

SFP-70D2 Polishing Manual (IPC)

SC/FC/ST Connector / Ferrule, HPC Convex Polishing

Polishing Holder (IPC holder):
PH072-CP-2 (SC connector)
PH072-FP-2 (FC connector)
PH072-SP-2 (ST connector)
PH072-FF-2 (2.5mm ferrule)

POLISHING PROCESS	POLISHING CONDITIONS			
	POLISHING PAD	POLISHING FILM (service life)	POLISHING LIQUID	POLISHING TIME (min)
ADHESIVE REMOVAL	PR07-500	GA07 (5)	None	0.3
ROUGH POLISHING	PR07-500	DR07 (15)	PL50	0.5
MIDDLE POLISHING	PR07-500	DM07 (15)	PL50	1.0
FINAL POLISHING	PR07-500	HF07 (2)	Distilled water	0.5
CLEANING	PR07-500	CF07 (30)	Distilled water	0.1

SC/FC Connector / Ferrule, APC Convex Polishing

Polishing Holder (IPC holder):

PH072-CP8A-2 (SC connector, Step ferrule)

PH072-CP8C-2 (SC connector, Conical ferrule)

PH072-FP8R-2 (FC connector, Step ferrule, Narrow key)

PH072-FP8N-2 (FC connector, Step ferrule, Wide key)

PH072-FP8RC-2 (FC connector, Conical ferrule, Narrow key)

PH072-FP8NC-2 (FC connector, Conical ferrule, Wide key)

PH072-FF8A-2 (2.5mm Step ferrule)

PH072-FF8C-2 (2.5mm Conical ferrule)

POLISHING PROCESS	POLISHING CONDITIONS			
	POLISHING PAD	POLISHING FILM (service life)	POLISHING LIQUID	POLISHING TIME (min)
ADHESIVE REMOVAL	PG07-490	GA07 (5)	Distilled water	1.0
ANGLE GLINDING	PG07-490	DR07 (15)	PL50	1.0(1~5times) 1.5(6~15times)
ROUGH POLISHING	PR07-500	DR07 (20)	PL50	0.5
MIDDLE POLISHING	PR07-500	DM07 (20)	PL50	0.5
FINAL POLISHING	PR07-500	HF07 (2)	Distilled water	0.5
CLEANING	PR07-500	CF07 (30)	Distilled water	0.1

LC/MU Connector / Ferrule, HPC Convex Polishing

Polishing Holder (IPC holder):
PH072-PL-2 (LC connector)
PH072-PM-2 (MU connector)

POLISHING PROCESS	POLISHING CONDITIONS			
	POLISHING PAD	POLISHING FILM (service life)	POLISHING LIQUID	POLISHING TIME (min)
ADHESIVE REMOVAL	PR07-500-90	GA07 (5)	None	0.5
FIRST POLISHING	PR07-500-90	DM07 (15)	PL50	0.5
FINAL POLISHING	PR07-500-90	HF07 (2)	Distilled water	1.0
CLEANING	PR07-500	CF07 (30)	Distilled water	0.1

LC Connector, Angled Convex Polishing (Tuning)

Polishing Holder (IPC holder):

HPC polishing (before tuning) PH07-PL-2 (LC plug)

APC polishing PH07-PL8A-2 (LC connector, 8° angled polishing)

Pre-tuning polishing procedure

POLISHING PROCESS	HPC POLISHING CONDITIONS (For tuning)			
	POLISHING PAD	POLISHING FILM (service life)	POLISHING LIQUID	POLISHING TIME (min)
ADHESIVE REMOVAL	PR07-500-90	GA07 (5)	None	0.2
FIRST POLISHING	PR07-500-90	DM07 (15)	PL50	0.5
FINAL POLISHING	PR07-500-90	HF07 (5)	Distilled water	1.0
CLEANING	PR07-500	CF07 (50)	Distilled water	0.1

