

BLT 442T Intelligent Cutting Head

Product Manual

Version: 1.0.0



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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 BOCHU Technology, otherwise the warranty will be invalid!

Revision History

Version No.	Date	Description
1.0.0	2024/12/05	First version

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Chapter 1 Product Specification

1.1 Product View

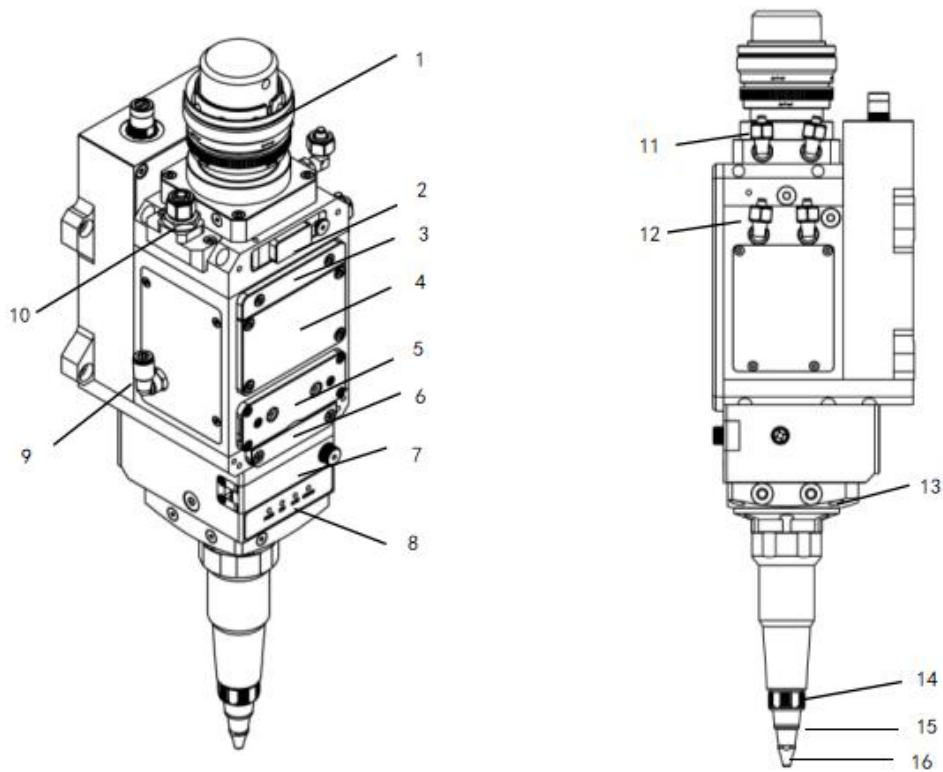


Figure 1-1 Product view

- | | |
|---------------------------------|----------------------------------|
| 1. Fiber optic interface; | 9. Nozzle cooling air interface; |
| 2. 1st upper protective window; | 10. Cutting gas interface; |
| 3. 2nd upper protective window; | 11. Cooling water inlet; |
| 4. Alignment module; | 12. Cooling water outlet; |
| 5. Focusing module; | 13. Protective screw; |
| 6. 2nd lower protective window; | 14. Ceramic body locking ring; |
| 7. 1st lower protective window; | 15. Ceramic body; |
| 8. Work indicator light; | 16. Nozzle; |

1.2 Technical Parameters

Table 1-1 BLT 442T Cutting Head Technical Parameters

Cutting Head Parameters	Values
Laser Wavelength	1030 ~ 1090 nm
Laser Power	≤ 15 kW
Fiber Interface	Q+/QD/QBH/ADD
Spot Magnification	M = 2.0/2.5
Max Focusing Adjustment Range	±50 mm
NA	Max 0.13 at Fc100
Alignment Adjustment Range	±1.5 mm
Focusing Acceleration	7.5 m/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 ~ 55°C
Storage Temperature	-25 ~ +55°C
Dimension	478.6 x 122 (M = 2.5, Q+ Interface Version)
Weight	About 6.5 kg





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



Caution:

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

Chapter 2 Gas Interfaces

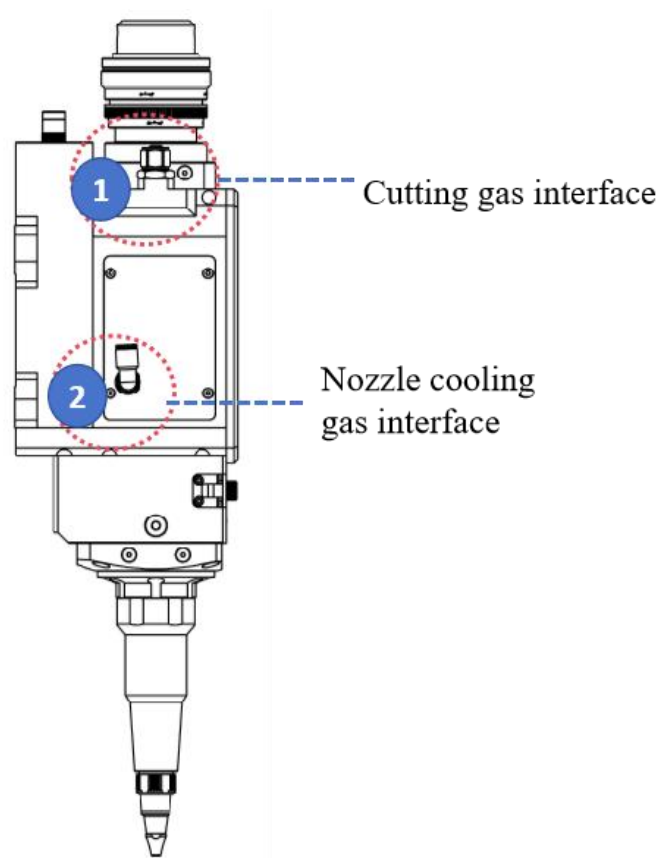


Figure 2-1 Installation connection: Cutting gas 1 and nozzle cooling gas 2



Caution:

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

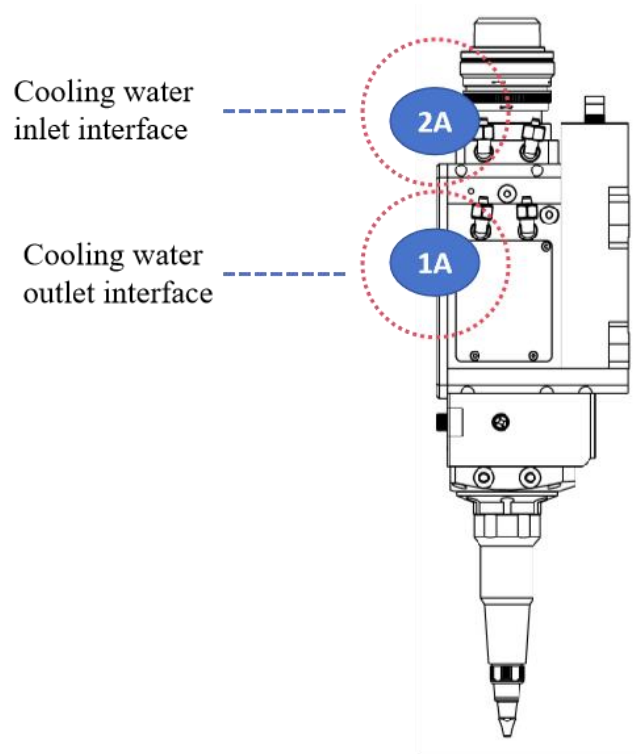


Figure 3-1 Cooling water inlet: 2A, Outlet: 1A.

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 $-10\sim 0^{\circ}\text{C}$, a 30% ethylene glycol solution must be used and replaced every two months.
4. When the temperature around the device is below -10°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 $\leq 5\text{ bar}$ (0.5 MPa), water flow rate $\geq 2.0\text{ L/min}$.
6. Please refer to the dew point table for setting the cooling water temperature to prevent condensation on optical components.

