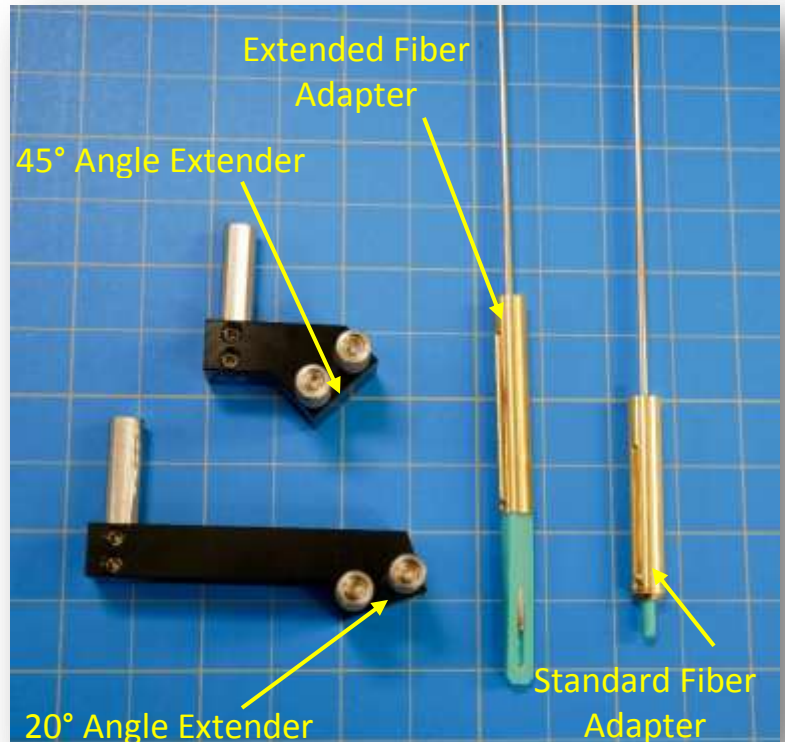


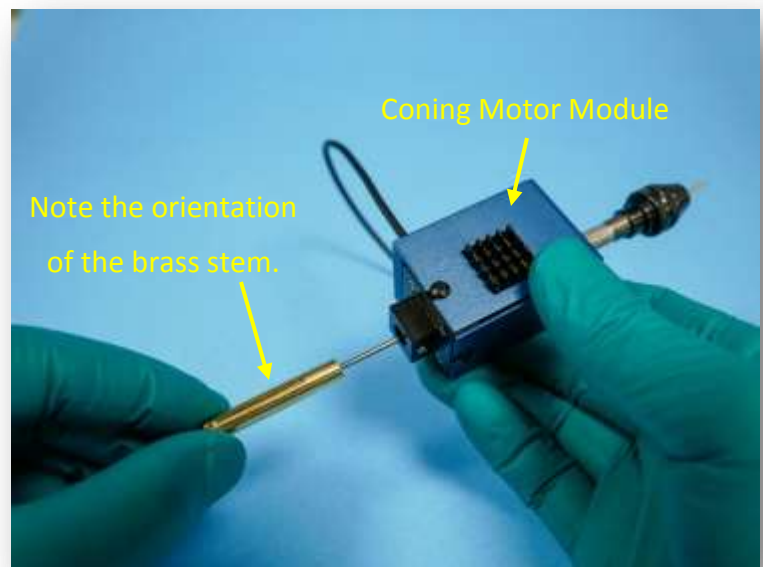
Setup:

1. Identify the following Accessories:

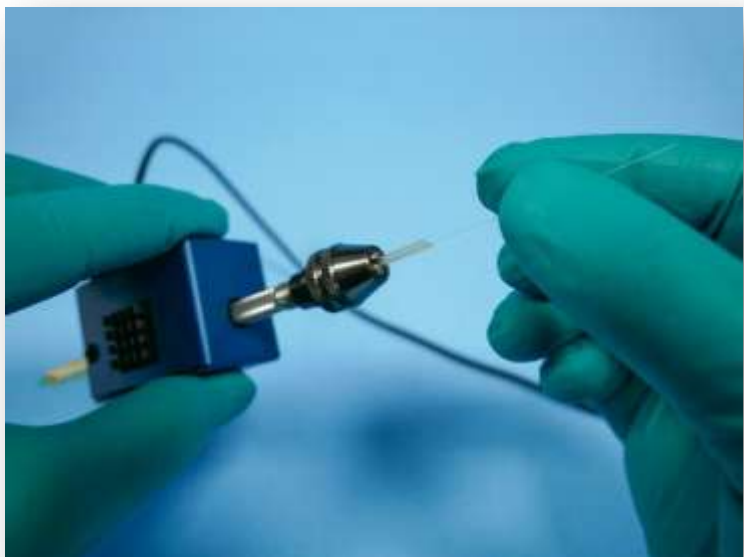
1. 45° Angle Extension Adapter
2. 20° Angle Extension Adapter
3. Standard Fiber Adapter
4. Extended Fiber Adapter



