

To bring you intelligent manufacturing



BLT 4122 Intelligent Cutting Head Product Manual

Version: 1.0.0



www.bochu.com



Foreword

Thank you for choosing the BLT intelligent cutting head. This manual provides you with important information such as product parameters, installation, and maintenance. Please read this manual carefully before using the product. At the same time, to ensure both operational safety and optimal product performance, please carefully adhere to the precautions outlined in this manual.

BOCHU is constantly updating/upgrading products, so our company reserves the right to modify the product models and descriptions in this manual without prior declaration.



Disassembly of the product is strictly prohibited without the authorization of BOCI Technology, otherwise the warranty will be invalid!



Revision History

| Version No. | Date | Description |
|-------------|------------|---------------|
| 1.0.0 | 2024/11/08 | First version |
| | | |
| | | |
| | | |



Contents

| Chapter 1 Product Specification | |
|--|----|
| 1.1 Product View | 1 |
| 1.2 Technical Parameters | 2 |
| 1.3 LED Indicators | 3 |
| Chapter 2 Gas Interfaces | |
| Chapter 3 Water Cooling Interfaces | 5 |
| Chapter 4 Electrical Interface | 7 |
| 4.1 Bus System | |
| Chapter 5 Cutting Head Installation | 9 |
| 5.1 Preparations before Installation | 9 |
| 5.2 Specified Procedures | |
| 5.2.1 Prepare the Clean Workbench | 10 |
| 5.2.2 Put the Cutting Head inside the Clean Workbench | 11 |
| 5.2.3 Clean and Wipe the Fiber Optic Interface of the Cutting Head | 12 |
| 5.2.4 Check the Laser Fiber Optic Connector End Face | 12 |
| 5.2.5 Remove the Protective Film / Remove the Protective Cap | |
| 5.2.6 Insert the Laser Fiber Connector into the Cutting Head | 13 |
| 5.2.7 Wrap and Seal | 13 |
| 5.2.8 Install the Cutting Head on the Back Plate | 14 |
| 5.2.9 Install the Ceramic Body and Nozzle | 15 |
| 5.2.10 Beam Centering | |
| Appendix A Maintenance | 17 |

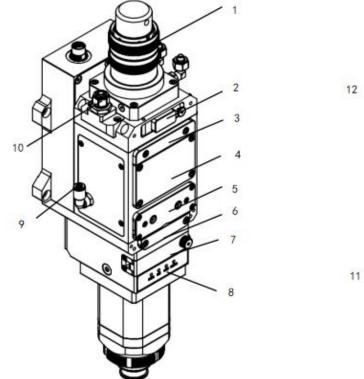
(1) BOCHU

| A.1 | Product Structure Diagram | . 17 |
|-------|------------------------------------|------|
| A.2 | Change the Upper Protective Window | 18 |
| A.3 | Change the Lower Protective Window | . 19 |
| | | |
| Appen | dix B Mechanical Size | .20 |
| | dix B Mechanical Size | |

(1) ВОСНИ

Chapter 1 Product Specification

1.1 **Product View**



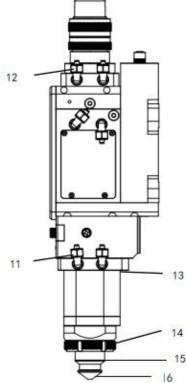


Figure 1-1 Product view

- 1. Fiber optic interface;
- 2. 1st upper protective window;
- 3. 2nd upper protective window;
- 4. Alignment module;
- 5. Focusing module;
- 6. 2nd lower protective window;
- 7. 1st lower protective window;
- 8. Work indicator light;

- 9. Nozzle cooling air interface;
- 10. Cutting gas interface;
- 11. Cooling water outlet;
- 12. Cooling water inlet;
- 13. Protective screw;
- 14. Ceramic body lock ring;
- 15. Ceramic body;
- 16. Nozzle;



