

INTERNATIONAL STANDARD

IEC
60874-10-2

QC 910003XX0002

First edition
1997-06

Connectors for optical fibres and cables –

Part 10-2:

**Detail specification for fibre optic connector
type BFOC/2,5 terminated to single-mode
fibre type B1**



Reference number
IEC 60874-10-2: 1997(E)

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- IEC 60027: *Letter symbols to be used in electrical technology*;
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- IEC 60878: *Graphical symbols for electromedical equipment in medical practice*.

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IEC publications prepared by the same technical committee

The attention of readers is drawn to the end pages of this publication which list the IEC publications issued by the technical committee which has prepared the present publication.

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Commission Electrotechnique Internationale
International Electrotechnical Commission
Международная Электротехническая Комиссия

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INTERNATIONAL ELECTROTECHNICAL COMMISSION

CONNECTORS FOR OPTICAL FIBRES AND CABLES –

**Part 10-2: Detail specification for fibre optic connector type BFOC/2,5
terminated to single-mode fibre type B1**

FOREWORD

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International Standard IEC 60874-10-2 has been prepared by subcommittee 86B: Fibre optic interconnecting devices and passive components, of IEC technical committee 86: Fibre optics.

The text of this standard is based on the following documents:

FDIS	Report on voting
86B/869/FDIS	86B/999/RVD

Full information on the voting for the approval of this standard can be found in the report on voting indicated in the above table.

The QC number that appears on the front cover of this publication is the specification number in the IEC Quality Assessment System for Electronic Components (IECQ).

The references to clauses or subclauses of IEC 60874-1 indicated in this part apply to the third edition of IEC 60874-1.

CONNECTORS FOR OPTICAL FIBRES AND CABLES**Part 10-2: Detail specification for fibre optic connector type BFOC/2,5 terminated to single mode fibre type B1**

NATIONAL STANDARDS ORGANIZATION:

Date:

DETAIL SPECIFICATION IEC QC 910003XX0002.

FIBRE OPTIC COMPONENT OF ASSESSED QUALITY IN ACCORDANCE WITH

- GENERIC SPECIFICATION: QC 910000 (IEC 60874-1)
- BLANK DETAIL SPECIFICATION: QC 910001 (IEC 60874-1-1)

CONNECTOR SET FOR OPTICAL FIBRES AND CABLES

CLASSIFICATION:

Type: Name: BFOC/2.5
 Configuration: plug-adaptor-plug
 Coupling: bayonet
 Control dimensions:
 - Plug: see figures 1, 2 and 3
 - Adaptor: see IEC 60874-10-3

Arrangement: patchcord arrangement

Style: Fibre retention: as required
 Cable retention: as required
 Optical coupling: butting

Variants: see page 6

Climatic category: 10/60/4

Environmental category: 4

Assessment level: A

QUALIFICATION PROCEDURE: Fixed sample procedure

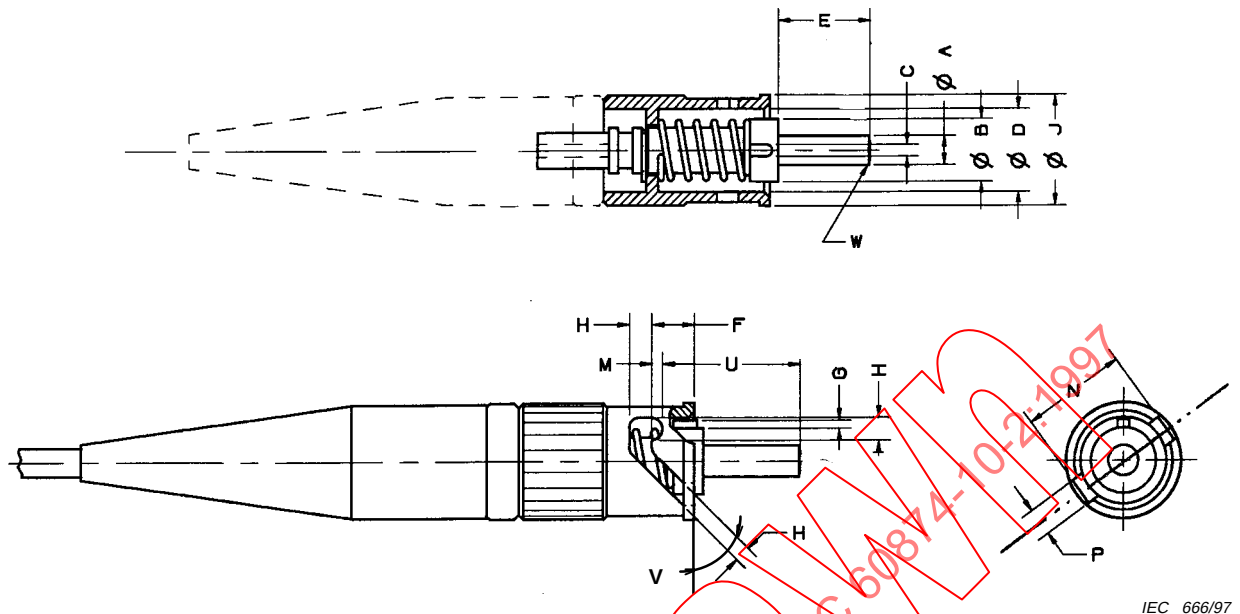
SAFETY WARNING: Take care when handling small diameter optical fibre to prevent puncturing the skin, especially in the eye area. Direct viewing of the end of an optical fibre when it is propagating energy is not recommended unless prior assurance is obtained as to the safe energy output level.

