the lid with the fiber entry location on the tray.
- **7.2.2** Placed the lid under the locking portion of the tray (above photos).
- **7.2.3** Secure the lid in place by pressing down on the center of the tray.

Note: Be sure that all 8 manifolds remain within the tray (required).

8.0 Routing and Securing the ST1-72 Tray

Fig. 9a

Fig. 9b



8.1 Route the fiber units back into the SB01 enclosure in a clockwise direction. If longer lengths of fiber unit were required, remove any excess torque by rotating the tray during the routing process. Always install the tray with the lid of the tray facing the lid of the SB01 enclosure.

8.2 Place the center of the tray over the center shaft of the SB01 enclosure.

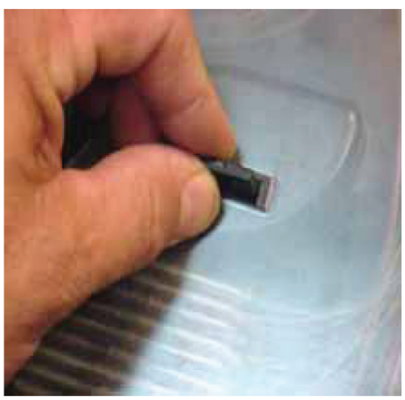
8.3 Place the aluminum spacer ring over the center shaft and onto the tray lid.

8.4 Secure the tray by installing the retainer ring above the spacer and onto the center shaft of the enclosure.

8.5 Seal the SB01 enclosure according to the AFL standard procedure.

9.0 Removing the ST1-72 Tray

Fig. 11



9.1 To remove the tray from within the enclosure, place two fingers on each of the two raised taps and slightly move the tray to the left (against the torque of the tray) and lift upward.

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