













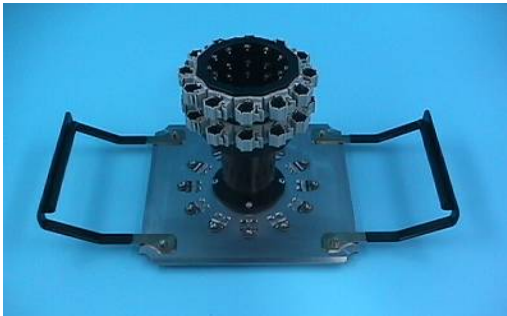
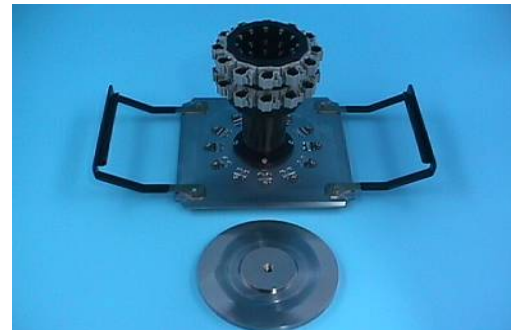


**■ Introduction of Universal MIL Ferrule Holder for SFP-560A**
**Various MIL Ferrule**

Type	O.D	Length	Pedestal	MIL	Glennair
	1.0	5.2	0.4		181-065
	1.25	5.7	0.6		
	1.25	4.1	1.0		
	1.25	5.0	0.6		ARINC 801
	1.25	5.1	1.0		181-056
	1.25	6.0	1.0		
	1.6	4.1	1.0	29504/5	181-001
	1.6	6.7	1.0	29504/4	181-002
	1.6	4.1	1.0		181-011
	1.6	7.1	1.0		
	2.0	4.0	0.55	29504/15	181-040
	2.0	4.2	0.55	29504/14	181-039
	2.5	7.3	2.0		
	2.5	6.4	1.7		181-050

**Introduction of Polishing Holders**
**PH55-F0423-210**

**PH55-F0423-210B (with Setting jig)**

**PH55-F0423-210A (with CMH)**

**PH55-F0423-210C (with CMH and Setting jig)**


- Ferrule OD is acceptable from D1.0mm to D2.5mm
- Ferrule installation is 1) insert ferrule until hard stop of the ferrule flange with the top surface of the holder's V-groove 2) and then tighten V-block with torque wrench (20cNm).
- Acceptable ferrule length is from 4.0mm to 6.35mm (No upper limit if setting jig is used)
- Within the above ferrule length range, adhesive removal can be done by machine polishing.
- Ferrule length more than 6.35mm, install ferrule with the Setting jig. Then adhesive removal need to be done manually before installing the ferrule to the polishing holder.

## Polishing

Polishing pressure is determined by size of pedestal diameter not ferrule O.D.  
Below introduces reference polishing process for each pedestal types.

### Polishing process and Test

#### 1. Process for pedestal diameter D0.6mm

Polisher **SFP-560A**

Holder **PH55-F0423-210**

Installation **Insert ferrule until hard stop of the ferrule flange against the top surface of the V-groove.**

NOTE **If ferrule length is more than 6.35mm, use the Setting jig.**

**Conduct adhesive removal manually before installing ferrule.**

#### Process

	Pad	Film	Liquid	Speed (rpm)	Time (sec)	Press(N) / Capacity	Press. Mode
1st Step	PR5X-500-85	GA5D	D.I, Water	110	20	20/24	R-up
2nd Step	PR5X-500-85	DH5D-3U	D.I, Water	110	40	20/24	DPC
3rd Step	PR5X-500-85	DJ5D-1U	D.I, Water	110	40	20/24	DPC
Final Step	PR5X-500-85	XF5D	D.I, Water	110	40	20/24	DPC

#### Geometry Result

	PASS/FAIL	ROC (mm)	Fiber Height (um)	Apex Offset (um)
1	TRUE	12.0	-7.5	21.7
2	TRUE	12.2	-4.1	32.1
3	TRUE	10.5	-2.6	13.1
4	TRUE	12.2	-4.5	12.7
5	TRUE	13.0	-8.2	49.8
6	TRUE	17.4	-7.6	36.4
7	TRUE	12.9	10.0	22.0
8	TRUE	14.6	3.5	37.2
9	TRUE	12.1	12.3	20.6
10	TRUE	12.8	8.6	35.6
11	TRUE	13.9	7.8	19.1
12	TRUE	14.1	4.5	33.7
13	TRUE	13.9	7.3	27.7
14	TRUE	14.1	3.5	25.7
15	TRUE	13.7	5.1	16.0
16	TRUE	14.0	3.7	14.9
17	TRUE	13.2	-10.1	12.3
18	TRUE	14.1	2.6	15.0
19	TRUE	13.0	6.8	16.1
20	TRUE	13.1	-0.1	17.2
21	TRUE	11.0	6.5	18.7
22	TRUE	12.4	2.5	16.2
23	TRUE	11.7	4.2	21.0
24	TRUE	12.5	2.3	25.3
	AVE	13.1	1.9	23.3
	STD	1.3908237	6.19973415	9.69034074
	MAX	17.4	12.3	49.8
	MIN	10.5	-10.1	12.3

## 2. Process for pedestal diameter D1.0mm

**Polisher** SFP-560A

**Holder** PH55-F0423-210

**Installation** Insert ferrule until hard stop of the ferrule flange against the top surface of the V-groove.

**NOTE** If ferrule length is more than 6.35mm, use the Setting jig.

Conduct adhesive removal manually before installing ferrule.