Applicable fibre cable information

Mode field diameter	In accordance with IEC 60793-2
Cladding diameter	In accordance with IEC 60793-2
Buffer diameter	250 ± 15, 500 ± 30, 900 ± 50 µm
Jacket outer diameter	As required per variant
Fibre cut-off wavelength	1 100-1 280

Additional information

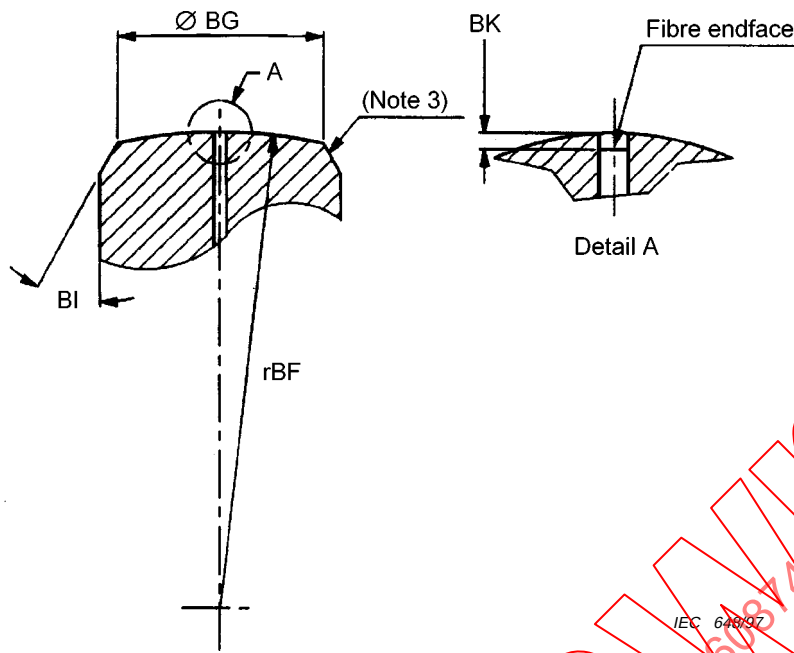
- Attenuation in random connection:
 - less than 0,80 dB (95 % probability)
 - less than 0,40 dB (average)



