

φ 2.5mm UPC Polishing Process (reference)

Polishing Machine **OFL-15A**
 Polishing Holder One-touch type 24-axis polishing holder (KKJ101701G)
 Ferrule Φ2.5mm pre-radius (SZ-3A)
 Qty of ferrule 24pcs、16pcs、12pcs、6pcs

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure	Film Life
Adhesive Removal	24pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely			8 times
	16pcs	↑	↑		↑				↑
	12pcs	↑	↑		↑				↑
	6pcs	↑	↑		↑				↑
Grinding	24pcs	KJW100240G	KMD100100G	KLP101510G	Purified water	0.5min	280rpm	4400g	20 times
	16pcs	↑	↑	↑	↑	↑	↑	2800g	27 times
	12pcs	↑	↑	↑	↑	↑	↑	2000g	35 times
	6pcs	↑	↑	↑	↑	↑	↑	750g	40 times
Polishing	24pcs	KJW100440G	KMD100100G	KLP101510G	Purified water	1.0min	240rpm	3800g	30 times
	16pcs	↑	↑	↑	↑	↑	↑	2400g	35 times
	12pcs	↑	↑	↑	↑	↑	↑	1650g	40 times
	6pcs	↑	↑	↑	↑	↑	↑	600g	↑
Finishing	24pcs	KJW101530G	KMD100100G	KLP101540G	Purified water	2.0min	220rpm	3800g	7 times
	16pcs	↑	↑	↑	↑	↑	↑	2400g	↑
	12pcs	↑	↑	↑	↑	↑	↑	1650g	10 times
	6pcs	↑	↑	↑	↑	↑	↑	600g	↑

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air afterward
 ※Size of KJW100110G is A4 paper size.

Polishing Machine **OFL-15A**
 Polishing Holder V-groove type 12-axis polishing holder (KKJ101101G)
 Ferrule Φ2.5mm pre-radius (SZ-3A)
 Qty of ferrule 12pcs、6pcs、3pcs

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure	Film Life
Adhesive Removal	12pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely			16 times
	6pcs	↑	↑		↑				↑
	3pcs	↑	↑		↑				↑
Grinding	12pcs	KJW100240G	KMD100100G	KLP101510G	Purified water	0.5min	280rpm	2100g	35 times
	6pcs	↑	↑	↑	↑	↑	↑	900g	40 times
	3pcs	↑	↑	↑	↑	↑	↑	300g	↑
Polishing	12pcs	KJW100440G	KMD100100G	KLP101510G	Purified water	1.0min	240rpm	1800g	40 times
	6pcs	↑	↑	↑	↑	↑	↑	750g	↑
	3pcs	↑	↑	↑	↑	↑	↑	300g	↑
Finishing	12pcs	KJW101530G	KMD100100G	KLP101540G	Purified water	2.0min	220rpm	1800g	10 times
	6pcs	↑	↑	↑	↑	↑	↑	750g	↑
	3pcs	↑	↑	↑	↑	↑	↑	300g	↑

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air afterward
 ※Size of KJW100110G is A4 paper size.

Polishing Machine **OFL-12**
 Polishing Holder V-groove type 12-axis polishing holder (KJJ101102G)
 Ferrule Φ2.5mm pre-radius (SZ-3A)
 Qty of ferrule 12pcs、6pcs、3pcs

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure Point	Film Life
Adhesive Removal	12pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely			16 times
	6pcs	↑	↑		↑				↑
	3pcs	↑	↑		↑				↑
Grinding	12pcs	KJW100240G	KJD100100G	KLP101500G	Purified water	1.0min	180rpm	Point 0	30 times
	6pcs	↑	↑	↑	↑	↑	↑	Point 2	35 times
	3pcs	↑	↑	↑	↑	↑	↑	Point 3	↑
Polishing	12pcs	KJW100440G	KJD100100G	KLP101500G	Purified water	1.5min	180rpm	Point 0	40 times
	6pcs	↑	↑	↑	↑	↑	↑	Point 2	↑
	3pcs	↑	↑	↑	↑	↑	↑	Point 3	↑
Finishing	12pcs	KJW101530G	KJD100100G	KLP101540G	Purified water	2.0min	180rpm	Point 0	10 times
	6pcs	↑	↑	↑	↑	↑	↑	Point 2	↑
	3pcs	↑	↑	↑	↑	↑	↑	Point 3	↑

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air afterward
 ※Size of KJW100110G is A4 paper size.

φ2.5mm Conical APC Polishing Process (reference)

Polishing Machine **OFL-15A**
 Polishing Holder APC ferrule 24-axis polishing holder (KKJZM05101G)
 Ferrule Φ2.5mm conical APC ferrule (SNZ-1A)
 Qty of ferrule 24pcs
 Polishing Step

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure
Adhesive Removal	24pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely		
Grinding	24pcs	KJW100240G	KMD100310G		Purified water	2.5min	180rpm	2650g
Polishing	24pcs	KJW100440G	KMD100301G	KLP101510G	Purified water	1.0min	180rpm	2650g
Finishing	24pcs	KJW101530G	KMD100301G	KLP101500G	Purified water	2.0min	180rpm	2650g

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air.
 ※Size of KJW100110G is A4 paper size.

