

SUMITOMO RECOMMENDED PROCEDURE

SRP SP-F04-006



FIBER BUNDLE STRIPPING PROCEDURE

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SUMITOMO ELECTRIC LIGHTWAVE CORP.

201 South Rogers Lane, Suite 100, Raleigh, NC 27610
(919) 541-8100 or 1-800-358-7378

www.sumitomoelectriclightwave.com

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1.0 General

1.1 This procedure describes the standard techniques for stripping the jacketing materials from any FutureFLEX® Fiber Bundle so the individual fibers can be spliced or terminated.

1.2 FutureFLEX® (PEF) Fiber Bundles identified by Part-No. (FBxxXXXX) are available in strand counts of 6, 12, 24 and 48 fibers. Each of these Fiber Bundles have a jacketing material constructed of an outer PEF Polyethylene Foam Jacket and an inner Nylon colored single Sub-Unit for 6f-12f or (4) colored Sub-Units for the 24f-48f Fiber Bundles. FutureFLEX® (PVDF) Fiber Bundles identified by Part-No. (FPxxPVx) are available in strand counts of 48 and 72 fibers. These Fiber Bundles have a jacketing material constructed of an outer PVDF Polyvinylidene Fluoride Foam Jacket containing multiple 12f Pliable Freeform Ribbon Fibers: 4x12 for 48f and 6x12f for 72f Bundles.

1.3 PEF Fiber Bundles: the 6f and 12f Fiber Bundles have a 2 mm OD outer foam jacket. The 24f Fiber Bundles have a 3mm OD outer foam jacket. The 48f Fiber Bundles have a 3.7 mm outer foam jacket. PVDF Fiber Bundles: the 48f has a 3.1mm OD outer foam jacket, the OS2 72f has a 3.7mm OD outer foam jacket and the OM3 and OM4 72f have a 4.1mm OD outer foam jacket.

1.4 (PEF series only) The inner Sub-Units have a colored Nylon coating around the optical fiber strands. Each Sub-Unit also contains a Polyester Ripcord (or Ripcords) used to cut through the Nylon coating. Some Sub-Unit designs contain more than one (1) Ripcord. The extra Ripcords are used as “fillers” to give each Sub-Unit a consistent diameter.

1.5 All PVDF series Fiber Bundles do not have Sub-Units and are constructed with a single Nylon Ripcord.

1.6 FutureFLEX® Fiber Bundles (both PEF and PVDF) do not have any tensile strength members nor contain any waterproofing gels or materials typically found in many conventional fiber optic cables.

2.0 Safety Precautions

2.1 When stripping jacketing materials from Fiber Bundles, use care and properly dispose of any individual fiber ends that are removed. The fiber ends are easily misplaced and can pierce the skin resulting in splinters that are not easily removed.

2.2 Exercise caution when using tools used to strip the jackets from Fiber Bundles. They may have sharp blades.

2.3 The use of safety glasses is strongly recommended during this procedure.

3.0 Reference Documents

3.1 Sumitomo Recommended Procedure, *FutureFLEX® Field Termination Kit Installation Procedure for 900 µm Sub-Unit Kit*, SRP SP-F04-010.

4.0 Equipment / Tools Required

The following equipment and tools are required to complete this procedure:

4.1 Felt tip pen / marker

4.2 Tape Measure

4.3 Multi-gauge (10-to-20-gauge) wire stripper

4.4 Fiber stripper

4.5 Scissors

4.6 Soft, clean cloth

4.7 utility knife

Note: This SRP will describe the detailed stripping procedures for 6, 12, 24, 48 and 72 strand Fiber Bundles.

5.0 General Guidelines for Stripping PEF Jacketed Fiber Bundles – 2 to 48 Fiber Bundles

5.1 Marking the Outer Foam Jacket

Generally, at least 6" - 8" of additional Fiber Bundle needs to be stripped beyond the required fiber length. This is in case any optical fibers are damaged near the end of the bundle during stripping procedures. Always use your best judgement based on the splicing/termination hardware you are using. You may also choose to consult the Manufacturer's instructions for recommended strip lengths.

5.2 Use a felt tip pen to mark the Fiber Bundle outer jacket at the determined location for jacket removal. **See Fig. 1.**

Note: Field Termination Kit FTFLD06 has a buffer tube length of about 24". The Fiber Bundle strip length should be between 30"-32". Field Termination Kit FT12FBK, FT24FBK, FT48FBK and FT72FBK have buffer tube lengths of about 36". The Fiber Bundle strip length should be between 42"-44". Field Termination Kit FT72FBK-12SU/12MU, have buffer tube lengths of about 36". The Fiber Ribbon Bundle strip length should be between 45"-48".

5.3 Stripping the Outer Foam Jacket; Use a wire stripper to strip the first 3" - 4" of the outer foam jacket. Next, insert the Fiber Bundle into the 10-gauge position of the of wire stripper so the Fiber Bundle is positioned "lays" at the same angle of the cutting blades. Use a light touch/squeeze to carefully shear off a portion of the outer jacket. *Once you've sheared the Jacket, put the tool down.* **See Fig. 2 and Fig. 3.**

