

SP1000 Polishing Machine Process for NP-APC and UPC, FC, SC, and ST®-Compatible Single-mode Connectors with Preradiused Ceramic Ferrules

The SP1000-SF-S Single-mode Advanced PC connector polishing kit contains all film consumables required for this process. Other necessary items include alcohol, compressed air, lint-free wipes, and distilled water.

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STEP NO.	FILM Part # and Description	PRESSURE (lbs)	SPEED (RPM)	TIME (seconds)	FILM LUBRICANT	Pucks per film usage
1	95-515-SC GRAY	N/A	N/A	N/A	See Polishing Note a)	4
2	95-503-SC LIGHT GRAY	4 70 D Rubber Pad	130	30	Distilled Water	2
3	95-501-DIA LAVENDER	6 70 D Rubber Pad	130	30	Distilled Water	3
4	95-50002-SD OPAQUE	6 70 D Rubber Pad	140	90	Distilled Water	1

Table 1

*Film (pack of 50 sheets) may be ordered separately using the part numbers provided in Table 1.

General Information:

- All steps are performed with the polishing film placed on a precision-ground 70 durometer rubber pad.
- Prior to loading the ferrules into the polishing jig, ensure that the jig is clean.
- Clean the rubber polishing pad on the polisher with alcohol and wipes before and after each polishing step.
- All 12 ports of the polishing jig must be filled, no ports may be left empty. Use dummy connectors to fill any empty ports.

Connector Polishing Notes:

- a) Prior to placing the connectors into the polishing fixture, remove the sharp glass cleave and flush the fiber to the bead, by hand, using the green film with light pressure in a circular motion.
- b) Place the appropriate polishing film on the clean polishing pad by securing it in place with a 0.5-inch piece of double-sided tape. For the films used in all steps, clean with distilled water and a lint-free wipe, then blow dry with air. Do not clean any films with alcohol.
- c) Apply film lubricant as shown in Table 1.
- d) Set the polisher timer for the required number of seconds.
- e) The pressure and speed should be adjusted to the required setting designated in the chart.
- f) Position the loaded polishing jig onto the polisher.
- g) Clean the connector end-faces using alcohol and a lint-free wipe.

- h) Lower the polishing jig onto the polishing film, secure the jig into place, then press the start button to allow the cycle to begin.
- i) After each polishing step, ensure the connector end-faces and polishing jig are clean using distilled water and wipes, then again with alcohol and wipes. Blow dry with compressed air.
- j) After the final polishing step, inspect the connector end-faces with a microscope.

Reworks:

- a) All ports of the polishing jig must be loaded. Use dummy connectors to fill the fixture as needed.
- b) For LIGHT SCRATCHES, SMALL PITS: Follow the polishing chart, beginning at step 3 through step 4.



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p/n 006-328 / May 2005