

Nic Mather

From: ianf@theshapemakers.com
Sent: Thursday, 18 June 2015 10:22 AM
To: aaanic
Subject: Fw: yag laser

From: leeyoung
Sent: Saturday, April 19, 2014 12:38 AM
To: ianf@theshapemakers.com
Cc: EDISON LEE
Subject: RE: yag laser

Hello Ian,

You know for cutting 5mm steel, the process are not the same as thin material

You could make sure the setting on your laser power supply is correct, 70HZ, 150MS, 540-560V.

For cutting thicker material, we need to make sure the focal is inside the material. That means you could clockwise rotate the ring on laser head to decrease the focal. And make sure it's around 1.5-1.8 below the material upper surface.

The other important thing is that the steel must be shoot through at first. There is one setting, OPEN AHEAD in LASER SET of display panel. You could try to set it at 1500. That's for the delay time of the first shoot.

And you could use speed, 2mm/s, to test firstly. If success, you can try to increase it. And also normally machine need higher pressure, around 0.8-1.0MPA for cutting this thickness material. Too much cutting dust need to be blow away.

When the lens surface is not clean, it will absorb heat, and that will create a high temperature. That will decrease cutting power, and focal lens will be broken after a long time working. If the surface is clean, you can still try to use it. But if it heats too much, you still need to change a new one.

Regards
Youngr

From: ianf@theshapemakers.com
To: youngr_lee@hotmail.com
Subject: yag laser
Date: Thu, 17 Apr 2014 11:57:05 +1000

Hello Youngr,

I am trying to pierce 5mm steel plate and am not having any success.
I have checked red beam alignment and checked red beam is in the centre of round green circle.
I am not sure what else I can do.

I have replaced the focusing lense and will try to have surface defects polished out of the damaged one.