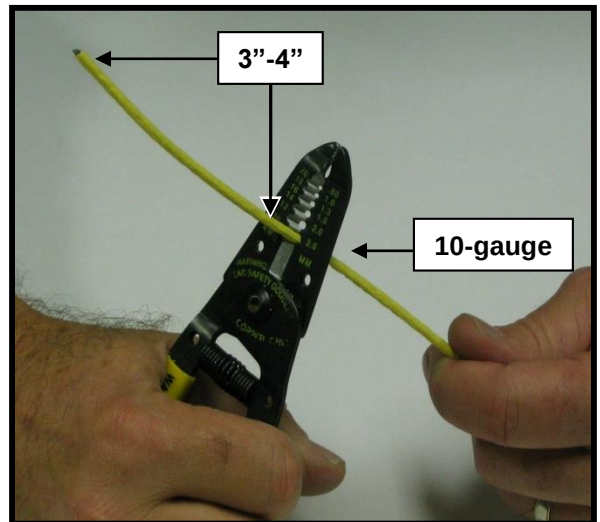


Figure 2
Stripping Foam Jacket with Wire Stripper

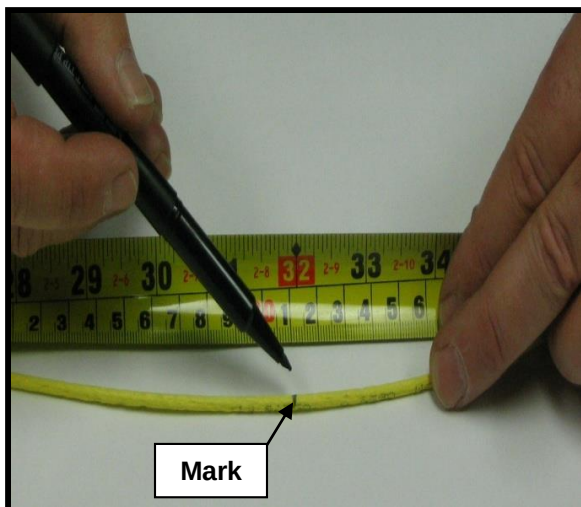


Figure 1

Marking Fiber Bundle Outer Foam Jacket
Between 30" - 32" for 6 Fiber Bundles
Between 42" - 44" for 12, 24 and 48 Fiber Bundles
Between 45" - 48" for 48 and 72 "Ribbon Fiber" Bundles

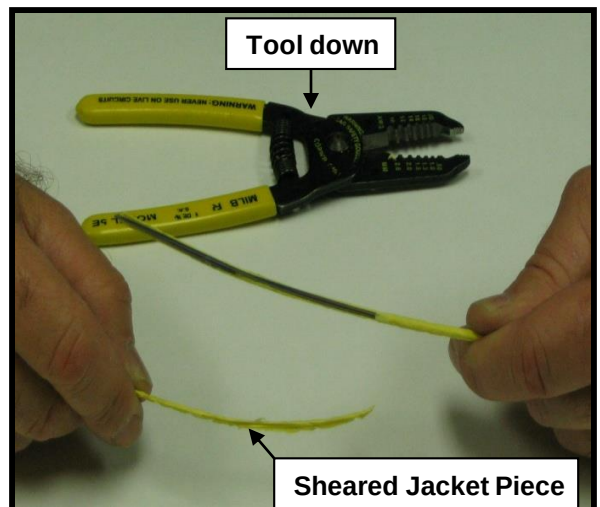


Figure 3
Sheared Piece of Foam Jacket
(About 3" - 4")

5.4 Use your fingernails to pull the remaining foam back until it reaches the point you marked on the outer jacket. If the foam jacketing breaks during this step, re-engage the process and proceed with removal. Next, using a pair of scissors, carefully cut away the outer jacket See Fig. 4.

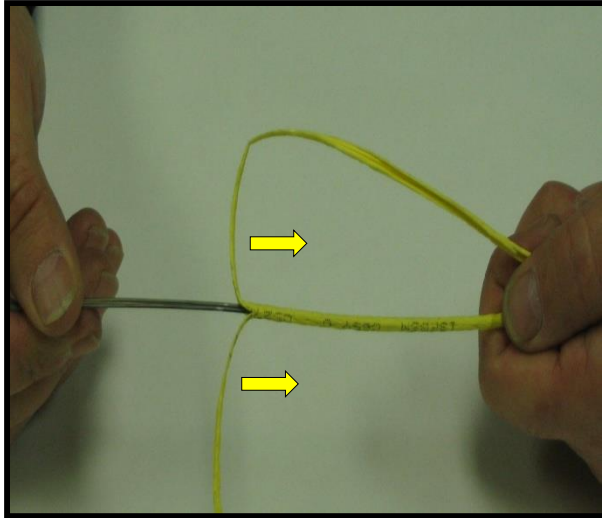


Figure 4

Pull Foam Jacket Back to Marked Point

Note: The 24-fiber bundle has four (4) colored Nylon Sub-Units and a spare strand of fiber that has been Nylon-Up-coated to 360um for 24f and 500um for 48f. The Nylon Up-coating may be colored or neutral and is used as a Central Member. The Central Member positions each of the four Sub-Units "uniformly separated" to maintain a consistent outside diameter and shape.

After the jacket of the Fiber Bundle is stripped back, locate the Central Member and cut it off at the pre-determined mark. This is done first to prevent the Central Member fiber(s) from mistakenly being used for termination.

5.5 Stripping the Inner Nylon Jacket. Use a wire stripper to strip the first 3"- 4" of the Nylon Sub-Unit. Insert the first Sub-Unit into the 18-gauge position of your wire stripper be sure that the Sub-Unit is positioned "lays" at the same angle of the cutting blades. Use a light touch/squeeze to carefully shear off a portion of Nylon. Once you've sheared the Jacket, put the tool down.. See Fig.5 and 6.

