

Service Call:

Fiber Optic Bulkhead Termination

Tools Required:

Stripper Block: P/N 65-020-01

- Available from www.bohlinger.biz

New Razor Blade

Wire Stripper

Crimping Tool (can be purchased at Auto or Electronic store. Needs to be able to crimp .178)

Tape Measure

Bulkhead Terminal (part # 9123192)



Model(s): All TM

Video Tech-tip:

A [video tech-tip](#) is available as a reference to this written procedure.

Tech Tip Safety Rules



Danger

Failure to obey the instructions and safety rules in the appropriate Operator's Manual and Service Manual for your machine will result in death or serious injury. Many of the hazards identified in the operator's manual are also safety hazards when maintenance and repair procedures are performed.

Do Not Perform Maintenance Unless:

- You are trained and qualified to perform maintenance on this machine.
- You read, understand and obey:
 - manufacturer's instructions and safety rules
 - employer's safety rules and worksite regulations
 - applicable governmental regulations
- You have the appropriate tools, lifting equipment and a suitable workshop.

The information contained in this tech tip is a supplement to the service manual. Consult the appropriate service manual of your machine for safety rules and hazards.

Step 1

Cut the old fiber flush with the outer casing and measure and mark it at 4 inches.



Step 2

Using the fiber optic stripper block in roughly 2" chunks score the outer casing carefully by putting pressure with your thumb and rotating the cable and stripper 360 degrees.

Excessive pressure could cause the razor blade to go too deep, scoring the black inner core. Too little pressure will prevent it from cutting through.

Once scored, bend the outer casing to separate it. If it doesn't separate fully, use the other razor blade and finish cutting the orange outer casing.



Repeat at the 4" mark.

Step 3

Inspect the black coating to make sure it didn't get cut deep enough to expose the inner glass.



Step 4

Use your fingers to split the black inner coating, so that they are separated all the way down to the orange coating.



Step 5

Using a tape measure and wire strippers, measure back 9/16" and strip the black coating back.

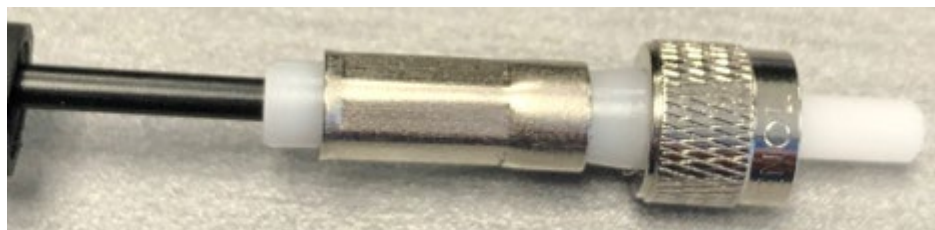
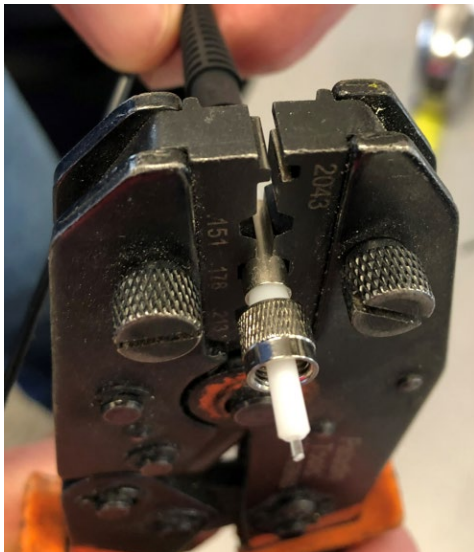


Make sure it is cut at least 9/16". Cutting it shorter will cause the inner glass to be too short when crimping the end. The inner glass will recede into the terminal when crimped, creating a gap when installed at the bulkhead.



Step 6

Slide the rubber boot onto the fiber cable then the bulkhead terminal fitting onto the cable. Make sure the terminal is pushed all the way down tight so that the inner glass is sticking out of the end of the terminal. Then with the .178 crimping tool, crimp the metal collar onto the terminal.



Once crimped pull the rubber boot up all the way to the thumb nut.



Step 7

Trim the remaining inner clear glass flush with the end of the terminal. Make sure you use a new sharp blade to prevent the shattering of the glass when cut.