1.2 Technical Parameters

Table 1-1 BLT 4122 Cutting Head Technical Parameters

| Cutting Head Parameters | Values |
|-------------------------------|---|
| Laser Wavelength | 1030-1090 nm |
| Laser Power | ≤60 kW |
| Fiber Interface | Q+/ADD |
| Spot Magnification | M=3.0 |
| Max Focusing Adjustment Range | \pm 50 mm |
| NA | Max.0.13 at Fc100 |
| Centering Adjustment Range | $\pm 1.5 \text{ mm}$ |
| Focusing Acceleration | 7.5m/s ² |
| Cutting Gas Interface | ø10, Max 25 bar (2.5 MPa) |
| Nozzle Cooling Gas interface | ø6, Max 5 bar (0.5 MPa) |
| Water Cooling Interface | ø8, Max 5 bar (0.5 MPa), Min flow 2.0 L/min |
| Working Temperature | $5 \sim 55^{\circ}$ C |
| Storage Temperature | -25 \sim +55 °C |
| Dimension | 524x122 (Q+Interface Version) |
| Weight | About 7 kg |

To avoid the damage of cutting head during storage or transportation, the following shall be taken into consideration.

LCaution:



1. The cutting head should be stored in the environment within the allowed temperature and humidity range.

2. Avoid storing in magnetic fields (such as permanent magnets or strong alternating fields) and their vicinity.

3. Avoid collision during transportation or usage.



1.3 LED Indicators

| Icon | Status and Indication |
|--------|--|
| POWER | Green: The power is normal.Red: Under-voltage alarm due to insufficient electrical power.Light Off: Power off. The cause might be no power is on, the connecting wires are damaged or malfunctioning, or the interface is loose. |
| RUN | Green: The system is normal.Red: Motor exception. The motor current consumption is too high, and the mechanical components cannot operate smoothly.Light off: The connecting wires are damaged or malfunctioning, or the interface is loose. |
| | Green: The communication is normal. Red: Communication exception. Light off: The connecting wires are damaged or malfunctioning, or the interface is loose. |
| SENSOR | Green: The readings of each sensor are normal.Red: There are exceptions in the readings of the sensors.Light off: The connecting wires are damaged or malfunctioning, or the interface is loose. |



Chapter 2 Gas Interfaces

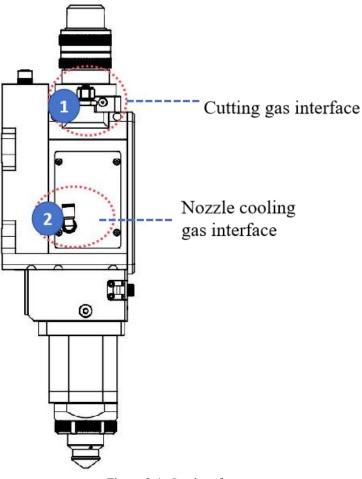


Figure 2-1 Gas interfaces

Installation connection: Cutting gas 1 and nozzle cooling gas 2.

1. The maximum pressure of the cutting gas is 25 bar (2.5 MPa)

Caution:



2. The quality of cutting gas should meet the requirements of ISO 8573-1:2010: solid particles - grade 2, water - grade 4, oil grade 3. The purer the cutting gas, the longer the service life of the protective window.

3. Cutting gas diameter (outer diameter) is 10 mm, while the spraying cooling gas diameter (outer diameter) is 6 mm.



Chapter 3 Water Cooling Interfaces

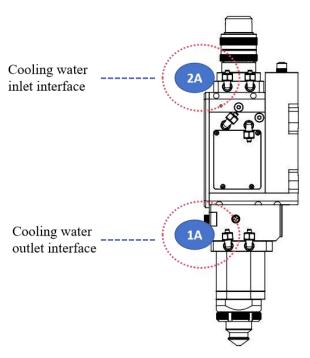


Figure 3-1 Cooling water interfaces

Installation connection: Cooling water inlet interface 2A, and Cooling water outlet interface 1A.