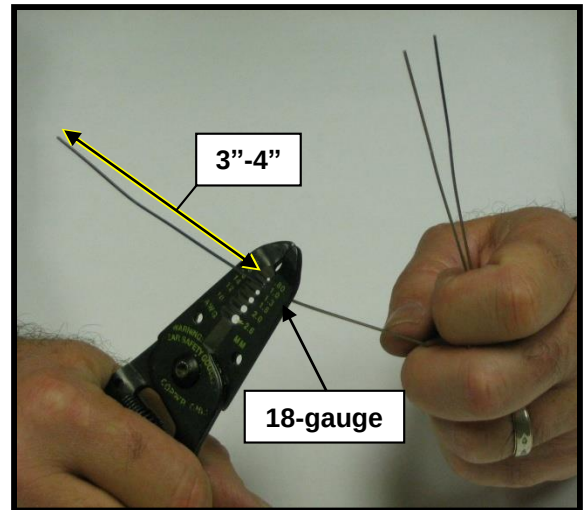


Figure 5

Stripping Nylon Jacket with Wire Stripper

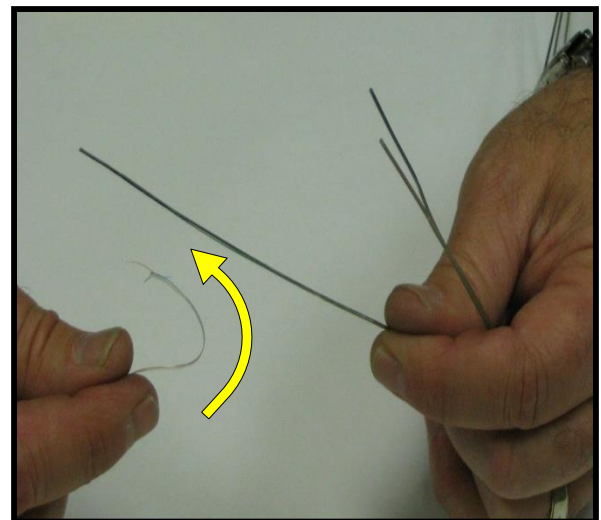


Figure 6

Sheared Piece of Nylon

Note: Always attempt to strip Nylon Sub-Units with an 18-gauge wire stripper. If the 18-gauge slot appears too large and is not stripping the Nylon, move down to the next smaller "20-gauge" (If a smaller gauge works it's a good indication that your stripping tool may have dull blades or has become noticeably worn.)

6.0 Stripping the 2mm OD 6f and 12f Fiber Bundles

Note: Stripping techniques for the 2mm OD 6f, and 12f Fiber Bundles are extremely similar to those of the 24 Fiber Bundles. The only key differences are highlighted below.

6.1 Marking the Outer Foam Jacket: Same Procedure Mark at 30"- 32". **Refer to Fig. 7a and 7b.**

6.2 Stripping the Outer Foam Jacket
Same procedure but use 12-gauge position of the wire stripper. Use the 14-gauge only if required.
Refer back to Fig. 2 and Fig. 3.

6.3 Stripping the Inner Nylon Jacket

Note: The 6-Fiber Bundles have one (1) Nylon Sub-Unit.

6.3.1 Same procedure, use the 18-gauge hole in wire stripper. Use 20-gauge hole only if required.
Refer back to Fig. 5.

6.4 Finding Ripcords

Note: The 24 and 48 Fiber Bundles have one (1) Polyester Ripcord in each Sub-Unit.

6.4.1 Access and separate the Polyester Ripcords from among optical fibers and remaining Nylon jacketing.

6.4.2 To assist in locating the Ripcord,

1. Strip Back about 2-3" of the Sub-Unit
2. Fold Over Fibers 180° to Form a Loop
3. Pinch the Fibers at Apex of the Fold
4. Release Fibers. Ripcord will Retain the Bend, (Repeat as necessary) **See Fig. 8**

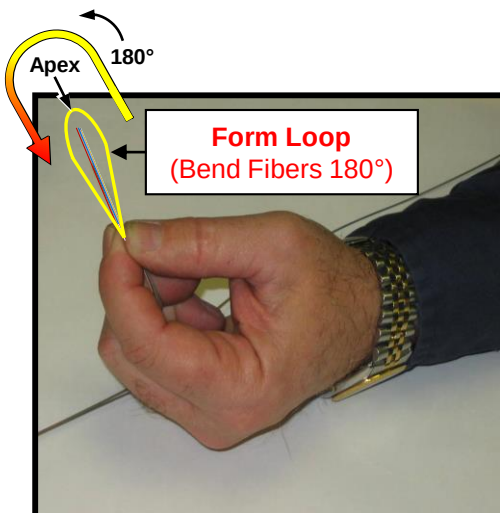


Figure 8

Pinch the First Inch "Strands & Ripcord" to Create a Loop "Pinch the Apex" and let them Spring Back

Strand Count→	6f, 12f	24f, 48f	48/72 Ribbon Fiber
MARKING LENGTH	30"- 32"	42"- 44"	45"- 48"
OUTER JACKET (Stripping Tool)	12-gauge	12-gauge	12-gauge
NYLON SUB-UNIT (Stripping Tool)	18-gauge	18-gauge	N/A

Figure 7a

Marking and Stripping Chart

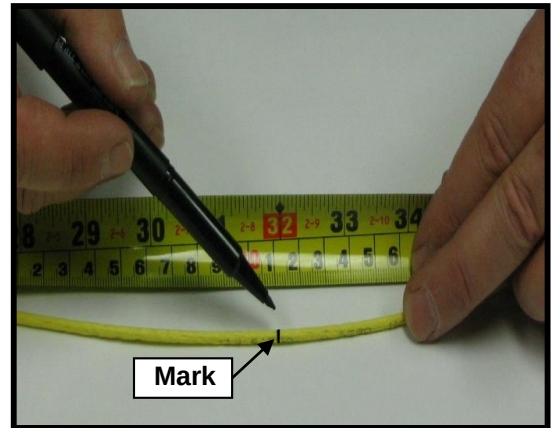


Figure 7

Marking Fiber Bundle Outer Foam Jacket

6.4.3 The Fiber Strands will return to their original position "straight" while the Polyester Ripcords will retain some or all of the bend and make them easy to identify. **See Fig. 9.**

Note: If Ripcords were accidentally cut during first stripping procedure, repeat procedure about 3"- 4" back from first attempt. Use less of an angle and less pressure on the wire stripper.