IEC 666/97

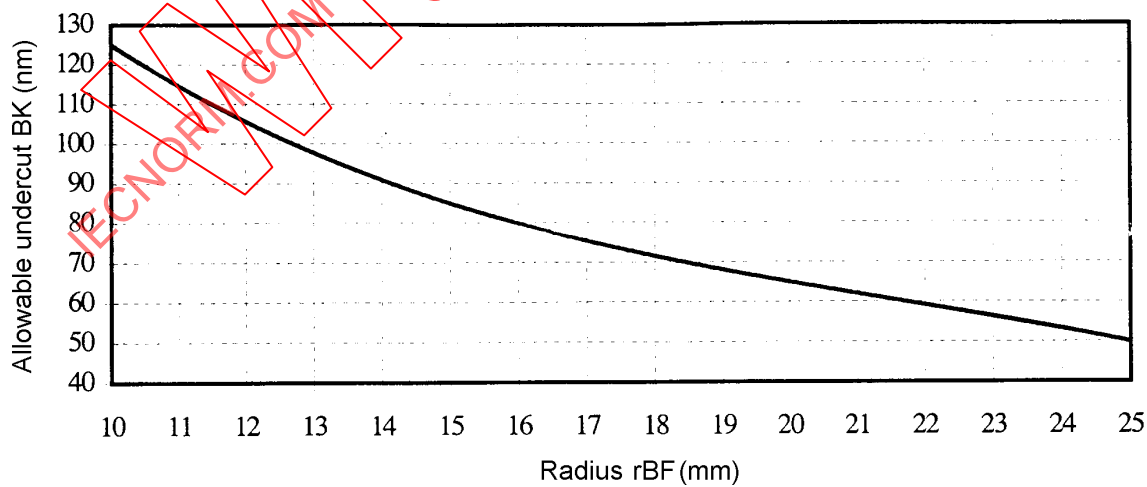
Reference	Dimensions		Notes
	Minimum	Maximum	
A	2,4985 mm	2,4995 mm	1
B	5,25 mm	5,46 mm	
C	0,91 mm	1,07 mm	
D	7,06 mm	7,24 mm	
E	7,75 mm	8,00 mm	
F	2,56 mm	4,50 mm	
G	0,58 mm	0,76 mm	
H	1,60 mm	3,2 mm	
J	9,40 mm	9,65 mm	
K	0,59 mm	0,89 mm	
M	0,60 mm	1,12 mm	
N	8,56 mm		
P	1,60 mm	3,2 mm	
U	9,54 mm	11,11 mm	
V	37°	90°	
NOTES			
1 Ferrule compression forces shall be from 7,0 to 15,0 N when the ferrule is compressed to a point where U is in the range specified.			
2 Where a tolerance of form is not specified, the limits of the dimensions for a feature control the form as well as the size.			
3 Where interrelated features of size (features shown with a common axis or centre plane) have no geometric tolerance of location or run out specified, the limits of the dimensions for a feature control the location tolerance as well as the size.			
4 Where perpendicular features (features shown at right angles) have no geometric tolerance of orientation or run out specified, the limits of the dimensions for a feature control the orientation tolerance as well as the size.			

Figure 1 – Plug outline and mating face dimensions



Reference	Dimensions		Notes
	Minimum	Maximum	
rBF	10 mm	25 mm	1
BK	–0,0001 mm	see graph	2
BG	1,90 mm	2,26 mm	diameter
BI	25°	35°	
NOTES			
1 Eccentricity of a spherical polished ferrule endface is less than 50 µm.			
2 The negative dimension refers to the fibre protrusion.			
3 Break edge.			

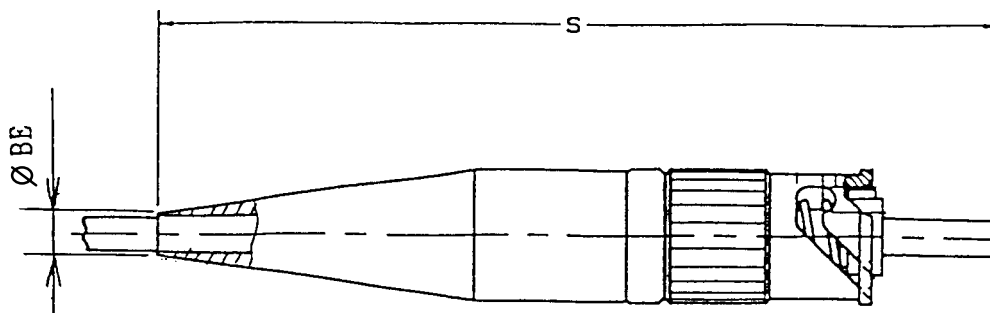
Figure 2a – Ferrule endface geometry after termination



Allowable undercut = $-0,02 \cdot \text{Radius}^3 + 1,3 \cdot \text{Radius}^2 - 31 \cdot \text{Radius} + 325$

IEC 649/97

Figure 2b – Allowable undercut BK versus radius rBF



IEC 667/97

Reference	Dimensions mm		Notes
	Minimum	Maximum	
S		60	
BE	2,2		1
BE	2,6		2
BE	2,9		3
BE	3,2		4
NOTES 1 This value is applicable to the variant number –1001. 2 This value is applicable to the variant number –1002. 3 This value is applicable to the variant number –1003. 4 This value is applicable to the variant number –1004.			