Polishing Machine **OFL-15A**
 Polishing Holder APC ferrule 24-axis polishing holder (KKJZM05101G) Polishing holder for Adhesive removal: KKJ101701G
 Ferrule Φ2.5mm conical APC ferrule (SNZ-1A)
 Qty of ferrule 24pcs
 <with Tuning>

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure
Adhesive Removal	24pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely		
Polishing	24pcs	KJW100440G	KMD100100G	KLP101510G	Purified water	1.5min	180rpm	2650g
Tuning								
Grinding	24pcs	KJW100240G	KMD100310G	KLP101500G	Purified water	2.5min	180rpm	2650g
Polishing	24pcs	KJW100440G	KMD100301G	KLP101510G	Purified water	1.0min	180rpm	2650g
Finishing	24pcs	KJW101530G	KMD100301G	KLP101500G	Purified water	2.0min	180rpm	2650g

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air.
 ※Size of KJW100110G is A4 paper size.

Polishing Machine **OFL-15A**
 Polishing Holder APC ferrule 24-axis polishing holder (KKJZM05101G) Polishing holder for Adhesive removal: KKJ101701G
 Ferrule Φ2.5mm conical APC ferrule (SNZ-1A)
 Qty of ferrule 12pcs , 6pcs
 <without Tuning>

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure
Adhesive Removal	12pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely		
	6pcs	↑	↑		↑			
Grinding	12pcs	KJW100240G	KMD100301G	KLP101500G	Purified water	2.5min	180rpm	1150g
	6pcs	↑	↑	↑	↑	↑	↑	380g
Polishing	12pcs	KJW100440G	KMD100301G	KLP101510G	Purified water	1.0min	180rpm	1150g
	6pcs	↑	↑	↑	↑	↑	↑	380g
Finishing	12pcs	KJW101530G	KMD100301G	KLP101500G	Purified water	2.0min	180rpm	1150g
	6pcs	↑	↑	↑	↑	↑	↑	380g

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air.
 ※Size of KJW100110G is A4 paper size.

Polishing Machine **OFL-15A**
 Polishing Holder SC plug APC 12-axis polishing holder (KKJ101320G) Polishing holder for Adhesive removal: KKJ101101G
 Ferrule Φ2.5mm conical APC ferrule (SNZ-1A)
 Qty of ferrule 12pcs , 6pcs
 <with Tuning>

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure
Adhesive Removal	12pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely		
	6pcs	↑	↑		↑			
Polishing	12pcs	KJW100440G	KMD100100G	KLP101510G	Purified water	1.5min	180rpm	1150g
	6pcs	↑	↑	↑	↑	↑	↑	380g
Tuning								
Grinding	12pcs	KJW100240G	KMD100301G	KLP101500G	Purified water	2.5min	180rpm	1150g
	6pcs	↑	↑	↑	↑	↑	↑	380g
Polishing	12pcs	KJW100440G	KMD100301G	KLP101510G	Purified water	1.0min	180rpm	1150g
	6pcs	↑	↑	↑	↑	↑	↑	380g
Finishing	12pcs	KJW101530G	KMD100301G	KLP101500G	Purified water	2.0min	180rpm	1150g
	6pcs	↑	↑	↑	↑	↑	↑	380g

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air.
 ※Size of KJW100110G is A4 paper size.

Polishing Machine **OFL-12**
 Polishing Holder SC plug APC 12-axis polishing holder (KJJ100320G)
 Ferrule Φ2.5mm conical APC ferrule (SNZ-1A)
 Qty of ferrule 12pcs , 6pcs
 <without Tuning>

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure
Adhesive Removal	12pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely		
	6pcs	↑	↑		↑			
Grinding	12pcs	KJW100240G	KJD100301G	KLP101500G	Purified water	2.5min	180rpm	Point 1
	6pcs	↑	↑	↑	↑	↑	↑	Point 3
Polishing	12pcs	KJW100440G	KJD100301G	KLP101510G	Purified water	1.0min	180rpm	Point 1
	6pcs	↑	↑	↑	↑	↑	↑	Point 3
Finishing	12pcs	KJW101530G	KJD100301G	KLP101500G	Purified water	2.0min	180rpm	Point 1
	6pcs	↑	↑	↑	↑	↑	↑	Point 3

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air.
 ※Size of KJW100110G is A4 paper size.