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

Air Temperature °C	Relative Humidity																		
	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	6	4	4	3	2	1	0										
4	4	4	3	2	1	0													
2	2	1	0																
0	0																		

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 cable 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

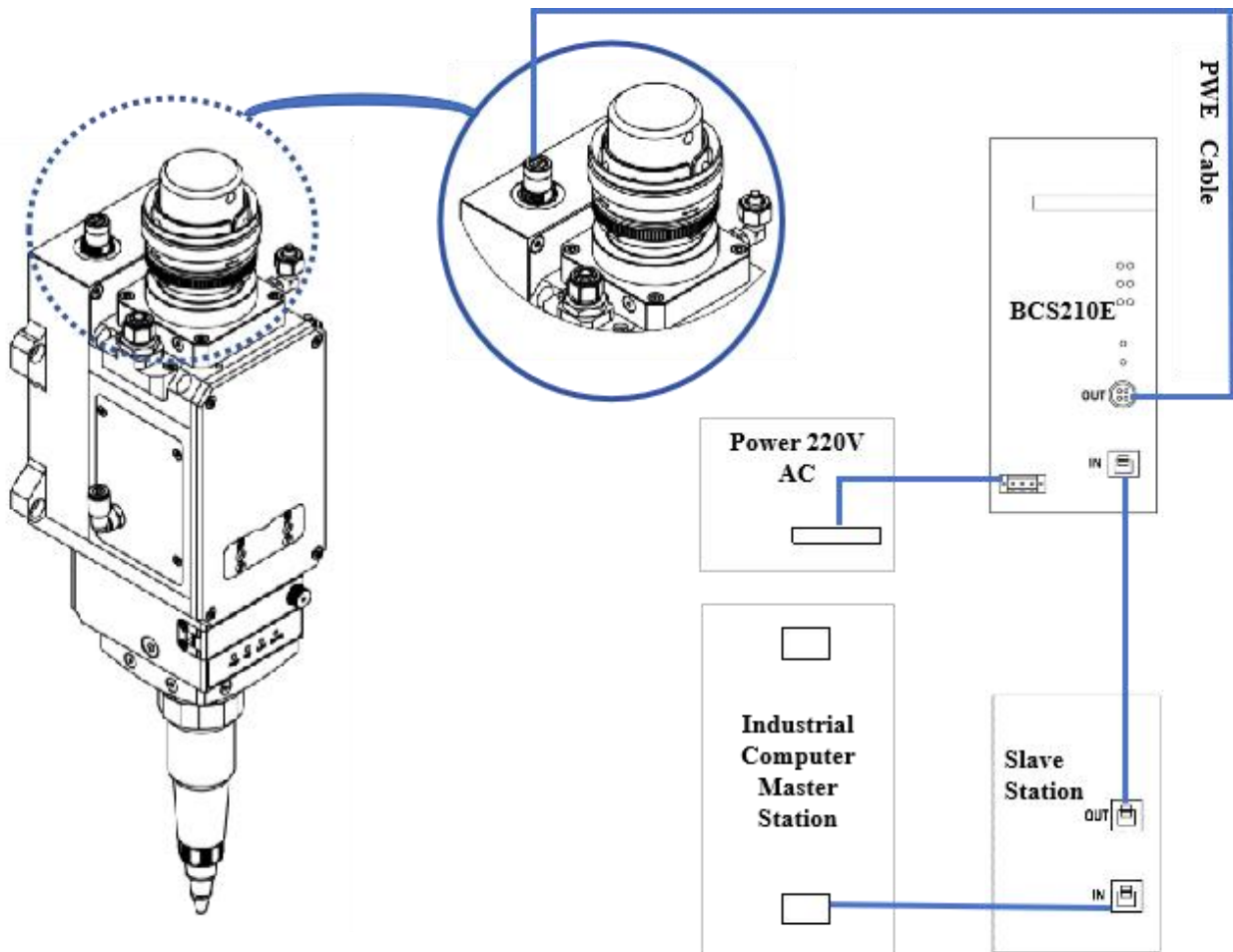


Figure 4-1 Bus system



Caution:

1. Only the personnel who has received the training and has the professional knowledge can perform the operations above.
2. BCS210E shall be powered off when connecting the cutting head.

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).

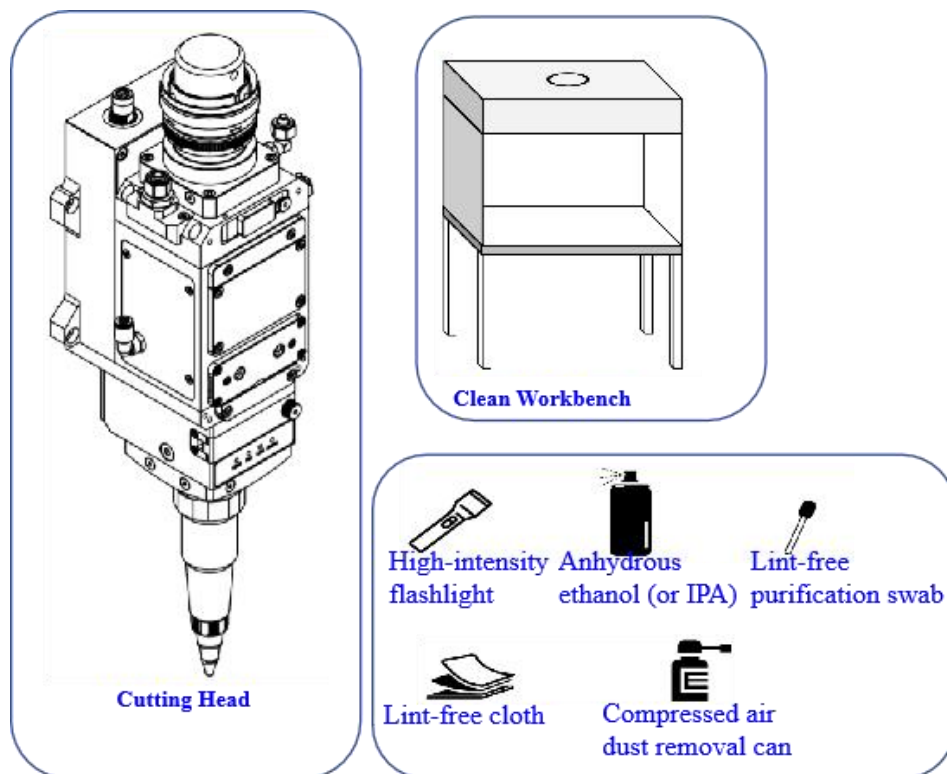


Figure 5-1 Example

**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.

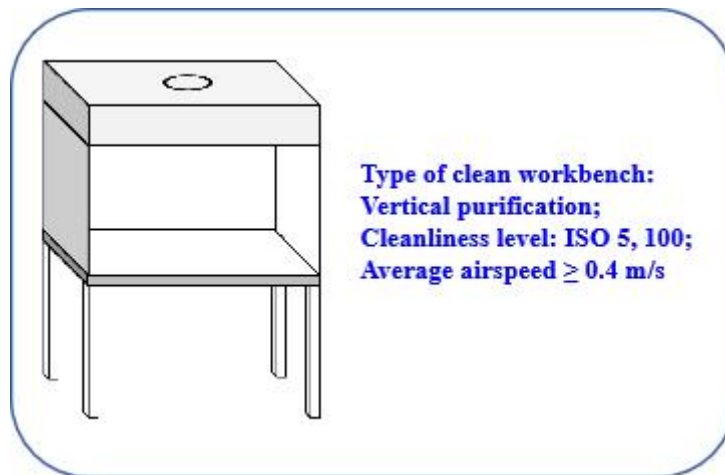


Figure 5-2 Clean workbench

- 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.

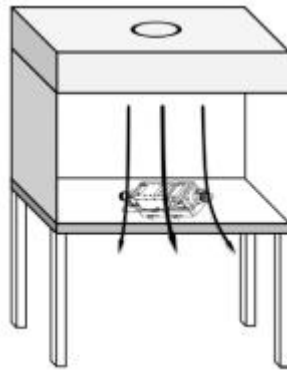


Figure 5-3 Cutting head inside the workbench



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

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.

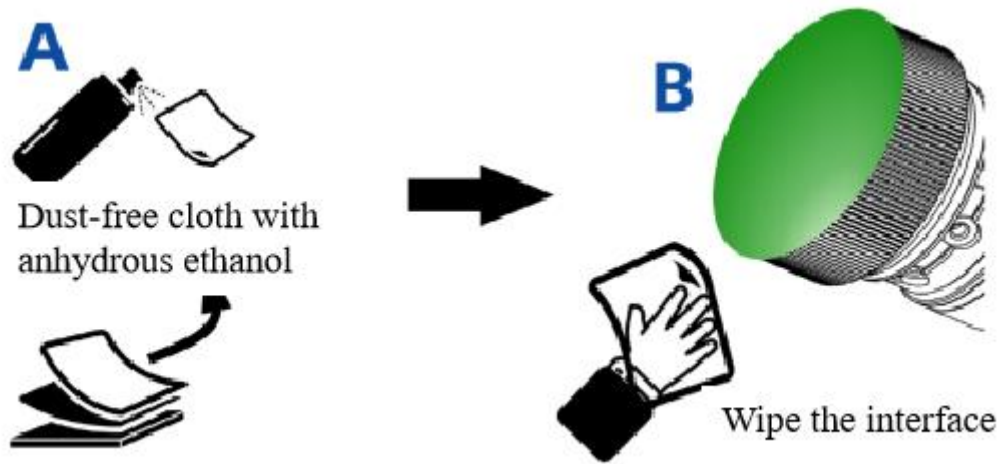


Figure 5-4 Clean the interface

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.