2. Insert coning module into designated Orbit port, as shown.

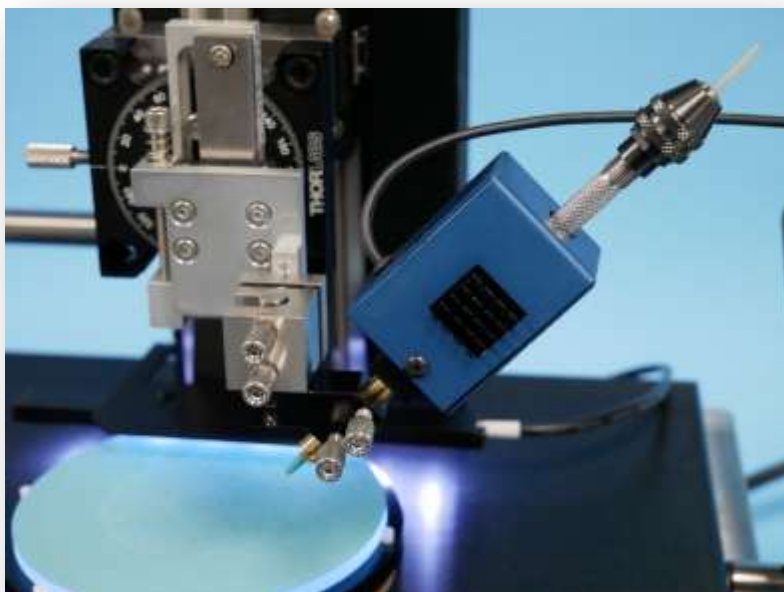


3. See figure 2 for choosing correct adapters and insert into the coning motor module. Tighten locking screw with 0.05" driver. **Note: Do not remove the steel fiber guides, as they are set to designated heights.**



3. Loosen collet and insert bare fiber. Set estimated protrusion length and tighten collet. Fiber protrusion lengths may be better set while on the machine with aid of the profile microscope. **Tip: Spin the fiber as it's guided through the ferrule. This is especially true when loading the extended Fiber Adapter**

4. See figure 2 to choose correct Angle extender. Loosen thumbscrews and insert designated extender. Place flat towards thumbscrews.



5. Place entire coning module into adapter. Set angle and check protrusion lengths using profile scope.

Polishing Guide:

Use the following figures to get started on coning fibers.

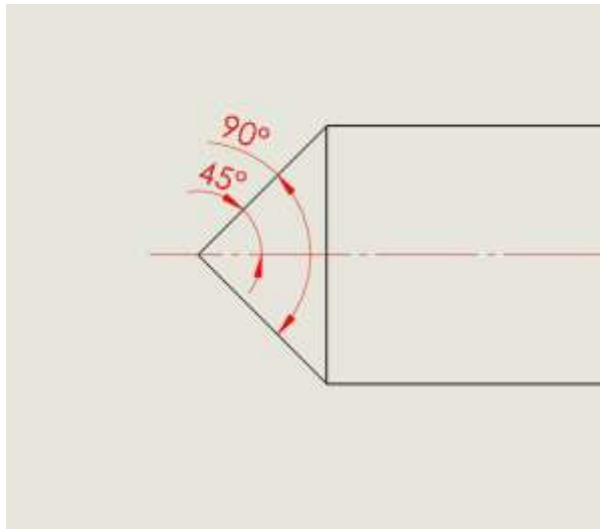


Figure 1a. Use as reference to figure 2. To Polish a **90° Cone**, set polishing angle to 45 °

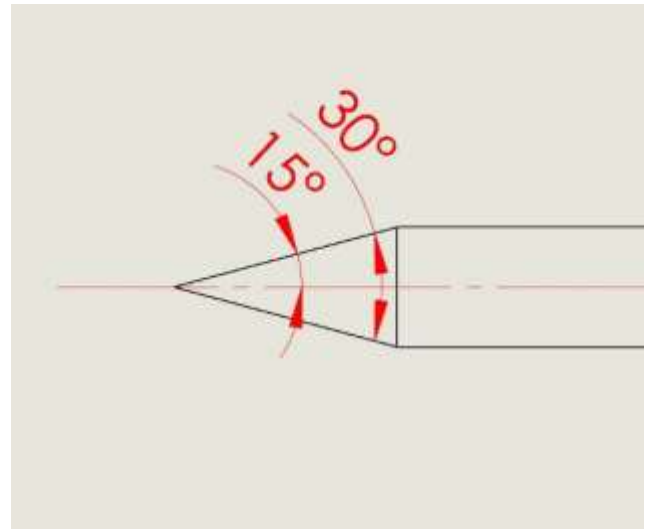


Figure 1b. Use as reference to figure 2. To Polish a **30° Cone**, set polishing angle to 15 ° from horizontal or 75° from vertical

Coning Angle	Angle Extender	Fiber Adapter
Flat - 90°	None	Standard
90° - 60°	45° Angle Extender	Standard
60° - 0°	20° Angle Extender	Extended

Figure 2. Accessory chart, for reference only. Angles are based on stiff, 200um sapphire bare fibers. For softer materials, angle may change due to the ferrule protrusion limits of fiber's material.

