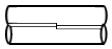
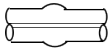
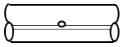
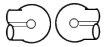
4 Bad welding,Cause and Solution

Core axial misalignment 	Too Thin 	Black line pattern 	Core Bending 
Too Fat 	Bubble 	Separation 	

Problems	Causes	Solutions
Core axial misalignment	▪ V-Groove is dirty or fiber clamps chips have dust	▪ Clean V-Groove and Fiber Clamps Chips
Too Thin	▪ The discharge current intensity is not suitable ▪ The overlap is small	▪ Do Arc calibration,Adjust current intensity
Black line pattern Core Bending	▪ Inappropriate welding parameters ▪ Bad fiber end face ▪ The discharge current intensity is small or the overlap increases	▪ Adjust current intensity and discharge time Check if the fiber cleaver work in a good condition ▪ Do Arc calibration till it reveals calibration finishing
Too Fat	▪ Too much overlap ▪ Discharge current is too small	▪ Do the Arc calibration and adjust the discharge current
Bubble	▪ Bad Fiber End Face or with dust ▪ The discharge current is small or the discharge time becomes shorter	▪ Check if the fiber cleaver work in a good condition ▪ Do Arc test to increase current intensity
Separation	▪ The overlap is too small ▪ The discharge current is too large or the discharge time is too long	▪ Do an arc calibration test to reduce the intensity of discharge current

Contact Address

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FX39 Fusion Splicer Quick Reference Guide

1 Splicing Operation

Turning splicer ON

When splicing only standard SM fibers, "SM AUTO" mode is recommended.

Confirming splice and heater modes

Cleaning coating or sheath of fiber

Placing protection sleeve over fiber

Stripping fiber

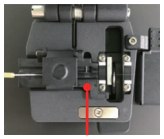
Striping a fiber around 3cm.

Cleaning fiber

Make sure the stripped fiber is free of coating debris or contamination.Use only 99% or better purity alcohol.

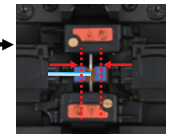
Cleaving fiber

Put the fiber in the cleaver fixture around 15mm scale line then cut the fiber.



Around 15 mm position

Loading fiber on to splicer



- Do not allow the cleaved fiber ends to touch anything or become contaminated.
- Place the fiber end between V-groove edge and Electrode center. (Don't exceed the electrode tip)

Closing wind protector and press " ⊙ "

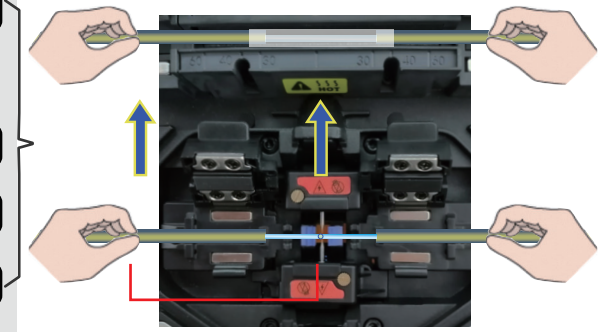
Visual inspection on LCD during splice

Removing spliced fiber

Centering protection sleeve in tube heater

Centering spliced point in tube heater

Closing tube heater lid, Automatic Heating

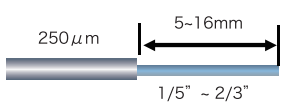


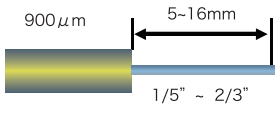
Hold the fiber at edge of splicer body, open the holder, gentry pull the fiber and put on the center of heater.

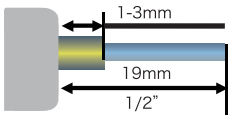
Completed

When an altitude changes drastically, stabilizing elctrodes must be excecuted before splicing.