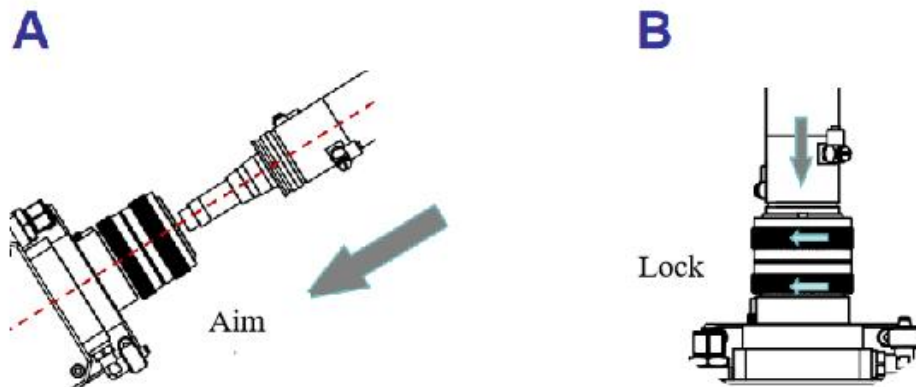


Figure 5-5 Inset the fiber connector

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.

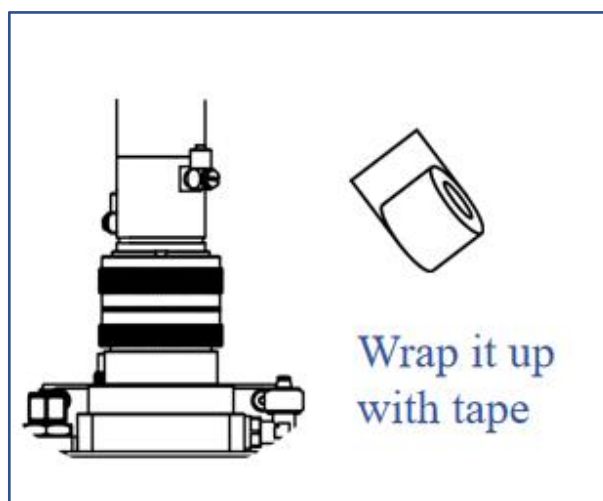


Figure 5-6 Wrap & seal



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

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.

