



**OFL-11/OFL-12**

**POLISHING SPECIFICATIONS**

## NEW POLISHING TECHNOLOGIES FOR OFL-11 & OFL-12

Dear Sirs,

On the below shown table we listed up all polishing technologies which are now available for our polishing machines OFL-11 & OFL-12.

Our latest developed technologies are for UPC and Advanced PC polishing.

Attached you can find some further documentation on the various polishing methods.

### POLISHING SPECIFICATIONS FOR OFL-11 & OFL-12

Polishing Shape	I/L	R/L	Fibre undercut	Radius (mm)	Fibre Offset (mm)
SPC	< 0.5 dB	> 40 dB	< 0.1 um	10 - 25 mm	< 50 um
UPC	< 0.5 dB	> 50 dB	< 0.1 um	10 - 25 mm	< 50 um
Advanced PC	< 0.5 dB	> 40 dB*	< 0.05 um	10 - 25 mm	< 50 um
Angle Flat (8 degree)	-	> 60 dB	-	-	-
Angle PC (8 degree)	< 0.5 dB	> 60 dB	< 0.1 um	10 - 25 mm	< 50 um

\* random mating R/L measurements

**Please inform all your customers about these innovations.**

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Zirconia ferrule R20 polishing(Standard)

- Applied ferrule:SII Zirconia ferruleφ2.5mm
- Polishing shape:R20 SPC

Standard consumer supplies kit (For 1200 ferrules)

No	Part name	Model No.	Price	Q'ty
OFL-11 Standard consumer supplies kit		110-S-001		---
CON- TENT	1 Polishing fluid(Finishing)	110-A-001		1 SET (2 PIECES)
	2 Polishing film(Adhesive removal)	110-W-001		1 SET (100 SHEETS)
	3 Polishing film(Grinding)	110-W-002		1 SET (10 SHEETS)
	4 Polishing film(Polishing)	110-W-003		1 SET (10 SHEETS)
	5 Polishing film(Finishing)	110-W-004		1 SET (10 SHEETS)

Standard polishing process

Polishing step	Holding jig Polishing disk	Polishing film	Polishing fluid	Thrust (Std.)	Polishing time(Std.)	Polishing film life
1 Adhesive removal (hand polishing)	Holding jig 110-J-001 Adhesive removal pad 110-O-001	For adhesive removal 110-W-001	None	Approx. 1~2 Kg ※	0.5 min	Dispose of every time (max. 12 ferrules)
2 Grinding	Holding jig 110-J-001 Polishing disk 110-D-001	For grinding 110-W-002	Water	Point 1 ※	1.5 min	10 times (max. 120 ferrules)
3 Polishing		For polishing 110-W-003	Water	Point 2 ※	1.5 min	10 times (max. 120 ferrules)
4 Finishing		For finishing 110-W-004	Polishing fluid 110-A-001	Point 2 ※	1 min	10 times (max. 120 ferrules)

※In case of 12 ferrules polishing.

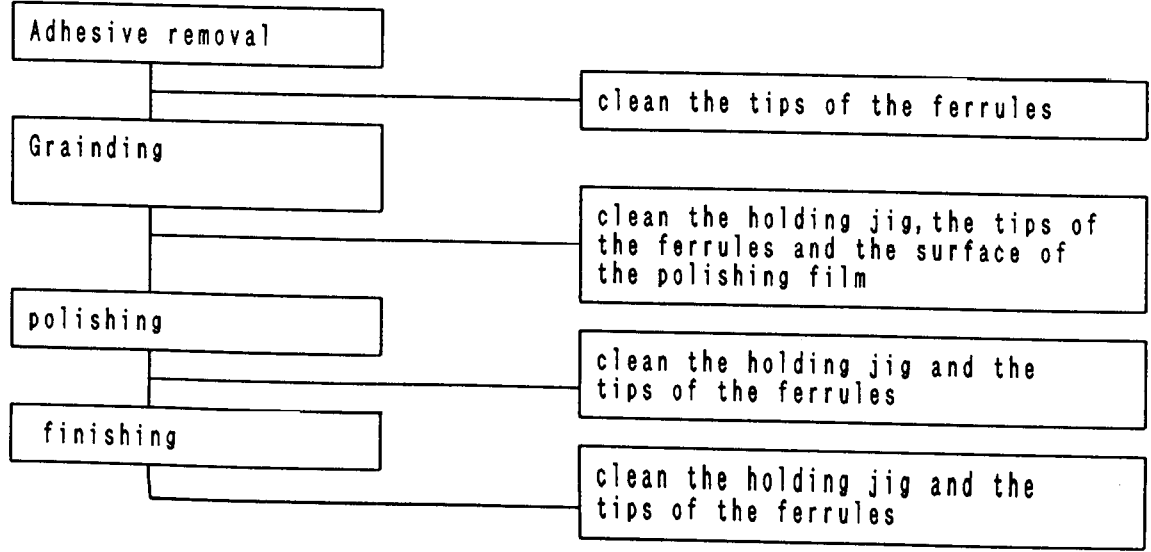
# Reference FIBER UNDER CUT $\leq 0.05 \mu\text{m}$ , R/L $\geq 40\text{dB}$ POLISHING CONDITION (OFL-11)