### Process

	Pad	Film	Liquid	Speed(rpm)	Time (sec)	Press(N) / Capacity	Press. Mode
1st Step	PR5X-500-80	GA5D	D.I, Water	110	20	40/24	R-up
2nd Step	PR5X-500-80	DR5D-9U	D.I, Water	110	40	40/24	DPC
3rd Step	PR5X-500-80	DJ5D-1U	D.I, Water	110	40	40/24	DPC
Final Step	PR5X-500-80	XF5D	D.I, Water	110	40	40/24	DPC

### Geometry Result

	PASS/FAIL	ROC (mm)	Fiber Height (um)	Apex Offset (um)
1	TRUE	13.9	17.3	21.9
2	TRUE	14.2	13.3	36.2
3	TRUE	13.9	10.5	5.7
4	TRUE	14.0	5.8	8.1
5	TRUE	13.4	6.4	11.1
6	TRUE	13.9	2.1	12.5
7	TRUE	13.0	4.2	11.9
8	TRUE	13.3	-2.5	16.5
9	TRUE	12.6	4.7	3.8
10	TRUE	13.0	3.0	12.1
11	TRUE	12.7	9.0	5.4
12	TRUE	13.4	5.8	48.1
13	TRUE	12.4	8.0	16.2
14	TRUE	12.4	1.4	12.8
15	TRUE	11.7	2.3	8.6
16	TRUE	12.2	-3.8	5.7
17	TRUE	12.0	-5.7	8.9
18	TRUE	12.8	-7.7	12.7
19	TRUE	13.4	-8.0	11.1
20	TRUE	14.8	9.3	17.3
21	TRUE	13.8	-2.1	8.8
22	TRUE	14.4	-2.1	11.6
23	TRUE	14.1	12.4	37.1
24	TRUE	14.6	11.7	22.8
	AVE	13.3	4.0	15.3
	STD	0.85419348	6.8687093	10.988208
	MAX	14.8	17.3	48.1
	MIN	11.7	-8.0	3.8

### 3. Process for pedestal diameter D2.0mm

This time polishing was done with the Setting jig to show how it is done.

**Polisher** SFP-560A

**Holder** PH55-F0423-210B

**Installation** Conduct adhesive removal manually before installing ferrule.

Insert ferrule until hard stop of the ferrule against the Setting jig.

#### Process

	Pad	Film	Liquid	Speed(rpm)	Time (sec)	Press(N) / Capacity	Press. Mode
1st Step	PR5X-500-80	DR5D-9U	D.I, Water	110	40	120/24	DPC
2nd Step	PR5X-500-80	DJ5D-1U	D.I, Water	110	40	120/24	DPC
Final Step	PR5X-500-80	XF5D	D.I, Water	110	40	120/24	DPC

#### Geometry Result

	PASS/FAIL	ROC (mm)	Fiber Height (um)	Apex Offset (um)
1	TRUE	14.8	-8.9	13.0
2	TRUE	14.9	-13.0	4.4
3	TRUE	16.5	4.2	33.8
4	TRUE	15.8	1.6	45.1
5	TRUE	16.3	7.0	11.9
6	TRUE	16.8	8.7	7.9
7	TRUE	17.2	15.4	22.3
8	TRUE	17.7	13.2	37.6
9	TRUE	17.2	5.1	22.9
10	TRUE	17.1	-7.8	19.8
11	TRUE	16.4	-10.6	3.3
12	TRUE	16.4	-12.8	4.3
13	TRUE	16.2	-19.4	15.9
14	TRUE	15.7	-20.8	24.0
15	TRUE	15.0	-22.6	16.6
16	TRUE	14.9	-23.8	17.7
17	TRUE	14.7	-8.8	21.3
18	TRUE	15.3	-13.3	16.0
19	TRUE	15.0	-5.9	9.9
20	TRUE	15.6	-17.5	11.6
21	TRUE	15.2	-20.2	12.3
22	TRUE	16.0	-19.5	16.9
23	TRUE	15.0	-17.5	21.3
24	TRUE	14.8	-14.7	18.4
	AVE	15.9	-8.4	17.8
	STD	0.90755326	11.9068226	10.1561579
	MAX	17.7	15.4	45.1
	MIN	14.7	-23.8	3.3

#### Caution for Handling

All V-blocks shall be tighten even unused channels.

This is to prevent unwilling disassembly of composing parts by air blow during cleaning.



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