After-tuning polishing procedure

ANGLED-CONVEX POLISHING PROCESS	APC POLISHING CONDITIONS			
	POLISHING PAD	POLISHING FILM (service life)	POLISHING LIQUID	POLISHING TIME (min)
ANGLED POLISHING	PG07-490-00	DR07 (15)	PL50	0.5
CONVEX SHAPING	PR07-500-70	DM07 (15)	PL50	0.5
FINAL POLISHING	PR07-500-70	HF07 (2)	Distilled water	1.0
CLEANING	PR07-500	CF07 (30)	Distilled water	0.1

Note: 1. The use of HF films more than 2 times may result in a higher frequency of ferrule scratching. However, this will not affect the tuning procedure

Note: 2. Make sure that angled polishing is done completely before convex polishing.

LC Connector, Angled Convex Polishing (No Tuning)

Polishing Holder (IPC holder):
PH07-PL8A-2 (LC connector, 8° angled polishing)

POLISHING PROCESS	POLISHING CONDITIONS			
	POLISHING PAD	POLISHING FILM (service life)	POLISHING LIQUID	POLISHING TIME (min)
ADHESIVE REMOVAL	PG07-490-00	GA07 (1)	None	0.3
ANGLED POLISHING	PG07-490-00	DR07 (15)	PL50	0.5
CONVEX SHAPING	PR07-500-70	DM07 (15)	PL50	0.5
FINAL POLISHING	PR07-500-70	HF07 (1)	Distilled water	1.0
CLEANING	PR07-500	CF07 (30)	Distilled water	0.1

Note: 1. Make sure that angled polishing is done completely before convex polishing.

MU Connector, Angled Convex Polishing (Tuning)

Polishing Holder (IPC holder):

HPC polishing (before tuning) PH07-FLM-2 (D1.25mm Ferrule)

APC polishing PH07-PM8A-2 (MU connector, 8° angled polishing)

Pre-tuning polishing procedure

RIGHT-ANGLED CONVEX POLISHING PROCESS	HPC POLISHING CONDITIONS (For Tuning)			
	POLISHING PAD	POLISHING FILM (service life)	POLISHING LIQUID	POLISHING TIME (min)
ADHESIVE REMOVAL	PR07-500-90	GA07 (1)	None	0.2
FIRST POLISHING	PR07-500-90	DM07 (15)	PL50	0.5
FINAL POLISHING	PR07-500-90	HF07 (5)	Distilled water	1.0
CLEANING	PR07-500	CF07 (50)	Distilled water	0.1

After-tuning polishing procedure

ANGLED-CONVEX POLISHING PROCESS	APC POLISHING CONDITIONS			
	POLISHING PAD	POLISHING FILM (service life)	POLISHING LIQUID	POLISHING TIME (min)
ANGLED POLISHING	PG07-490-00	DR07 (15)	PL50	0.5
CONVEX SHAPING	PR07-500-70	DM07 (15)	PL50	0.5
FINAL POLISHING	PR07-500-70	HF07 (1)	Distilled water	1.0
CLEANING	PR07-500	CF07 (30)	Distilled water	0.1

Note: 1. The use of HF films more than 2 times may result in a higher frequency of ferrule scratching. However, this will not affect the tuning procedure.

Note: 2. Make sure that angled polishing is done completely before convex polishing.

MU Connector, Angled Convex Polishing (No Tuning)

Polishing Holder (IPC holder):
PH07-PM8A-2 (MU connector, 8° angled polishing)

POLISHING PROCESS	POLISHING CONDITIONS			
	POLISHING PAD	POLISHING FILM (service life)	POLISHING LIQUID	POLISHING TIME (min)
ADHESIVE REMOVAL	PG07-490-00	GA07 (1)	None	0.3
ANGLED POLISHING	PG07-490-00	DR07 (15)	PL50	0.5
CONVEX SHAPING	PR07-500-70	DM07 (15)	PL50	0.5
FINAL POLISHING	PR07-500-70	HF07 (1)	Distilled water	1.0
CLEANING	PR07-500	CF07 (30)	Distilled water	0.1

Note: 1. Make sure that angled polishing is done completely before convex polishing.