Caution:

1. Use purified water for the cooling water; purified drinking water is adoptable.

2. To prevent the pipeline blockage caused by mold growth in the water of the water cooler, it is recommended to add alcohol in purified water, with an alcohol content of 10% of the purified water.

3. When the temperature around the device is between $-10\sim0$ °C, a 30% ethylene glycol solution must be used and replaced every two months.

4. When the temperature around the device is below $-10 \,^{\circ}\text{C}$, a water cooler machine with dual functioning system must be used, and the cooling system must operate continuously.

5. Recommended settings for cooling water: cooling water pressure ≤ 5 bar (0.5 MPa), water flow rate ≥ 2.0 L/min.

6. Please refer to the dew point table for setting the cooling water temperature to prevent condensation on optical components.



| Air | | | | | | | | | Relati | ve Hur | nidity | | | | | | | | |
|------------------|-----|----|----|----|----|----|----|----|--------|--------|--------|----|----|----|----|----|----|----|----|
| Temperature ℃ | 100 | 95 | 90 | 85 | 80 | 75 | 70 | 65 | 60 | 55 | 50 | 45 | 40 | 35 | 30 | 25 | 20 | 15 | 10 |
| 43 | 43 | 42 | 41 | 40 | 39 | 38 | 37 | 35 | 34 | 32 | 31 | 29 | 27 | 24 | 22 | 18 | 16 | 11 | 5 |
| 41 | 41 | 39 | 38 | 37 | 36 | 35 | 34 | 33 | 32 | 29 | 28 | 27 | 24 | 22 | 19 | 17 | 13 | 8 | 3 |
| 38 | 38 | 37 | 36 | 35 | 34 | 33 | 32 | 30 | 29 | 27 | 26 | 24 | 22 | 19 | 17 | 14 | 11 | 7 | 0 |
| 35 | 35 | 34 | 33 | 32 | 31 | 30 | 29 | 27 | 26 | 24 | 23 | 21 | 19 | 17 | 15 | 12 | 9 | 4 | 0 |
| 32 | 32 | 31 | 31 | 29 | 28 | 27 | 26 | 24 | 23 | 22 | 20 | 18 | 17 | 15 | 12 | 9 | 6 | 2 | 0 |
| 29 | 29 | 28 | 27 | 27 | 26 | 24 | 23 | 22 | 21 | 19 | 18 | 26 | 14 | 12 | 10 | 7 | 3 | 0 | |
| 27 | 27 | 26 | 25 | 24 | 23 | 22 | 21 | 19 | 18 | 17 | 15 | 13 | 12 | 10 | 7 | 4 | 2 | 0 | |
| 24 | 24 | 23 | 22 | 21 | 20 | 19 | 18 | 17 | 16 | 14 | 13 | 11 | 9 | 7 | 5 | 2 | 0 | | |
| 21 | 21 | 20 | 19 | 18 | 17 | 16 | 15 | 14 | 13 | 12 | 10 | 8 | 7 | 4 | 3 | 0 | | | |
| 18 | 18 | 17 | 17 | 16 | 15 | 14 | 13 | 12 | 10 | 9 | 7 | 6 | 4 | 2 | 0 | | | | |
| 16 | 16 | 14 | 14 | 13 | 12 | 11 | 10 | 9 | 7 | 6 | 5 | 3 | 2 | 0 | | | | | |
| 13 | 13 | 12 | 11 | 10 | 9 | 8 | 7 | 6 | 4 | 3 | 2 | 1 | 0 | | | | | | |
| 10 | 10 | 9 | 8 | 7 | 7 | 6 | 4 | 3 | 2 | 1 | 0 | | | | | | | | |
| 7 | 7 | 6 | б | 4 | 4 | 3 | 2 | 1 | 0 | | | | | | | | | | |
| 4 | 4 | 4 | 3 | 2 | 1 | 0 | | | | | | | | | | | | | |
| 2 | 2 | 1 | 0 | | | | | | | | | | | | | | | | |
| 0 | 0 | | | | | | | | | | | | | | | | | | |

Table 3-1 Dew point temperature at different temperatures and humidity levels

⑤ВОСНИ

Chapter 4 Electrical Interface

Waterproof cautions for PWE and aviation plug interfaces:

1. The PWE interface and aviation plug interface come with dust plugs at the factory, which can achieve a protection level of IP64 with the dust cap securely in place. At the same time, with the PWE line and aviation plug line connected properly, the protection level of IP64 can also be achieved.

