

# ***Pro'sKit®***

## **TE-620 series**

### **Fiber Optic Fusion Splicing Machine Kit**



## **User's Manual**

2<sup>ND</sup> Edition' 2018

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Please read this Operation Manual carefully before operating the equipment.

Comply with all safety procedures and warnings in this manual.

Keep this manual properly in a safe place.

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The Optical Fiber Fusion Splicer is designed for the optical quartz glass Fiber used in the communications, except which it cannot be used to splice any other substances and for other applications.

Considering the user's personal safety, here we provide the user with a lot of safety cautions, because it is possible to result in electric shock, fire and personal injury if the user improperly uses the Optical Fiber Fusion Splicer.

**Please read seriously, by all means, this Operation Manual before operating the equipment.**

**Comply with all safety requirements and warnings in this manual.**

**Keep this manual properly in a safe place.**

**In case of meeting a failure, please stop using the equipment, and contact us as soon as possible**

**Keep this manual properly in a safe place, so as to refer to it in the future.**



## **WARNINGS AND CAUTIONS FOR SAFE OPERATION**

It is necessary to immediately turn off the power switch of the Optical Fiber Fusion Splicer ; pull the AC power cord out of the AC power outlet; and take out the storage battery from the Optical Fiber Fusion Splicer, in case of meeting the following failures:

- Smoke, peculiar smell, abnormal sound or heating abnormalities;
- Liquid or foreign objects into the equipment;
- The Optical Fiber Fusion Splicer has been damaged or broken.

If the user has not timely adopted measures to solve failures of the Optical Fiber Fusion Splicer in case of meeting these failures, it may cause the equipment scrap, electric shock, fire or personal injury or even death.

The AC-DC adapter and battery charger of the Optical Fiber Fusion Splicer can only use an AC power source (100V-240V AC, 50hz-60hz). If the user uses the improper AC power source, it may possibly lead to smoke, electric shock, equipment damage, and even cause the fire or personal injury or death. (Note: Usually, AC generators output abnormal high pressure and irregular frequency, so that it is necessary to measure generator's output voltage value with the ammeter before connecting the AC power cord. Abnormal high pressure or frequency can lead to smoke, electric shock, equipment damage, and can even cause fire or personal injury or death. Make sure the generator's regular check and maintenance.

Please use the specific AC-DC adapter. If you use the inadequate AC-DC adapter, it may possibly lead to smoke, electric shock, equipment damage, and cause the fire or personal injury or even death.

Please use the specific batteries. Only the batteries supplied by the manufacturer are allowed to be used for the equipment. Please use the specific battery charger to charge the batteries. If you use other batteries or battery chargers, it may possibly lead to smoke, electric shock, equipment damage, and cause the fire or personal injury or even death.

Don't make bold to disassembly or modify the Optical Fiber Fusion Splicer, the specific AC adapter, or the batteries, esp., any electronic and mechanical devices (fuses or safety switches) inside the equipment can not be removed or bridged. Any improper maintenance may possibly lead to the damage of the Optical Fiber Fusion Splicer, and even cause electric shock, the fire or personal injury or death

It is prohibited to use the Optical Fiber Fusion Splicer in the flammable liquid or gas environments, where the discharge of the Optical Fiber Fusion Splicer may cause the fire or explosion.

Do not use the compressed or canned air cleaner to clean the Optical Fiber Fusion Splicer. Otherwise the arcing generated by splicing will ignite the residual flammable matter.

Don't use the Optical Fiber Fusion Splicer in the environment of high temperature or nearby the high temperature object, and also in the place where there are too much dusts or higher humidity, otherwise it may possibly lead to equipment damage, cause the fire, get an electric shock, degrade the equipment performance, and cause the worse splicing loss.

Please don't use the wet hand to contact the Optical Fiber Fusion Splicer, the AC power cord and AC power plug; otherwise it may possibly cause the risk of getting an electric shock.

When the surface of the Optical Fiber Fusion Splicer is vapor-condensed, please don't operate the Optical Fiber Fusion Splicer, otherwise it may lead to electric shock or equipment damage.

When the Optical Fiber Fusion Splicer is operating, please don't touch the electrode, otherwise the high pressure and high temperature generated by electrode discharge may cause severe electric shocks and burns (Before changing the electrode, you must firstly turn off the power supply of the Optical Fiber Fusion Splicer, remove the batteries, and pull out the AC power cord.)

Do not let the DC input ports of the Optical Fiber Fusion Splicer be short-circuited. The excessive current may lead to personal injury, smoke, electric shock or equipment damage.

Do not use any chemical substances other than alcohol to clean such devices as the objective lens, the V-shaped groove, reflecting mirror, LCD screen, etc., of the Optical Fiber Fusion Splicer. Otherwise it will cause the imaging to be unclear, with stains, corrosion and damage.

The Optical Fiber Fusion Splicer does not need any lubricant, lubricating oil or grease, which will reduce the performance of the Optical Fiber Fusion Splicer and possibly damage the Optical Fiber Fusion Splicer.

For the Optical Fiber Fusion Splicer having passed through the accurate adjustment and calibration, don't subject it to strong shock or collision, otherwise this may possibly cause damage to the equipment. Please use the provided case to transport and store the Optical Fiber Fusion Splicer, so as to effectively protect it from strong vibration or collision.

Don't let the Optical Fiber Fusion Splicer be positioned at an unstable or uneven place, otherwise it may possibly move and lose its balance and fall over, causing the equipment damage and the personal injury.

For the heat-shrinkable sleeve during heating or just at the end of being heated, please don't touch it, because at this time, the temperature of its surface is very high, if you touch it, this may possibly cause burns to you. When you need to bring the portable Optical Fiber Fusion Splicer with shoulder-strap carrying case, please check whether the shoulder strap and hook are intact to you or not. If you use a damaged shoulder strap, it may possibly cause the shoulder strap to be ruptured or escape from the hook, resulting in the personal injury or the equipment damage.

The Optical Fiber Fusion Splicer must be maintained and debugged by a professional technician or an engineer. The incorrect maintenance for it may possibly cause the fire and the electric shock. If the Optical Fiber Fusion Splicer fails, please contact a service center.

Please use the storage batteries strictly according to the Operation Manual. The wrong use may cause the battery explosion and the personal injury.

- Do not use certain methods other than those mentioned in the Operation Manual for battery charging;
- Do not dispose of batteries in fire or incinerator;
- Do not charge and discharge the storage batteries at the place being close to the fire or under the direct sunlight;
  - Do not let the batteries be subjected to the severe shock;
- If the battery leaks, you must handle it with caution, and pay attention to preventing the battery leaking liquid from touching your skin or eyes. In case that you have accidentally touched the battery leaking liquid, you must immediately and thoroughly clean the touched parts, and seek medical care immediately. At the same time, please properly handle the leaking

battery and notify the maintenance service center for solving the related issues.

- In case of charging the batteries, it is not allowed that the batteries will be stacked up on top of the AC-DC adapter or charger.

Please correctly use the electrodes according to the Operation Manual.

- Use only the specific electrodes
- Correctly replace the electrodes
- The electrodes must be replaced in pairs

If the above instructions are ignored, it may cause the abnormal discharge of the Optical Fiber Fusion Splicer, the splicing performance degradation or even damage to the equipment.

**The manufacturer or Seller will not assume the responsibility for the Buyer's or user's personal injury and losses of the articles or equipment caused by that the user ignores the warning and uses or repairs the Optical Fiber Fusion Splicer incorrectly.**

### **Recycling and Disposal**





EU countries:

According to the EU's European Parliament's implementation standard:2012/19/EU, in order to use the new resources and make the number of buried waste to be minimized, the reusable and / or recycling electronic components and materials have been identified and recognized. If you are in the EU countries, please do not use this product as unsorted municipal living solid waste to be discarded. Please contact your local relevant agencies.

Other countries:

For recycling this product, please firstly disassemble it, and then classify each part according to different materials, and keep to the relevant local regulations related to the recycling.

