

## Standard Operation Instruction

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**Document # SOI-27-02**

### **CLEANING PROCEDURE FOR TFOCA GenX PLUG CONNECTORS**

#### **1.0 GENERAL CONSIDERATIONS**

This document outlines the procedure for cleaning TFOCA GenX plug connectors.

#### **2.0 SAFETY**

- Refer to Isopropyl Alcohol MSDS Sheet

#### **3.0 TOOLS AND CONSUMABLES**

Description	Part Number
Probe Microscope 250X	NA
Insert Extraction Tool	420-0111
Kim Wipes	NA
Isopropyl Alcohol	NA

#### **4.0 PROCEDURE**

1. Follow this step to clean TFOCA GenX plug connectors that are dirty on both the outside of the connector and the connector front insert. For connector front insert cleaning only skip to step 4.
2. Immerse connector in bucket of clean water and agitate to remove dirt. (Photo 1) Repeat for as long as necessary. Use clean hands to scrub the outside of connector if dirt is still present. Inspect connector front insert and termini for any remaining dirt. Repeat step until all dirt is removed.

**PHOTO 1**

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3. Ensure all dirt is removed from outside of connector and the front insert. (Photo 2) Use canned air to blow off any remaining water. (Photo 3)



PHOTO 2



PHOTO 3

4. Use the following tools and consumables for a thorough and complete connector interface (front insert and termini) cleaning. From left to right and top to bottom: Isopropyl alcohol, lint-free wipes or Kimwipes, foam swabs, and insert extraction tool. (Photo 4) For a quick cleaning between connector mates use an alcohol soaked foam pad. Use a gentle rotating motion to clean the termini endface. Repeat for all termini and blow off using canned air. (Photo 5)



PHOTO 4



PHOTO 5

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5. Use hex end of the extraction tool to loosen the two front insert screws. (Photo 6) Turn tool around and use the threaded portion to thread the tool onto the middle hole in the front insert (Photo 7)

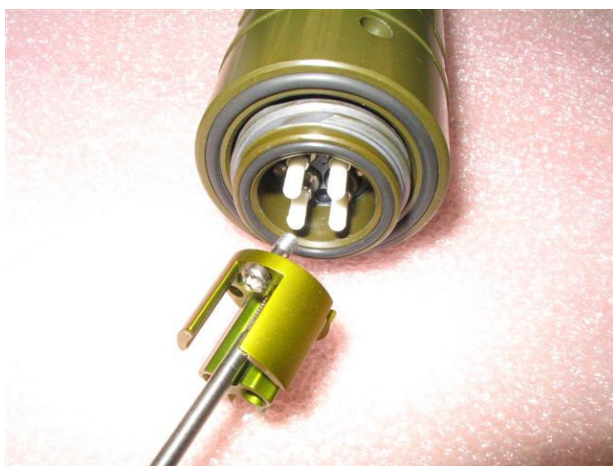


**PHOTO 6**



**PHOTO 7**

6. Remove the front insert by pulling straight back. (Photo 8) Use a foam swab to clean the sides of the ferrules. (Photo 9) Repeat until all debris is removed. Blow off using canned air.



**PHOTO 8**



**PHOTO 9**

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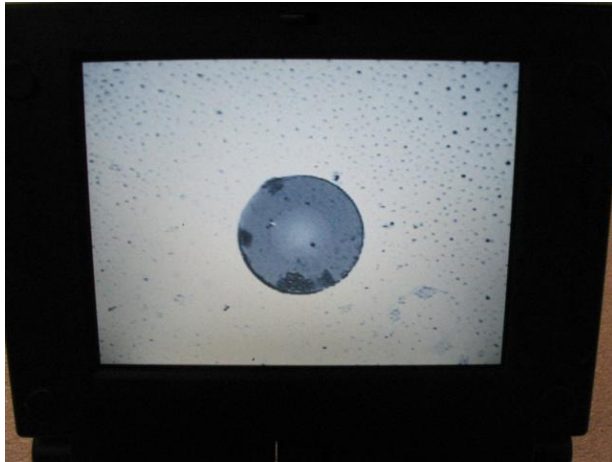
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7. Use the probe microscope to inspect the termini endface. (Photo 10) Clean using a kimwipe soaked in Isopropyl alcohol. (Photo 11)