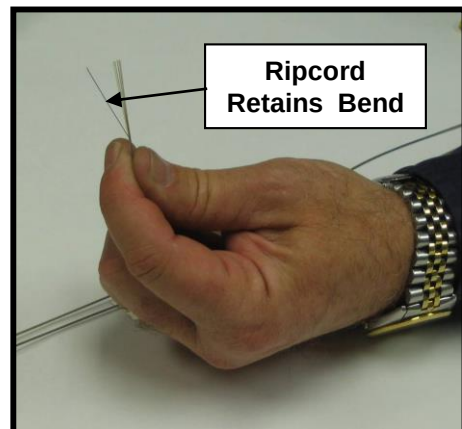


Figure 9

6.4.4 Important Step. Use care when pulling the Ripcord. If it becomes tangled / twisted within the fiber strands, stop and Untangle the Ripcord then resume pulling the Ripcord.

6.4.5 Critical Step. Ensure all Sub-Unit Ripcords are positioned next to the blue strand of fiber. If not, the Ripcord is more likely to be twisted/tangled with other strands when pulled and may result in broken strands.

6.4.6 Key Step. With one hand, hold on to all fiber strands and any remaining Nylon jacket material. Refer to Fig. 10.

6.4.7 With your opposite hand, pull the Ripcord using a quick hard pull to get the Ripcord started and begin to cut/slice through the Nylon. Next, in a slow and steady motion pull the Ripcord back until it reaches the point previously marked.

6.4.8 Important Step. Use care when pulling the Ripcord. If it becomes tangled / twisted within the fiber strands, Stop! Untangle and then resume with the pulling operation. A utility knife can also be used (very carefully) to cut the end of the colored Nylon longitudinally if pulling is difficult.

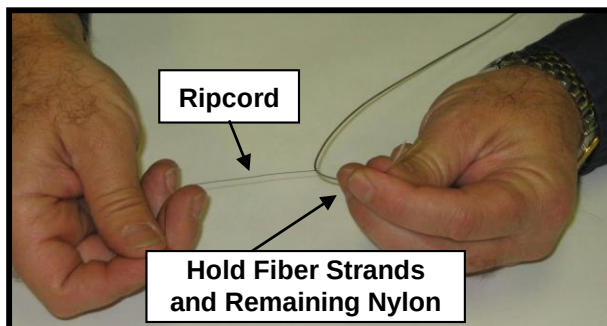


Figure 10

Note: The 2f Fiber Bundles have five (5) Polyester Ripcords per subunit the 4f Fiber Bundles have three (3) Polyester Ripcords per subunit. The 6f Fiber Bundles have one (1) Polyester Ripcord in the Sub-Unit. The 12, 24, 48 and 72 Fiber Bundles are also constructed using a single, (1) Polyester Ripcord.

Note: the 2f and 4f Fiber Bundles are no-longer a standard product offering. They are mentioned to provide continued support for SEL's installed products. - (Applies to following Sec. 6.5 & 6.6)

6.5 Pulling Ripcords - 2f Fiber Bundles

To remove the Nylon jacket of 2-Fiber Bundle, select any one of the five (5) Ripcords.

6.6 Pulling Ripcords - 4f Fiber Bundles

To remove the Nylon jacket of 4-Fiber Bundle, select any one of the three (3) Ripcords.

6.7 Pulling Ripcord - 6f Fiber Bundles

To remove the Nylon jacket of 6-Fiber Bundle, there is only one (1) Ripcord.

6.7.1 Critical Step. Ensure the Ripcord inside the Sub-Unit is positioned next to blue strand of fiber. If not, the Ripcord will be twisted among other strands and, when pulled, may break strands.

6.8 For all Fiber Bundles, carefully separate the ripped Nylon jacket from fiber strands. Pull the Nylon jacket back with slow, steady motion until it reaches the point marked on the outer jacket. Next, use a pair of scissors to carefully cut away the Nylon and all Ripcord Material(s).

6.9 your 2f, 4f or 6f Fiber Bundles should now be ready to be terminated.

7.0 General

7.1 This next procedure describes the standard techniques for stripping the jacketing materials from the FutureFLEX® 12 and 48 Fiber Bundles whenever the individual fibers are to be spliced or terminated.

7.2 The outer foam jacket is a lightweight, aerodynamically designed Polyethylene Extruded Foam (PEF) material. The 12 Fiber Bundle has a 2mm O.D. and the 48-Fiber Bundles have an 3.7mm .O.D.

7.3 The 12 Fiber Bundle has one 12 fiber subunit and the 48 Fiber Bundle has four (4) 12 fiber Sub-Units. Both 12 and 48 Fiber Bundles have colored Nylon coatings around the subunits. Each Sub-Unit has a clear Polyester Ripcord used to cut through the colored Nylon

8.0 Stripping the 12 and 48-Fiber Bundles

8.1 Marking the Outer Foam Jacket;

Generally, 6"- 8" of additional Fiber Bundle should be stripped beyond the required length. This is in case any optical fibers are damaged near the end of the Fiber Bundle during the stripping procedures. This is a recommendation only and should be determined based on the actual fiber splicing / termination hardware that is being used. (Optionally, you may chose to Consult your hardware manufacturer's instructions for their recommended splicing / termination strip length.)

8.2 Use a felt tip pen to mark the Fiber Bundle outer PEF jacket at the appropriate location for jacket removal. **See Fig. 11.**

Note: Field Termination Kit "FT12FBK" has a buffer tube length of about 24". The Fiber Bundle strip length should, therefore, be between 30"-32". "FT48FBK" has a buffer tube length of about 36". The Fiber Bundle strip length should, therefore, be between 42"-44".

