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1.0 General

The Fibrlok™ 2670 Multi-Fiber Ribbon Construction Tool is used to bond individual, 250 µm coated fibers into a ribbon format. The tool can bond fibers of any count, from 2 to 24, without any additional parts or adjustments.

2.0 Ribbon Construction Tool Kit

2.01 Kit Components:

2670 Carrying Case (A)
Tweezers (B)
Adhesive Backed Tape (C)
Blade Assembly (D)
Ribbon Construction Tool Assembly (E)
Swing-Out Arms (F)
Retaining Pins (G)
Packing Shim (H)
Guide Rail (I)

2.02 Additional Tools and Materials Required:

Scotchcast™ 4415 Service Wire Cleaning Kit
Cable Sheath Removal Tools
Lint Free Wiping Cloths
Reagent Grade Isopropyl Alcohol

3.0 Preparing the Fibers

3.01 Remove the cable sheath and buffer tubes per splice case, splice tray, or fiber distribution unit instructions.

3.02 Thoroughly clean the gel from the buffer tubes and fiber strands. The 3M brand 4415 Service Wire Cleaning Kit provides suitable cleaning pads and towels for this process.

Note: The fibers and tool must be clean for good bonding.

Note: Carefully follow safety, health, and disposal information on cleaning pad label or Material Safety Data Sheet.
3.03 Arrange the fibers in the splice tray per tray instructions. Trim the fiber ends so that they extend 2” - 3” (51 mm - 76 mm) beyond the center of the splice.

4.0 Arranging the Fibers

4.01 Unwind the fibers from the organizer tray, and position the ribbon construction tool in a comfortable location in front of you. Fibers may enter the tool from either end.

4.02 At least 18” (457 mm) from the end of the fibers, select the first fiber to be "ribbonized", according to the proper color sequence. Lift this fiber from the group and, if gel residue remains, clean it with alcohol and a lint free wipe.

**Note:** Carefully follow safety, health, and disposal information on container label or Material Safety Data Sheet for isopropyl alcohol being used.

4.03 Now slide the fiber under the swing-out arms. Lay the fiber so that at least 2” (51 mm) extend beyond the tool.

**Caution:** Glass fibers are easily damaged. When inserting, do not let them snag on the retaining pins or swing-out arms.

4.04 Repeat steps 4.02 and 4.03 for the remaining fibers, being careful to lay them in the proper sequence. The ends of the fibers should be within 1/2” (13 mm) of each other.

[Image of fiber arrangement]
4.05 After all fibers are inserted, smooth them flat so that they are not crossing each other.

4.06 Release the packing shim and slide it slowly against the fibers. Apply only a light force, do not over pack the fibers.

4.07 Slide a finger over the top of the fibers to smooth them down. The fibers should be flat; check that no fibers are crossed.

4.08 Now grasp the fibers and pull them back, so that the fiber ends are all aligned within 1/2" (13 mm) of the edge of the tool.
4.09 If any gel residue remains, clean the top of fibers with alcohol and a lint free cloth. Dry the fibers with a cloth wipe.

5.0 "Ribbonizing" the Fibers

5.01 Pull the tape from its peel-off liner and grasp it as shown.

5.02 Place the tape over the fibers. The tape should be positioned so that its end is within the square notches in the shims.

5.03 Press the tape firmly into the fibers by sliding a finger over the top, applying pressure.

5.04 At either end, lay the blade assembly over the front guide rail, in preparation for trimming.

*Note:* The trimming process must begin with the blade at either end of the rail. Always trim the front edge first.
5.05 Apply downward pressure and slide the blade along the rail so that the tape is trimmed.

5.06 Repeat this procedure for the rear rail.

5.07 Using the tweezers, grasp the end of the excess tape where it overlaps the square notches.

5.08 Pull the tape up and dispose of according to company practice. Remove the second piece of excess tape in the same manner.

6.0 Removing the Ribbon

6.01 Lightly run your finger along the top of the ribbon to ensure good adhesion.
6.02 While holding the ribbon in place, slide the packing shim back.

6.03 Swing the arms outward and slowly lift the ribbon up.

6.04 Snip the ends of the fiber in preparation for stripping. When using the Fibrlok™ 2630 Multi-Fiber Stripper, leave approximately 1/2" (13 mm) of unbonded fibers.

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