**Fiber Optic Patchcord Production Flow**

Cut fiber optic cable - Wear parts - Matching glue - Fiber insertion - Heating curing - De-gluing - Grinding - End face inspection - Assembly - Testing - QA sampling - Packaging.

1) Cutting fiber optic cable: Mainly use aramid shears to cut the length of fiber optic cable as needed, and then simply coil it.

2) Putting on parts: This part is mainly to put on various loose parts to the fiber in advance to facilitate the process later. When putting in the wire, in order of rubber sheath, heat shrinkable tube, support tube, spring, the direction should pay attention to whether the correct.

3) Glue distribution: mainly through the auxiliary tools in the 353nd glue partA and partB according to the 10:1 ratio of uniform deployment, and minimize the bubble.

4) Fiber insertion: First, use the stripping pliers to strip the outer skin of the fiber and the coating layer, and then inject the glue into the tailstock of the insert with a syringe or dispenser, and then manually thread the fiber into the glue-injected insert and expose part of the fiber.

5) Heating and curing: Put the core into the curing oven and bake it until the 353nd glue is completely cured.

6) Removal of glue: first, the cured fiber head with a cutting knife to cut off the excess fiber exposed in front, and then the fiber head all mounted on the top of the grinding jig, and then sandpaper sanding to remove the purpose of the core head glue.

7) Lapping: Lapping the jig after debonding, lapping on the lapping machine, general process 9u 3u 1u 0.05u, lapping time and pressure are related to the lapping paper.

8) End face inspection: Use the end checker with 400 times magnification to check how well the end face of the insert is ground. Generally, the end face with black spots and large scratches is regarded as unqualified and needs to be reground and processed.

9) Assembly: Assemble the ground core and loose parts together into a joint, and crimp the tail sleeve by crimping pliers or crimping machine.

10) Testing: Using the insertion and return loss tester to measure the main data insertion loss and return loss of the fiber optic head, the general requirements of single-mode insertion loss is less than or equal to 0.3dB, return loss is greater than or equal to 50dB.

11) QA sampling: quality inspection personnel to test the qualified products for sampling to control the quality.

12) Packaging: Final packaging of qualified products.