# 1.Specifications:

Model no.	TE-6201A	TE-6201F	TE-6201A-W	TE-6201F-W
Applicable fiber	SM, MM, NZDS, EDF			
Average splice loss	0.02dB(SM), 0.01dB(MM), 0.04dB(NZDS), 0.04dB(ED)			
Splice time	6s (SM)			
Suitable for cutting optical fiber length	10~16mm			
Suitable for optical fiber core	Cladding diameter:80-150μm, Coating diameter:100-1000μm			
Return loss	≥ 60dB			
Fiber image magnification	520 times for single X or Y view; 200 times for X and Y view			
Tension test	2.0N(200gf)(standard)			
Splice program	50 groups			
Electrode life	5000 times			
Protection sleeve length	20mm~60mm			
Storage of splice result	6000 groups of splice results			
Monitor	4.3 "high resolution colorful LCD			
Communication port	Micro USB			
Working light	1 LED light			
Power indication	5 led indication			
Operation condition	Temperature: -10~+50℃			
	Humidity: 0~95%RH			
	altitude: 0~5000m			
Standard plug	A type 	F type 	A type 	F type 
Package	1. Machine x 1pc 2. Fiber Cleaver x 1pc 3. Fiber Stripper x 1pc 4. AC Adaptor x1pc 5. Optical fiber splicing fixture (3-in-1)x1set 6. Battery x1pc 7. Spare Electrodesx1set 8. Protection sleeve (60mm)x 25pcs 9. Liquid dispenser bottle x 1pc 10. Cooling Tray x 1pc		1. Machine x 1pc 2. AC-DC Adaptor x1pc 3. Optical fiber splicing fixture (3-in-1)x1set 4. Battery x1pc 5. Spare Electrodes x 1set 6. Protection sleeve(60mm) x 25pcs 7.Cooling Tray x 1pc 8.Operation Manual x 1pc 9.Carrying Belt x 1pc 10.Carrying Case with Carrying Strap x 1pc	

	11.Operation Manual x 1pc 12.Carrying Belt x 1pc 13.Carrying Case with Carrying Strap x 1pc 14.Communication soft and operation manual	11.Communication soft and operation manual
Power supply	Lithium battery: 11.1V/5.2A Adapter: Input AC 100~240 50/60Hz; Output: DC15V/5A	
Dimension (W x D x H)	145x135x142mm	
Weight	1.7Kgs (include battery) , 1.35Kgs(not include battery)	



TE-6201A-W / TE-6201F-W



TE-6201A / TE-6201F

## 2.OTHER NECESSARY ACCESSORIES FOR SPLICING OPERATION

1. Optical Fiber heat-shrinkable sleeve (20~60mm, not include)
2. Alcohol Without Water(Purity: >99%)(not include)
3. Tissue, Gauze or Skim Cotton Cloth (not include)



### 3.DESIGNATION OF COMPONENTS OF OPTICAL FIBER FUSION SPLICER



V- Shaped groove

Electrode

Optical fiber pressure head



Optical fiber clamp

# **MAIN POINTS OF FUSION SPLICING PROCEDURES**

## **1. How to Get Small Splicing Loss**

### **1-1. Necessary Regular Cleaning Jobs**

- To Clean V-Shaped Groove
- To Clean Reflecting Mirror
- To Clean Optical Fiber Pressure Head
- To Clean Objective Lenses

In case of cleaning Objective Lens , it is unnecessary to remove needle electrodes

### **1-2. Selection/Usage of Appropriate Splicing Modes**

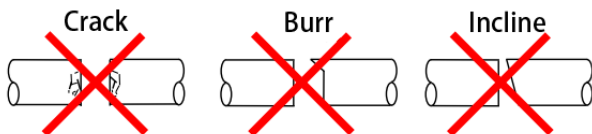
Please select the appropriate splicing modes according to different sorts of the Optical Fibers.

### **1-3. Equipment Clean-up before Each Fusion Splicing Operation**

- To clean the blades of Optical Fiber Stripper.
- To clean the rubber pad and blades of the Optical Fiber Cleaver.

### **1-4. FUSION SPLICING PROCEDURES**

- Make sure that the coating residue and other contaminants on the optical fiber will have been removed after stripping the optical fiber.
- Please use the pure alcohol with a concentration of more than 99%.
- Do not let the well-cut end of the optical Fiber touch any object or be contaminated.
- Please put the end of the optical Fiber at the place between the edge of the V-shaped groove and the center of electrode.
- Please put the optical Fiber rightly on the bottom of the V-shaped groove.
- Make sure the correct cut length. If the cut length is too short, the optical Fiber's coating edge may possibly encounter the V-shaped groove, so that two optical fibers can not be, in the discharge process, fully close to each other, resulting in undesirable loss of fusion splicing.
- Do not tight the optical fibers, otherwise, two optical fibers can not be, in the discharge process, fully close to each other, resulting in undesirable loss of fusion splicing.
- Please check the cutting angle and shape of the optical fiber's end face. The optical Fiber's cutting angle will affect the fusion-splicing quality, and a large cutting angle will increase the loss of fusion splicing.



- It is possible to observe the discharge from the display screen. If the discharge "vibration" or "flickering light" are being observed, the discharge may be unstable at this time and will result in adverse loss.
- In case of heating, the Optical Fiber heat-shrinkable sleeve shall be placed in the center of the heater, so as to avoid uneven heating and lead to additional losses.

## **2. Power Supply**

Please only use the AC-DC Adaptor provided by the manufacturer. Please only use the Storage Battery and Battery Charger provided by the manufacturer.

### **2-1. Avoidance of Damage to AC Adapter**

- The AC generators may possibly produce abnormal output of AC high voltage or irregular frequency.
- The abnormal high voltage and frequency output from the generator may possibly lead to smoke, electric shocks and damage to the equipment, and even cause the fire, the personal injury or death. So, before connecting the AC power supply, you must use a multimeter to measure the generator output voltage.

### **2-2. Storage Battery**

- Even if the storage battery is not used, its capacity will also gradually go down along with the time goes, and if it is fully discharged, it would never be able to charge into the electricity. So, if it will be stored for a long time or it has been used, please charge it in time.
- If it is necessary to store a pack of storage battery for a long time, and no matter how much electricity quantity it has been charged before, you should charge it every six months.
- For operating/charging/longtime storing the storage battery, please refer to the conditions as below:
-

**Operating: -10 °C ~ +50 °C**

**Charging: 0 °C ~ +40 °C**

**Longtime Storing: +20 °C ~ +30 °C**

## **BASIC OPERATIONS**

### **1. POWER CONNECTION**

OPTICAL FIBER FUSION SPLICER provide two power-supply modes: ① Storage Battery; ② AC-DC Adapter. Please make sure that OPTICAL FIBER FUSION SPLICER shall be turned off .in case of operating it.

#### **1-1. Insertion of the Storage Battery**

Insert the storage battery into the battery slot until it is properly in place.

#### **1-2. Removal of the Storage Battery**

Using one hand to press and hold the release button and also support the edge of OPTICAL FIBER FUSION SPLICER, and the other hand to push the storage battery out.

#### **1-3. Connection of the AC-DC Adapter**

Put the plug into socket on the back of device.

#### **1-4. Disconnection of the AC-DC Adapter**

Pull out the plug.

### **2. TURNING ON POWER OF OPTICAL FIBER FUSION SPLICER**


Press power button  to switch ON/OFF device.

### **3. LAYING OPTICAL FIBER**

- 1) To open the wind-protector cover and the optical fiber clamp cover;
- 2) To get the ready optical fiber to be placed in the V-shaped groove, and make the end of optical fiber be placed at the position between the edge of the V-shaped groove and the electrode tip;
- 3) To use fingers to nip the optical fiber, then to close the optical fiber clamp cover so as to ensure that the optical fiber will not move, and make sure that the optical fiber will be placed at the bottom of the V-shaped groove. If the optical fiber is placed incorrectly, please place the optical fiber over again;
- 4) To place another optical fiber according to the above step;
- 5) To close the windproof cover.

## **4. SPLICING OPERATION**


### **4-1. Optional Operation Modes: AUTO/MANUAL**

**AUTO:** By pressing the  key, it is able to start the fusion splicing operation.

**MANUAL:** For the Manual operation, please refer to the details on P15.

### **4-2. Optional Types of Optical Fibers: Single Mode (SM) / Multi Mode (MM) / Non-Zero Dispersion-Shifted (NZDS) / Erbium-Doped (ED) Optical Fiber**

### **4-3. Pause Functions: Open/Close**

**Open:** After the completion of the core-to-core, press the  key to perform the fusion splicing.





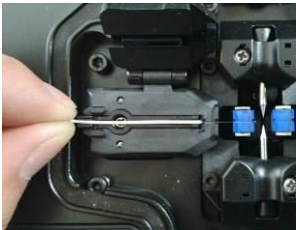
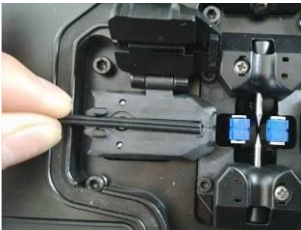
**Close:** After the completion of the core-to-core, automatically perform the fusion splicing.