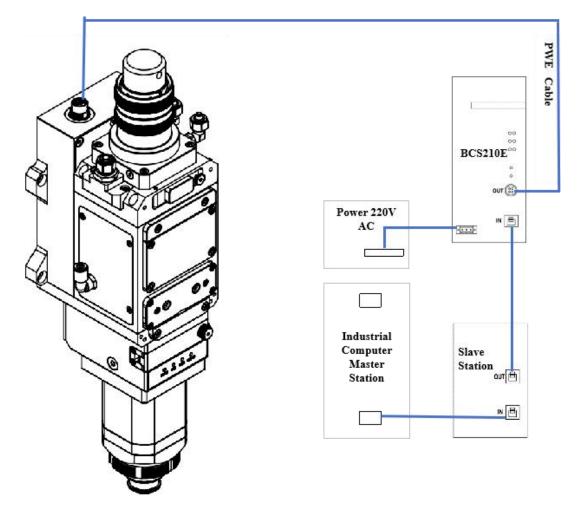
2. After the dust plug is removed, it cannot achieve the protection level of IP64. If it encounters spraying or flushing, it will cause water to ingress into the product, affecting its function.

3. Ensure that the waterway is properly connected and the water pipe interface is tightened before removing the dust plug to prevent the water pipe from accidentally loosening and causing water to rush into the interface, resulting in water ingress into the product.

4. When adjusting the machine wiring, remove the dust plug for wiring, and it is recommended to keep the removed dust plug of the PWE interface. Install the dust plug immediately after removing the wire to prevent accidental water ingress during transportation, water connection, and other processes.



4.1 Bus System







ACaution:

1. Only the personnel who has received the training and has the professional knowledge can perform the operations above.

2. To prevent the pipeline blockage caused by mold growth in the water of the water cooler, it is recommended to add alcohol in purified water, with an alcohol content of 10% of the purified water.

Chapter 5 Cutting Head Installation

During the installation of the cutting head, dust or dirt may accidentally enter the cutting head and contaminate the optical window, affecting its normal use. Please refer to the following installation methods to avoid contamination.

5.1 Preparations before Installation

Please prepare the following items below:

- Cutting head;
- Clean workbench (Type of clean workbench: vertical purification; Cleanliness level: ISO 5, 100; Average airspeed ≥ 0.4 m/s);
- Clean kit: high-intensity flashlight, anhydrous ethanol (or IPA), lint-free purification swabs, lint-free cloth, compressed air dust removal can (or air blower).

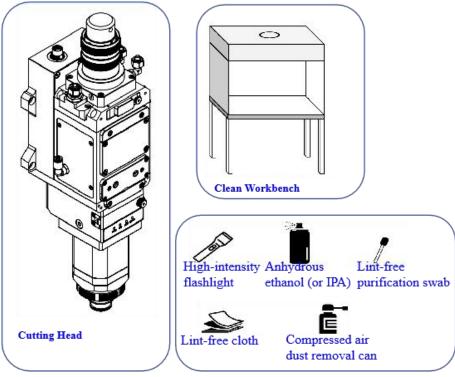


Figure 5-1 Example

⑤ВОСНИ

Caution:

1. Only the personnel who has received the training and has the professional knowledge can perform the operations above.

2. For the normal performance of the laser equipment and the safety of the operating personnel, please adhere to the relative operation guidance.

5.2 Specified Procedures

5.2.1 Prepare the Clean Workbench

Prepare the clean workbench and start it to work properly.