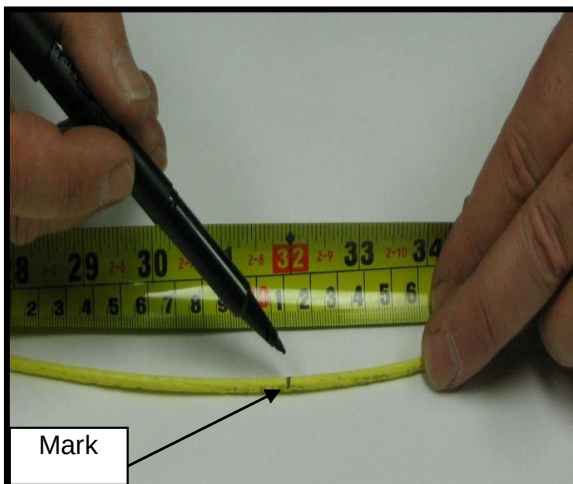


Figure 11

Marking the Fiber Bundle Outer Jacket
Between 30"- 32" for 12f-Fiber Bundles

8.3 Stripping Outer Foam Jacket

Use a wire stripper to strip first 3"- 4" of outer foam jacketing. Insert bundle into **10-gauge** notches / cutting blades of wire stripper so bundle lays with the angle of the cutting blades. Use a light touch / squeeze and shear off a portion of outer jacket or you can strip using your finger nails. Then put the tool down. **See Fig. 12a and Fig. 12b.**

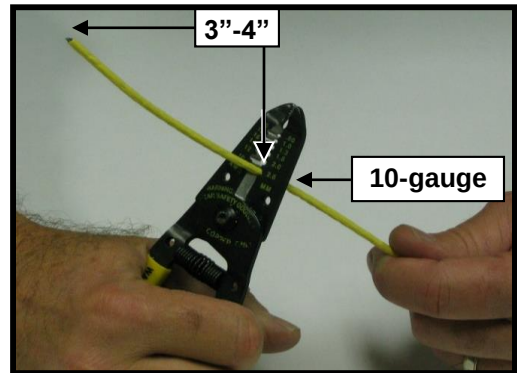


Figure 12a

Stripping Foam Jacket with Wire Stripper

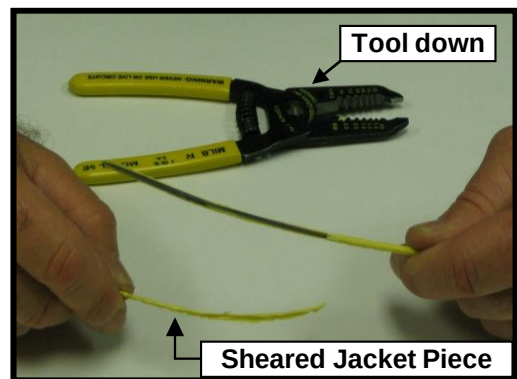


Figure 12b

Sheared Piece of Foam Jacket (3"- 4")

8.4 Use your fingers to pull the remaining foam back until it reaches point marked on outer jacket. If the PEF jacketing breaks during this step, continue to peel the PEF with your fingers. Then use scissors to carefully cut away the outer jacket **See Fig. 13.**

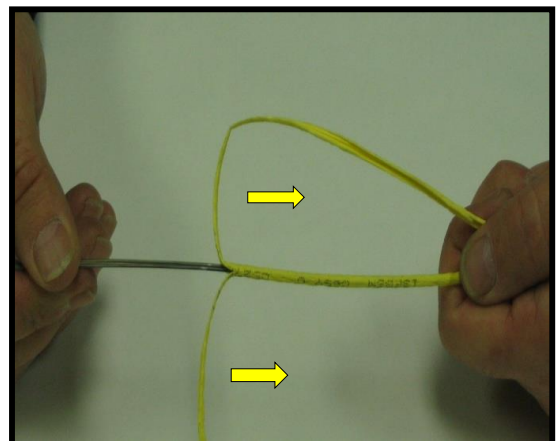


Figure 13

Pull Foam Jacket Back to Marked Point

Note: The 48-fiber bundle has four (4) colored Nylon Sub-Units and a spare strand of fiber that has been Nylon-Up-coated to 500um. The Nylon Up-coating may be colored or neutral and is used as a Central Member. The Central Member positions each of the four Sub-Units "uniformly separated" to maintain a consistent outside diameter and shape.

After the jacket of the Fiber Bundle is stripped back, locate the Central Member and cut it off at the pre-determined mark. This is done first to prevent the Central Member fiber(s) from mistakenly being used for termination.

8.5 Stripping Inner Colored Nylon Jackets

Use a wire stripper to strip first 3"- 4" of Nylon Sub-Unit. Insert first Sub-Unit into **18-gauge** notches / cutting blades of wire stripper so Sub-Unit lays with the angle of the cutting blades. Use a light touch / squeeze and shear off a portion of Nylon. Then put the tool down. See Fig. 14a and 14b.