## **5. TAKING OUT OPTICAL FIBER AND HEAT IT UP**

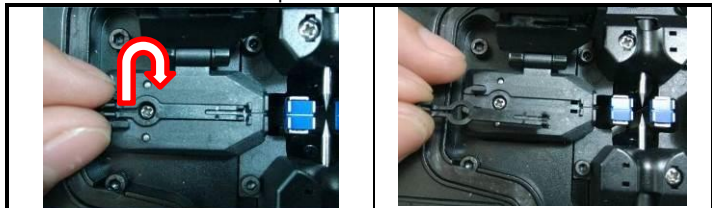
- 1) Open the heater lid;
- 2) Open the windproof cover;
- 3) Open the optical fiber clamp covers at the left and right;
- 4) Take out the optical fiber and move Optical Fiber heat-shrinkable sleeve to the splicing point;
- 5) Place the Optical Fiber heat-shrinkable sleeve in the centre of the heater and cover the heater lid;
- 6) Press the HEAT key to heat, the heat indicator will also light up;
- 7) When the heat indicator goes out and a hint sound appears, the heating is completed;
- 8) Turn on the heater lid, and take out the optical fiber to check and see if the optical fiber contains air bubbles or not;
- 9) After completing the checks, place the optical fiber in the Cooling Salver to cool it.

## **6. How to use fixture**

- 1) The fixture has purpose A and purpose B to achieve variety of optical cable optimum allocation, details as follows: ( the pictures for reference only)

Purpose A ( Assemble “removable guiding groove” )	Purpose B ( Remove “removable guiding groove” )
	
Bare fiber splice( purpose A )	[2mm/3mm]Pigtail/simplex optic cable splice(purpose B)
	
0.9mmPigtail/Simplex cable splice( purpose A )	rubber-insulated wire/Drop cable splice ( purpose B)
	

- 2) Steps of Assembling and removing “removable guiding groove”:  
Holding the tail of “removable guiding groove”, lift it up and forward, and take out. As below pictures:



## **MAINTENANCE OF FUSION SPLICING QUALITY**

### **1. CLEANING AND CHECKING BEFORE FUSION SPLICING**

The following describes the maintenance checks for the key cleaning points and the important parts.

#### **1-1. Cleaning the V-Shaped Groove**

If there are dusts or contaminations in the V-shaped groove, the optical Fiber Pressure Head can not suppress the Optical Fiber correctly, resulting in that the loss of fusion splicing is larger. So, in regular operation, it is necessary to check more often and clean regularly the V-shaped groove.

- To open the windproof cover.
- To clean the bottom of the V-shaped groove with a cotton swab just having had a dip in alcohol (above 99% alcohol), and remove the excess alcohol in the V-shaped groove with a dry cotton swab.
- If contaminations in the V-shaped groove can not be removed with a cotton swab just having had a dip in alcohol, you can use the well-cut end face of the optical Fiber to clean the bottom of the V-shaped groove, and then repeat the previous step.
- In case of cleaning the V-shaped groove, be careful and don't exert an excessive force, so as to avoid damage to the V-shaped groove.
- Be careful and don't touch the tip of the needle electrode.

#### **1-2. Cleaning Up the Optical Fiber Pressure Head**

If there are contaminations on the Optical Fiber Pressure Head, the optical Fiber Pressure Head can not suppress the Optical Fiber normally, resulting in degrading the quality of fusion splicing.

- To open the windproof cover.

- To clean the surface of the Optical Fiber Pressure Head with a cotton swab just having had a dip in alcohol (above 99% alcohol), and remove the excess alcohol on the surface of the Optical Fiber Pressure Head with a dry cotton swab.

### **1-3. Cleaning the Optical Fiber Cleaver**

If there are contaminations on the blades of the Optical Fiber Cleaver or the rubber pad, the cleaving quality will be degraded, and lead to dusts on the surface of the optical Fiber, resulting in the increase of the loss of the fusion splicing. It is necessary to clean the blades of the Optical Fiber Cleaver. or the rubber pad with a cotton swab just having had a dip in alcohol (above 99% alcohol)

### **1-4. Discharge Tests**

Atmospheric environment, such as: temperature, humidity, air pressure, is constantly changing, so that the discharge temperature is also changing. Due to the electrode wear, it is unable to automatically correct the discharge strength caused by the bonding of the optical Fiber debris. The center of the discharge sometimes will move to the left or to the right. At this time, it is necessary to make the discharge tests to solve these problems.

It is also necessary to do discharge tests in case of using the Optical Fiber Fusion Splicer under the following conditions: such as ultra-high temperature, ultra-low temperature, very dry, very wet, electrode degradation, fusion splicing of the heterogeneous optical Fibers, cleanness, after replacing the electrode, or in the case that above conditions exist simultaneously.

## **2. REGULAR CHECKING AND CLEANING**

In order to ensure the better splicing quality, it is suggested to check and clean the Optical Fiber Fusion Splicer regularly.

### **2-1. Cleaning the Objective Lens**

If there are contaminations on the surface of the Objective Lens, the normal location of the observed optical Fiber core may be affected, resulting in the increase of the fusion splicing loss or poor fusing splicing, so, it is necessary to regularly clean two objective lenses, otherwise, the cumulative contaminations are difficult to remove.

- Before cleaning, please firstly turn off the power supply.
- Using a cotton swab just having had a dip in alcohol (above 99% alcohol), to gently wipe the surface of the objective lens,



starting the wipe from the middle of the lens to do a circular movement until the edge of the lens, and repeating several times until there are no contaminations or stains or stripes. Finally, use a clean and dry cotton swab to wipe out the residual alcohol on the surface of the objective lens.

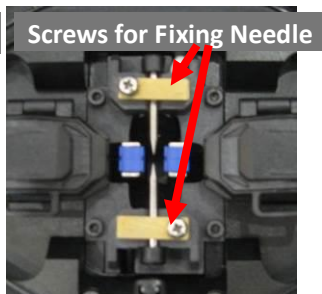
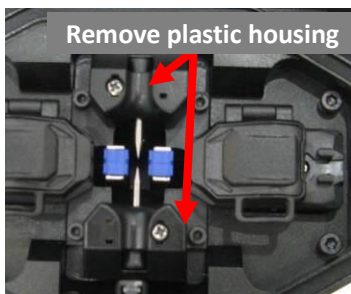
- Be careful and don't touch the electrode tip in case of cleaning.
- It is recommended to clean the lens in case of replacing the needle electrode.

## 2-2.Replacing the Electrode

The electrode will wear in use, and the electrode tip will be aggregated with silicon oxide, so, to regularly clean the oxide can effectively extend the life of the needle electrode. It is recommended to replace the electrode after Optical Fiber Fusion Splicer has discharged 3000 times. If you continue to use the electrode, it may most probably lead to have a very large fusion-splicing loss and reduce the strength of the fusion-splicing points.

Steps of replacement of the needle electrode:

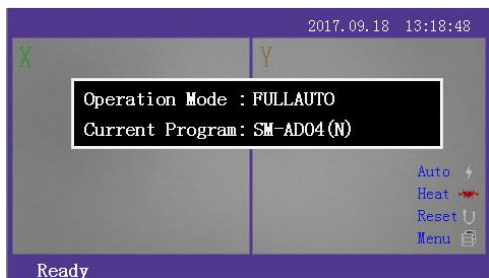
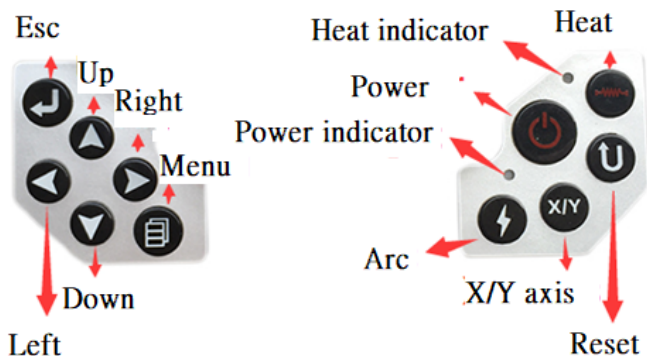
- To turn off the power supply of the Optical Fiber Fusion Splicer.
- To screw out fixing screws, and remove the old needle electrode suffered from electric shock.
- To use a tissue just having had a dip in alcohol to clean the new needle electrode, and then install correctly the needle electrode on the Optical Fiber Fusion Splicer and tighten the fixing screws.
- To turn on the power, and put the prepared fiber into the Optical Fiber Fusion Splicer to do the discharge tests.



## MENU

### How to Enter and Select Menu

Once the system is "ready", press "ENTER" to enter the menu, and press the keys "▲", "▼", "◀", "▶" to select Menu



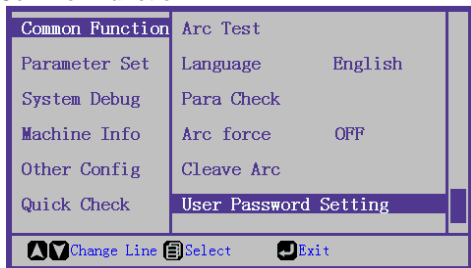
Menu for Common Function  
Menu for Machine Info

Menu for Parameter Set  
Menu for Other Config.