Polishing pad for OFL-12 is KJP100***G. But it is OK to use KLP101***G (easier for replacement)

Polishing Machine **OFL-12**
 Polishing Holder SC plug APC 12-axis polishing holder (KJJ101320G) Polishing holder for Adhesive removal: KJJ100102G
 Ferrule Φ2.5mm conical APC ferrule (SNZ-1A)
 Qty of ferrule 12pcs , 6pcs
 <with Tuning>

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure
Adhesive Removal	12pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely		
	6pcs	↑	↑		↑			
Polishing	12pcs	KJW100440G	KJD100100G	KLP101510G	Purified water	1.5min	180rpm	Point 1
	6pcs	↑	↑	↑	↑	↑	↑	Point 3
Tuning								
Grinding	12pcs	KJW100240G	KJD100301G	KLP101500G	Purified water	2.5min	180rpm	Point 1
	6pcs	↑	↑	↑	↑	↑	↑	Point 3
Polishing	12pcs	KJW100440G	KJD100301G	KLP101510G	Purified water	1.0min	180rpm	Point 1
	6pcs	↑	↑	↑	↑	↑	↑	Point 3
Finishing	12pcs	KJW101530G	KJD100301G	KLP101500G	Purified water	2.0min	180rpm	Point 1
	6pcs	↑	↑	↑	↑	↑	↑	Point 3

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air.
 ※Size of KJW100110G is A4 paper size.

Film Life
16 times
10 times
30 times
10 times

r afterward

Film Life
16 times
25 times
10 times
30 times
10 times

r afterward

Film Life
32 times
40 times
10 times
15 times
40 times
↑
10 times
12 times

r afterward

Film Life
32 times
40 times
30 times
↑
10 times
15 times
40 times
↑
10 times
12 times

r afterward

Film Life
32 times
40 times
10 times
15 times
40 times
↑
10 times
12 times

r afterward

Film Life
32 times
40 times
30 times
↑
10 times
15 times
40 times
↑
10 times
12 times

r afterward

φ2.5mm Step APC Polishing Process (reference)

Polishing Machine OFL-15A

Polishing Holder APC ferrule 24-axis polishing holder (KKJZM05101G)、APC ferrule 16pcs polishing holder (KKJZM05201G) Polishing holder SC plug APC 12-axis polishing holder (KKJ101320G)

Ferrule Φ2.5mm step APC ferrule (SGZ-1A)

Polishing Step 24pcs、16pcs、12pcs、6pcs

<Tuning>

Polishing Step	Termination	Polishing Holder	Film	Disk	Pad	Liquid	Time	Speed
Adhesive Removal	24pcs	KKJ101701G	KJW100110G			Purified water	By holder weight until adhesion completely	
	16pcs	↑	↑			↑		
	12pcs	↑	↑			↑		
	6pcs	↑	↑			↑		
Grinding	24pcs	KKJ101701G	KJW100240G	KMD100100G	KLP101510G	Purified water	1.0min	220rpm
	16pcs	↑	↑	↑	↑	↑	↑	↑
	12pcs	↑	↑	↑	↑	↑	↑	↑
	6pcs	↑	↑	↑	↑	↑	↑	↑
Polishing	24pcs	KKJ101701G	KJW100440G	KMD100100G	KLP101510G	Purified water	1.0min	220rpm
	16pcs	↑	↑	↑	↑	↑	↑	↑
	12pcs	↑	↑	↑	↑	↑	↑	↑
	6pcs	↑	↑	↑	↑	↑	↑	↑
Tuning								
Grinding-1	24pcs	KKJZM05101G	KJW100700G	KMD100200G	None	Purified water	1.0min以上	180rpm
	16pcs	↑	↑	↑	↑	↑	↑	↑
	12pcs	KKJ101320G	↑	↑	↑	↑	↑	↑
	6pcs	↑	↑	↑	↑	↑	↑	↑
Grinding-2	24pcs	KKJZM05101G	KJW100240G	KMD100100G	KLP101500G	Purified water	1.25min	160rpm
	16pcs	↑	↑	↑	↑	↑	↑	↑
	12pcs	KKJ101320G	↑	↑	↑	↑	↑	↑
	6pcs	↑	↑	↑	↑	↑	↑	↑
Polishing	24pcs	KKJZM05101G	KJW100440G	KMD100100G	KLP101510G	Purified water	1.0min	180rpm
	16pcs	↑	↑	↑	↑	↑	↑	↑
	12pcs	KKJ101320G	↑	↑	↑	↑	↑	↑
	6pcs	↑	↑	↑	↑	↑	↑	↑
Finishing	24pcs	KKJZM05101G	KJW101530G	KMD100100G	KLP101540G	Purified water	2.0min	150rpm
	16pcs	↑	↑	↑	↑	↑	↑	↑
	12pcs	KKJ101320G	↑	↑	↑	↑	↑	↑
	6pcs	↑	↑	↑	↑	↑	↑	↑

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow

※Size of KJW100110G is A4 paper size.

