

SP500 Single-Fiber Single-Mode Ultra PC (<-55dB Reflectance) Polishing Process for FC, SC, and ST®-Compatible Connectors with Pre-Radiused Ceramic Ferrules

This process is designed to yield typical reflectance of < -55 dB. SP500-SF-S Single-Mode Ultra PC Connector Polishing Kit contains all film consumables required for this process.* Other necessary items include alcohol, compressed air, and distilled water.

NOTES:

- Set pressure adjustment to "A" while raising or lowering the overarm. This step is very important in preventing connector endfaces from crashing.
- Secure film to rubber pad with a 0.5-inch piece of double-sided tape placed in the center of the pad.
- Clean film with alcohol and blow dry prior to use. Do not use alcohol on part # 95-40002-FAS.
- 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 in a circular motion.
- Process steps 2-4 below require a spray of distilled water on the polishing film; step 5 requires an even layer of water over the film until it is completely covered. Allow the film to set for 20 seconds before use.
- Lower arm and start timer cycle with the pressure adjustment set on "A". After the film is rotating, set pressure as indicated in the process.
- Bead removal (process step 2) cycle time is dependent on bead size and epoxy type. Larger beads with harder epoxy may require more time.
- If rework is necessary on any connector, set that connector aside while continuing to polish the remainder of the connectors. A minimum of six connectors of the same type can be reworked at one time with 12 connectors being the optimum number required for rework. To rework, repeat process steps 4 and 5 as described below for that connector.
- All times and pressures are based on Corning Cable Systems connectors and fiber using F-123 epoxy with medium bead size.

Process for ST and FC Connectors				
STEP No.	FILM Part # Description	PRESSURE Setting	TIME (in seconds)	PUCKS per film usage
1	95-430-AO Green	see note "d"	N/A	4
2	95-403-SC Light Gray w/water	C	20	2
3	95-401-DIA Lavender w/water	C	20	5
4	95-4005-DIA Tan w/water	C	20	5
5	95-40002-FAS Light Purple w/water	E	30	1

Process for SC Connectors				
STEP No.	FILM Part # Description	PRESSURE Setting	TIME (in seconds)	PUCKS per film usage
1	95-430-AO Green	see note "d"	N/A	4
2	95-403-SC Light Gray w/water	C	20	2
3	95-401-DIA Lavender w/water	C	20	5
4	95-4005-DIA Tan w/water	C	20	5
5	95-40002-FAS Light Purple w/water	D	30	1

*Film (packs of 50 sheets) and slurry may also be ordered separately using the "95-XXX-XX" number.

Corning Cable Systems welcomes your comments concerning this Standard Recommended Procedure. You may send your comments to the following address:

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You may also submit comments via email to:
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