Polishing Step	Polishing Film	Polishing Fluid	Thrust (std.)	Polishing Time (Std.)	Polishing Film Life
Adhesive removal	adrasive paper (110-w-001 standard)	none	approx. 1 to 2kg (2.2 to 4.4 lbs)	0.5min.	dispose of every time (max. 12 ferrules)
Grainding	green label (110-w-002 standard)	water ... approx. 2ml	Point 1 (10,12) Point 2 (8)	1.5min.	10 times (max. 120 ferrules)
Polishing	yellow label (110-w-003 standard)	water ... approx. 2ml	Point 2 (10,12) Point 3 (8 pieces)	1.5min.	10 times (max. 120 ferrules)
Polishing-2	none label (BROWN film) (KJW101000 option)	*Polishing fluid (80-A-001 option) ... approx. 3.5ml	Point 2 (10,12) Point 3 (8 pieces)	2.0min.	(10 times) (max. 120 ferrules)
Finishing	none label (White film) (KJW101100 option)	*Polishing fluid D (KJA100400 option) ... approx. 3.5ml	Point 1 (10,12) Point 2 (8 pieces)	3.0min.	dispose of every time (max. 12 ferrules)

the number of mounted ferrules - 8 to 12  
 (If you have less than eight ferrules to polish, use dummy and/or unusable ferrules so there are atleast eight ferrules mounted in the holding fixure.)

\* Polishing fluid 80-A-001 and D... Evenly to put polishing fluid about 10mm from the edge of the polishing disk

## OPERATIONAL PROCEDURE



Detail - See instruction manual

# (REFERENCE) FOR UPC PREDOME FERRULE POLISHING CONDITION)

Polishing Step	Polishing Film	Polishing Fluid	Thrust (std.)	Polishing Time (Std.)	Polishing Film Life
Adhesive removal	adrasive paper (110-w-001 standard)	none	approx. 1 to 2kg (2.2 to 4.4 lbs)	0.5min.	dispose of every time (max. 12 ferrules)
Polishing	yellow label (110-w-003 standard)	water approx. 2ml	Point 2 (12 pieces)	1.5min.	10 times (max. 120 ferrules)
Finishing	none label (BROWN film) (110-w-010 option)	*Polishing fluid D (110-A-004 option) approx. 2ml	Point 2 (12 pieces)	3.0min.	10 times (max. 120 ferrules)

the number of mounted ferrules - 6 to 12  
 (If you have less than ten ferrules to polish, use dummy and/or unusable ferrules so there are atleast ten ferrules mounted in the holding fixure.)

\* Polishing fluid D and 80-A-001... Evenly to put polishing fluid about 10mm from the edge of the polishing disk surface which is get wet with water



\* If there are any defects, see the notes below for the defects and correction procedures

1. speckles

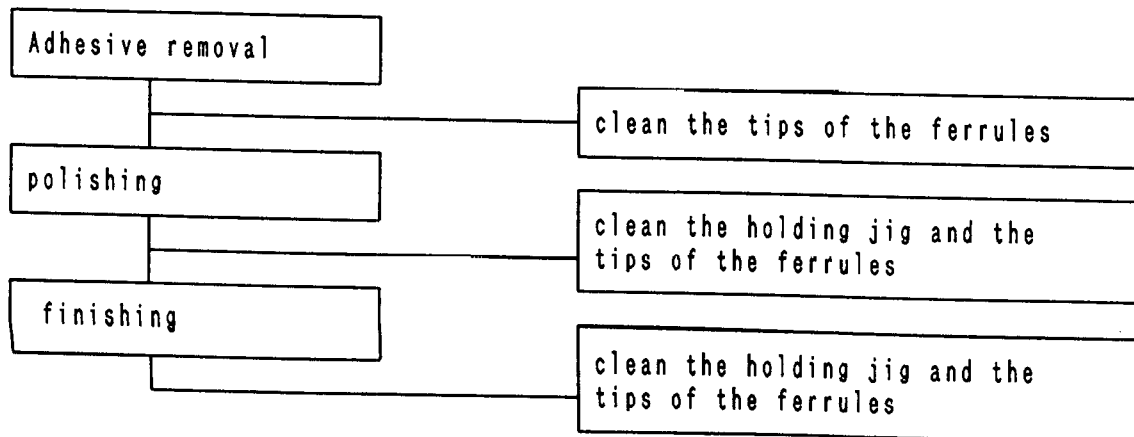


problem:  
 ferrule-fiber maching is not so good  
 procedure:  
 between polishing and finishing,  
 add process  
 · polishing film 110-w-010  
 · life reference 10cycles  
 · polishing fluid 80-A-001  
 · polishing time 2min