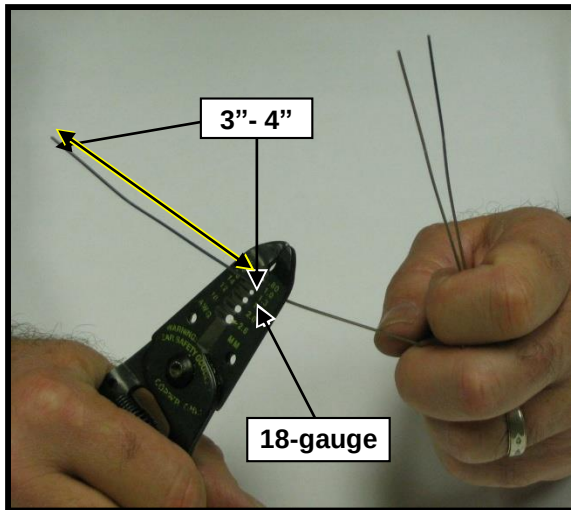


Figure 14a

Stripping Nylon Jacket with Wire Stripper

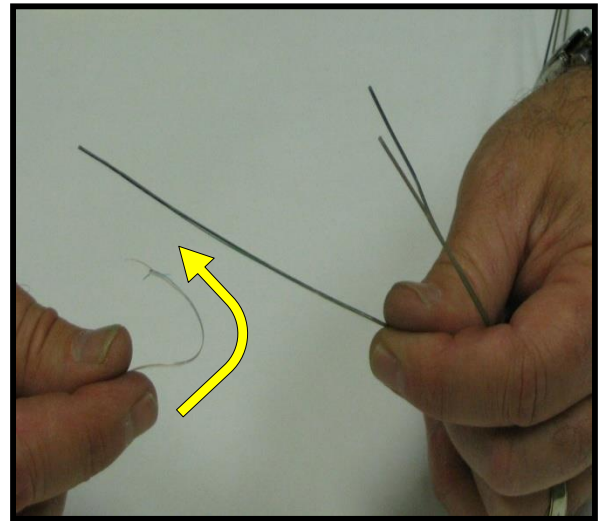


Figure 14b

Sheared Piece of Nylon

Note: Always attempt to strip Nylon Sub-Units with an 18-gauge wire stripper. If the 18-gauge slot appears too large and is not stripping the Nylon, move down to the next smaller "20-gauge" (If a smaller gauge works it's a good indication that your stripping tool may have dull blades or has become noticeably worn.)

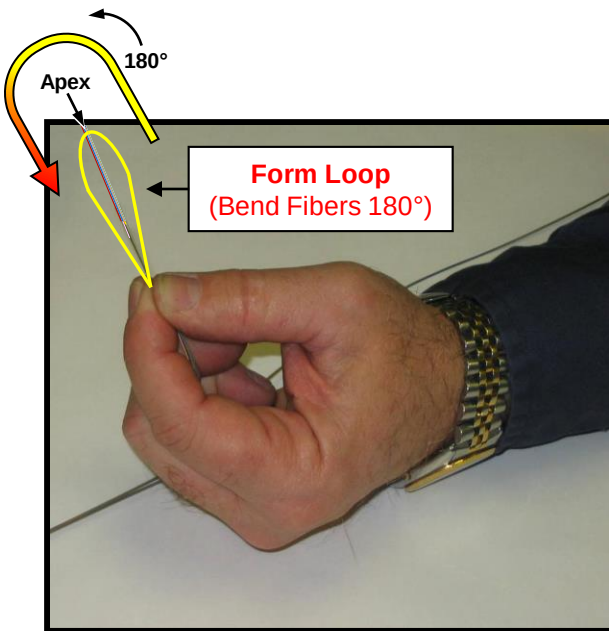
8.6 Finding the Ripcord

Note: Both the 12 and 48 Fiber Bundles have one (1) Clear Polyester Ripcord in each Sub-Unit. The position of the Ripcord can vary between each sub unit.

8.6.1 Access and separate the Polyester Ripcord from among optical fibers and remaining Nylon jacketing.

8.6.2 To assist in locating the Ripcord,

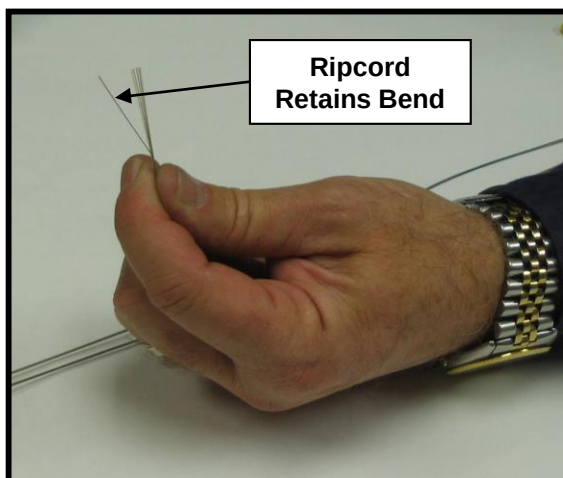
1. Strip Back about 2-3" of Fiber
2. Fold Over Fibers 180° to Form a Loop
3. Pinch the Fibers at Apex of the Fold
4. Release Fibers. Ripcord will Retain the Bend, (Repeat if necessary) See Fig. 15.

**Figure 15**

Pinch the First Inch "Strands & Ripcord" to Create a Loop "Pinch the Apex" and let them Spring Back

8.6.3 The Fiber Strands will return to their original position "straight" while the Polyester Ripcords will retain some or all of the bend and make them easy to identify. **See Fig. 16.**

Note: If Ripcords were accidentally cut during first stripping procedure, repeat procedure about 3"- 4" back from first attempt. Use less angle and pressure on wire stripper.

**Figure 16**

The Fiber Strands will Remain Straight while the Ripcord Retains the Bend for Easy Identification

8.7 Pulling the Ripcord

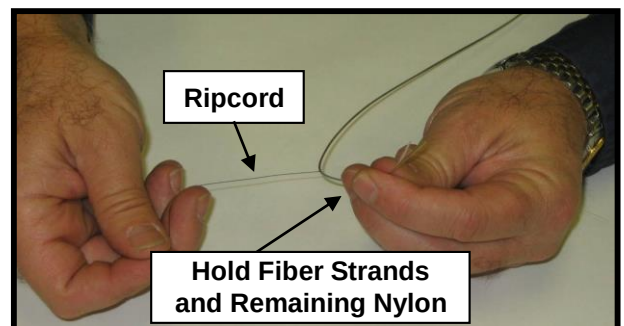
To Remove the Nylon jacket of a Subunit you must use the clear polyester Ripcord. One (1) Ripcord can be found in each Sub-Unit.