Figure 3 – Plug dimension

VARIANT IDENTIFICATION NUMBERS			
Number: QC 910X01/0004-ZZZZ			
ZZZZ	Component name	Variant feature	
		Applicable cable jacket diameter	Ferrule material
1001	Plug	2,0 mm	Ceramic
1002	Plug	2,4 mm	Ceramic
1003	Plug	2,7 mm	Ceramic
1004	Plug	3,0 mm	Ceramic

SUPPLEMENTARY INFORMATION

Component marking:

The name and manufacturer's identification mark shall be permanently identified.

TABLE 1 FIXED SAMPLE TEST SCHEDULE FOR QUALIFICATION APPROVAL		
Test sequence	Reference IEC 60874-1 (IEC 61300)	<i>n</i>
Group 0 – Visual examination – Dimensions	4.4.1 (3-1) 4.4.2 (3-1)	20
Group 1 – Attenuation – Ferrule compression force – Return loss	4.4.7 (3-4) (3-22) 4.4.12 (3-6)	20
Group 2 – Cold – Dry heat – Damp heat, steady state	4.5.17 (2-17) 4.5.18 (2-18) 4.5.19 (2-19)	6
Group 3 – Drop – Engagement and separation force – Mechanical endurance	4.5.14 (2-12) 4.4.5 (3-11) 4.5.32 (2-2)	6
Group 4 – Vibration – Change of temperature (test Nb)	4.5.1 (2-1) 4.5.22 (2-22)	4
Group 5 – Strength of coupling mechanism – Cable pulling – Cable torsion	4.5.6 (2-6) 4.5.4 (2-4) 4.5.5 (2-5)	4
Group 6 – Fibre or ferrule retention	4.5.2 (2-4)	NA
NOTES 1 <i>n</i> = sample size (number of plugs). 2 To satisfy the qualification approval requirements of the detail specification there must be no failures of any in the sample groups for any test parameter. If a failure does occur this must be investigated and the cause of failure identified and corrected. The test which is affected must then be repeated using the minimum sample size stated in this detail specification. A fully documented test report and supporting data shall be prepared and must be available for inspection. Failures and the corrective action taken to eliminate failures must be documented and evidence must be presented to show that the corrective action will have no detrimental effect on the performance in any of the other tests. Design changes, as opposed to improvements in quality control, will usually be deemed to necessitate a repeat of the full qualification programme. 3 Unless otherwise indicated, the test details, measurements and performance requirements are given in table 4. 4 Only group 1 tests shall be carried out using a reference connector. All other tests shall be carried out using the samples from the relevant group at random.		

TABLE 2 LOT-BY-LOT QUALITY CONFORMANCE INSPECTION SCHEDULE GROUPS A AND B			
Test sequence	Reference IEC 60874-1 (IEC 61300)	Assessment level A	
		IL	AQL
Group A – Visual examination – Radius Undercut/protrusion Eccentricity of spherical polished endface	4.4.1 (3-1) 4.4.2 (3-1) (3-23) (3-25)	II	4 %
Group B – Attenuation – Return loss	4.4.7 (3-4) 4.4.12 (3-6)	II	4 %
NOTES 1 Unless otherwise indicated, the details, measurements and performance requirements are given in table 4. 2 IL = Inspection level; AQL = Acceptable quality level. 3 Only attenuation tests shall be carried out using a reference connector. All other tests shall be carried out using the samples from the relevant group at random.			