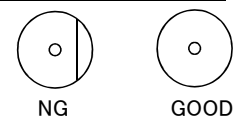
If no Tuning, then skip Grinding and Polishing steps for before Tuning

Polish until angle is completely formed (Refer Figure1 on the right)

Guide for Polishing time (if using KJW100700G)

1.0 min for 1~33 times 1.5min for 34 times~66 times 2min for 67 times~100 times

Figure 1 (ferrule endface)



Polishing Machine OFL-12

Polishing Holder APC ferrule 12-axis polishing holder (KJJ100340G)、SC plug APC 12-axis polishing holder (KJJ100320G) Polishing holder

Ferrule Φ2.5mm step APC ferrule (SGZ-1A)

Qty of ferrule 12pcs、6pcs

<Tuning>

Polishing Step	Termination	Polishing Holder	Film	Disk	Pad	Liquid	Time	Speed
Adhesive Removal	12pcs	KJJ100102G	KJW100110G	KJ100101G		Purified water	By holder weight until adhesion completely	
	6pcs	↑	↑			↑		
Grinding	12pcs	KJJ100102G	KJW100240G	KJD100100G	KLP101510G	Purified water	1.0min	180rpm
	6pcs	↑	↑	↑	↑	↑	↑	↑
Polishing	12pcs	KJJ100102G	KJW100440G	KJD100100G	KLP101510G	Purified water	1.0min	180rpm
	6pcs	↑	↑	↑	↑	↑	↑	↑
Tuning								
Grinding-1	12pcs	KJJ100320G	KJW100700G	KJD100200G	None	Purified water	1.0min以上	180rpm
	6pcs	↑	↑	↑	↑	↑	↑	↑
Grinding-2	12pcs	KJJ100320G	KJW100240G	KJD100100G	KLP101500G	Purified water	1.25min	180rpm
	6pcs	↑	↑	↑	↑	↑	↑	↑
Polishing	12pcs	KJJ100320G	KJW100440G	KJD100100G	KLP101510G	Purified water	1.0min	180rpm
	6pcs	↑	↑	↑	↑	↑	↑	↑
Finishing	12pcs	KJJ100320G	KJW101530G	KJD100100G	KLP101540G	Purified water	2.0min	180rpm
	6pcs	↑	↑	↑	↑	↑	↑	↑

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow

※Size of KJW100110G is A4 paper size.

If no Tuning, then skip Grinding and Polishing steps for before Tuning

Polish until angle is completely formed (Refer Figure1 on the right)

Figure 1 (ferrule endface)



Guide for Polishing time (if using KJW100700G)

1.0 min for 1~33 times 1.5min for 34 times~66 times 2min for 67 times~100 times

Polishing pad for OFL-12 is KJP100***G. But it is OK to use KLP101***G (easier for replacement)



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er for Adhesive removal: KK

Pressure	Film Life
ve is removed	16 times
	↑
	32 times
	↑
3800g	10 times
2400g	↑
1700g	20 times
600g	↑
2650g	30 times
1600g	35 times
1100g	40 times
300g	↑

2800g	50 times
1700g	↑
1250g	100 times
450g	↑
3100g	10 times
1900g	↑
1400g	20 times
500g	↑
2800g	30 times
1700g	35 times
1250g	40 times
450g	↑
2800g	7 times
1700g	↑
1250g	10 times
450g	↑

w air afterward

er for Adhesive removal: KJ

Pressure	Film Life
ve is removed	32 times
	↑
Point 0	20 times
Point 2	↑
Point 1	40 times
Point 3	↑
Point 1	100 times
Point 3	↑
Point 0	20 times
Point 3	↑
Point 1	40 times
Point 3	↑
Point 1	10 times
Point 3	↑

w air afterward

φ 1.25mm MU Polishing Process (reference)

2009.4.2 rev.2

Below process can be applicable for plug polishing using KKJ401301G (for OFL-15) and KJJ400301G (for OFL-12) polishing holder
But there is tendency of having slightly larger ROC. Please adjust pressure for smaller ROC

Polishing Machine OFL-15A
Polishing Step One-touch type 24-axis polishing holder (KKJ401400G)
Ferrule Φ1.25mm MU ferrule (MUZ-1A)
Qty of ferrule 24pcs、16pcs、12pcs

Polishing Step	Termination	Film	Disk		Liquid	Time	Speed	Pressure	Film Life
Adhesive Removal	24pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely			20 times
	16pcs	↑	↑		↑				32 times
	12pcs	↑	↑		↑				↑
Grinding	24pcs	KJW100240G	KMD100200G	None	Purified water	0.5min	180rpm	1000g	40 times
	16pcs	↑	↑	↑	↑	↑	↑	540g	45 times
	12pcs	↑	↑	↑	↑	↑	↑	320g	60 times
Polishing	24pcs	KJW100440G	KMD100100G	KLP101530G	Purified water	1.5min	180rpm	1700g	30 times
	16pcs	↑	↑	↑	↑	↑	↑	1000g	35 times
	12pcs	↑	↑	↑	↑	↑	↑	660g	40 times
Finishing	24pcs	KJW101530G	KMD100100G	KLP101530G	Purified water	2.0min	180rpm	1700g	10 times
	16pcs	↑	↑	↑	↑	↑	↑	1000g	↑
	12pcs	↑	↑	↑	↑	↑	↑	660g	15 times

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air afterwards
 ※Size of KJW100110G is A4 paper size.

