

# 3M™ Lapping Film 865X

## Final Polish for Fiber Optic Connectors

### Product Description

3M™ Lapping Film 865X consists of precision coated silica on a polyester film. This long lived product produces high quality connectors that meet Telecoria standards.

### Applications

Lapping Film 865X is used as the final polishing step for fiber optic connectors. It can also be used for lapping and polishing small electronic, optical or miscellaneous parts where silica slurry is used.

### Key Features

- Long life
- Clean end faces
- Minimal cleaning
- Eliminates messy slurries
- Produces superior surface finish
- Reduces overall process time
- Produces high connector yields
- Used on all polishing machines
- Consistent fiber heights
- Easy to identify working side

### Converted Forms

Sheets, discs and rolls.

### Backing

Polyester Film

Nominal thickness: 3 mil

Actual thickness: 2.97 mil ( $\pm 0.05$ )

Ultimate tensile strength: 26,500 psi (typical)

### Storage and Shelf Life

Recommended Storage Conditions:

Temperature: 50 - 90°F (10 - 32°C)

Relative humidity: 30 - 70%

There is no degradation with time. It is recommended that product be used within 24 months of purchase.

### Number of Uses

The number of uses are dependent on equipment, connectors, process parameters, etc.

### Cleaning

The film should be wiped clean between uses with a clean tissue. Connectors and jig should also be cleaned to minimize scratching.

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## Process Conditions Chart

3M™ Lapping Film 865X Process Conditions After 3M's 1um or 0.5um DLF						
Machine	Connector	Pad	Time(s)	Speed	Pressure/Conn	Lubricant
Domaille	SC	70d	30-60	140	0.4-0.5 lbs	Deionized or Distilled water
Domaille	LC	80d	30-60	100	0.2-0.3 lbs	Deionized or Distilled water
SII-OFL 12	SC	65d	60-90	na	point 1	"
SII-OFL 12	LC	70d	60-90	na	point 2	"
SII-OFL 15	SC	70d	45-60	210	200-250 gms	"
SII-OFL 15	LC	80d	45-60	220	150-200 gms	"
Seikoh Giken SPFG550	SC	70d	45-90	na	na	"
Seikoh Giken SPFG550	LC	80d	45-60	na	na	"
Nanometer	SC	65d	50-100	na	0.35 psi	"
Nanometer	LC	70 - 80d	50-100	na	0.30 psi	"
Generic Conditions	SC	65-70d	60	Medium	200-250 gms	"
Generic Conditions	LC	80-90d	60	Slower	150-200 gms	"

These recommendations provide typical starting points. Actual process may vary depending on equipment used and finish requirements.

### Certification/Recognition

**MSDS:** Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.

**TSCA:** This product is an article as defined by TSCA regulations and is exempt from TSCA Inventory listing requirements.

**RoHS:** Abrasives products are not considered 'electrical or electronic equipment' (EEE) under EU Directive 2002/95/EC and 2005/618/EC, (WEEE and RoHS). They are considered consumables and are not subject to RoHS Directive.

### For Additional Information

To request additional product information or to arrange for sales assistance, call toll free 1-800-251-8634. Address correspondence to: 3M Electronics Markets Materials Division, Building 21-1W-10, 900 Bush Avenue, St. Paul, MN 55144-1000. Our fax number is 651-778-4244 or 1-877-369-2923. In Canada, phone: 1-800-364-3577. In Puerto Rico, phone: 1-787-750-3000. In Mexico, phone: 52-70-04-00.



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60-5002-0362-9

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