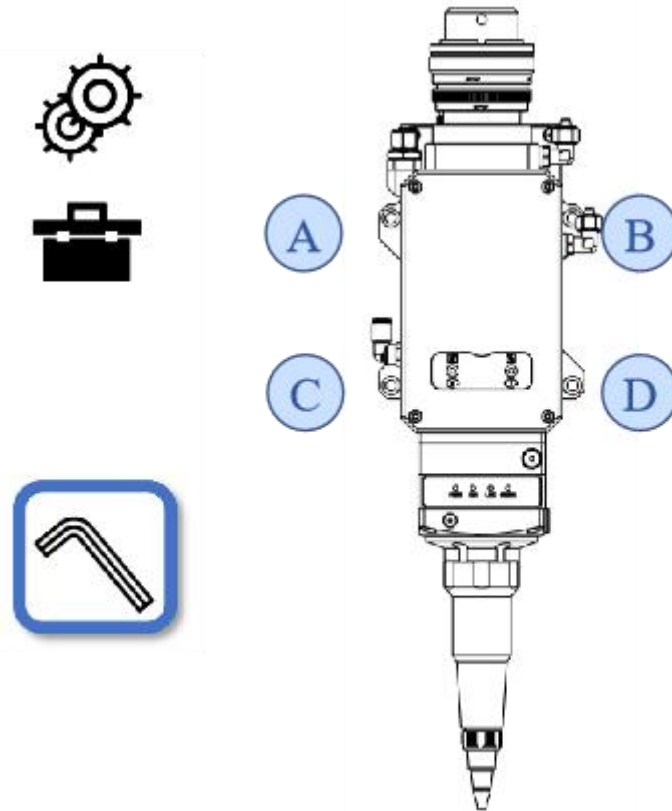


Figure 5-7 Screw A, B, C, D

5.2.9 Install the Ceramic Body and Nozzle

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

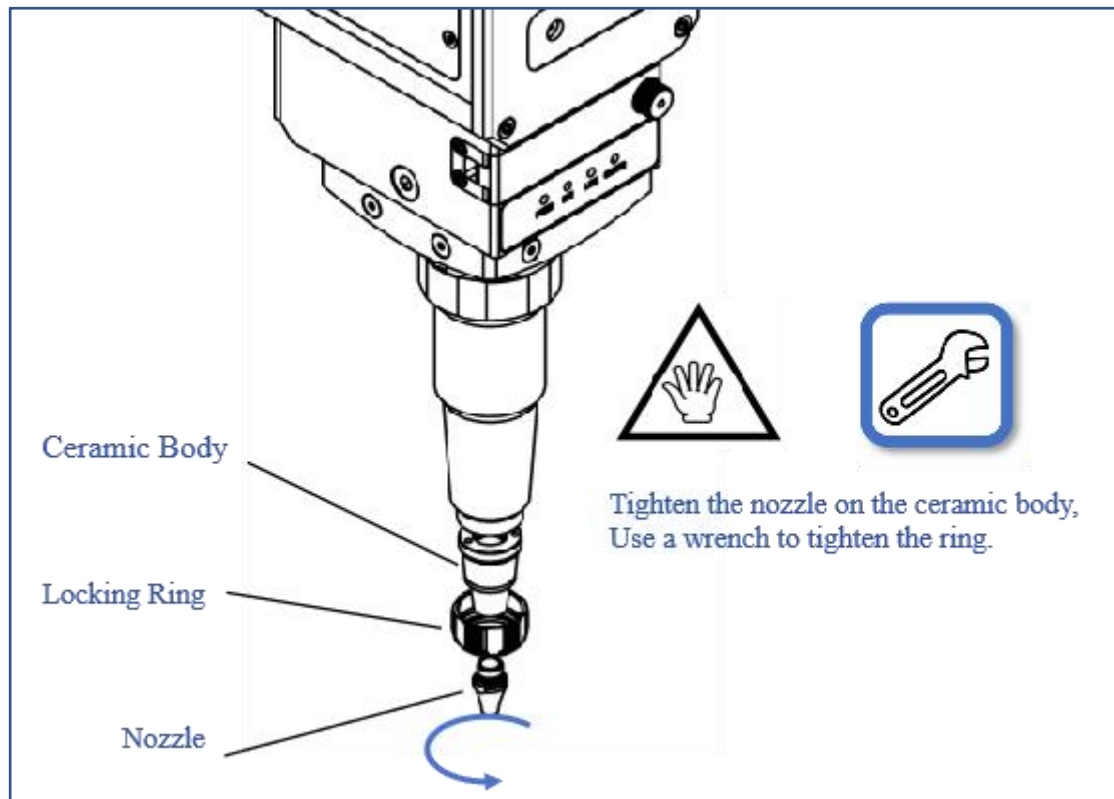


Figure 5-8 Ceramic body and nozzle

5.2.10 Nozzle Centering

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

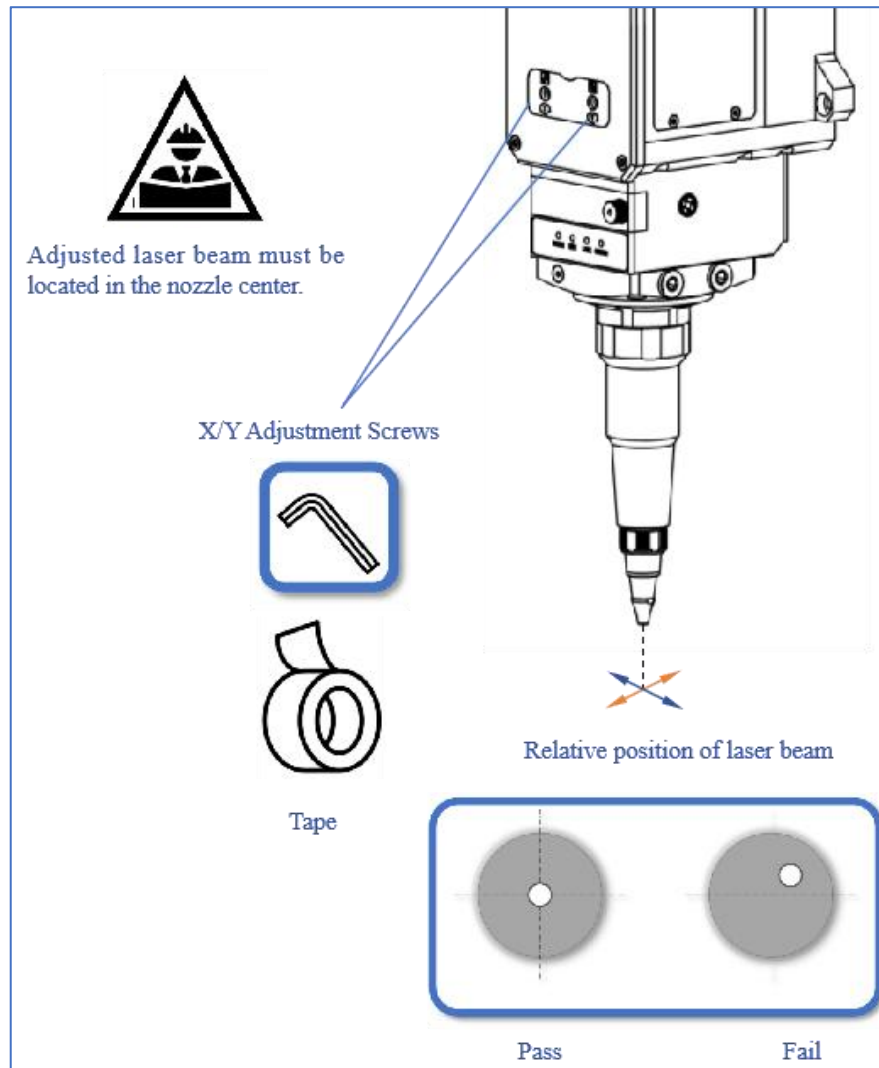


Figure 5-9 Beam centering

Manual Operations for Beam Centering:

- Step 1** Make sure the laser beam has been turned off.
- Step 2** Put the tape below 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.

Chapter 6 Appendix A Maintenance

A.1 Product Structure Diagram

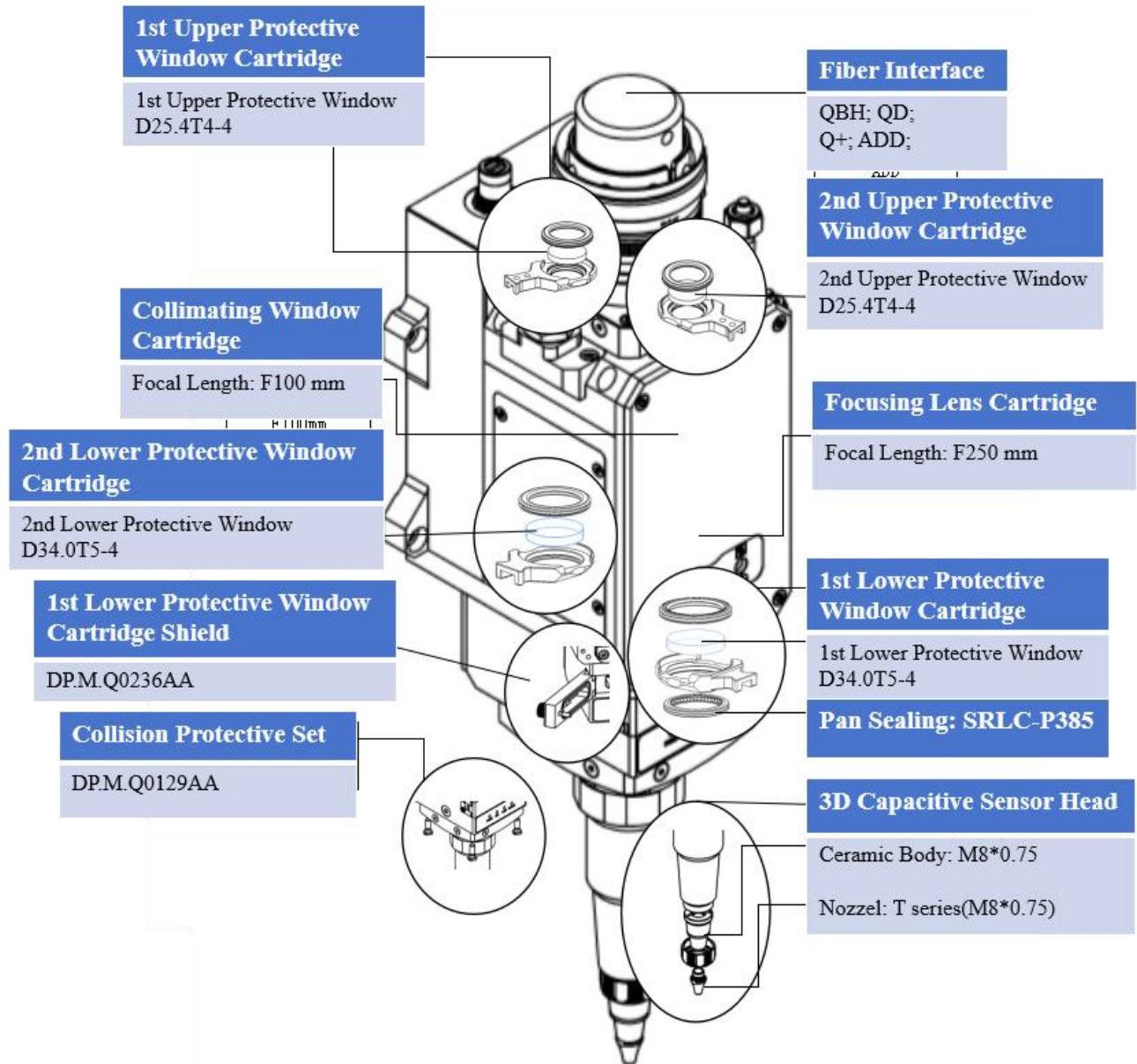


Figure 6-1 Product Structure Diagram

A.2 Change the Upper Protective Window

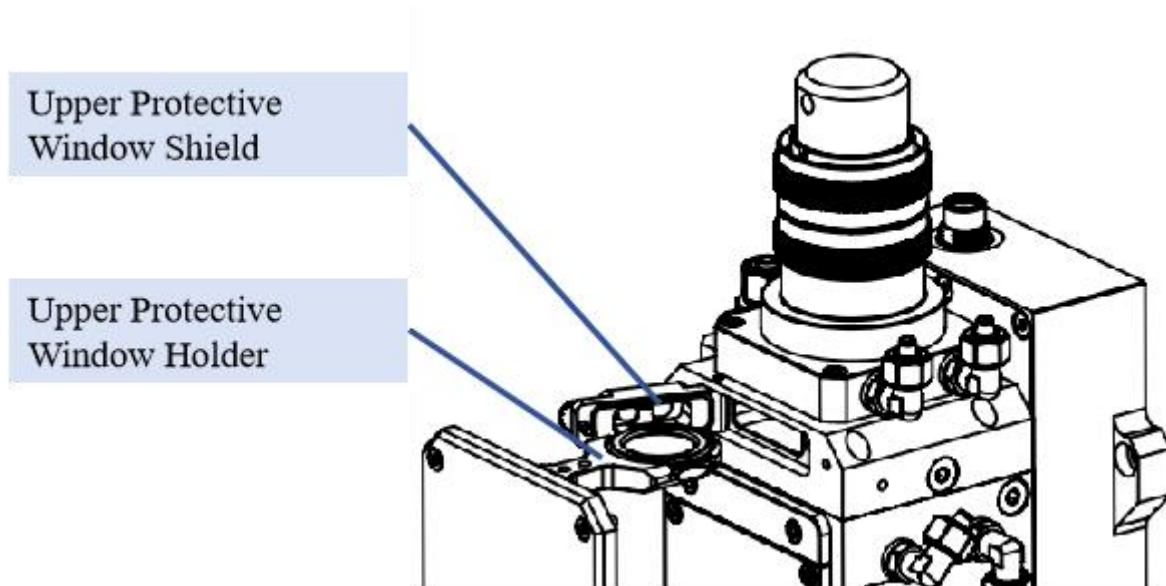


Figure 6-2 Change protective window

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.