8.7.1 Critical Step: Ensure the Ripcord is positioned next to a fiber strand and not twisted around any fiber strands.

Note: If the Ripcord is twisted around a fiber strand, the colored Nylon jacketing will Bunch-Up, potentially breaking Fiber Strands and / or Ripcord. Stop if this happens and remove / strip the bunched up Nylon jacket and reposition the Ripcord next to a non-twisted Fiber Strand.

8.7.2 Key Step. With one hand, hold on to all fiber strands and any remaining Nylon jacket material. **Refer to Fig. 17.**

8.7.3 With your opposite hand, pull the Ripcord using a quick hard pull to get the Ripcord started and to cut / slice through the Nylon. Next, in a slow and steady motion pull the Ripcord back until it reaches the point previously marked.

**Figure 17**

8.8 Once you've pulled the Ripcord to your previously marked length, carefully separate the ripped Nylon jacket from the fiber strands. You can now pull the Nylon jacket back using a slow and steady motion until it reaches the marked length. Next, use scissors to carefully cut away and remove both the Nylon and the Ripcord.

8.9 Repeat this procedure for the remaining Sub-Units.

8.10 The Fiber Bundles should now be ready for termination.

9.0 General

9.1 This procedure describes the standard techniques for stripping the jacketing materials from 48 and 72 air blown “Ribbon Fiber” type Fiber Bundles when preparing for splicing or termination.

9.2 The outer jacket is a lightweight, aerodynamically designed Polyvinylidene Fluoride (PVDF) material. The 48 & 72 Fiber Bundles have a 3.1mm and 3.7mm outer jacket. This type of Fiber Bundle requires a slightly different Fiber Bundle stripping procedure than polyethylene foam (PEF) jacketed Fiber Bundle referenced previously.

9.3 FutureFLEX® Fiber Bundles do not have tensile strength members (Kevlar) nor do they contain any waterproofing gels / materials typically found in conventional fiber optic cables.

9.4 All PVDF outer jacket Fiber Bundles contain a Ripcord to ease the process of accessing the fiber ribbons.

10.0 Safety Precautions

10.1 When stripping jacketing materials from Fiber Bundles, use care and properly dispose of any individual fiber ends that are removed. The fiber ends are easily misplaced and can pierce the skin resulting in splinters that are not easily removed. Keep in mind that the 48 Fiber Bundle consists of 4-12 fiber ribbons and the 72 Fiber Bundle consists of 6-12 fiber pliable ribbons.

10.1.1. Refer to SRP: SP-F04-046 to learn how to differentiate between the individual 12 fiber ribbons in the Fiber Bundle. Further identification of individual fibers in each ribbon is based on the standard fiber color code from blue to aqua.

10.2 Exercise caution when using tools used to strip the jackets from Fiber Bundles. They may have sharp blades.

10.3 The use of safety glasses is strongly recommended during this procedure.

10.4 Make sure you have a clean work area when working with bare fibers.

11.0 Reference Documents

11.1 Refer to Sumitomo Recommended Procedures SRP: SP-F04-046 - Field Termination Procedure” for both Single Mode “-SU” and Multimode “-MU” **Ribbon** Fiber Bundles using the FT72FBK-12SU / -12MU Breakout Kit. Refer Drawing SD-F04-056 for Product Details.

Note: SRP: SP-F04-045 defines detailed stripping procedures for both Pliable Freeform 48 and 72 Ribbon Fiber Bundles. SRP: SP-F04-046 defines Field Termination for Ribbonized Fiber. SRP: SP-F04-047 defines Field Termination for PEF jacketed Single Fibers -or- de-ribbonized fibers.

11.2 Sumitomo Recommended Procedure, FP72PVS Fiber Bundle Procedure for Single Fiber Termination Using a FB72FBK 900µm Breakout Kit - SRP: SP-F04-047

12.0 Equipment / Tools Required

The following equipment and tools are required to complete this procedure:

- Felt Tip Pen or Marker
- Tape Measure
- 10-20 AWG Wire Strippers
- Soft, Clean Cloth
- Needle Nose Pliers

13.0 Stripping 48 & 72 Fiber Bundle

13.1 Mark the Outer Jacket.

Generally, strip 6" - 8" of additional fiber ribbon beyond the actual fiber required length needed. This is in case any optical fibers are damaged near the end of the bundle during stripping procedures. This point should be determined based on the actual fiber splicing or termination hardware used. (Also Consult splicing or termination hardware manufacturer's instructions for recommended strip length.)

13.2 Use a felt tip pen to mark Fiber Bundle outer foam jacket at appropriate location for jacket removal. **See Fig. 18.**

Note: Field Termination 48 or 72 Fiber Breakout Kits (FT72FBK) Fiber Bundle strip length should be between 42"-44".

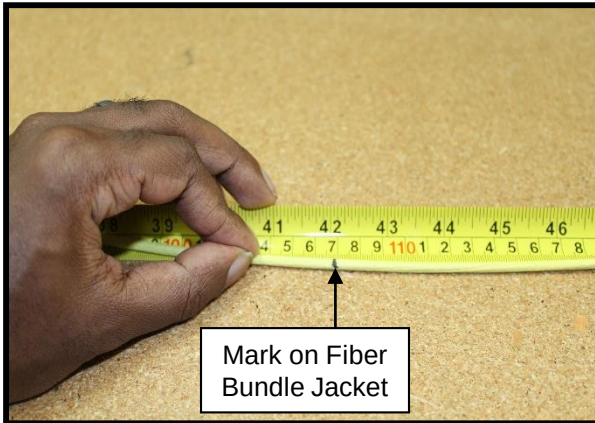


Figure 18

Marking Fiber Bundle Outer Foam Jacket Between 42"- 44" for Fiber Bundles

13.3 Stripping the Outer Jacket.

Use your fingers or wire strippers, break into 1-2" of outer jacketing to expose the Fiber Bundle Ripcord. A wire stripper can be used at the very end of the Fiber Bundle in order to expose the Ripcord, but will likely damage the ends of the fiber. **Always Remember** to cut off the damaged end before termination. See Fig 19.

