

# Contents

<b>Preface</b> . . . . .	xiii
<b>1 Introduction</b>	
1.1 Document Description . . . . .	1-1
1.2 Organization . . . . .	1-1
1.3 Analysis Criteria . . . . .	1-2
1.4 Reliability Audit . . . . .	1-3
1.5 Definitions of Key Terms . . . . .	1-4
1.6 Reasons for Reissue and Major Changes . . . . .	1-5
1.6.1 Reasons for Reissue . . . . .	1-5
1.6.2 Major Changes from TR-TSY-000264, Issue 1 . . . . .	1-6
1.6.2.1 Usage-Sensitive Criteria . . . . .	1-6
1.6.2.2 Measurement of Angled Cleaves . . . . .	1-6
1.6.2.3 Cleaving of Specialty Fibers . . . . .	1-6
1.6.2.4 Cleaving in Various Environments . . . . .	1-7
1.6.2.5 Classification of Defects . . . . .	1-7
1.6.2.6 Classification of Cleave Quality . . . . .	1-7
1.6.2.7 Electrical Requirements . . . . .	1-7
1.6.2.8 Thermal Shock . . . . .	1-7
<b>2 General Information</b>	
2.1 Product Description . . . . .	2-1
2.1.1 Types of Splices . . . . .	2-1
2.1.1.1 Fusion Splices . . . . .	2-1
2.1.1.2 Mechanical Splices . . . . .	2-1
2.1.2 Processes for Preparing Fiber Ends . . . . .	2-2
2.1.3 The Cleaving Process . . . . .	2-2
2.1.3.1 Producing a Cleave . . . . .	2-2
2.1.3.2 Characterizing a Cleave . . . . .	2-2
2.1.3.3 Calculation of Loss Contribution From Angled Cleave . . . . .	2-3
2.1.4 Reflectance . . . . .	2-5
2.1.5 Low-Precision Cleavers . . . . .	2-5
2.1.6 Multi-Fiber Splices . . . . .	2-7
2.1.7 Specialty Fibers . . . . .	2-8
2.2 Product Applications . . . . .	2-8
2.3 Product Testing . . . . .	2-9
2.3.1 Reporting of Test Data . . . . .	2-9
2.3.2 Number of Test Samples . . . . .	2-9
2.4 Supplier-Provided Data . . . . .	2-9
<b>3 General Requirements and Objectives</b>	
3.1 Documentation . . . . .	3-1

3.1.1 Practices . . . . .	3-1
3.1.2 Workcenter Information Package . . . . .	3-1
3.2 Marking, Packaging, and Shipping . . . . .	3-2
3.2.1 Marking . . . . .	3-2
3.2.2 Packaging and Shipping . . . . .	3-2
3.3 Equipment: General Requirements and Objectives . . . . .	3-3
3.3.1 Carrying Case . . . . .	3-3
3.3.2 Chemicals and Moisture . . . . .	3-3
3.3.3 Product Information . . . . .	3-3

## 4 Performance Requirements and Objectives

4.1 Criteria Applicable to Product As-Received . . . . .	4-2
4.1.1 Criteria Applicable to All Cleavers . . . . .	4-2
4.1.2 Cleave Angle Criteria . . . . .	4-3
4.1.2.1 High Precision Perpendicular Cleavers . . . . .	4-4
4.1.2.2 High Precision Angled Cleavers . . . . .	4-4
4.1.2.3 Low-Precision Cleavers . . . . .	4-5
4.1.3 Multi-Fiber Cleavers . . . . .	4-6
4.1.3.1 Fiber-Count and Ribbon Construction Tolerance . . . . .	4-6
4.1.3.2 Multi-Fiber Perpendicular Cleavers . . . . .	4-7
4.1.3.3 Multi-Fiber Angled Cleavers . . . . .	4-8
4.2 Mechanical and Storage Environments Criteria . . . . .	4-8
4.2.1 Shock . . . . .	4-8
4.2.2 Storage Environment . . . . .	4-9
4.2.3 Electrical Requirements . . . . .	4-9
4.3 Fiber Cleaving Environmental Conditions . . . . .	4-10
4.3.1 Low Temperature . . . . .	4-10
4.3.2 High Temperature, High Humidity . . . . .	4-10
4.3.3 High Temperature, Low Humidity . . . . .	4-11
4.3.4 Operation When Wet . . . . .	4-11
4.3.5 Exposure to Dust and Vibration . . . . .	4-11
4.4 Cleaver Extended Operation . . . . .	4-11

## 5 Measurement of Cleave Angle Test Procedure

5.1 Interferometry . . . . .	5-1
5.1.1 Basic Principle . . . . .	5-1
5.1.2 Defects . . . . .	5-3
5.1.3 Measurement Error . . . . .	5-4
5.2 Beam Deflection . . . . .	5-5
5.2.1 Basic Principle . . . . .	5-5
5.2.2 Description of the Measurement Technique . . . . .	5-8
5.3 Cleaving Schedule . . . . .	5-10

## 6 Lists of Requirements and Objectives

### Appendix A: References

Note . . . . .	A-3
To Contact Telcordia Customer Service or to Order Documents . . . . .	A-3
To Order Documents From Within Telcordia (Employees Only) . . . . .	A-3
To Request Telcordia Testing Services . . . . .	A-3



## List of Figures

Figure 2-1	Core Separation Due to Angled Cleave . . . . .	2-4
Figure 2-2	Temperature Dependence of Reflection From Mechanical Splices	2-5
Figure 2-3	Effect of Cleave Angle on Fusion Splice Loss for Long-Duration Arcs . . . . .	2-6
Figure 2-4	Cleave Lengths in Ribbon Fiber . . . . .	2-8
Figure 5-1	Schematic Diagram of Interferometer . . . . .	5-2
Figure 5-2	Measurement of Cleave Angle by Interferometry . . . . .	5-3
Figure 5-3	Distinguishing Protruding and Non-Protruding Defects . . . . .	5-4
Figure 5-4	Basic Principle of Beam Deflection Technique . . . . .	5-6
Figure 5-5	Cleave Angle as Function of Beam Displacement . . . . .	5-8
Figure 5-6	Schematic Diagram of Beam Deflection Measurement Apparatus .	5-9



## List of Tables

Table 2-1	Worst-Case Loss Due to Core Separation from Cleave Angle . . .	2-4
Table 4-1	Summary of Cleave Angle Criteria . . . . .	4-4
Table 5-1	Cleave Angle as Function of Beam Displacement . . . . .	5-7
Table 5-2	Cleaving Schedule . . . . .	5-10