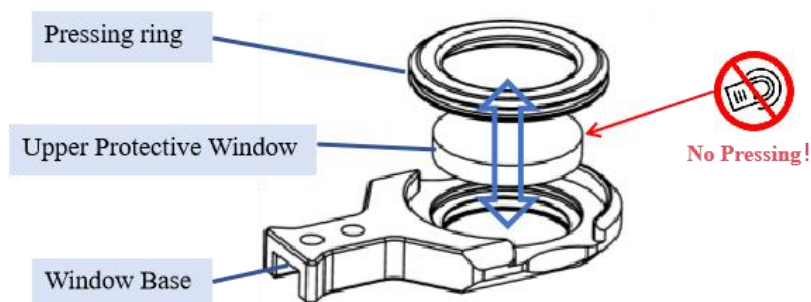


Figure 6-3 Insert window cartridge

A.3 Change the Lower Protective Window

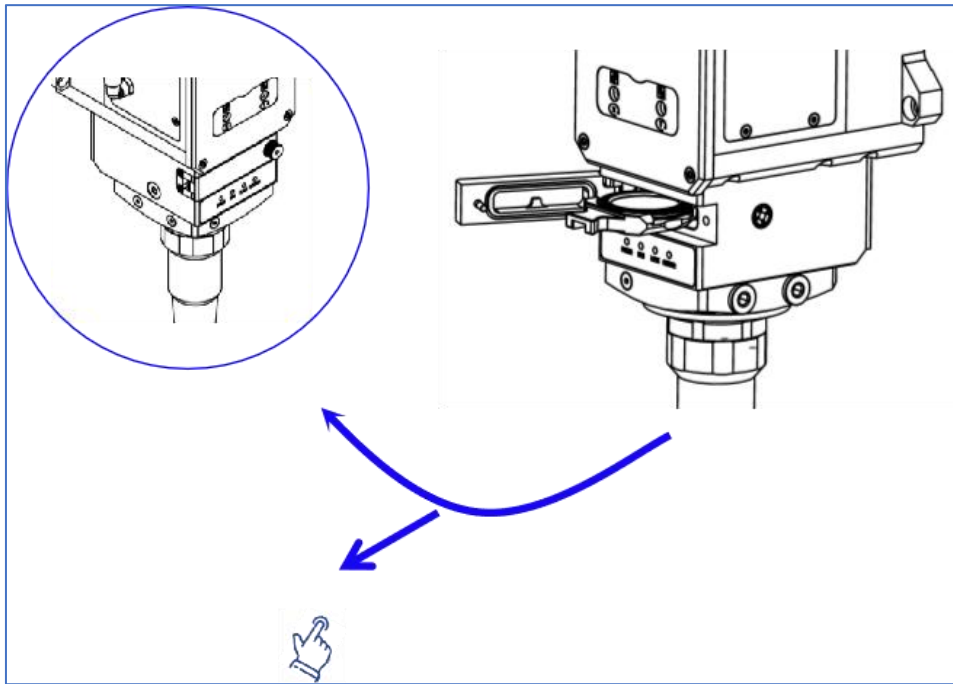


Figure 6-4 Change the lower protective window

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.

Chapter 7 Appendix B Mechanical Size

B.1 Installation Size for Cutting Head

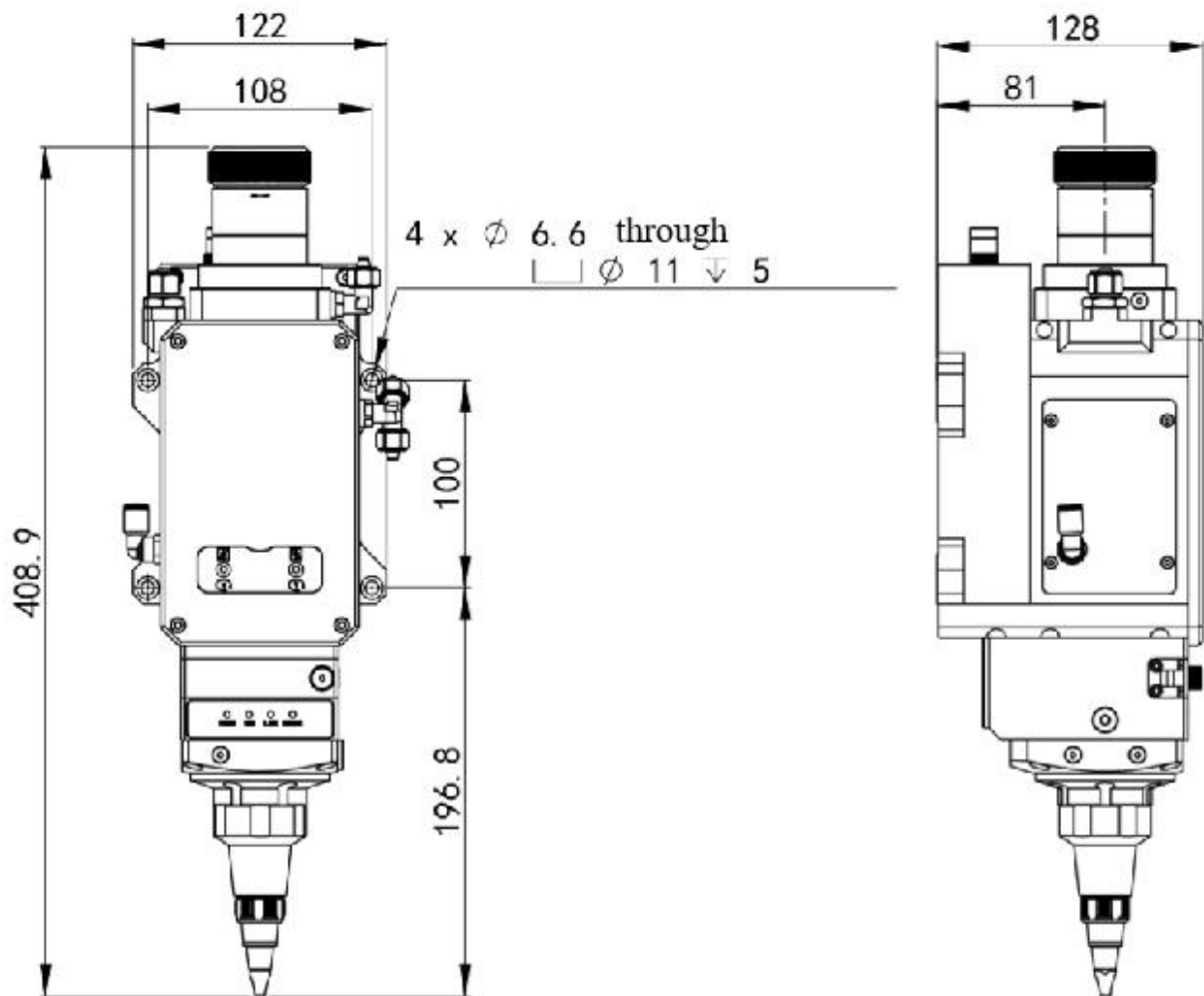


Figure 7-1 BLT 442T-QBH(M=2.0)