Menu for System Debug  
Menu for Quick Check





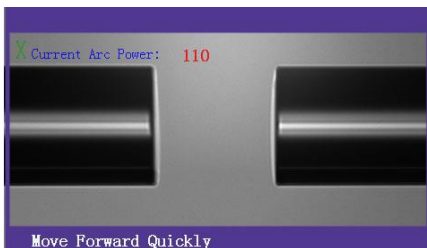
## 1. Menu: Common Function




### 1-1. "Arc Test"

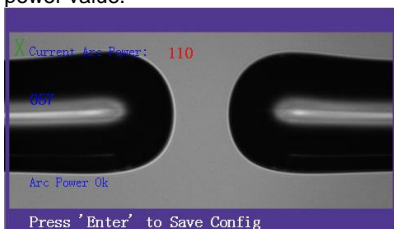
In order to ensure the stable fusion-splicing quality, the user should operate regularly. It is necessary to do arc test in case of using the Optical Fiber Fusion Splicer under the following conditions: ultra-high temperature, ultra-low temperature, very dry, very wet, electrodes degradation, fusion splicing of the heterogeneous optical fibers, cleanness, or after replacing the electrode.

The arc test needs to use two optical fibers being ready to be fusion-spliced, according to the general method of fusion splicing, these optical fiber should be stripped, cleaved off, and placed on the fixture. Press  to enter arc test program. When seeing "Place fiber and press Enter", place the fiber well and press the .



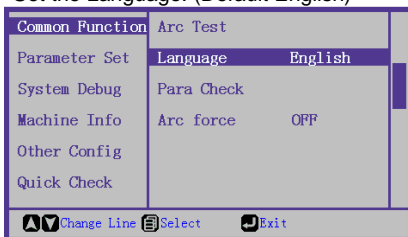
After arc, a numeric value will be displayed on the screen. If the value is within the range of 45-65, it means that the arc power is OK. If the value is less than 45, it means that the arc power is weak, if more than 65, arc power is too strong

After arc, if shown weak or strong, please press , store the record, and then do arc test again until shown the proper arc power value.



## 1-2. "Language"

### Set the Language. (Default English)



### 1-3. "Para Check"

This is an Automatic calibrated program, no need to modify manually

Common Function	Para Check
Parameter Set	Correct Value: 10
System Debug	Base Width: 179
Machine Info	Self-check Status:
Other Config	
Quick Check	
Change Line Select Exit	

### 1-4. "Arc Force"

It is off when use normally

When turned on, it is still work when splicing even if the fiber is not proper to splice.

Common Function	Arc Test
Parameter Set	Language English
System Debug	Para Check
Machine Info	Arc force OFF
Other Config	
Quick Check	
Change Line Select Exit	

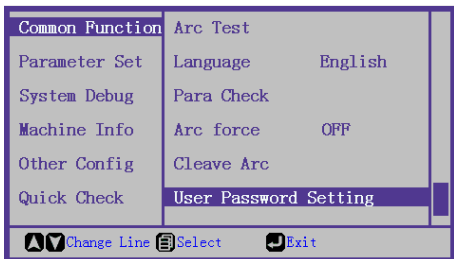
### 1-5. "Cleave Arc"

Clean fiber for Splicing-on-Connector (SOC).

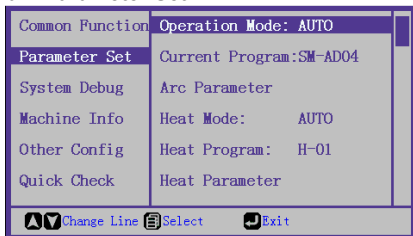
Common Function	Arc Test
Parameter Set	Language English
System Debug	Para Check
Machine Info	Arc force OFF
Other Config	Cleave Arc
Quick Check	User Password Setting
Change Line Select Exit	

## 1-6. “User Password Setting”






When set user password.



## 2. Menu: “Parameter Set”



### 2-1. “Operation Mode”

Press the key “” to enter the “Operation Mode” Menu; press the keys “”, “” to select one of the three operation modes, “FULL AUTO” mode, “AUTO” mode or “MANUAL” mode. After selection, press “” to confirm and save. Press “” to exit.

#### “FULL AUTO” Operation Mode

After place the fibers, cover the windproof cover then do splicing automatically

#### “AUTO” Operation Mode


After place the fibers, press “”, then the program for fusion splicing will automatically execute.


In case of normal fusion-splicing operation, generally select the “AUTO” or “FULL AUTO” operation mode


## “MANUAL” Operation Mode



In “MANUAL” Operation Mode, each step of the optical fiber alignment, the arc and the fusion splicing is controlled by the operator via the keypad.



Keypad Functions in the “MANUAL” Operation Mode are as below:

“” as a “Select” key: It is able to select the operation modes of such four motors as the Left, Right, X, and Y motors.





“” as a “Shift” key: It is able to move the cursor up or down, so as to select the operation commands.




“” as an “Optical Fiber Forward” key: It is able to get the Optical Fiber to advance.

“” and “” separately as the “Forward” key and “Backward” key of the left and right motors: Being able to separately control the left and right motors to go forward or to back off”.

“” and “” separately as the “Upward” key and “Downward” key for tuning the cores of the X and Y motors: Being able to separately control the X and Y motors to go upward or downward.

### 2-2. “Current Program”

Common Function	Operation Mode: AUTO
Parameter Set	Current Program: SM-AD04
System Debug	Arc Parameter
Machine Info	Heat Mode: AUTO
Other Config	Heat Program: H-01
Quick Check	Heat Parameter
  Change Line  Select  Exit	

Press the “” “” to select, then press the Button  to enter the “Current Program” you want

Common Function	Current Program:
Parameter Set	Single Mode
System Debug	Muti Mode
Machine Info	NZDS
Other Config	Erbium Doped
Quick Check	Other
Change Line             Select             Exit	

Press the “▲” “▼” choose the Procedure Number you need to operate or change, press the to choose the Procedure you want (the red is the current Procedure operating). If need to change the Procedure Parameters, please repress to enter the Procedure to change the detailed Parameters (DEFAULT is Factory settings, cannot be changed)

Common Function	Name: 0000AD04
Parameter Set	PreArc Time: 018
	PreArc Power: 070
System Debug	Arc Time: 018
	Arc Power: 080
Machine Info	Forward: 010
Other Config	Forward Speed: 055
	Cleave Angle: 010
Quick Check	Gap: 005
Change Line             Select             Exit	

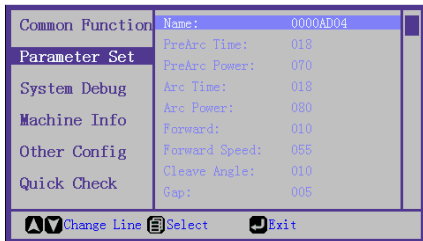
Press the “▲” “▼” to select, press the to enter the menu need to be changed, press “▲” “▼” change the detailed Parameters, then press the to save the result. When changing finished, press Exit.






Function Items	Function Instructions	Range
PreArc time	PreArc time	0-1.0
PreArc Power	PreArc Power	0-250
Arc Time	Splice Arc time	0-10.0
Arc Power	Splice Arc Power	0-250
Forward	The forward distance of the motor when splicing	0-60
Forward Speed	The forward speed of the motor when splicing	0-60
Cleave angle	The angle of cleaving the fiber	0-15
Gap	The gap when the left and right fiber finished alignment	0-50

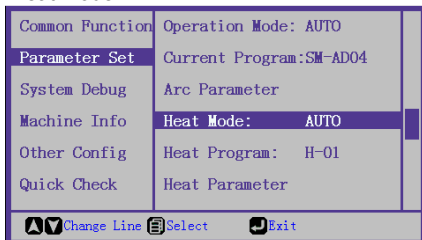
### 2-3. "Arc Parameter"






The Arc Parameter menu is the splicing arc parameters using now



Press “▲”“▼”to select, press the  to enter the menu needed to change, press the “▲”“▼”to change the Parameters, then press  to save the results . When the changing finished, press  to exit.

## 2-4. "Heat Mode"




Press the  to enter the "heat program" menu, press  " to choose the working mode "Auto" or "Manual". When the choosing finished, press  to save the results. When changing finished, press  to exit.