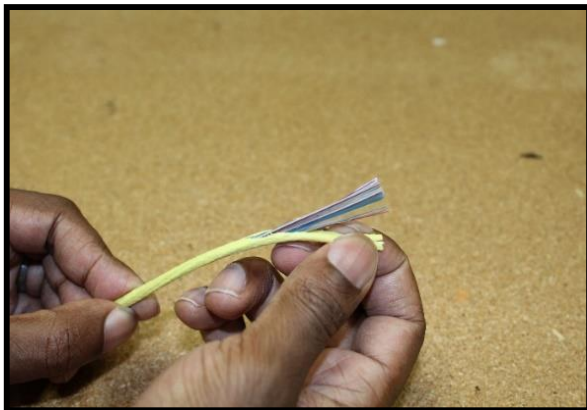


Figure 19

Breaking into a Fiber Jacket by Hand

Note: If you find that identifying the Ripcord is difficult, use the following procedures:

13.3.1 Locating the Ripcord (Ribbon Fiber)

1. Strip Back about 2-3" of Fiber
2. Fold Over Fibers 180° to Form a Loop
3. Pinch the Fibers at Apex of the Fold
4. Release Fibers. Ripcord will Retain the Bend, (Repeat if necessary) See Fig. 20

Once you've completed the above steps you should be able to identify the Clear Polyester Ripcord. See Fig 20a.

Note: Protective gloves should be worn in the event fibers are broken and protective eyewear should be worn as an added safety precaution.

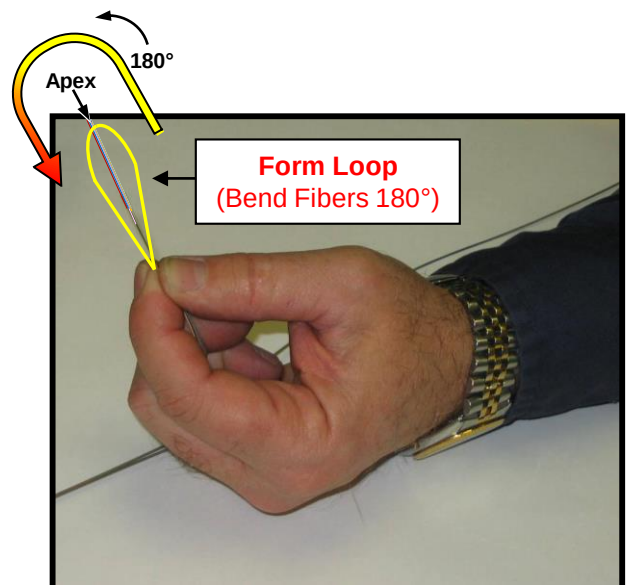


Figure 20

Pinch the First Inch "Strands & Ripcord" to Create a Loop "Pinch the Apex" and let them Spring Back

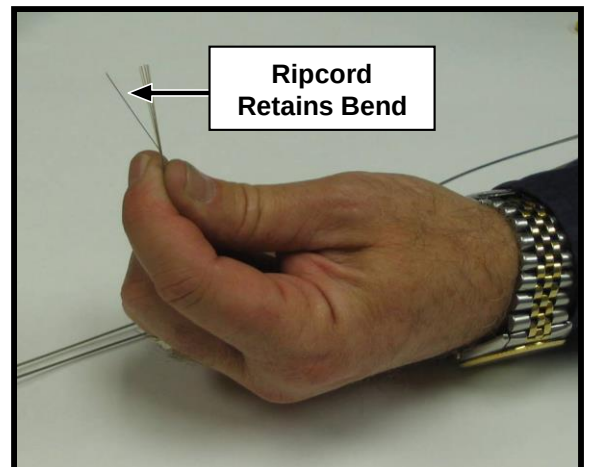


Figure 20a
Locating the Ripcord

13.4 After breaking into the fiber jacket, pinch the Fiber Bundle with your fingers or clean cloth and carefully hold it between 30° and 35° from the jacket. Gently pull the Ripcord, by hand, using needle nose pliers or wire strippers, away from the Fiber Bundle. The Ripcord pulling allows the jacket to peel away from the Fiber Bundle easily. Continue to peel the PVDF jacket until you have reached the marked location.

Remove any excess jacket filaments until only the exposed ribbons remain. **See Fig 21.**

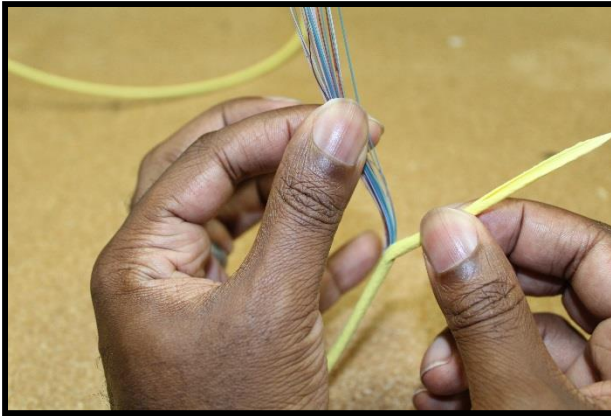


Figure 21

Peal Fiber Bundle and Jacket Back to Marked Point

13.5 The completes the process requirements for Fiber Bundle Stripping of PVDF Jacketed Fiber Bundles.