2. RETURN LOSS LESS THAN (50dB)

problem:  
 see instruction manual  
 procedure:  
 repolish finishing 1 min  
 or finishing polishing time  
 change 4min

## OPERATIONAL PROCEDURE



OFL-11 12

UPC polishing

- Applied ferrule:SII Zirconia ferruleφ2.5mm
- Polishing shape:R20 UPC

UPC polishing consumer

No	Part name	Model No.	Price	Q'ty
1	Polishing fluid(Finishing)	KJA100400		1 SET (2 PIECES)
2	Polishing film(Finishing)	KJW101000		1 SET (10 SHEETS)

UPC polishing process

Polishing step		Holding jig Polishing disk	Polishing film	Polishing fluid	Thrust (Std.)	Polishing time(Std.)	Polishing film life
1	Adhesive removal (hand polishing)	Holding jig 110-J-001 Adhesive removal pad 110-O-001	For adhesive removal 110-W-001	None	Approx. 1~2 Kg ※	0.5 min	Dispose of every time (max. 12 ferrules)
2	Grinding	Holding jig 110-J-001 Polishing disk 110-D-001	For grinding 110-W-002	Water	Point 1 ※	1.5 min	10 times (max. 120 ferrules)
3	Polishing		For polishing 110-W-003	Water	Point 2 ※	1.5 min	10 times (max. 120 ferrules)
4	Finishing		For finishing KJW101000	Polishing fluid KJA100400	Point 2 ※	3.0min	10 times (max. 120 ferrules)

※In case of 12 ferrules polishing.

# FOR ZrO<sub>2</sub> CAPILLARY PREDOME FERRULE

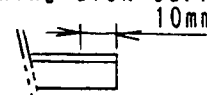
## POLISHING CONDITION (REFERENCE)

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Polishing Step	Polishing Film	Polishing Fluid	Thrust (std.)	Polishing Time (Std.)	Polishing Film Life
Adhesive removal	adrasive paper (110-w-001 standard)	none	approx. 1 to 2kg (2.2 to 4.4 lbs)	0.5min.	dispose of every time (max. 12 ferrules)
Polishing	none label (110-w-006 option)	*Polishing fluid (80-A-001 option) ...approx. 2ml	Point 3 (12 pieces)	3.5min.	1 or 2 times (max. 24 ferrules)
Finishing	none label (BROWN film) (KJW101000 option)	*Polishing fluid A (110-A-001 standard) ...approx. 2ml	Point 3 (12 pieces)	3.0min.	10 times (max. 120 ferrules)

the number of mounted ferrules ~ 10 to 12  
 (If you have less than ten ferrules to polish, use dummy and/or unusable ferrules so there are atleast ten ferrules mounted in the holding fixure.)

\* Polishing fluid A and 80-A-001... Evenly to put polishing fluid about 10mm from the edge of the polishing disk surface which is get wet with water



\* If there are any defects, see the notes below for the defects and correction procedures  
 1. speckles

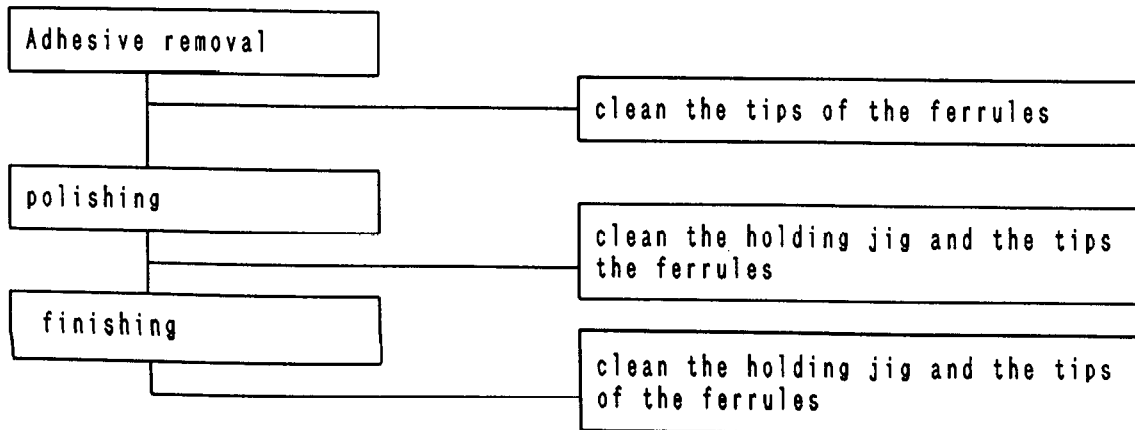
problem: ferrule-fiber maching is not so good  
 procedure: between polishing and finishing, add process