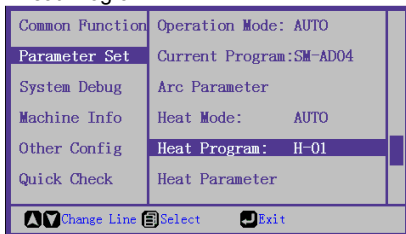
### "AUTO" mode

Put the fiber protective sleeve in the heating box, close the heating box cover, it will heat automatically

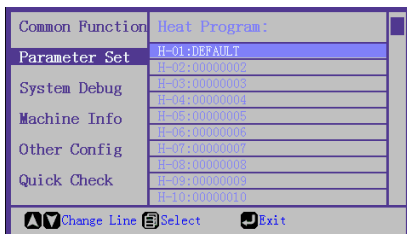
### "Manual" mode



Put the fiber protective sleeve in the heating box, close the heating box cover, press  , it will heat

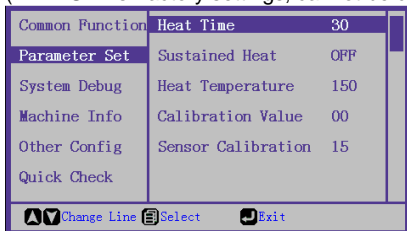
## 2-5. "Heat Program"






Press " " to select, press  to enter the "heat Program" you want.



Press the “▲”“▼” choose the Procedure Number you need to operate or change, press the  to choose the Procedure you want(the red is the Procedure operating now).If need to change the Procedure Parameters, please repress  to enter the Procedure to change the detailed Parameters (DEFAULT is Factory settings, cannot be changed)



Press the “▲”“▼”to select, press the  to enter the menu need to be changed, press “▲”“▼”change the detailed Parameters, then press the  to save the result. When changing finished, press  Exit.

Function	Function Instructions	Range
Heat time	Heating box working time	10-90
Sustained heat (4 mins)	Sustained heat (4 mins)	Turn off/turn off
Heat Temperature	Heat Temperature	100-250
Calibration value	Sensor Calibration value	0
Sensor Calibration	Using to correct the temperature sensor deviation	15

## 2-6. "Heat parameter"

The heat parameter is the current heating parameter.

Common Function	Heat Time	30
Parameter Set	Sustained Heat	OFF
System Debug	Heat Temperature	150
Machine Info	Calibration Value	00
Other Config	Sensor Calibration	15
Quick Check		
Change Line            Select            Exit		

Common function	Heat Time(seconds)	30
Parameter Set	Sustained Heat(4 minutes)	off
System debug	Heat Temperature	150
Machine Info	Calibration Value	00
Other Config	Sensor Calibration	15
Quick Check		

## 3. Menu "System debug"

Common Function	Sensor Status
Parameter Set	Stabilize Electrodes
System Debug	Display Config-Auto
Machine Info	Display Config-Manual
Other Config	Display Config-CCD
Quick Check	Display Config-LED
Change Line            Select            Exit	

Common function	Sensor Status
Parameter Set	Stabilize Electrodes
System debug	Display Config-Auto
Machine Info	Display Config-Manual
Other Config	Display Config-CCD
Quick Check	Display Config-LED

### 3-1. "Sensor Status"

Check the status of each Sensor.

Common Function	Sensor Status		
Parameter Set	000221	322	319
System Debug		469	469
		669	669
Machine Info		124	122
Other Config		774	800
Quick Check		132	127
		080	077
Change Line     Select     Exit			

### 3-2. “Stabilize Electrodes”

Sometimes when the outside environment changes, the Arc power will be unstable. That leads to a big splicing loss. Especially that when the fusion splicer from low altitude area to high altitude area, so it needs some time to stabilize Arc power. When this occasion, it needs to do several Arc tests to stabilize electrodes, which will speed up Arc power stabilization.



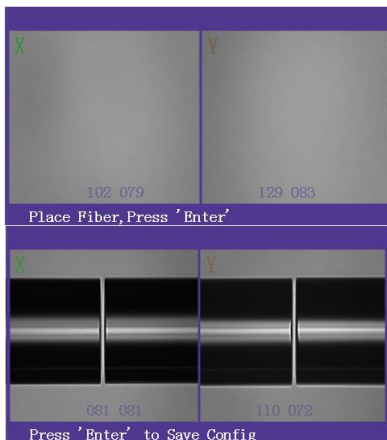
### 3-3. “Display Config-Auto”

Display Config-Auto is to adjust the display range of optical fiber, and make the optical fiber showed in the center of screen.


According to general splicing steps to strip, cut and place optical fiber. Press to enter the “Display Config-Auto”.

The screen will show the follows: Place fiber and press “Enter”.

Press after place the optical fiber.

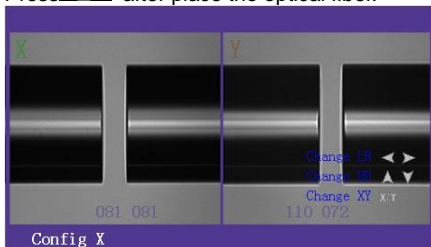


### 3-4. "Display Config-Manual"

According to general splicing steps to strip, cut and place optical fiber. Press  to enter the "Display Config-Manual".


The screen will show the follows: Place fiber and press Enter.

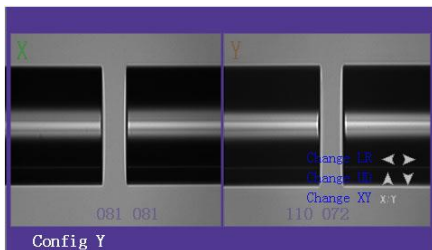
Press  after place the optical fiber.




"◀" and "▶" are movement about left and right position of optical fiber.


"▲" and "▼" are movement about up and down position of optical fiber.

 it changes the X axis and Y axis display.








### 3-5. "Display Config-CCD"

Press , and enter in the menu of "Display Config-CCD"  
The display will show: Press "Auto" to Self Check.

After place the optical fiber and press the button .




### 3-6. Display Config – LED

Press , select "Display Config -LED", press  and  to adjust lightness of X-axis,  and  to adjust lightness of Y-axis.




### 3-7. Display Setting – Dust Check

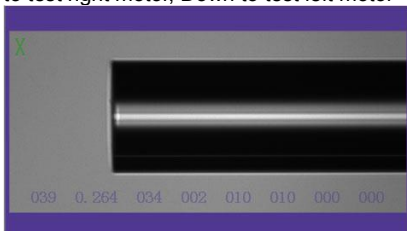
Check whether there is dust in the display system

Press , enter Display Config – Dust Check Menu, check whether the screen show Dust Check Success.

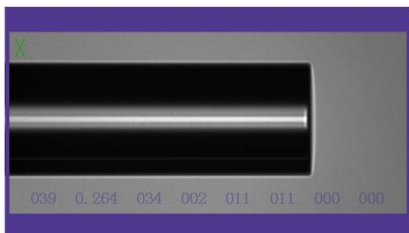


### 3-8. Motor Forward Test


Press , enter “Motor Forward Test”, screen will show“ UP to test right motor, Down to test left motor”

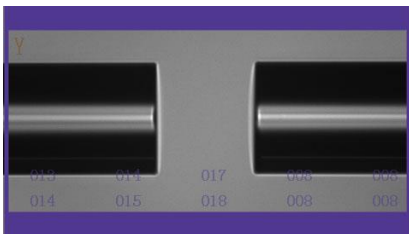
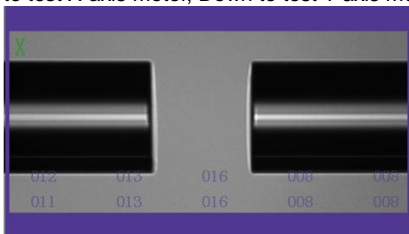








### 3-9. Motor Alignment Test




Press , enter Motor Alignment Test, screen will show “UP to test X-axis motor, Down to test Y-axis motor”






### 3-10. Moto Manually Test

Press , enter Motor Manually Test, press  to select the motor




Left Moto Manual Trigger

Press , select L Moto Manual Trigger, fix a cleaved fiber on the left fixture, make the fiber view in the screen, press and hold  or  to move the fiber.




Right Moto Manual Trigger

Press , select R Moto Manual Trigger, fix a cleaved fiber on the right fixture, make the fiber view in the screen, press and hold  or  to move the fiber.




X-axis Moto Manual Trigger

Press , select X Moto Manual Trigger, fix a cleaved fiber on the left fixture, make the fiber view in the screen, press and hold  or  to move the fiber.




Y-axis Moto Manual Trigger

Press , select Y Moto Manual Trigger, fix a cleaved fiber on the right fixture, make the fiber view in the screen, press and hold  or  to move the fiber.