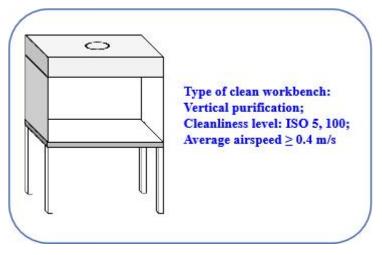


Figure 5-2 Clean Workbench

- Step 1 Check the cleanliness of the equipment (use a particle counter to check cleanliness) and confirm that the FFU (Fan Filter Unit) is within its validity period (measure the average airflow speed in the work area; if the airflow speed cannot reach 0.3 m/s, the FFU must be replaced).
- Step 2 Check whether all switches are functioning properly and verify that the fan is operating normally.
- Step 3 Unnecessary items should not be installed in the clean workbench to prevent the clean airflow from being obstructed.
- Step 4 For newly installed or long-unused clean workbenches, clean the surface with a lint-free cloth and anhydrous ethanol before use.



Startup Procedures:

- Step 1 Turn on the power and pull the glass sliding door of the clean workbench to the lowest position (leaving a gap of approximately 10 cm).
- **Step 2** Start the fan and it is recommended to allow the workbench to purify for about 30 minutes before use.
- Step 3 After normal operation, turn on the clean workbench's lighting.

5.2.2 Put the Cutting Head inside the Clean Workbench

Put the cutting head horizontally inside the clean workbench.

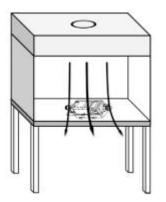


Figure 5-3 Cutting Head inside the workbench

Caution: To prevent dust from falling inside the chamber, please check the integrity of the specified protection film/cap for the fiber interface.

ВОСНИ

5.2.3 Clean and Wipe the Fiber Optic Interface of the Cutting Head

Wipe the fiber interface with the dust-free cloth with anhydrous ethanol.

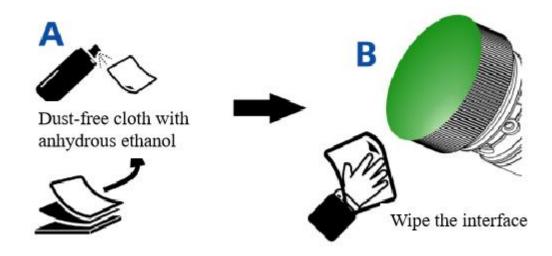


Figure 5-4 Clean the interface

5.2.4 Check the Laser Fiber Optic Connector End Face

Remove the protective cap from the laser fiber optic connector. Use the high-intensity flashlight to inspect the fiber end face for contamination. If clean, the fiber can be directly inserted; if not clean, clean it with a swab dipped in anhydrous ethanol or IPA.

5.2.5 Remove the Protective Film / Remove the Protective Cap

Remove the dedicated protective cap or protective plug from the fiber optic connector on the cutting head.



5.2.6 Insert the Laser Fiber Connector into the Cutting Head

Align the positioning pin on the fiber optic plug with the notch on the connector, then insert it into the unlocked fiber optic connector, ensuring it is fully inserted. Rotate the locking cap until it is tightly secured.

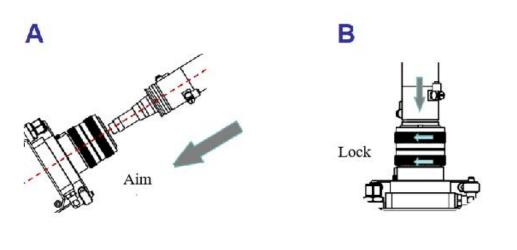


Figure 5-5 Inset the fiber connector

5.2.7 Wrap and Seal

After inserting the fiber, wrap the connection between the fiber and the interface of the cutting head with tape.