- polishing film KJW101000
- polishing fluid 80-A-001

- life reference 10cycles
- polishing time 2min

## OPERATIONAL PROCEDURE



Detail ~ See instruction manual

# OFL-11 Alumina capillary ferrule R20 polishing

■Applied ferrule: SII Alumina ceramic capillary type  $\phi 2.5\text{mm}$   
■Polishing shape: R20 SPC

Consumer supplies kit (For 1200 ferrules)

No	Part name	Model No.	Price	Q'ty
OFL-11 Consumer supplies kit for alumina ceramic capillary ferrule.		110-S-002		---
CON- TENT	1 Polishing fluid(Finishing)	110-A-001		1 SET (2PIECES)
	2 Polishing fluid C (Polishing)	110-A-003		1 SET (2PIECES)
	3 Polishing film(Adhesive removal)	110-W-001		1 SET (100SHEETS)
	4 Polishing film(Grinding)	110-W-005		1 SET (10SHEETS)
	5 Polishing film(Polishing)	110-W-006		1 SET (100SHEETS)
	6 Polishing film(Finishing)	KJW101000		2SETS (20SHEETS)
	7 Instruction manual	110-O-M03		1VOL.

## Polishing process

Polishing step	Holding jig Polishing disk	Polishing film	Polishing fluid	Thrust (Std.)	Polishing time(Std.)	Polishing film life
1 Adhesive removal (hand polishing)	Holding jig 110-J-001 Adhesive removal pad 110-O-001	For adhesive removal 110-W-001	None	Approx. 1~2 Kg ※	0.5 min	Dispose of every time (max. 12 ferrules)
2 Grinding	Holding jig 110-J-001 Polishing disk 110-D-001	For grinding 110-W-005	Water	Point 2 ※	2~6.5 min	10 times (max. 120 ferrules)
3 Polishing		For polishing 110-W-006	Polishing fluid C 110-A-003	Point 3 ※	7 min ※1	Dispose of every time (max. 12 ferrules)
4 Finishing		For finishing KJW101000	Polishing fluid 110-A-001	Point 2 ※	7 min	5 times (max. 60 ferrules)

※In case of 12 ferrules polishing.

※1 Resupply polishing fluid C in the middle of polishing.



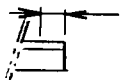
# Aluminum ceramic capillary ferrule

## POLISHING CONDITION (OFL-11)

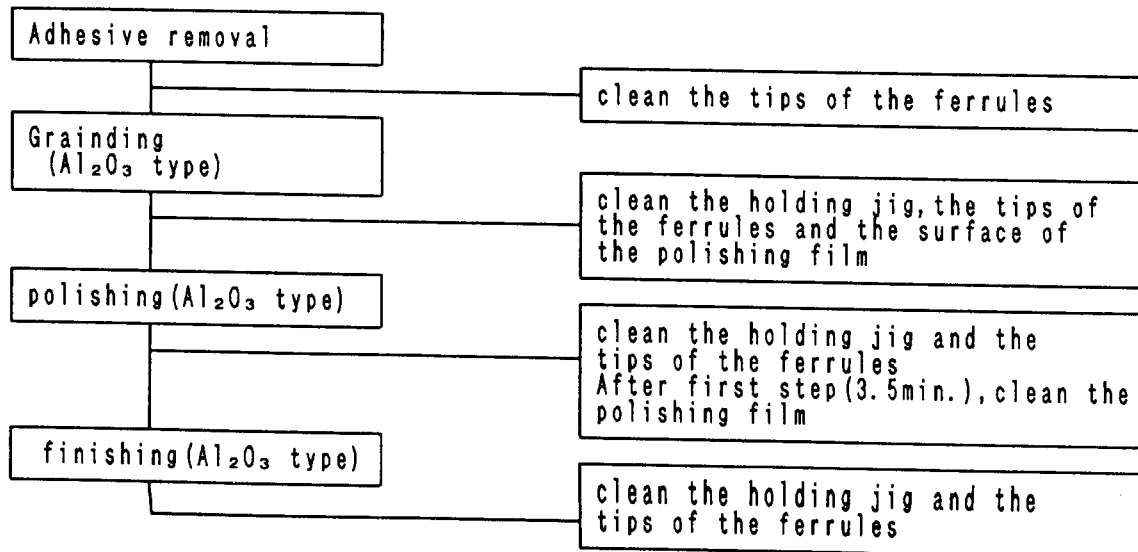
Polishing Step	Polishing Film	Polishing Fluid	Thrust (std.)	Polishing Time (Std.)	Polishing Film Life
Adhesive removal	adrasive paper (110-w-001 standard)	none	approx. 1 to 2kg (2.2 to 4.4 lbs)	0.5min.	dispose of every time (max. 12 ferrules)
Grainding (Al <sub>2</sub> O <sub>3</sub> type)	red lavel (110-w-005) option)	water ... approx. 4ml	Point 2	2~6.5min. Initial 2min. after every cycles, additi onal time is 0.5min.	10 times (max. 120 ferrules)
Polishing (Al <sub>2</sub> O <sub>3</sub> type)	none lavel (110-w-006 option)	*Polishing fluid C (110-A-003 option) ... approx. 1ml x 2TIMES	Point 3	3.5min. x 2TIMES First step Polishing fluid C 1ml 3.5min. Second step Polishing fluid C 1ml 3.5min.	dispose of every time (max. 12 ferrules)
Finishing (Al <sub>2</sub> O <sub>3</sub> type)	none lavel (BROWN film) (KJW101000 option)	*Polishing fluid A (110-A-001 standard) ... approx. 2ml	Point 2	7min.	dispose of 5 times (max. 60 ferrules)