Left Moto Auto Trigger

Press , select L Moto Auto Trigger, fix a cleaved fiber on the left fixture, make the fiber view in the screen, press  or  to move the fiber automatically, press again to stop moving, .




Right Moto Auto Trigger

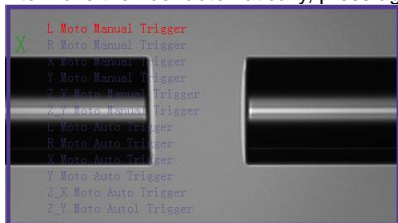
Press , select R Moto Auto Trigger, fix a cleaved fiber on the right fixture, make the fiber view in the screen, press  or  to move the fiber automatically, press again to stop moving.

X-axis Moto Auto Trigger



Press , select X Moto Auto Trigger, fix a cleaved fiber on the left fixture, make the fiber view in the screen, press  or  to move the fiber automatically, press again to stop moving.

Y-axis Moto Auto Trigger


Press , select Y Moto Auto Trigger, fix a cleaved fiber on the right fixture, make the fiber view in the screen, press  or  to move the fiber automatically, press again to stop moving.



### 3-11. Menu of Fine Parameter Check

Press , enter Menu of Fine Parameter Check, according to the general method of fusion splicing, prepare 2 Single-Mode fiber which should be stripped, cleaved off, and placed on the fixture. press  to continue



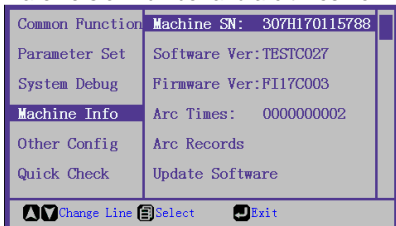
Prepare 2 Multi-Mode fiber which should be stripped, cleaved off, and placed on the fixture. press  to continue



Finally press  to save setting.


## 4. Menu: Machine Info

You can check machine serial number, software version number, firmware version number and arc times from this menu.



- 4-1. Machine SN  
Machine serial number
- 4-2. Software Ver  
Machine software version number
- 4-3. Firmware Ver  
Machine firmware version number
- 4-4. Arc Times  
Machine splicing arc times
- 4-5. Arc Records





Enter “Arc times” menu by pressing  and check arc records by pressing “◀”, “▶”

The machine can store 6000 times splicing arc records.

- 4-6. Update Software  
Update the machine software
- 4-7. Update Firmware  
Update the machine firmware

## 5. Other Config

### 5-1. Pause

Press  to enter “Pause” menu, press “▲” “▼” to choose the pause function “turn on or off”. Press  to ensure save the function after choosing.

When do splicing, usually turn off the pause function.

Common Function	Pause:	OFF
Parameter Set	Stretch Test:	OFF
System Debug	Monitor Flip:	OFF
Machine Info	Buzzer Volume:	ON
Other Config	Fiber Detect:	OFF
Quick Check	Auto Focus:	OFF
Change Line     Select     Exit		

## 5-2. Stretch Test

Press to enter “Stretch Test” menu, press “▲”“▼”to choose “on” or “off”. Press to ensure save the function after choosing.

Common Function	Pause:	OFF
Parameter Set	Stretch Test:	OFF
System Debug	Monitor Flip:	OFF
Machine Info	Buzzer Volume:	ON
Other Config	Fiber Detect:	OFF
Quick Check	Auto Focus:	OFF
Change Line     Select     Exit		



## 5-3. Monitor Flip




Press to enter “Monitor Flip” menu, press “▲”“▼”to choose turn off or turn on of image rotation. Press to ensure save the function after amending.

Envisage image or rotate 180 to show the image on the screen.




Common Function	Pause:	OFF
Parameter Set	Stretch Test:	OFF
System Debug	Monitor Flip:	OFF
Machine Info	Buzzer Volume:	ON
Other Config	Fiber Detect:	OFF
Quick Check	Auto Focus:	OFF
Change Line     Select     Exit		




#### 5-4. Buzzer Volume

Press  to enter Buzzer Volume menu, press “▲”“▼” to choose turn off or turn on the button voice. Press  to ensure save the function after choosing.




Common Function	Pause:	OFF
Parameter Set	Stretch Test:	OFF
System Debug	Monitor Flip:	OFF
Machine Info	Buzzer Volume:	ON
Other Config	Fiber Detect:	OFF
Quick Check	Auto Focus:	OFF
 Change Line  Select  Exit		

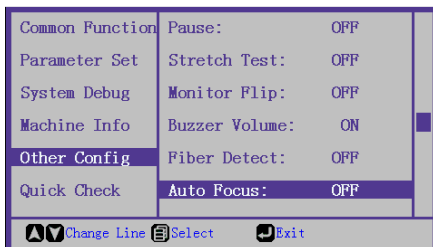
#### 5-5. Time Set

Press  to enter “Time Set” menu, press “▲”“▼” to choose “year, month, date, hour, minute,”, press “◀”, “▶” to amend the data. Press  to ensure save the function after amending, then press  to exist.

Common Function	Pause:	OFF
Parameter Set	Stretch Test:	OFF
System Debug	Monitor Flip:	OFF
Machine Info	Buzzer Volume:	ON
Other Config	Fiber Detect:	OFF
Quick Check	Auto Focus:	OFF
 Change Line  Select  Exit		

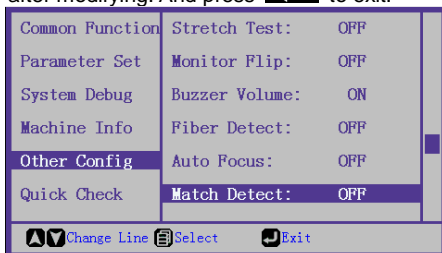
#### 5-6. Function Setting

Press  to enter “Function Setting” menu, press “▲”“▼” to choose “saving power switch, Motor reset time”, press “▲”“▼” to amend the data. Press  to ensure save the function after amending, then press  to exist.



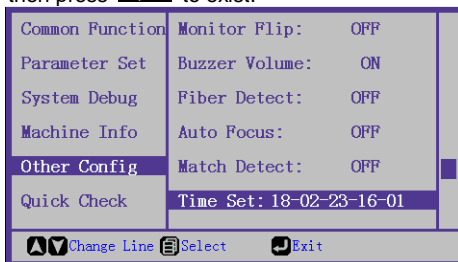
#### 5-7. Motor reset time

Press **📄** to enter the "Motor Reset Time" function menu and press "▲" "▼" to modify the parameter. Press **📄** to save after modifying. And press **↵** to exit.






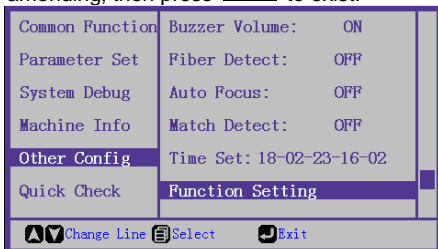
#### 5-8. Time Set

Press **📄** to enter "Time Set" menu, press "▲" "▼" to choose "year, month, date, hour, minute,", press "◀", "▶" to amend the data. Press **📄** to ensure save the function after amending, then press **↵** to exist.





## 5-9. Function Setting

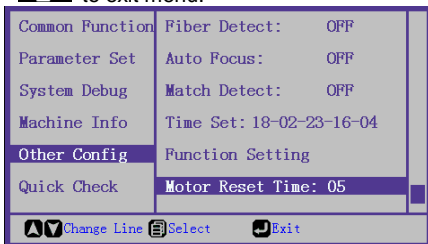
Press  to enter "Function Setting" menu, press "▲" "▼" to choose "saving power switch, Motor reset time", press "▲" "▼" to amend the data. Press  to ensure save the function after amending, then press  to exist.



## 5-10. Motor reset time




When "Tension Test" function is off, the motor resetting time could be modified.

Press  into "Motor Resetting Time "function menu, then press "▲" "▼" to modify parameters. After modification, press  to exit menu.

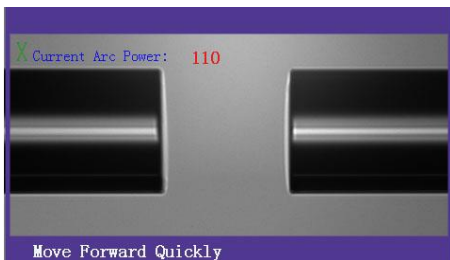


## 6. Menu: Quick Check


### 6-1. Arc parameter calibration

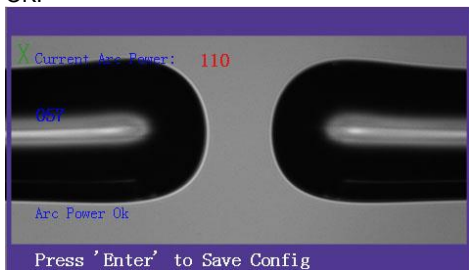
Press  to enter the "Arc parameter calibration" menu, according to the general fusion process to strip, cut and fix the fiber, and press  to confirm. Press  to exit when the calibration is complete.