Polishing Machine OFL-15A
Polishing Holder V-groove type 16-axis polishing holder (KKJ401120G)
Ferrule Φ1.25mm MU ferrule (MUZ-1A)
Qty of ferrule 16pcs、12pcs、6pcs

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure	Film Life
Adhesive Removal	16pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely			32 times
	12pcs	↑	↑		↑				↑
	6pcs	↑	↑		↑				40 times
Grinding	16pcs	KJW100240G	KMD100200G	None	Purified water	0.5min	180rpm	700g	45 times
	12pcs	↑	↑	↑	↑	↑	↑	450g	60 times
	6pcs	↑	↑	↑	↑	↑	↑	300g	↑
Polishing	16pcs	KJW100440G	KMD100100G	KLP101530G	Purified water	1.5min	180rpm	1150g	35 times
	12pcs	↑	↑	↑	↑	↑	↑	800g	40 times
	6pcs	↑	↑	↑	↑	↑	↑	300g	↑
Finishing	16pcs	KJW101530G	KMD100100G	KLP101530G	Purified water	2.0min	180rpm	1150g	10 times
	12pcs	↑	↑	↑	↑	↑	↑	800g	15 times
	6pcs	↑	↑	↑	↑	↑	↑	300g	↑

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air afterwards
 ※Size of KJW100110G is A4 paper size.

Polishing Machine OFL-12
Polishing Holder V-groove type 16-axis polishing holder (KJJ400120G)
Ferrule Φ1.25mm MU ferrule (MUZ-1A)
Qty of ferrule 16pcs、12pcs、6pcs

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure Poin	Film Life
Adhesive Removal	16pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely			32 times
	12pcs	↑	↑		↑				↑
	6pcs	↑	↑		↑				40 times
Grinding	16pcs	KJW100240G	KJD100200G	None	Purified water	0.5min	180rpm	Point 2	45 times
	12pcs	↑	↑	↑	↑	↑	↑	Point 3	60 times
	6pcs	↑	↑	↑	↑	↑	↑	Point 3	↑
Polishing	16pcs	KJW100440G	KJD100100G	KLP101530G	Purified water	1.5min	180rpm	Point 1	35 times
	12pcs	↑	↑	↑	↑	↑	↑	Point 2	40 times
	6pcs	↑	↑	↑	↑	↑	↑	Point 3	↑
Finishing	16pcs	KJW101530G	KJD100100G	KLP101530G	Purified water	2.0min	180rpm	Point 1	10 times
	12pcs	↑	↑	↑	↑	↑	↑	Point 2	15 times
	6pcs	↑	↑	↑	↑	↑	↑	Point 3	↑

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air afterwards
 ※Size of KJW100110G is A4 paper size.

φ 1.25mm LC Polishing Process (reference)

2009.4.2 rev.2

Polishing Machine OFL-15A

Polishing Holder One-touch type 24-axis polishing holder (KKJ401400G)

Ferrule Φ 1.25mm LC ferrule (LCZ-2A)

Qty of ferrule 24pcs、16pcs、12pcs、8pcs

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure	Film Life
Adhesive Removal	Termination	Film	KJo100101G		Liquid	By holder weight until adhesive is removed completely			20 times
	16pcs	↑	↑	↑	32 times				
	12pcs	↑	↑	↑	↑				
	8pcs	↑	↑	↑	40 times				
Grinding	24pcs	KJW100240G	KMD100200G	None	Purified water	0.5min	180rpm	1000g	40 times
	16pcs	↑	↑	↑	↑	↑	↑	540g	45 times
	12pcs	↑	↑	↑	↑	↑	↑	320g	60 times
	8pcs	↑	↑	↑	↑	↑	↑	300g	70 times
Polishing	24pcs	KJW100440G	KMD100100G	KLP101530G	Purified water	1.5min	180rpm	2380g	30 times
	16pcs	↑	↑	↑	↑	↑	↑	1470g	35 times
	12pcs	↑	↑	↑	↑	↑	↑	1000g	40 times
	8pcs	↑	↑	↑	↑	↑	↑	550g	↑
Finishing	24pcs	KJW101530G	KMD100100G	KLP101530G	Purified water	2.0min	180rpm	2380g	10 times
	16pcs	↑	↑	↑	↑	↑	↑	1470g	↑
	12pcs	↑	↑	↑	↑	↑	↑	1000g	15 times
	8pcs	↑	↑	↑	↑	↑	↑	550g	↑

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air afterwards.
※Size of KJW100110G is A4 paper size.