\* Polishing fluid A and C ... Evenly to put polishing fluid about 10mm from the edge of the polishing disk

the number of mounted ferrules ~ 10 to 12  
(If you have less than ten ferrules to polish, use dummy and/or unusable ferrules so there are atleast ten ferrules mounted in the holding fixure.)



### OPERATIONAL PROCEDURE



Detail ~ Shall meet instruction manual

OFL-11  
Angled PC polishing (1/3)

- Applied ferrule: SZ-5A
- Polishing shape: Angled PC ( 8deg )
- Recommended Housing: SSC Series SC Housing  
SAP-3 FC Housing

Angled PC polishing set (Standard set) (With consumables for 600 ferrules )

No	Part name	Model No.	Price	Q'ty
Angled PC polishing set for OFL-11 (Standard set)		110-NK-001		---
CON- TENT	1 Holding jig for angled PC(8deg)	110-J-003		3 PIECES
	2 Polishing disk for flat polishing	110-D-002		1 PIECE
	3 Polishing disk for angled PC	110-D-003		2 PIECES
	4 Polishing fluid(Finishing) *	110-A-001		1 SET (2 PIECES)
	5 Polishing sheet(Rough grinding) *	110-W-007		1 SHEET
	6 Polishing film(Grinding) *	110-W-002		1 SET (10 SHEETS)
	7 Polishing film(Polishing) *	110-W-003		1 SET (10 SHEETS)
	8 Polishing film(Finishing) *	110-W-004		1 SET (10 SHEETS)
	9 Ball-end hex wrench	110-O-005		1 PIECE
	10 Setup stand	110-O-006		1 PIECE
	11 Instraction manual	110-O-M01		1 VOL.
	12 Carrying case	110-O-007		1 PIECE

\* Consumables

OFL-11  
Angled PC polishing (2/3)

- Applied ferrule: SZ-5A
- Polishing shape: Angled PC ( 8deg )
- Recommended Housing: SSC Series SC Housing  
SAP-3 FC Housing

Angled PC polishing set (Minimum set) (With consumables for  
600 ferrules )

No	Part name	Model No.	Price	Q'ty
Angled PC polishing set for OFL-11 (Minimum set)		110-NK-002		---
CON- TENT	1 Holding jig for angled PC(8deg)	110-J-003		1 PIECE
	2 Polishing disk for flat polishing	110-D-002		1 PIECE
	3 Polishing disk for angled PC	110-D-003		1 PIECE
	4 Polishing fluid(Finishing) ※	110-A-001		1 SET ( 2 PIECES)
	5 Polishing sheet(Rough grinding) ※	110-W-007		1 SHEET
	6 Polishing film(Grinding) ※	110-W-002		1 SET ( 10 SHEETS)
	7 Polishing film(Polishing) ※	110-W-003		1 SET ( 10 SHEETS)
	8 Polishing film(Finishing) ※	110-W-004		1 SET ( 10 SHEETS)
	9 Instraction manual	110-O-M02		1 VOL.

※ Consumables

# O F L - 1 1

## Angled PC polishing (3/3)

- Applied ferrule : SZ-5A
- Polishing shape : Angled PC ( 8deg )
- Recommended Housing : SSC Series SC Housing  
SAP-3 FC Housing

### Angled PC polishing process

Polishing step	Holding jig Polishing disk	Polishing film	Polishing fluid	Thrust (Std.)	Polishing time(Std.)	Polishing film life
1 Adhesive removal (hand polishing)	Holding jig 110-J-001 Adhesive removal pad 110-O-001	For adhesive removal 110-W-001	None	Approx. 1~2 Kg ※1	0.5 min	Dispose of every time (max. 12 ferrules)
2 PC Grinding	Holding jig 110-J-001  Polishing disk 110-D-001	For grinding 110-W-002	Water	Point 1 ※1	1.5 min	10 times (max. 120 ferrules)
3 PC Polishing		For polishing 110-W-003	Water	Point 2 ※1	1.5 min	10 times (max. 120 ferrules)
4 Key adjustment						
5 Rough grinding (Angled flat)	Holding jig for angled PC 110-J-003 Polishing disk for flat polishing 110-D-002	For rough grinding 110-W-007	Water	Point 1  ※2	2~4 min.	100 times (max. 600 ferrules)
6 Angled PC Grinding	Holding jig for angled PC 110-J-003  Polishing disk for angled PC 110-D-003	For grinding 110-W-002	Water	Point 2 ※2	3 min.	10 times (max. 60 ferrules)
7 Angled PC Polishing		For polishing 110-W-003	Water	Point 2 ※2	2 min.	10 times (max. 60 ferrules)
8 Angled PC finishing		For finishing 110-W-004	Polishing fluid 110-A-001	Point 2 ※2	1 min.	10 times (max. 60 ferrules)

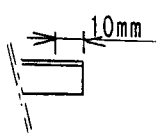
※1 In case of 12 ferrules polishing.  
※2 In case of 6 ferrules polishing.