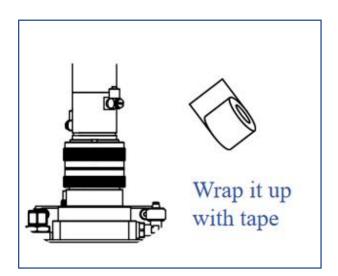


Figure 5-6 Wrap & Seal



Caution: To ensure a proper seal, it is recommended to wrap at least three layers of tape for



5.2.8 Install the Cutting Head on the Back Plate

The cutting head can be mounted onto the machine's Z-axis back plate using four screws: A, B, C, and D. When securing the cutting head to the machine, it is essential to ensure that the cutting head is properly tightened and free from any wobbling.

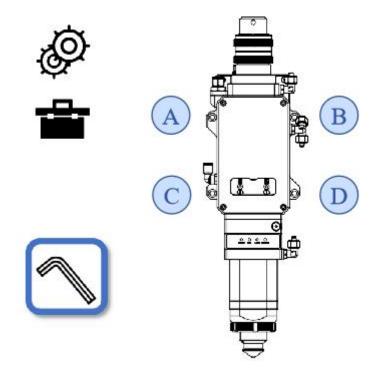


Figure 5-7 Screw A, B, C, D



5.2.9 Install the Ceramic Body and Nozzle

Install the ceramic body, and tighten it by the locking ring. Then, install the nozzle.

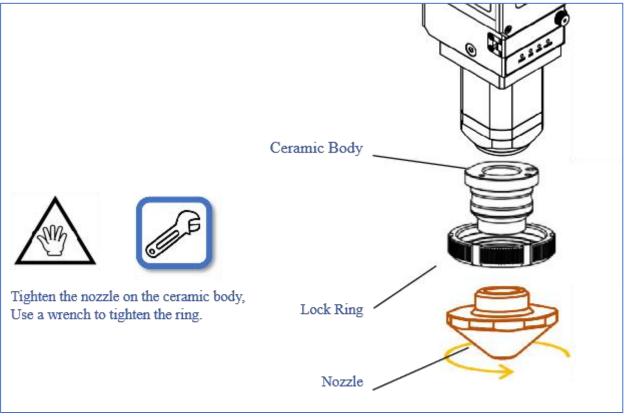
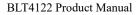


Figure 5-8 5.2.9 Ceramic body and nozzle





5.2.10 Beam Centering

Adjust the X-Y alignment knobs using low-power pinpointing to ensure the focus is at the center of the nozzle.