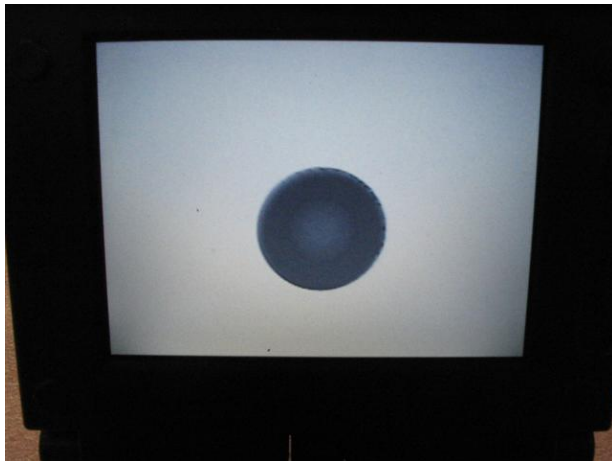


**PHOTO 10**

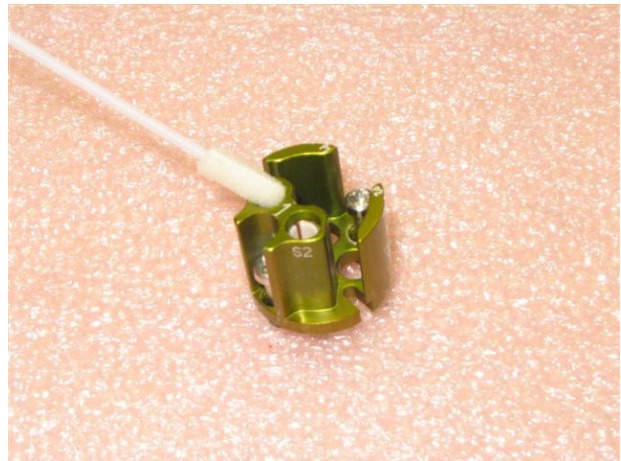


**PHOTO 11**

8. Inspect all termini until the endfaces are clean. (Photo 12) Clean front insert alignment sleeves using an alcohol soaked foam swab and blow off using canned air. (Photo 13)



**PHOTO 12**



**PHOTO 13**

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9. Assemble front insert onto the connector. Note: the rear insert (insert inside connector) has 2 guide pins of different diameters which have to align with the holes on the front insert. Failure to properly align the holes with the correct pins will result in the front insert not seating correctly and the connector not mating properly. (Photo 14) Push back insert until it stops. Use hex end of the extraction tool to tighten the two front insert screws. Cleaning procedure is complete.

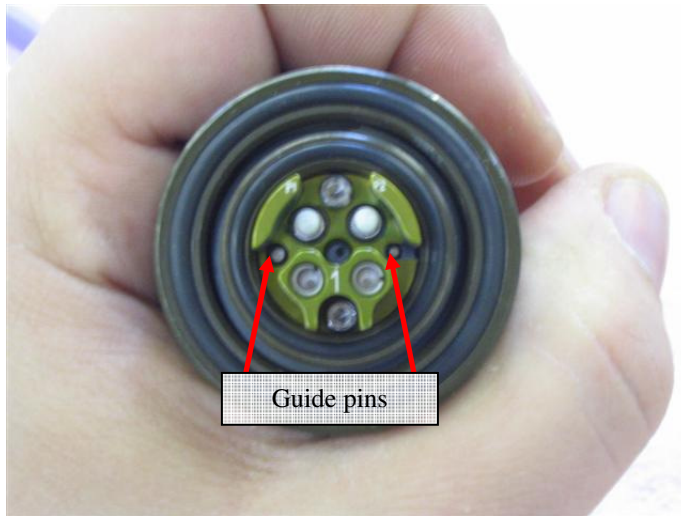


PHOTO 14

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