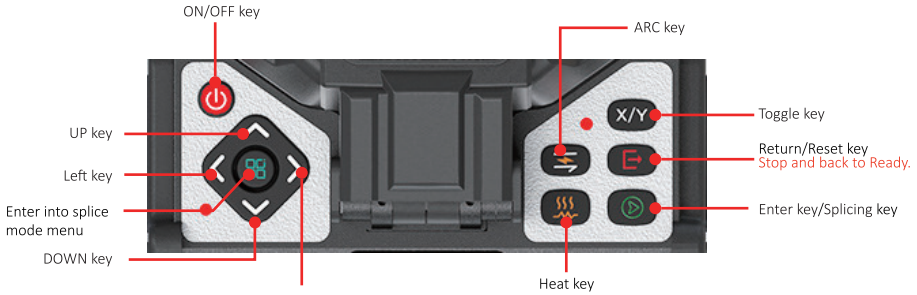
Cleaving Length







2 Sheet Key Operation



Power Supply

AC Adapter / Battery Pack

Power adapter

AC power cord

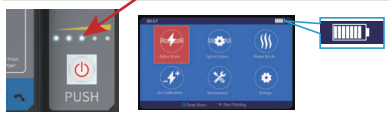
- This model of fusion splicer comes standard with AC/DC charger specifications
  INPUT: AC100-240V 50/60Hz OUTPUT: DC12.6V ⎓ 4.5A 。
- Please first use the AC power cord to correctly connect the AC power to the charger interface. When the charger power LED turns green, insert the charger output DC power into the fusion splicer "12.6V 4.5A charging port" to supply power, that is, the charger is in the normal power supply for fusion splicer working and also charges the internal lithium battery.
- U盘插座。用于系统的升级，数据的导出。

How to recharge battery

The charging indicator on the side of the battery is red to indicate that the lithium battery is charging; green to indicate that the lithium battery is fully charged.

Please use the charger specified by our company correctly. This model of fusion splicer is strictly prohibited from using AC/DC adapters other than the specified range to supply power, so as not to affect the battery life or damage

How to check remaining capacity



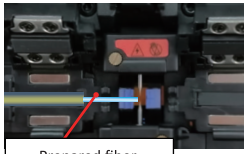
- The temperature of the battery during long-term storage (storage time more than 3 months): -20℃~30℃, short-term storage can be stored with the whole machine.
- Keep the following operations to avoid battery damage.
  Fully charge each time.
  Observe the following conditions:
  Operation:-10 ℃ ~ 50℃
  Charging: 0 ℃ ~ 40 ℃
- If the fusion splicer has power, turn on the fusion splicer, and the power of the "battery" will automatically identify the remaining battery capacity and display it in the upper right corner of the screen.If you wana check the remaining power of the battery in the shutdown state, please press the power indicator displayed on the battery to check the remaining power

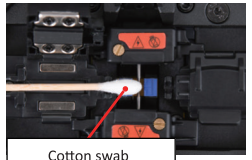
Confirm power saving function is working when using battery pack.

FX39 Fusion Splicer Quick Reference Guide

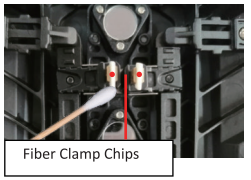
3 Cleaning before Splice Operation

V-groove





Fiber Clamp Chips

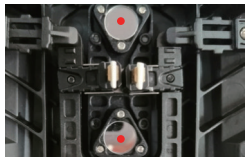


Clean Fiber Cleaver

- Clean rubber pads
- Clean rubber anvil
- Clean blade

- Clean bottom of V-groove with a thin cotton swab with alcohol.
- Remove excess alcohol from V-grooves with a clean dry swab.
- Use a cleaved fiber end-face to dislodge.

1) Do not contact the electrode tips.
2) Use only 99% or better purity of alcohol



Clean Objective Lens

Periodical Maintenance

Replace electrodes

The regular original electrode can generally be welded more than 3000 times. When the electrode is used more than this value,you should replace it, otherwise it may affect the welding quality. On the maintenance page of the machine menu, the electrode-replace the electrode.

Exchange to new electrode

1） Power off
2） Do stablize electrode
3） Do Arc calibration
4） Put on the prepared fiber