Polishing Machine OFL-15A

Polishing Holder V-groove type 16-axis polishing holder (KKJ401120G)、LC plug 16-axis polishing holder (KKJ401200G)

Ferrule Φ 1.25mm LC ferrule (LCZ-2A)

Qty of ferrule 16pcs、12pcs、6pcs

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure	Film Life
Adhesive Removal	16pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely			32 times
	12pcs	↑	↑	↑	↑				
	6pcs	↑	↑	↑	↑				40 times
Grinding	16pcs	KJW100240G	KMD100200G	None	Purified water	0.5min	180rpm	700g	45 times
	12pcs	↑	↑	↑	↑	↑	↑	450g	60 times
	6pcs	↑	↑	↑	↑	↑	↑	300g	↑
Polishing	16pcs	KJW100440G	KMD100100G	KLP101530G	Purified water	1.5min	180rpm	1600g	35 times
	12pcs	↑	↑	↑	↑	↑	↑	1150g	40 times
	6pcs	↑	↑	↑	↑	↑	↑	460g	↑
Finishing	16pcs	KJW101530G	KMD100100G	KLP101530G	Purified water	2.0min	180rpm	1600g	10 times
	12pcs	↑	↑	↑	↑	↑	↑	1150g	15 times
	6pcs	↑	↑	↑	↑	↑	↑	460g	↑

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air afterwards.
※Size of KJW100110G is A4 paper size.

Polishing Machine OFL-12

Polishing Holder V-groove type 16-axis polishing holder (KJJ400120G)、LC plug 16-axis polishing holder (KJJ400200G)

Ferrule Φ 1.25mm LC ferrule (LCZ-2A)

Qty of ferrule 16pcs、12pcs、6pcs

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure Point	Film Life
Adhesive Removal	16pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely			32 times
	12pcs	↑	↑	↑	↑				
	6pcs	↑	↑	↑	↑				40 times
Grinding	16pcs	KJW100240G	KJD100200G	None	Purified water	0.5min	180rpm	Point 2	45 times
	12pcs	↑	↑	↑	↑	↑	↑	Point 3	60 times
	6pcs	↑	↑	↑	↑	↑	↑	Point 3	↑
Polishing	16pcs	KJW100440G	KJD100100G	KLP101530G	Purified water	1.5min	180rpm	Point 0	35 times
	12pcs	↑	↑	↑	↑	↑	↑	Point 1	40 times
	6pcs	↑	↑	↑	↑	↑	↑	Point 3	↑
Finishing	16pcs	KJW101530G	KJD100100G	KLP101530G	Purified water	2.0min	180rpm	Point 0	10 times
	12pcs	↑	↑	↑	↑	↑	↑	Point 1	15 times
	6pcs	↑	↑	↑	↑	↑	↑	Point 3	↑

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air afterwards.
※Size of KJW100110G is A4 paper size.

φ 1.25mm LC/APC Polishing Process (reference)

2009.4.2 rev.2

Polishing Machine OFL-15A

Polishing Holder LC/APC plug 12-axis polishing holder (KKJZM01802G)

Ferrule Φ 1.25mm LC/APC ferrule (LCNZ-1A)

Qty of ferrule 12pcs , 6pcs

Polishing Step

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure	Film Life
Adhesive Removal	12pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely			32 times
	6pcs	↑	↑		↑				40 times
Grinding	12pcs	KJW100240G	KMD100200G	None	Purified water	1.0min	180rpm	450g	20 times
	6pcs	↑	↑	↑	↑	↑	↑	300g	30 times
Polishing	12pcs	KJW100440G	KMDZM02101G	KLP101520G	Purified water	1.0min	180rpm	800g	40 times
	6pcs	↑	↑	KLP101530G	↑	↑	↑	800g	↑
Finishing	12pcs	KJW101530G	KMDZM02102G	KLP101510G	Purified water	2.0min	180rpm	450g	10 times
	6pcs	↑	↑	KLP101520G	↑	↑	↑	300g	↑

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air after
※Size of KJW100110G is A4 paper size.