# Aluminum ceramic capillary ferrule

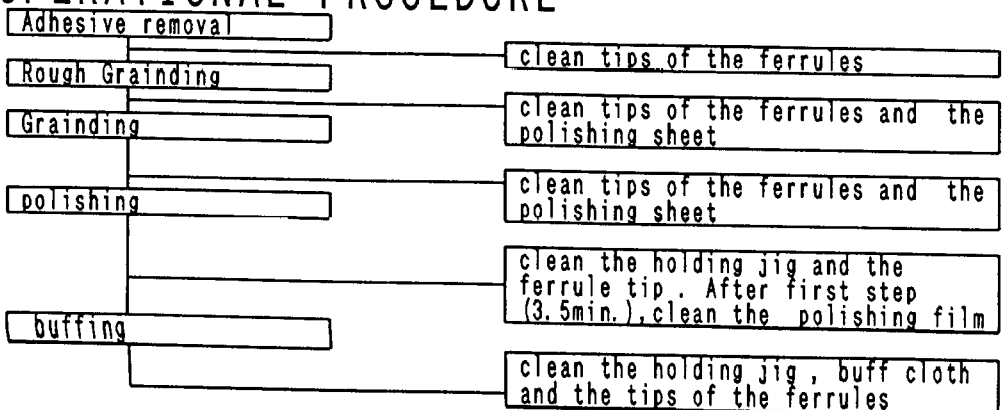
## 8° ANGLE FLAT POLISHING CONDITION (OFL-11, 12)

Polishing Step	Holding Jig/ Polishing Disk	Polishing Film and Sheet	Polishing Fluid	Thrust (std.)	Polishing Time (Std.)	Polishing Film Life
Adhesive removal	Holding Jig 110-J-001 Adhesive Removal Pad 110-O-001	adrasive paper (110-w-001 standard)	none	approx. 1 to 2kg (2.2 to 4.4 lbs)	0.5min.	dispoed of every time (max. 12 ferrules)
Rough Grainding (FLAT)	Holding Jig 110-J-001 Polishing Disk 110-D-002-- option	metal bond sheet (110-w-008) option)	water ...approx. 4ml	Point 1	1.5~5.5min. Initial 1.5min. after every 10cycles, additional time is 1.0 min.	50 times (max. 600 ferrules)
Grainding (8° ANGLE FLAT)	Holding Jig 110-J-003-- option Polishing Disk 110-D-002-- option	metal bond sheet (110-w-008) option)	water ...approx. 4ml	Point 1	0.5~1.0min.	50 times (max. 300 ferrules)
Polishing (8° ANGLE FLAT)	Holding Jig 110-J-003-- option Polishing Disk 110-D-002-- option	none label (110-w-006) option) fix center of film with both sides tape	*Polishing fluid C (110-A-003) option) ...approx. 1ml × 2TIMES	Point 1	5.0min. × 2TIMES First step Polishing fluid C 1ml 5.0min. Second step Polishing fluid C 1ml 5.0min.	dispose of every time (max. 6 ferrules)
Buffing (8° ANGLE FLAT)	Holding Jig 110-J-003-- option Polishing Disk 110-D-002-- option	Buff cloth (110-w-009) option)	*Polishing fluid A (110-A-001) standard) ...approx. 2ml	Point 1	3.0min.	dispose of 10 times (max. 60 ferrules)

\* water ...mix a little surface-active agent (e.g. detergent); prevent life down of metal bond sheet  
 \* Polishing fluid A and C ...Evenly to put polishing fluid about 10mm from the edge of the polishing disk  
 the number of mounted ferrules (holding jig 110-J-003) ~ 6 ferrules  
 (If you have less than six ferrules to polish, use dummy and/or unusable ferrules so there are atleast six ferrules mounted in the holding fixure.)



### OPERATIONAL PROCEDURE



Detail...shall meet instruction manual

OFL-11  
D4 ferrule R20 polishing

- Applied ferrule:SII Zirconia ceramic capillary type  $\phi$ 2.0mm(SDP-1Z)
- Polishing shape:R20 SPC

Option for D4 ferrule polishing

Part name	Model No.	Price	Q'ty
Holding jig for D4	110-J-002		1 Piece

Polishing disk and Consumables are standard.