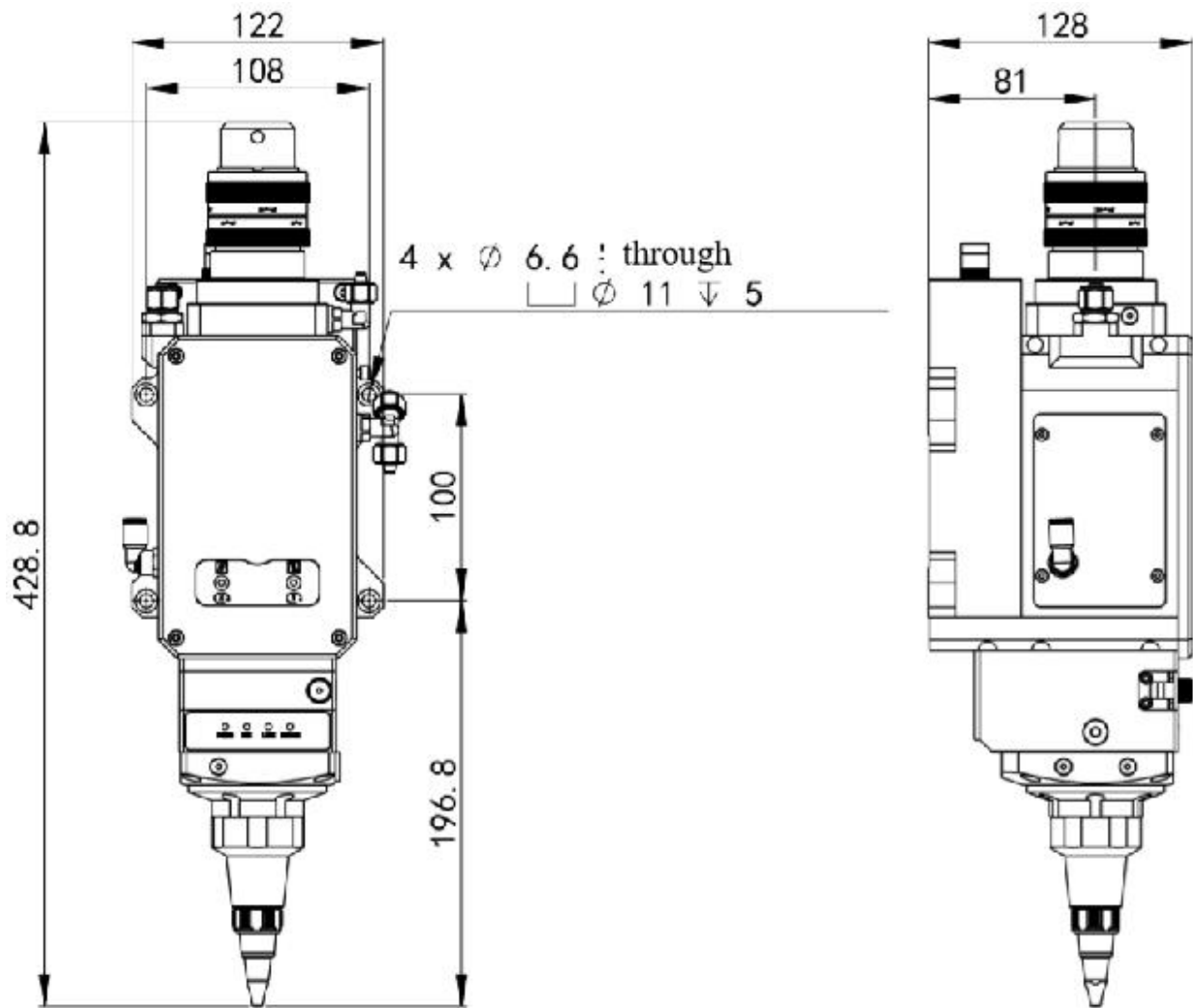


Figure 7-2 BLT442T-QD (M=2.0)

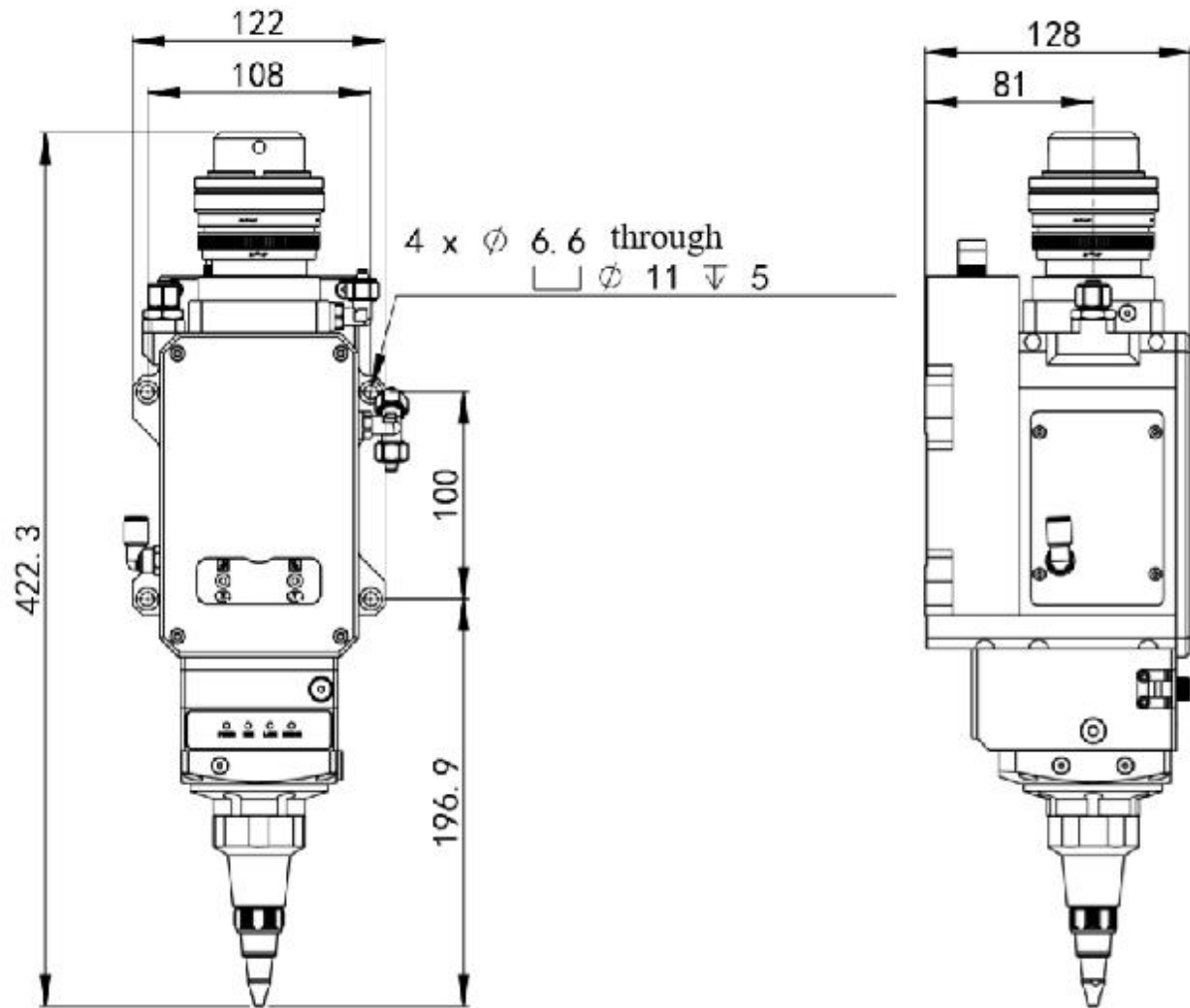


Figure 7-3 BLT442T-Q+(M=2.0)

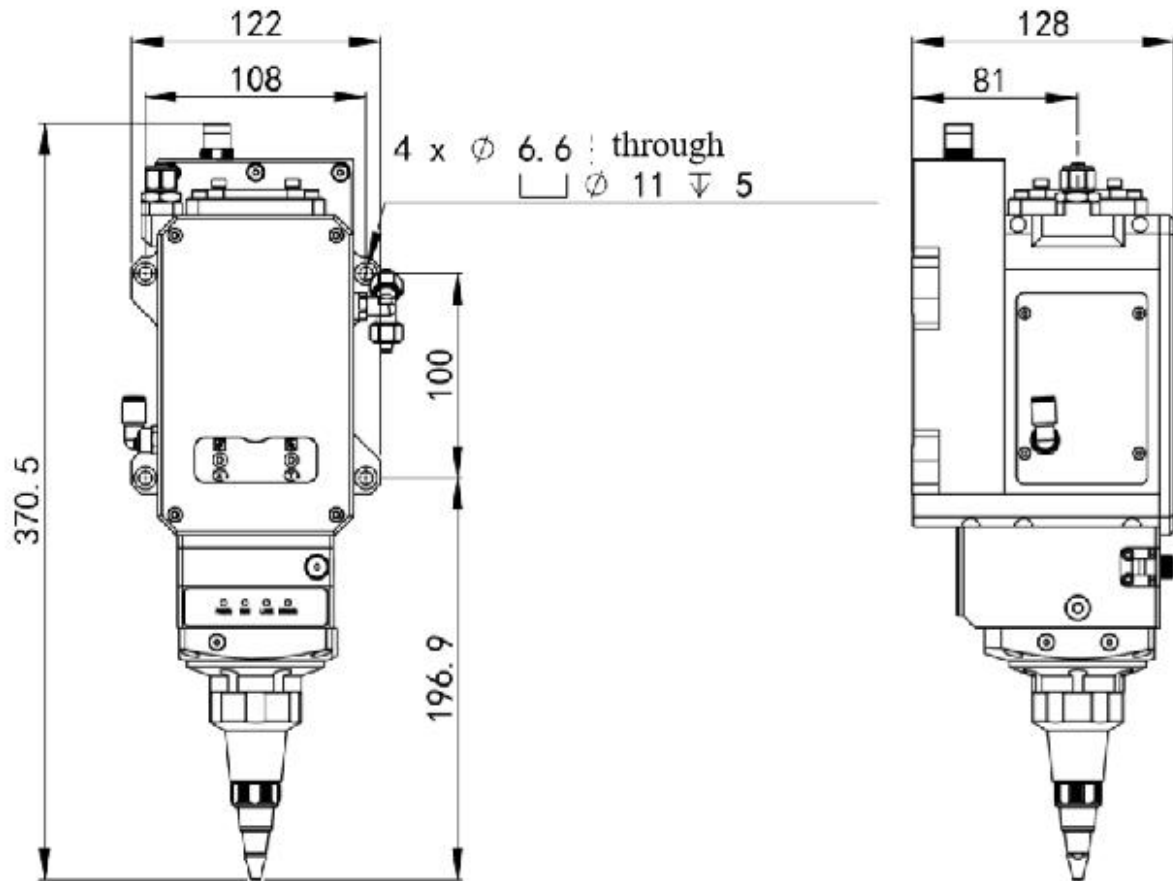


Figure 7-4 BLT442T-ADD(M=2.0)