Polishing Machine OFL-15A

Polishing Holder LC/APC plug 12-axis polishing holder (KKJZM01802G) Polishing holder for Adhesive removal: KKJ401120G

Ferrule Φ 1.25mm LC/APC ferrule (LCNZ-1A)

Qty of ferrule 12pcs , 6pcs

<with Tuning>

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure	Film Life
Adhesive Removal	12pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely			32 times
	6pcs	↑	↑		↑				40 times
Polishing	12pcs	KJW100440G	KMD100100G	KLP101510G	Purified water	1.5min	180rpm	800g	30 times
	6pcs	↑	↑	↑	↑	↑	↑	300g	↑
Tuning									
Grinding	12pcs	KJW100240G	KMD100200G	None	Purified water	1.0min	180rpm	450g	20 times
	6pcs	↑	↑	↑	↑	↑	↑	300g	30 times
Polishing	12pcs	KJW100440G	KMDZM02101G	KLP101520G	Purified water	1.0min	180rpm	800g	40 times
	6pcs	↑	↑	KLP101530G	↑	↑	↑	800g	↑
Finishing	12pcs	KJW101530G	KMDZM02102G	KLP101510G	Purified water	2.0min	180rpm	450g	10 times
	6pcs	↑	↑	KLP101520G	↑	↑	↑	300g	↑

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air after
※Size of KJW100110G is A4 paper size.

Polishing Machine OFL-12

Polishing Holder LC/APC plug 12-axis polishing holder (KJJZM01B01G)

Ferrule Φ 1.25mm LC/APC ferrule (LCNZ-1A)

Qty of ferrule 12pcs , 6pcs

<without Tuning>

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure	Film Life
Adhesive Removal	12pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely			32 times
	6pcs	↑	↑		↑				40 times
Grinding	12pcs	KJW100240G	KJD100200G	None	Purified water	1.0min	180rpm	Point 3	20 times
	6pcs	↑	↑	↑	↑	↑	↑	Point 3	30 times
Polishing	12pcs	KJW100440G	KJDZM02101G	KLP101520G	Purified water	1.0min	180rpm	Point 2	40 times
	6pcs	↑	↑	KLP101530G	↑	↑	↑	Point 2	↑
Finishing	12pcs	KJW101530G	KJDZM02102G	KLP101510G	Purified water	2.0min	180rpm	Point 3	10 times
	6pcs	↑	↑	KLP101520G	↑	↑	↑	Point 3	↑

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air after
※Size of KJW100110G is A4 paper size.

Polishing pad for OFL-12 is KJP100***G. But it is OK to use KLP101***G (easier for replacement)

Polishing Machine OFL-12

Polishing Holder LC/APC plug 12-axis polishing holder (KJJZM01B01G) Polishing holder for Adhesive removal: KJJ400120G

Ferrule Φ 1.25mm LC/APC ferrule (LCNZ-1A)

Qty of ferrule 12pcs , 6pcs

<with Tuning>

Polishing Step	Termination	Film	Disk	Pad	Liquid	Time	Speed	Pressure	Film Life
Adhesive Removal	12pcs	KJW100110G	KJo100101G		Purified water	By holder weight until adhesive is removed completely			32 times
	6pcs	↑	↑		↑				40 times
Polishing	12pcs	KJW100440G	KJD100100G	KLP101510G	Purified water	1.5min	180rpm	Point 2	30 times
	6pcs	↑	↑	↑	↑	↑	↑	Point 3	↑
Tuning									
Grinding	12pcs	KJW100240G	KJD100200G	None	Purified water	1.0min	180rpm	Point 3	20 times
	6pcs	↑	↑	↑	↑	↑	↑	Point 3	30 times
Polishing	12pcs	KJW100440G	KJDZM02101G	KLP101520G	Purified water	1.0min	180rpm	Point 2	40 times
	6pcs	↑	↑	KLP101530G	↑	↑	↑	Point 2	↑
Finishing	12pcs	KJW101530G	KJDZM02102G	KLP101510G	Purified water	2.0min	180rpm	Point 3	10 times
	6pcs	↑	↑	KLP101520G	↑	↑	↑	Point 3	↑

After Polishing and Finishing, please clean ferrule endface and jig surface by hitting lightly with water-soaked tissue under running water and blow air after
※Size of KJW100110G is A4 paper size.

OFL-15 Adhesive Removal Step with Polishing Machine

<PC polishing >

Polishing Holder One-touch type 24-axis polishing holder (KKJ101701G)

Ferrule Φ 2.5mm pre-radius (SZ-3A)

Qty of ferrule 24pcs , 16pcs , 12pcs

Polishing Step	Polishing Step	Film	Disk	Pad
Adhesive Removal	24pcs	KJWZM00A01G	KMD100100G	KLP101540G
	16pcs	↑	↑	↑
	12pcs	↑	↑	↑

※ If adhesive amount on endface is large, please use GA5D (30um) or GC5D (15um)

<APC polishing >

Adjust

Polishing Holder One-touch type 24-axis polishing holder (KKJ101701G)

Ferrule Φ 2.5mm conical APC ferrule (SNZ-1A)

Qty of ferrule 24pcs

Polishing Step	Termination	Film	Disk	Pad
Adhesive Removal	24pcs	KJWZM00A01G	KMD100100	KLP101540G

<APC polishing >

None Adjust

Polishing Holder SC plug APC 24-axis polishing holder (KKJZM05101G)