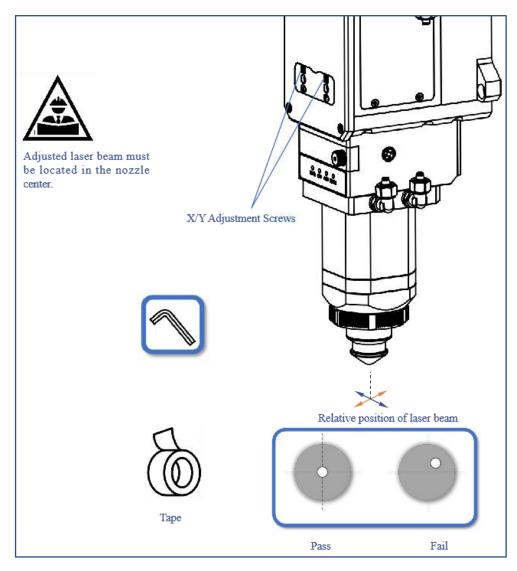


Figure 5-9 Beam centering

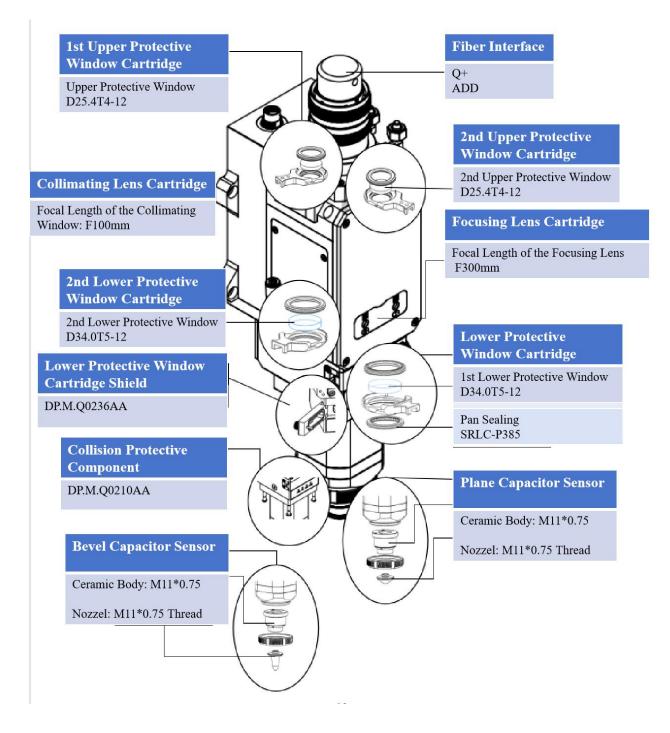
Manual Operations for Beam Centering:

- Step 1 Make sure the laser beam has been turned off.
- **Step 2** Put the tape blow the nozzle.
- **Step 3** Click to trigger a low-power laser pulse and assess the position of the laser beam relative to the nozzle based on the penetration of the tape.
- **Step 4** Adjust the X/Y alignment screws to position the laser beam at the center of the nozzle.



Appendix A Maintenance

A.1 Product Structure Diagram





A.2 Change the Upper Protective Window

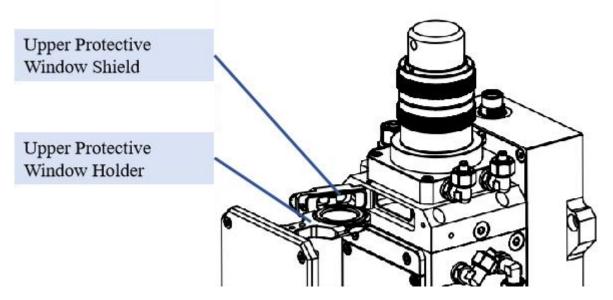


Figure 5-10 Change protective window

Procedures to change the upper protective window are shown below:

- Step 1 Open the upper protective window shield.
- **Step 2** Pull out the upper protective window cartridge.
- Step 3 Close the protective window cartridge shield to prevent dust from entering.
- **Step 4** Remove the pressing ring from the protective window.
- Step 5 Replace the upper protective window.
- Step 6 Open the upper protective window cartridge shield.
- Step 7 Insert the upper protective window cartridge with the window into the cutting head.