TABLE 3
PERIODIC QUALITY CONFORMANCE INSPECTION SCHEDULE
GROUPS C AND D

Test sequence	Reference IEC 60874-1 (IEC 61300)	Assessment level A	
		<i>n</i>	<i>p</i>
Group C0 – Visual examination – Dimensions – Ferrule compression force	4.4.1 (3-1) 4.4.2 (3-1) (3-22)	18	24
Group C1 – Attenuation – Return loss	4.4.7 (3-4) 4.4.12 (3-6)	18	24
Group C2 – Cold – Dry heat – Damp heat, steady state	4.5.17 (2-17) 4.5.18 (2-18) 4.5.19 (2-19)	6	24
Group D0 – Visual examination – Dimensions – Ferrule compression force	4.4.1 (3-1) 4.4.2 (3-1) (3-22)	20	48
Group D1 – Attenuation	4.4.7 (3-4)	20	48
Group D2 – Cold – Dry heat – Damp heat, steady state	4.5.17 (2-17) 4.5.18 (2-18) 4.5.19 (2-19)	6	48
Group D3 – Drop – Engagement and separation force – Mechanical endurance	4.5.14 (2-12) 4.4.5 (3-11) 4.5.2 (2-2)	6	48
Group D4 – Vibration – Change of temperature (Test Nb)	4.5.1 (2-1) 4.5.22 (2-22)	4	48
Group D5 – Strength of coupling mechanism – Cable pulling – Cable torsion	4.5.6 (2-6) 4.5.4 (2-4) 4.5.5 (2-5)	4	48
Group D6 – Fibre or ferrule retention	4.5.2 (2-4)	NA	NA

NOTES

- n = sample size (number of plugs); p = periodicity in months.
- To satisfy the quality conformance requirements of the detail specification there shall be no failures of any in the sample groups for any test parameter. If a failure does occur this shall be investigated and the cause of failure identified and corrected. The test which is affected shall then be repeated using the minimum sample size stated in this detail specification.

A fully documented test report and supporting data shall be prepared and shall be available for inspection. Failures and the corrective action taken to eliminate failures shall be documented and evidence shall be presented to show that the corrective action will have no detrimental effect on the performance in any of the other tests. Design changes, as opposed to improvements in quality control, will usually be deemed to necessitate a repeat of the full qualification programme.
- Unless otherwise indicated, the details, measurements and performance requirements are given in table 4.
- Only group C1 and D1 tests shall be carried out using a reference connector. All other tests shall be carried out using the samples from the relevant group at random.

TABLE 4 DETAILS, MEASUREMENTS AND PERFORMANCE REQUIREMENTS
<i>Visual examination</i> 4.4.1 (61300-3-1) Requirements: – Marking shall be clear – Coupling sleeve shall be movable smoothly
<i>Dimensions</i> 4.4.2 (61300-3-1) (61300-3-15) (61300-3-18) Requirements: – All size dimensions shall be in accordance with this specification.
<i>Attenuation</i> 4.4.7 (61300-3-4) Details: – Method No. 7 – Definitions of reference plug are as follows • Ferrule outer diameter is $2,499 \pm 0,0003$ mm • Concentricity of the fibre core with the outer diameter of the ferrule is less than $0,6 \mu\text{m}$ • Angular misalignment of ferrule with fibre installed is less than $0,2$ degree • Eccentricity of a spherical polished ferrule endface is less than $30 \mu\text{m}$ – Adaptor shall be in accordance with IEC 60874-10-3 – Number of measurements to be averaged: 5 – Source: LD – Peak wavelength: $1,3 \mu\text{m}$ – Preconditioning procedure: the ferrule endface of the reference plug shall be cleaned using lint free material. Requirements: – Allowable attenuation: less than $0,5$ dB against reference plug.
<i>Return loss</i> 4.4.12 (61300-3-6) Details: – Source: LD – Peak wavelength: $1,3 \mu\text{m}$ – Adaptor shall be in accordance with IEC 60874-10-3 Requirements – Return loss: 26 dB minimum
<i>Cold</i> 4.5.17 (61300-2-17) Details: – Temperature: -10°C – Duration: 96 h – Specimen optically functioning – Conditioning procedure: specimen lowered to test temperature and returned to room temperature at a rate not to exceed $1^\circ/\text{min}$ – Deviations: none – Adaptor shall be in accordance with IEC 60874-10-3 – Monitoring method of attenuation shall be in accordance with IEC 61300-3-20 – Change in attenuation during test: less than $0,2$ dB – Return loss during test: 26 dB minimum

(continued)