After arc, the screen shows a value, if the value is between 45-65, indicating the arc power is OK. If the value is less than 45, the arc power is weak, if the value is greater than 65, the arc power is too strong.

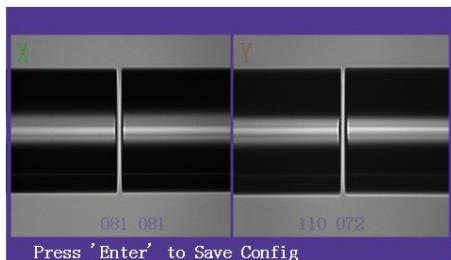
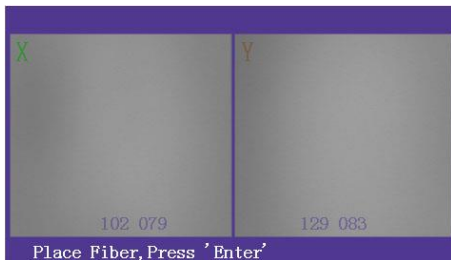
After arc, if shows too weak or too strong, press  directly to save config, and then repeat the arc test until the arc power is OK.



## 6-2. Display parameter calibration

Press  to enter the “Display parameter calibration” menu, according to the general fusion process to strip, cut and fix the fiber, and press  to confirm and test. Press  to exit when the calibration is complete.

According to general splicing steps to strip, cut and fix the fiber. Press  to enter the “Display Auto Config” menu. Screen shows “Place fiber, and press Enter”, press  after putting the fiber.



## QUESTIONS AND TROUBLE SHOOTING

### 1. TURNING ON POWER OF OPTICAL FIBER FUSION SPLICER AND POWER SUPPLY

- Turn on the power switch, but the power supply does not respond.

**Reason:**

- a. Power outlet is not plugged in.
- b. The contact of the power switch is bad.
- c. The storage battery is not properly inserted in.

**Solution:** Check to see if the power plug or the storage battery is plugged/inserted in well or not, and is connected to the optical fiber fusion splicer well or not. Then, check to see if the power switch is good or not.

- In case of turning on the optical fiber fusion splicer, it has no reaction. (The screen does not brighten.)

**Reason:**

- a. The power supply fuse disconnects.
- b. There is the short-circuit or the failure occurs inside the optical fiber fusion splicer

- c. The electricity capacity of the storage battery is not large enough or the polarity is connected in reverse direction.
- d. The AC adaptor is bad, the voltage output is not correct.
- e. The display screen is bad.

**Solution:** Check to see if the power supply fuse disconnects or not, and to see if there is the short-circuit or other failure occurs inside the optical fiber fusion splicer. Replace the power supply fuse on the main board. If there is the short-circuit or other failure inside the optical fiber fusion splicer, please contact your dealer to repair/maintain it or send it back to the factory for repair/maintenance.

Check to see if the electricity capacity of the storage battery is large enough or not. If it is not large enough, it is necessary to discharge the storage battery. Check to see if the battery polarity is connected in correct direction or not. If it is connected in reverse direction, it is necessary to correct it.

Check to see if the voltage output of the AC adaptor is normal or not. (The output voltage should be 12V. ).If it is not normal, it is necessary to replace the former AC adaptor by a new one. Please contact your dealer to replace the former AC adaptor by the special AC adapter.

The brightness of the display screen has been well adjusted at the factory, if the display screen can not properly show, it indicates that the display screen is faulty, please contact your dealer to repair/maintain it or send it back to the factory for repair/maintenance.

- After turning on the optical fiber fusion splicer, it always shows "system reset" and the equipment is at all times in the "Reset" status.

**Reason:** a. The photoelectric switch of the optical fiber fusion splicer is faulty.

b. The motor or the motor drive is faulty.

**Solution:** Please contact your dealer to repair/maintain it or send it back to the factory for repair/maintenance.

## 2.FUSION SPLICING OPERATIONS

- After having placed the optical fiber, there appears a very dark image or a dim image on the half of the display screen.

- Reason:** a. The windproof cover is not correctly put in its position  
b. The reflecting mirror in the windproof cover is positioned with a deviation angle.  
c. The corresponding light does not shine.  
d. The corresponding CCD signal control lines fall off or the CCD is faulty.

**Solution:** Check to see if the windproof cover is covered or not, with or without foreign body sticking the windproof cover. Adjust the angle of the reflecting mirror to the right position. Check to see if the corresponding light does shine or does not. If it does not shine, please contact your dealer to repair/maintain it or send it back to the factory for repair/maintenance.

- Press the "⚡" key, but the optical fiber stops moving; press the "U" key, and it is able to normally reset the system, but the optical fiber still does not move.

- Reason:** a. The optical fiber is broken off.  
b. The press board of the optical fiber did not pin the optical fiber.

**Solution:** Produce the optical fiber again. Lay the optical fiber again. Shut the press board, and gently pull the optical fiber back by hand. If the optical fiber can be easily pulled to move, it indicates the press board did not pin the optical fiber. Check to see if the compaction bar of the optical fiber is able to bounce or not. If the compaction bar is not able to bounce, it needs to be repaired.

- Press the "⚡" key, and the optical fiber moves forward to a certain position, and then moves forward again, and finally there will be shown "Lay Optical Fiber Again".

- Reason:** a. The length of the cleaved optical fiber is unable to meet the requirements.  
b. There is an obstacle for the press board of the optical fiber to move forward.

**Solution:** The length of the cleaved optical fiber should be about 16mm. If it does not meet the requirements, it is necessary to produce the optical fiber again. In the advancing direction of the press board of the optical fiber, gently push by hand the press board of the optical fiber, and to check to see if it has an obstacle or not. If it has an obstacle, it is necessary to find its location, and handle it.

- Press the "⚡" key, and in the course of the core-to-core of the optical fibers, the image of the optical fiber at one side is moving up and down in the vertical direction, and the end-faces of the optical fiber at two sides are not core-to-core, so that it is unable to do the fusion splicing.

**Reason:** a. There is the dust on the precision V-shaped groove, so that the position of the optical fiber at one side is somewhat higher, the data of which is greater than the max. position value of the optical fiber at the other side moving up and down.

- b. There are the dust and dark spots on the objective lens' surface, the lights, the reflecting mirrors, and the CCD has dust or dark spots.

**Solution:** Clean the bottom of the V-shaped groove with a cotton swab just having had a dip in alcohol (above 99% alcohol), and remove the excess alcohol in the V-shaped groove with a dry cotton swab. If contaminations in the V-shaped groove can not be removed with a cotton swab just having had a dip in alcohol, you can use the well-cut end-face of the optical fiber to clean the bottom of the V-shaped groove, and then repeat the previous step. Also, clean the objective lens' surface, the lights, and the reflecting mirrors with a cotton swab just having had a dip in alcohol (above 99% alcohol), and remove the excess alcohol on the objective lens' surface, the lights, the reflecting mirrors with a dry cotton swab. If it is still impossible to solve these issues, please contact your dealer to repair/maintain it or send it back to the factory for repair/maintenance.

- There often occurs that the fusion splicing is done despite of optical fibers being not core-to-core, so that after completing the fusion splicing, there will be shown a large loss or a failure in the fusion splicing.

**Reason:** a. An optical fiber is dirty, and its end-face is bad.

- b. There are the dust and the dark spots on the objective lens' surface, the lights, the reflecting mirrors.

**Solution:** Produce the qualified optical fiber again. Clean in the same way, the objective lens' surface, the lights, and the reflecting mirrors with a cotton swab just having had a dip in alcohol (above 99% alcohol), and remove the

excess alcohol on the objective lens' surface, the lights, the reflecting mirrors with a dry cotton swab. If it is still impossible to solve these issues, please contact your dealer to repair/maintain it or send it back to the factory for repair/maintenance.

- There always occurs that the end-face of the optical fiber at one side is not good.

**Reason:**

- a. In the Menu, the value of "End-Face Setup " is somewhat small.
- b. There are the dust and dark spots on the objective lens' surface, the lights, and the reflecting mirrors' lens.
- c. The corresponding light does not shine.
- d. There is the dust in the V-shaped groove, or the optical fiber had not properly been laid into the V-shaped groove.

