



**SPlice TECHNOLOGIES FUSION SPlice PROTECTION SPlice SLEEVES**  
**FUSION SPlicER HEAT SHRINK SLEEVE OVEN; RECOMMENDED TEMPERATURE AND TIME SETTINGS**

*NOTE: ALL TESTS WERE PERFORMED USING THE FIBERFOX 6s FUSION SPlicER HEATER OVEN*

	PART NUMBER	HEATER SETTINGS			
		TEMPERATURE (CELSIUS)	TIME (SECONDS)	LENGTH (MM)	HEATER CONTROL
1	FSS-SC32	175	60	50	LONG
2	FSS-SC40	175	60	50	LONG
3	FSS-SC60	175	60	60	LONG
4	FSS-SBK40	175	60	50	LONG
5	FSS-SBK60	175	60	60	LONG
6	FSS-DC40	175	60	50	LONG
7	FSS-DC60	175	60	50	LONG
8	FSS-LC40	165	50	50	LONG
9	FSS-LC60	175	60	60	LONG
10	FSS-LBK40	165	50	50	LONG
11	FSS-LBK60	175	60	60	LONG
12	FSS-TC40	160	45	50	LONG
13	FSS-TC60	165	60	60	LONG
14	FSS-MC15	150	30	20	LONG
15	FSS-MC20	150	30	30	LONG
16	FSS-MC25	150	30	30	LONG
17	FSS-MC30	155	30	40	LONG



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		TEMPERATURE (CELSIUS)	TIME (SECONDS)	LENGTH (MM)	HEATER CONTROL
18	FSS-MC40	155	30	50	LONG
19	FSS-MBK25	150	30	30	LONG
20	FSS-MBK40	155	30	50	LONG
21	FSS-RC15	145	30	20	LONG
22	FSS-RC20	145	30	20	LONG
23	FSS-RC25	145	30	30	LONG
24	FSS-RC30	150	30	40	LONG
25	FSS-RC40	150	30	50	LONG
26	FSS-RBK25	145	30	30	LONG
27	FSS-RBK40	150	30	50	LONG
28	FSS-ZC10	145	30	20	LONG
29	FSS-ZC15	145	30	20	LONG
30	FSS-ZC20	145	30	30	LONG
31	FSS-ZC25	145	30	30	LONG
32	FSS-FLEX-MC20	175	60	30	LONG
33	FSS-FLEX-MC25	175	60	30	LONG
34	FSS-FLEX-MC30	175	60	40	LONG



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		TEMPERATURE (CELSIUS)	TIME (SECONDS)	LENGTH (MM)	HEATER CONTROL
35	FSS-FLEX-MC40	175	60	50	LONG
36	FSS-FLEX-RC25	175	60	30	LONG
37	FSS-FLEX-RC40	175	60	50	LONG
38	MFSS-QQ30	190	60	40	LONG
39	MFSS-QQ40	190	60	50	LONG
40	MFSS-QP30	185	60	40	LONG
41	MFSS-QP40	185	60	50	LONG
42	MFSS-MM40	190	60	50	LONG
43	MFSS-SQ30	190	60	40	LONG
44	MFSS-SQ40	190	60	50	LONG
45	MFSS-SM40	190	60	50	LONG
46	MFSS-SP30	190	60	40	LONG
47	MFSS-SP40	190	60	50	LONG
48	MFSS-PP30	190	60	40	LONG
49	MFSS-PP40	190	60	50	LONG
50	MFSS-SS24D	175	60	30	LONG
51	MFSS-SS30D	175	60	40	LONG



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	PART NUMBER	HEATER SETTINGS			
		TEMPERATURE (CELSIUS)	TIME (SECONDS)	LENGTH (MM)	HEATER CONTROL
52	MFSS-SS40D	190	60	50	LONG
53	FSS-SCH32	215	60	60	LONG
54	FSS-SCH40	215	60	50	LONG
55	FSS-SCH60	230	80	60	LONG
56	FSS-LCH15	185	60	20	LONG
57	FSS-LCH20	185	60	30	LONG
58	FSS-LCH25	185	60	30	LONG
59	FSS-LCH30	185	60	40	LONG
60	FSS-LCH40	185	60	40	LONG
61	FSS-LCH60	215	60	60	LONG
62	FSS-MCH15	185	60	20	LONG
63	FSS-MCH20	185	60	30	LONG
64	FSS-MCH25	185	60	30	LONG
65	FSS-MCH30	185	60	40	LONG
66	FSS-MCH40	185	60	40	LONG
67	FSS-SHQD40	215	60	60	LONG
68	FSS-SHQD60	230	80	60	LONG



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**NOTE: ALL TESTS WERE PERFORMED USING THE FIBERFOX 6s FUSION SPlicER HEATER OVEN**

		<b>HEATER SETTINGS</b>			
	<b>PART NUMBER</b>	<b>TEMPERATURE (CELSIUS)</b>	<b>TIME (SECONDS)</b>	<b>LENGTH (MM)</b>	<b>HEATER CONTROL</b>
<b>69</b>	<b>*MFSS-SQH30</b>	<b>195/195 FLIP</b>	<b>60/60 FLIP</b>	<b>40</b>	<b>LONG</b>
<b>70</b>	<b>*MFSS-SQH40</b>	<b>195/195 FLIP</b>	<b>60/60 FLIP</b>	<b>50</b>	<b>LONG</b>

**\*These two parts must be heated on both sides as follows:**

- 1) Begin with the glass side down and follow heating process indicated.
- 2) Remove part from heater and wait until part is cool to the touch.
- 3) Flip part on opposite side (glass side up) and repeat heating process.

### **NOTES:**

Splice Technologies Sleeve products are compatible with all major manufacturers of fusion splicers.

The ambient temperature, humidity, and other environmental conditions during splicing may influence the heating process.

The goal is to assure that the sleeve is completely shrunk from end to end eliminating any visible bubbles or air voids within the sleeve.

Also make certain that the inner meltable adhesive flows past the strength member/members at both ends.

*The "Length" and "Heater Control" columns are part of the Fiberfox splicer settings that were used in each shrink process.*