Ferrule Φ 2.5mm conical APC ferrule (SNZ-1A)

Qty of ferrule 24pcs

Polishing Step	Termination	Film	Disk	Pad
Adhesive Removal	24pcs	KJWZM00A01G	KMD100310	KLP101540G

<APC polishing >

None Adjust

Polishing Holder SC plug APC 24-axis polishing holder (KKJZM05101G)

Ferrule Φ 2.5mm conical APC ferrule (SNZ-3A) pre-angled

Qty of ferrule 24pcs

Polishing Step	Termination	Film	Disk	Pad
Adhesive Removal	24pcs	KJWZM00A01G	KMD100200G	KLP101530G

※ If some ferrules out 24pcs still have adhesive left on endface, we consider improper fitting
Please make sure to insert ferrule until end and re-polish.

※ If adhesive on endface is large amount and please extend polishing time about 15 to 30 s

2009.2.16

Liquid	Time	Speed	Pressure	Film Life
Purified water	Liquid	220rpm	500g	2 times
↑	↑	↑	300g	2 times
↑	↑	↑	300g	3 times

Liquid	Time	Speed	Pressure	Film Life
Purified water	1.0min	180rpm	300g	2 times

Liquid	Time	Speed	Pressure	Film Life
Purified water	1.0min	180rpm	500g	1 times

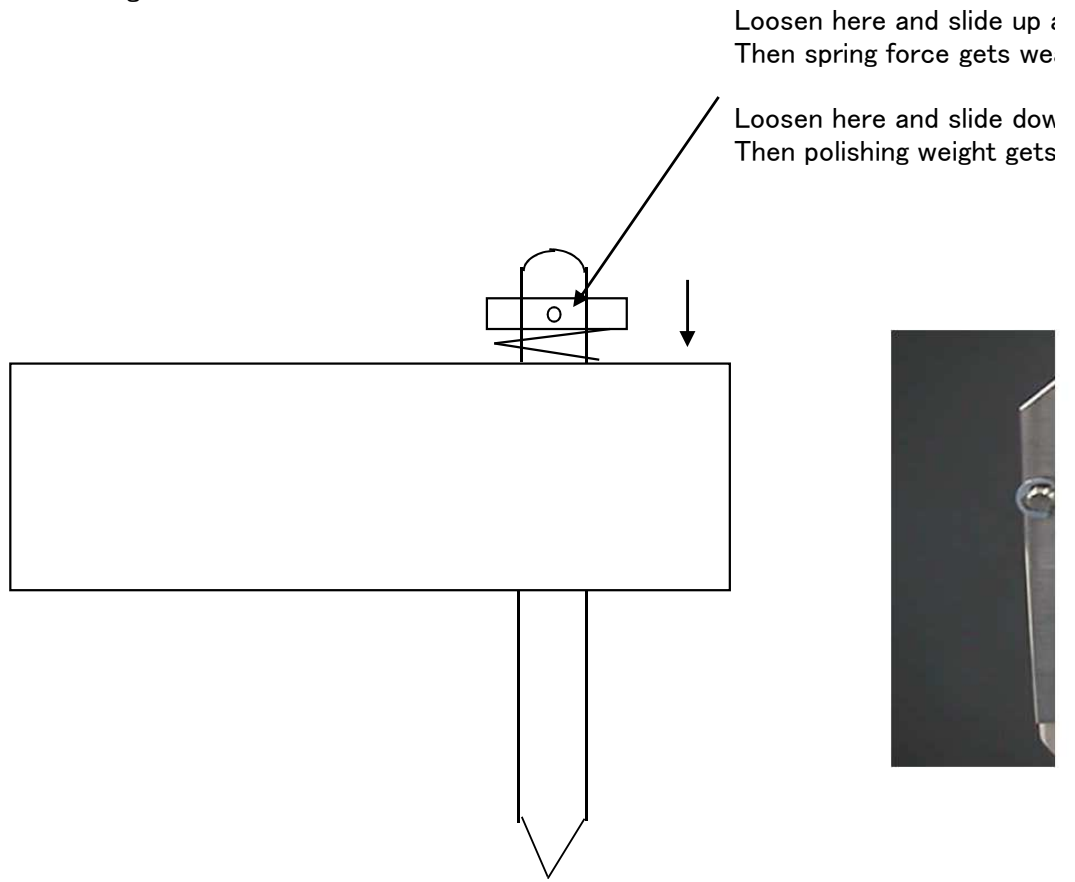
Liquid	Time	Speed	Pressure	Film Life
Purified water	0.5min	220rpm	500g	4 times

1g of these ferrules to polishing holder

ie.

OFL-12 pressure change

OFL-12/-12B Pressure change



2009.2.16

about 1mm
thicker and polishing weight gets increased => smaller ROC

r/n
; smaller

Fix by the stopping screw