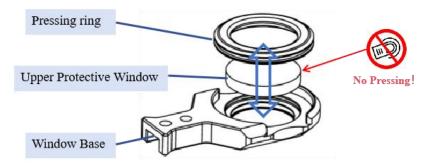


Figure 5-11 Insert window cartridge



A.3 Change the Lower Protective Window

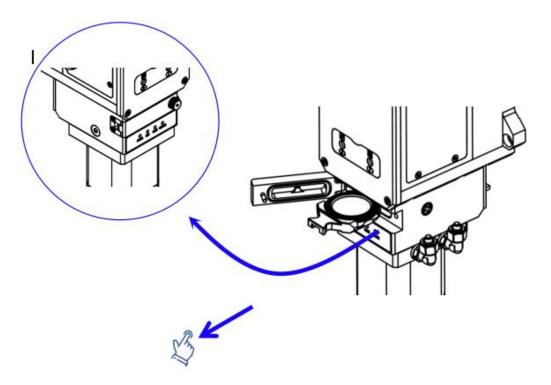


Figure 5-12 Change the lower protective window

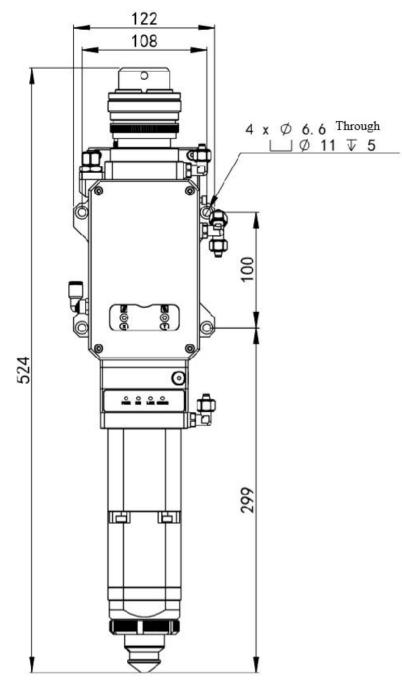
Procedures to change the lower protective window are shown below:

- Step 1 Press the button to open the lower protective window cartridge shield.
- Step 2 Pull out the lower protective window cartridge.
- Step 3 Close the lower protective window cartridge shield to prevent dust from entering.
- **Step 4** Remove the pressing ring from the protective window.
- Step 5 Replace the lower protective window.
- **Step 6** Open the lower protective window cartridge shield.
- Step 7 Insert the lower protective window cartridge with the window into the cutting head.

(1) BOCHU

Appendix B Mechanical Size

B.1 Installation Size for Cutting Head



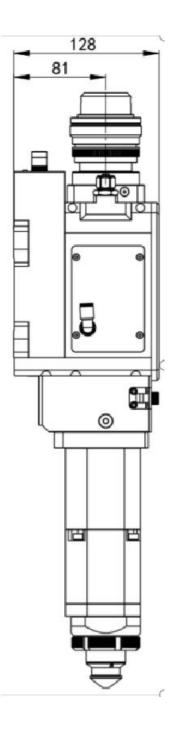


Figure 5-13 BLT 4122-Q+



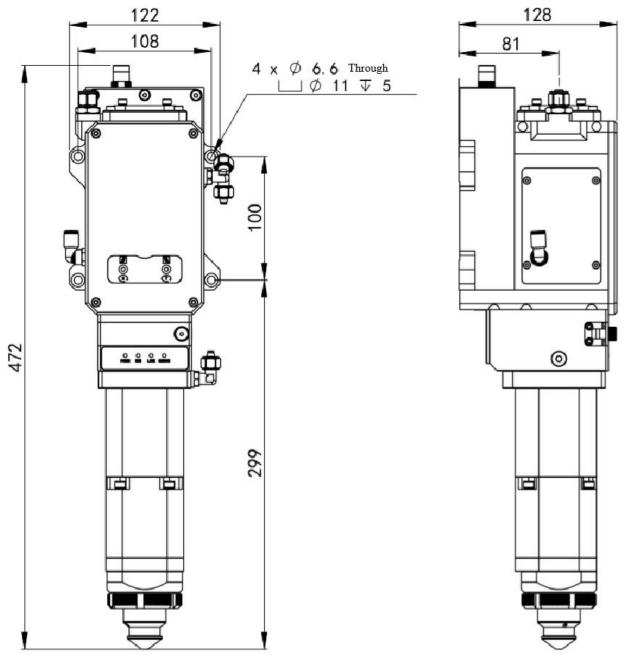


Figure 5-14 BLT4122-ADD



B.2 Interface Types

| General Type | Image | Other Compatible Interface Types |
|--------------|------------------|---|
| Q+ | Q+ | Raycus QPIPG HLC-16 |
| ADD | ADD Contractions | BWT QF-D Maxphotonics LOE 3.2 FEIBO HOC |

Table 5-1 Interface Types of BLT4122

Copyright Shanghai BOCHU Electronic Technology Co., Ltd.



Shanghai BOCHU Electronic Technology Co., Ltd.

No. 1000, South Lanxianghu Road, Minhang District, Shanghai City, China

Web: www.bochu.com Tel: +86(21)64309023 Email: Support@bochu.com