**Solution:** Enter the Menu and increase the value of "End-Face Setup ". Clean in the same way, the V-shaped groove, the objective lens' surface, the lights, and the reflecting mirrors with a cotton swab just having had a dip in alcohol (above 99% alcohol), and remove the excess alcohol on the V-shaped groove, the objective lens' surface, the lights, and the reflecting mirrors with a dry cotton swab. Check to see if the corresponding lights are normal or not, and to see if the optical fiber had properly been laid into the V-shaped Groove or not. If it is still impossible to solve these issues, please contact your dealer to repair/maintain it or send it back to the factory for repair/maintenance.

- The electrode does not discharge in the course of the fusion splicing.

**Reason:**

- a. The program without the set parameters had been selected or in the program the discharge strength is set to 0.
- b. The high-voltage power supply is damaged or the electrode connecting cable falls off.

**Solution:** Check to see if the selected program is correct or not, or to see if the set discharge strength in the program are proper or not. If it is still impossible to discharge normally, please contact your dealer to repair/maintain it or send it back to the factory for repair/maintenance.

- The fusion splicing phenomenon is normal, but the loss of the fusion splicing has been somewhat large at all times or there occurs the failure in the fusion splicing.

**Reason:** a. There occurs the failure in the detection system or there is the dust on the objective lens and the reflecting mirrors' lens.

b. In the parameters, the value of "End-Face Setup" of the optical fiber is larger.

c. After the operations of the electrode discharge and the fusion splicing, the windproof cover is opened before the equipment has completed its detection.

**Solution:** Clean in the same way, the objective lens' surface, the lights, and the reflecting mirrors with a cotton swab just having had a dip in alcohol (above 99% alcohol), and remove the excess alcohol on the objective lens' surface, the lights, the reflecting mirrors with a dry cotton swab. Check to see if the value of "End-Face Setup" of the optical fiber is larger in the parameters or not. Then operate the electrode discharge tests again, until the discharge current is moderate. If it is still impossible to solve these issues, please contact your dealer to repair/maintain it or send it back to the factory for repair/maintenance.

- Press the "⚡" key, and the gap setting and the core-to-core adjustment are normal, but it fails in completing the fusion splicing, resulting in always two balls.

**Reason:** a. The fusion-splicing current is too large, and the environmental humidity is too high.

b. The advancing amount is somewhat small or is 0; the advancing speed value is somewhat large.

c. The optical fiber's press board did not pin the optical fiber.

d. The quality of the optical fiber itself is poor, being disengaged from its cladding.

**Solution:** Change the fusion-splicing environment to a dry one, to see if there is that issue. Confirm that for the fusion-spliced optical fiber, there is no phenomenon that it is disengaged from its cladding. Enter the "Applications Program" menu; check the parameter setting and set the

correct parameters; and then do the electrode discharge tests again, until the discharge current is moderate. If it is still impossible to solve these issues, please contact your dealer to repair/maintain it or send it back to the factory for repair/maintenance.

- The multi-mode optical fiber is blistered, becoming thicker or thinner after its fusion splicing.

**Reason:** a. The end-face of the optical fiber is unqualified or the surface of the optical fiber is dirty.  
b. There is an issue about the parameter setting in the program.

**Solution:** Ensure that the end-face of the optical fiber is good, do the electrode discharge tests until the discharge current is moderate. If the optical fiber is still becoming thicker or is blistered, it is necessary to increase the values of the “Pre-Fusion Current” and “Pre-Fusion Time” in the program. In reverse, if the optical fiber is still becoming thinner or is blistered, it is necessary to decrease the values of the “Pre-Fusion Current” and “Pre-Fusion Time” in the program, and increase the quantity of the “Fusion-Splicing Boost”. If it is still impossible to solve these issues, please contact your dealer to repair/maintain it or send it back to the factory for repair/maintenance.

- The fusion splicing loss index has been somewhat large at all times.

**Reason:** a. There is the dust on the optical fiber, and in the V-shaped groove of the Fusion Splicer.  
b. The discharge current is not moderate.  
c. Do the optical fiber fusion splicing without having made the optical fibers being core-to-core.  
d. The electrode aging.  
e. The parameters set in the program are not proper.  
  
f. The end-face of the optical fiber is not good, and there is an issue about the optical fiber cleaver.  
g. The operating environment is rather poor, such as: the gale or wet, etc.  
h. The optical fiber is more special.

**Solution:** First of all, it is required that the test method should be correct, then do all kinds of cleaning (for the V-shaped



groove, the objective lens, the lights, the reflecting mirror, and the needle electrodes); select the appropriate procedures to do the discharge tests; adjust the optical fiber cleaver to ensure that the end-face of the optical fiber is well-cleaved .

If the fusion splicing loss index is still somewhat large, you may do the parameter setting many times so as to find the better parameters for the fusion splicing, by way of increasing or decreasing the values of the “Pre-Fusion Time, Pre-Fusion Strength, Pre-Fusion Boost Quantity, and Pre-Fusion Boost Speed”, or you may reset the parameters to be the default parameters set at the factory. If it is still impossible to solve these issues, please contact your dealer to repair/maintain it or send it back to the factory for repair/maintenance.

- It is sparking on the electrodes or the electrode is sparking to the metals nearby it.

Reasons: a. The electrode connecting cable is loose.

b. The operating environment is humid.

**Solution:** Check to see if the electrode connecting cable is loose or not. Change the operating environment to be the dry one, to see if there is the said phenomenon or there is not . If it is still impossible to solve these issues, please contact your dealer to repair/maintain it or send it back to the factory for repair/maintenance.

### 3. HEATING OPERATION

- The optical fiber heat-shrinkable sleeve has not completely shrunked.

**Reason:** a. The set heating time is too short.

b. As the outside temperature is too low so that the heating has not been fully and completely done.

**Solution:** Adjust the program to extend the heating time.

- The optical fiber heat-shrinkable sleeve adheres in the heating tank.

**Reason:** Some optical fiber heat-shrinkable sleeve may cause adhesions.

**Solution:** Take out the optical fiber heat-shrinkable sleeve after it is completely cooled. Or use a cotton swab to lightly poke at its edges to break it away from the heating tank.

- The heating indicator light does not shine, but the normal heating can be done.

**Reason:** a. The heater is faulty.

b. The heating indicator light is bad.

**Solution:** Please contact your dealer to repair/maintain it or send it back to the factory for repair/maintenance.

- The heating indicator light shines, but the heater does not heat. Or the heating indicator light does not shine; also the heater cannot heat.

**Reason:** The heater is faulty, or the heating control circuit is faulty.

**Solution:** Please contact your dealer to repair/maintain it or send it back to the factory for repair/maintenance.

## **GUARANTEE**

### **1. GUARANTEE**

#### **1-1. Warranty Period and Conditions**

If it occurs a failure in the optical fiber fusion splicer within one year starting from the date of goods delivery, we will provide a free repair/maintenance. However, we will not provide a free repair/maintenance within the Warranty Period, if it occurs the following events:

- 1) Failure or damage caused by natural disasters;
- 2) Failure or damage caused by the wrong operation;
- 3) Failure or damage caused by ignoring the operation instructions and procedures in this manual to make bold to operate;
- 4) The parts are easy to wear off or to be consumable. (For example, needle electrodes);
- 5) Failure or damage caused by the abnormal voltage power supply.

#### **1-2. Before delivering the Optical Fiber Fusion Splicer, please contact its manufacturer's agent in advance.**

#### **1-3. Information required for repair/maintenance**

Along with the Optical Fiber Fusion Splicer, please attach the following information:

- 1) Your full name, industry, company, department, address, telephone number, fax number and e-mail box.
- 2) The model and the serial number of the Optical Fiber Fusion Splicer.
- 3) Problems about the Optical Fiber Fusion Splicer you have met.

4) When did the Optical Fiber Fusion Splicer have the problem?  
Which problem has happened? How about the present situation? and so on.

1-4. Transportation of the Optical Fiber Fusion Splicer.

As the Optical Fiber Fusion Splicer is a high precision instrument, you should by all means use the original carrying case to transport and store it, so as to protect it against the moisture and shock. If you need repair/maintain the Optical Fiber Fusion Splicer, please put the related fitting accessories in the carrying case before sending it.

1-5. Information recorded before the repair/maintenance

Please record in advance the stored info contents in the Optical Fiber Fusion Splicer, such as the fusion splicing results, fusion splicing modes, etc., because these information and data may be lost in case of the repair/maintenance.

## **2. CONTACT**

Please contact the distributor nearest to your location or the following organization if the user needs supports or services.

Note: If the program has been updated and the structure been changed, resulting in errors and the unconformity to the manual, please take the actual product as the reference standard.

## **DESIGN AND CHANGE**

In order to improve the product performance, product hardware and software technology upgrades will change without noted advance.

Some pictures are for reference only, please subject to actual product.