D4 ferrule polishing process

Polishing step	Holding jig Polishing disk	Polishing film	Polishing fluid	Thrust (Std.)	Polishing time(Std.)	Polishing film life
1 Adhesive removal (hand polishing)	Holding jig for D4 110-J-002 Adhesive removal pad 110-O-001	For adhesive removal 110-W-001	None	Approx. 1~2 Kg ※	0.5 min	Dispose of every time (max. 12 ferrules)
2 Grinding	Holding jig for D4 110-J-002 Polishing disk 110-D-001	For grinding 110-W-002	Water	Point 2 ※	2 min	5 times (max. 60 ferrules)
3 Polishing		For polishing 110-W-003	Water	Point 3 ※	2 min	5 times (max. 60 ferrules)
4 Finishing		For finishing 110-W-004	Polishing fluid 110-A-001	Point 2 ※	2 min	5 times (max. 60 ferrules)

※In case of 12 ferrules polishing.

# FOR D4 PREDOME FERRULE UPC POLISHING CONDITION

## \* REFERENCE

94 4/20

Polishing Step	Polishing Film	Polishing Fluid	Thrust (std.)	Polishing Time (Std.)	Polishing Film Life
Adhesive removal	adrasive paper (110-w-001 standard)	none	approx. 1 to 2kg (2.2 to 4.4 lbs)	0.5min.	dispose of every time (max. 12 ferrules)
Polishing	yellow label (110-w-003 standard)	water ... approx. 2ml	Point 3 (12 pieces)	2.0min.	5 times (max. 60 ferrules)
Finishing	none label (BROWN film) (110-w-010 option)	*Polishing fluid D (110-A-004 option) ... approx. 2ml	Point 2 (12 pieces)	3.5min.	5 times (max. 60 ferrules)

the number of mounted ferrules -- 12  
 (If you have less than twelve ferrules to polish, use dummy and/or unusable ferrules so there are atleast twelve ferrules mounted in the holding fixure.)

\* Polishing fluid D and 80-A-001 ... Evenly to put polishing fluid about 10mm from the edge of the polishing disk surface which is get wet with water

\* If there are any defects, see the notes below for the defects and correction procedures

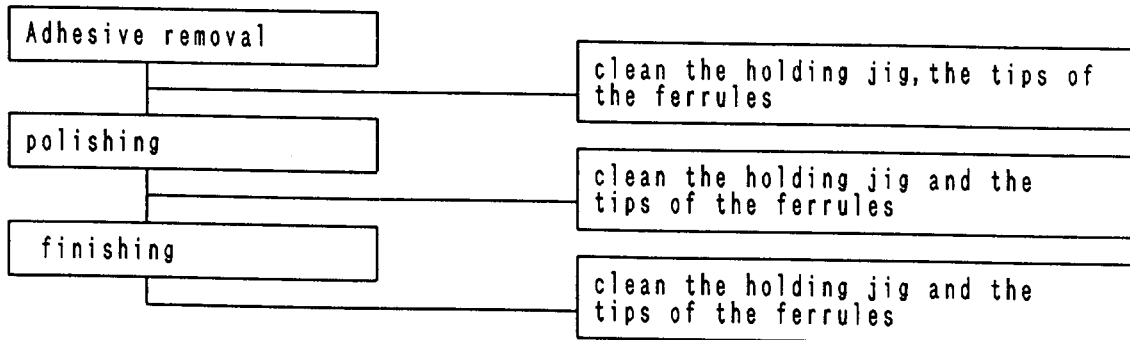
### 1. speckles

problem:  
 ferrule-fiber maching is not so good  
 procedure:  
 between polishing and finishing,  
 add process  
 · polishing film 110-w-010  
 · life reference 5cycles  
 · polishing fluid 80-A-001  
 · polishing time 2.5min  
 · THRUST POINT 3

### 2. RETURN LOSS LESS THAN (50dB)

problem:  
 see instruction manual  
 procedure:  
 repolish finishing 1 min  
 or finishing polishing time  
 change 4.5min

## OPERATIONAL PROCEDURE



Detail -- See instruction manual

# FOR D4 FERRULE UPC POLISHING CONDITION

## \*REFERENCE

94 4/20

Polishing Step	Polishing Film	Polishing Fluid	Thrust (std.)	Polishing Time (Std.)	Polishing Film Life
Adhesive removal	adrasive paper (110-w-001 standard)	none	approx. 1 to 2kg (2.2 to 4.4 lbs)	0.5min.	dispoede of every time (max.12 ferrules)
Grainding	green level (110-w-002 standard)	water ...approx. 2ml	Point 2 (12 pieces)	2.0min.	5 times (max.60 ferrules)
Polishing	yellow label (110-w-003 standard)	water ...approx. 2ml	Point 3 (12 pieces)	2.0min.	5 times (max.60 ferrules)
Finishing	none label (BROWN film) (110-w-010 option)	*Polishing fluid D (110-A-004 option) ...approx. 2ml	Point 2 (12 pieces)	3.5min.	5 times (max.60 ferrules)

the number of mounted ferrules = 12  
 (If you have less than twelve ferrules to polish, use dummy and/or unusable ferrules so there are atleast twelve ferrules mounted in the holding fixure.)