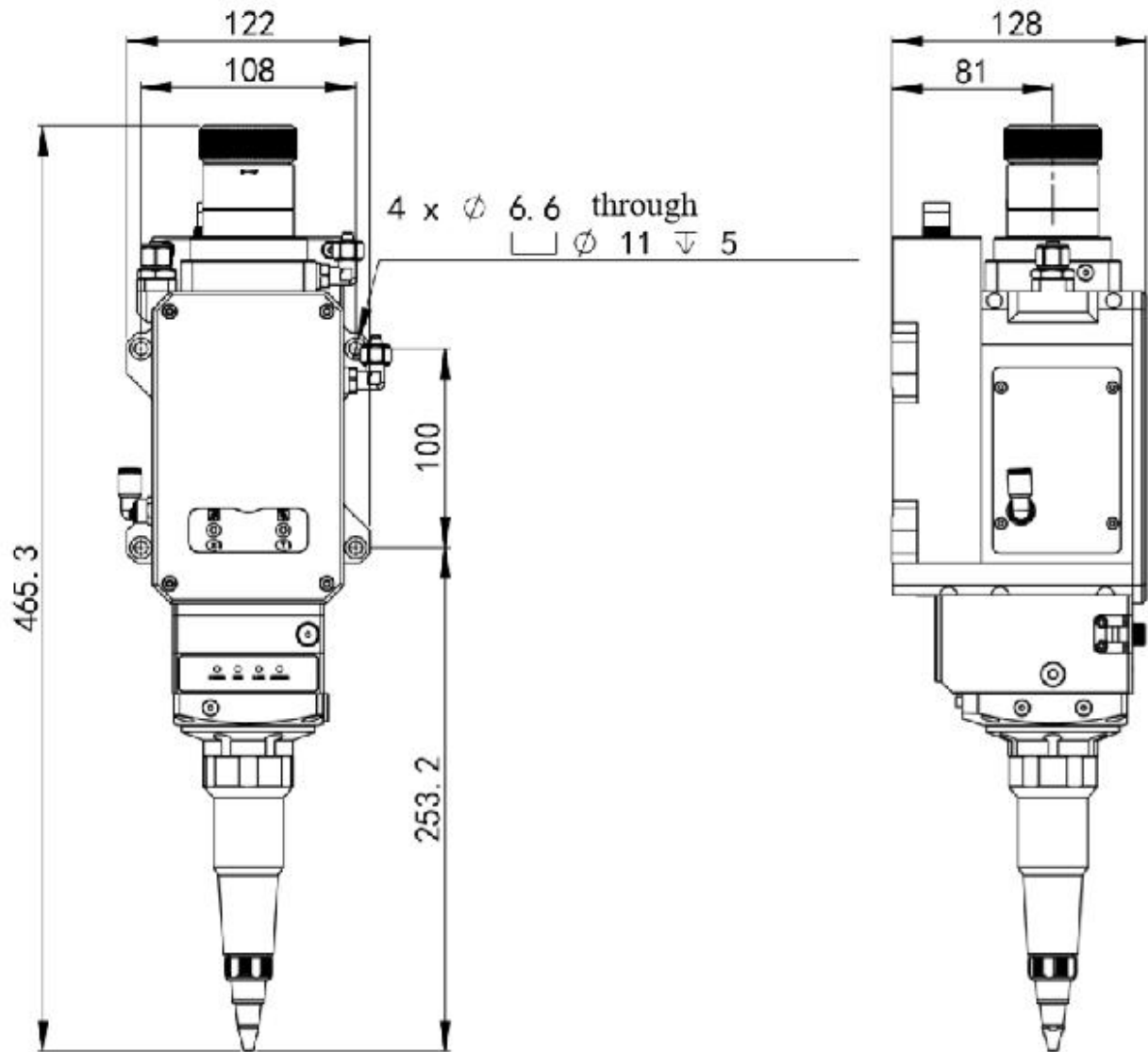


Figure 7-5 BLT442T-QBH(M=2.5)

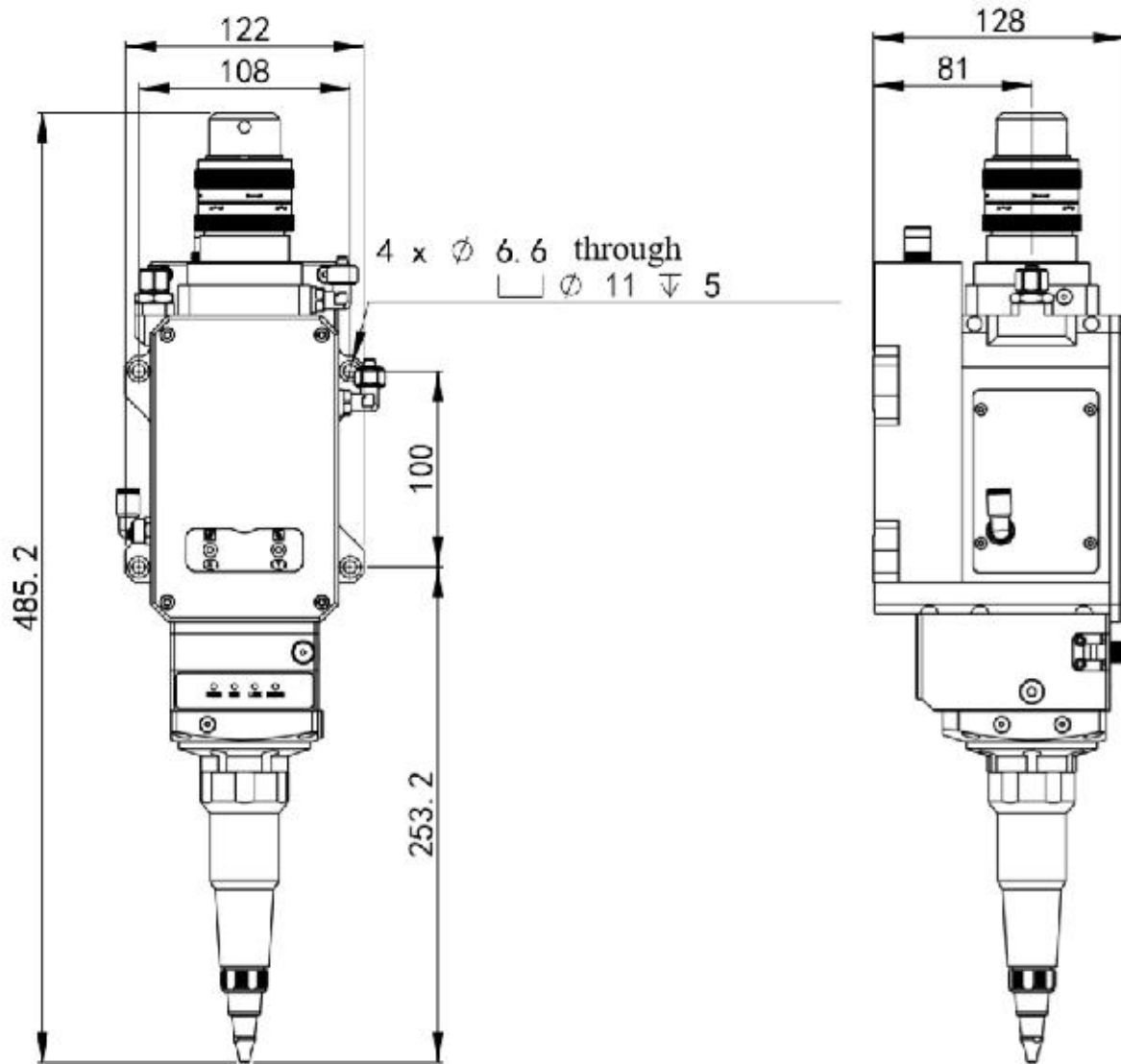


Figure 7-6 BLT442T-QD(M=2.5)

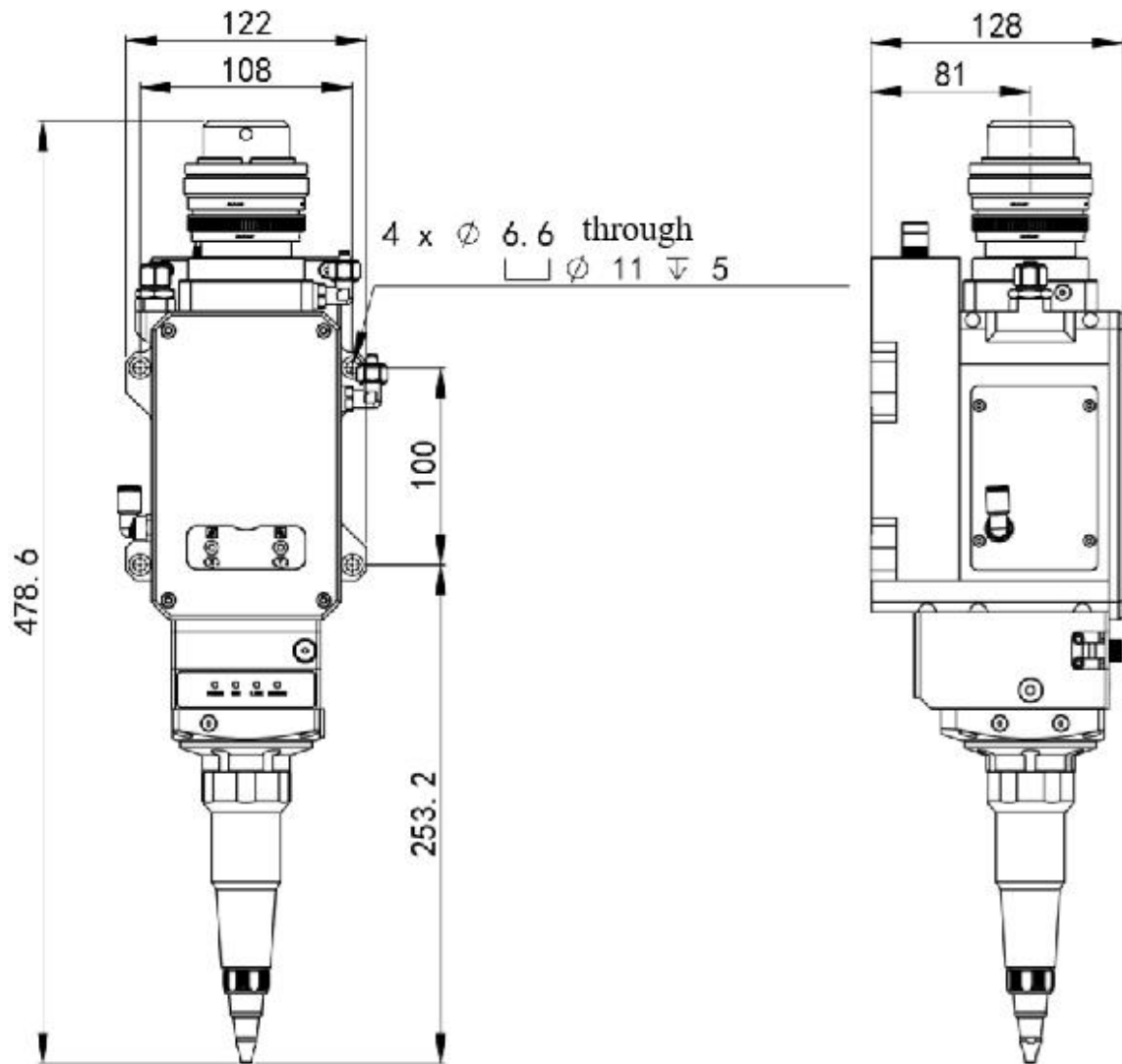


Figure 7-7 BLT442T-Q+(M=2.5)

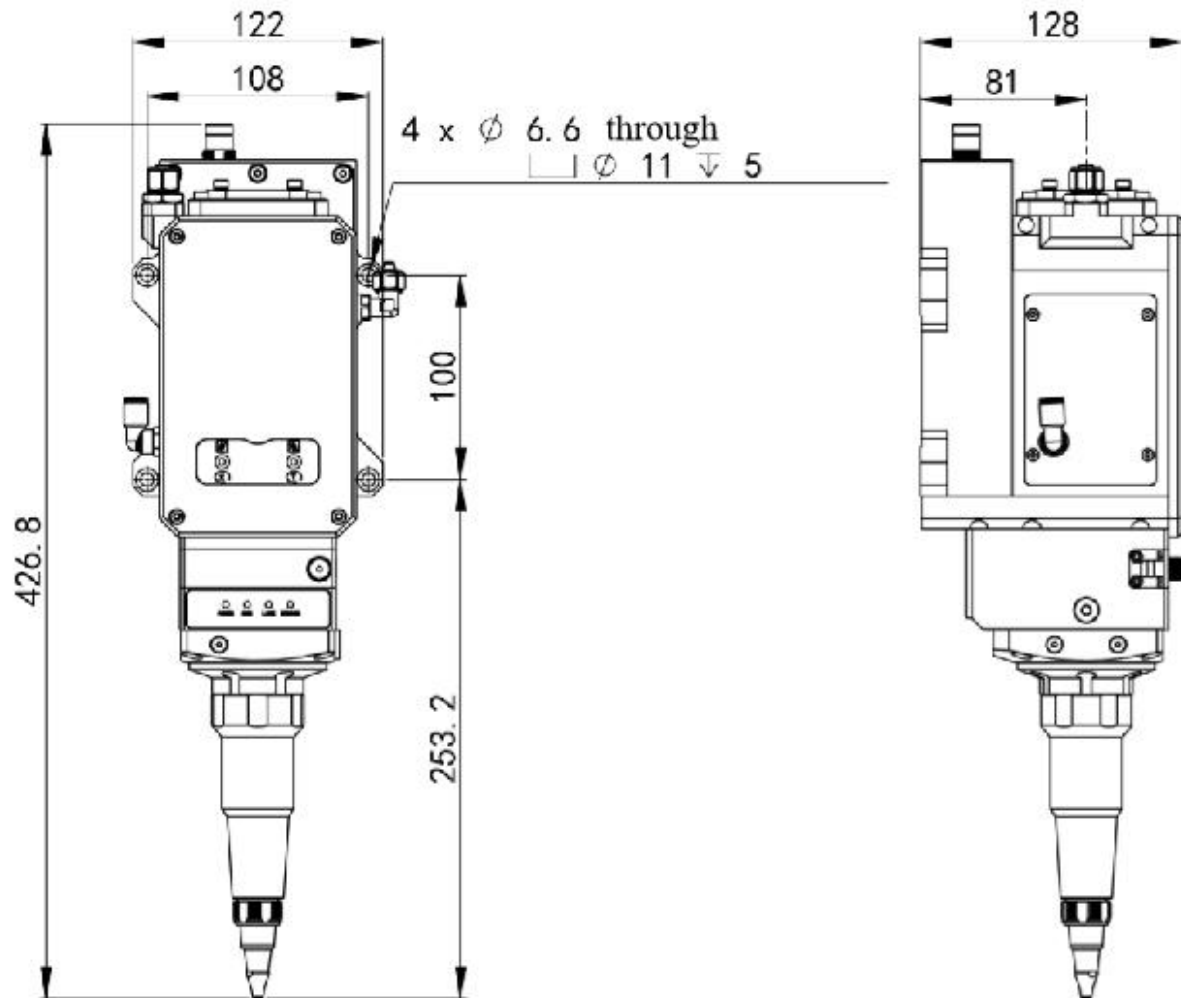

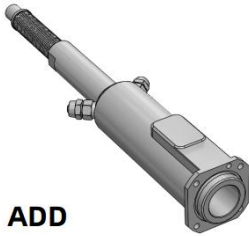


Figure 7-8 BLT442T-ADD(M=2.5)

B.2 Interface Types

Table 7-1 Interface Types of BLT442T

General Type	Image	Other Compatible Interface Types
QBH		<ul style="list-style-type: none"> ● Trumpf LLK-Q ● IPG HLC-8/LC-8
QD		<ul style="list-style-type: none"> ● Trumpf LLK-D, ● HIGHYAG LLK-Auto ● IPG LCA
Q+		<ul style="list-style-type: none"> ● Raycus QP ● IPG HLC-16
ADD		<ul style="list-style-type: none"> ● BWT QF-D ● Maxphotonics LOE 3.2 ● FEIBO HOC



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