- \* Polishing fluid D and 80-A-001... Evenly to put polishing fluid about 10mm from the edge of the polishing disk surface which is get wet with water
- \* If there are any defects, see the notes below for the defects and correction procedures

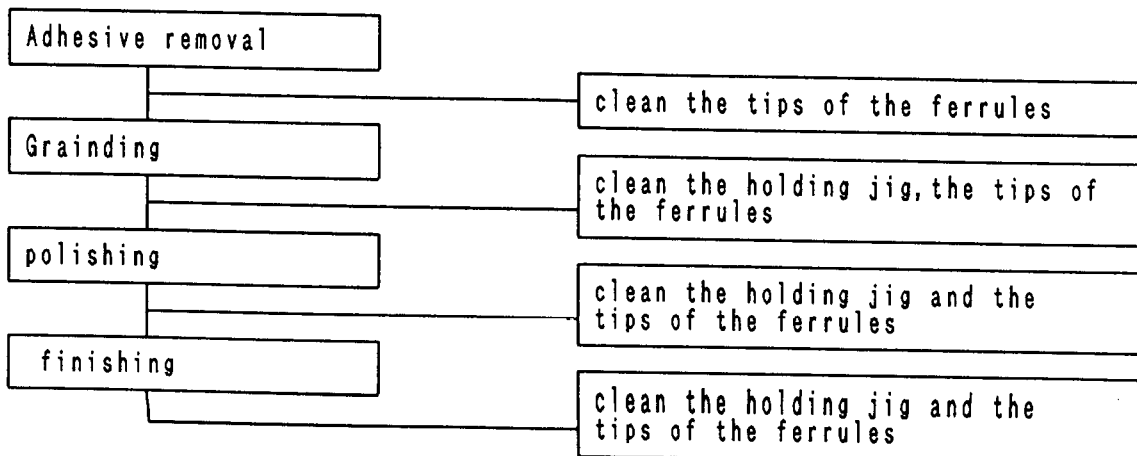
### 1. speckles

problem:  
 ferrule-fiber maching is not so good  
 procedure:  
 between polishing and finishing,  
 add process  
 · polishing film 110-w-010  
 · life reference 5 cycles  
 · polishing fluid 80-A-001  
 · polishing time 2.5min  
 · thrust point 3

### 2. RETURN LOSS LESS THAN (50dB)

problem:  
 see instruction manual  
 procedure:  
 repolish finishing 1 min  
 or finishing polishing time  
 change 4.5min

## OPERATIONAL PROCEDURE



Detail - See instruction manual



**SF-1A FLAT POLISHING CONDITIONS**

**FLAT POLISHING WITH OFL-11 OFL-12**

**SF-1A-SX SZ-1A-SX**

Polishing Proces	Holding Jig Polishing Plate	Sheet	Agent	Weight	Polishing Time	Life time of Polishing Film
<b>Adhesive Removal</b>	110-J-001 110-0-001	110-W-001	none	1 - 2 kg	0.5 minutes	only to be used once
<b>Grinding</b>	110-J-001 110-D-002	110-W-008	water 4 ml	point 1	1.5 minutes  increase of 1 minute after usage of 10 times	can be used 50 times
<b>Polishing</b>	110-J-001 110-D-002	*110-W-006	110-A-003 2 ml	point 1	5 minutes x 2 1 ml agent each time	only to be used once
<b>Buffing</b>	110-J-001 110-D-002	110-W-009	110-A-001 2 ml	point 1	7 minutes	can be used 10 times

**SZ-1A FLAT POLISHING CONDITIONS**

Polishing Proces	Holding Jig Polishing Plate	Sheet	Agent	Weight	Polishing Time	Life time of Polishing Film
<b>Adhesive Removal</b>	110-J-001 110-0-001	110-W-001	none	1 - 2 kg	0.5 minutes	can only be used once
<b>Rough Grinding</b>	110-J-001  110-D-002	110-W-008	water 4 ml	  point 1	1.5 minutes  increase of 1 minute after 10 times	can be used 50 times
<b>Grinding</b>	110-J-001 110-D-002	*110-W-002	water 2 ml	point 1	2 minutes	can be used 10 times
<b>Polishing</b>	110-J-001 110-D-002	*110-W-003	water 2 ml	point 1	2 minutes	can be used 10 times
<b>Buffing</b>	110-J-001 110-D-002	110-W-009	110-A-001 2 ml	point 1	7 minutes	can be used 10 times

\* Note: Please attach a sheet to polishing disk on both sides. It must be taped to the centre.  
Polishing agent must be applied about 10 mm inside the polishing disk all around.