TABLE OF CONTENTS

INTRODUCTION			
1.1 Las	ERS IN MATERIALS PROCESSING		
	EF REVIEW OF THE DEVELOPMENT OF LASER CUTTERS		
	EARCH OBJECTIVE		
	F LASER CUTTING OF MATERIALS		
2.1 CO ₂	LASER	6	
2.2 TYP	ES OF CO2 LASER	8	
2.2.1	Sealed-off System		
2.2.2	Slow-flow System		
2.2.3	Fast-flow System		
	ER MODES AND FOCUSING PROPERTIES		
2.3.1	Transverse Mode and Gaussian Beam		
2.3.2	Focusing Properties and Spot Size		
	ER CUTTING MECHANISM	l·	
2.4.1	Light Absorption Process in Laser Cutting	I.	
2.4.2	Thermal Heat Transport		
2.4.3 2.4.4	Energy Requirement		
	Plasma Ionisation Effect	/	
2.5 POS 2.5.1	Closed Loop Positioning Scheme	21	
2.5.1	Position Controller		
2.5.2			
2.5.2		2	
2.5.2			
2.5.3	Motor		
2.5.4	Controller Language: MINT	2	
DESIGN AN	IDINTECRATION	21	
	ID INTEGRATION		
3.1 INT	EGRATION OF THE LASER SYSTEM	30	
3.1 INTI 3.1.1	egration of the Laser System	30	
3.1 INTI 3.1.1 3.1.2	GGRATION OF THE LASER SYSTEM	30	
3.1 INTE 3.1.1 3.1.2 3.1.3	EGRATION OF THE LASER SYSTEM Power Supply Optical Resonator – output coupler, back mirror	30	
3.1 INTI 3.1.1 3.1.2 3.1.3 3.1.4	GRATION OF THE LASER SYSTEM Power Supply Optical Resonator – output coupler, back mirror Discharge Channels and Electrodes Cooling System and Gas Recirculating System	30	
3.1 INTI 3.1.1 3.1.2 3.1.3 3.1.4 3.1.5	GRATION OF THE LASER SYSTEM Power Supply. Optical Resonator – output coupler, back mirror Discharge Channels and Electrodes Cooling System and Gas Recirculating System Vacuum Pump	31 3. 3.	
3.1 INTI 3.1.1 3.1.2 3.1.3 3.1.4 3.1.5 3.2 DES	GRATION OF THE LASER SYSTEM. Power Supply. Optical Resonator – output coupler, back mirror	3: 3: 3.	
3.1 INTI 3.1.1 3.1.2 3.1.3 3.1.4 3.1.5 3.2 DES 3.3 INTE	GRATION OF THE LASER SYSTEM Power Supply. Optical Resonator – output coupler, back mirror Discharge Channels and Electrodes Cooling System and Gas Recirculating System Vacuum Pump IGN OF THE FRAME STRUCTURE AND THE JIG GRATION OF THE FRAME STRUCTURE AND THE JIG GRATION OF THE FRAME STRUCTURE AND THE JIG	31 3. 3. 3.	
3.1 INTI 3.1.1 3.1.2 3.1.3 3.1.4 3.1.5 3.2 DES 3.3 INTE 3.4 DES	GRATION OF THE LASER SYSTEM Power Supply. Optical Resonator – output coupler, back mirror Discharge Channels and Electrodes Cooling System and Gas Recirculating System Facuum Pump IGN OF THE FRAME STRUCTURE AND THE JIG GRATION OF THE HYBRID POSITIONING SYSTEM KON OF THE BEAM TRANSPORT SYSTEM AND AUXILIARY COMPONENTS	30 3. 3. 3. 3.	
3.1 INTI 3.1.1 3.1.2 3.1.3 3.1.4 3.1.5 3.2 DES 3.3 INTI 3.4 DES 3.4.1	GRATION OF THE LASER SYSTEM Power Supply Optical Resonator – output coupler, back mirror Discharge Chamnels and Electrodes Cooling System and Gas Recirculating System Vacuum Pump IGN OF THE FRAME STRUCTURE AND THE JIG IGN OF THE FRAME STRUCTURE AND THE JIG IGN OF THE BEAM TRANSPORT SYSTEM AND AUXILIARY COMPONENTS Beam Folding Mirror	30 3. 3. 3. 3.	
3.1 INTI 3.1.1 3.1.2 3.1.3 3.1.4 3.1.5 3.2 DES 3.3 INTE 3.4 DES	GRATION OF THE LASER SYSTEM Power Supply. Optical Resonator – output coupler, back mirror Discharge Channels and Electrodes Cooling System and Gas Recirculating System Vacuum Pump IGN OF THE FRAME STRUCTURE AND THE HIG GRATION OF THE HYBRID POSITIONING SYSTEM IGN OF THE BEAM TRANSPORT SYSTEM AND AUXILIARY COMPONENTS Beam Folding Mirror Beam Shutter and Beam Absorber	30 3. 3. 3. 3. 3.	
3.1 INTI 3.1.1 3.1.2 3.1.3 3.1.4 3.1.5 3.2 Dess 3.3 INTI 3.4 DES 3.4.1 3.4.2	GRATION OF THE LASER SYSTEM. Power Supply. Optical Resonator – output coupler, back mirror. Discharge Charmels and Electrodes. Cooling System and Gas Recirculating System. Vacuum Pump. IGN OF THE FRAME STRUCTURE AND THE JIG GRATION OF THE HYBRID POSITIONING SYSTEM. IGN OF THE BEAM TRANSFORT SYSTEM AND AUXILLARY COMPONENTS. Beam Folding Mirror. Beam Shutter and Beam Absorber. Laser Head and Assist Gas.	30 3. 3. 3. 36 36 36	
3.1 INTI 3.1.2 3.1.3 3.1.4 3.1.5 3.2 DES 3.3 INTI 3.4 DES 3.4.1 3.4.2 3.4.3 3.4.3 3.4.3	GRATION OF THE LASER SYSTEM Power Supply Optical Resonator – output coupler, back mirror Discharge Charmels and Electrodes Cooling System and Gas Recirculating System Vacuum Pump GRA OF THE FRAME STRUCTURE AND THE JIG GRATION OF THE FRAME STRUCTURE AND THE JIG GRATION OF THE HYBRID POSITIONING SYSTEM IGN OF THE BEAM TRANSPORT SYSTEM AND AUXILIARY COMPONENTS Beam Folding Mirror Beam Shutter and Beam Absorber Laser Head and Assist Gas 1. Focusing Lens 2. Assist Gas	36 333 334 336 338 338 338	
3.1 INTI 3.1.2 3.1.3 3.1.4 3.1.5 3.2 DES 3.3 INTI 3.4 DES 3.4.1 3.4.2 3.4.3 3.4.3 3.4.3	GRATION OF THE LASER SYSTEM Power Supply Optical Resonator – output coupler, back mirror Discharge Charmels and Electrodes Cooling System and Gas Recirculating System Vacuum Pump GRA OF THE FRAME STRUCTURE AND THE JIG GRATION OF THE FRAME STRUCTURE AND THE JIG GRATION OF THE HYBRID POSITIONING SYSTEM IGN OF THE BEAM TRANSPORT SYSTEM AND AUXILIARY COMPONENTS Beam Folding Mirror Beam Shutter and Beam Absorber Laser Head and Assist Gas 1. Focusing Lens 2. Assist Gas	36 333 334 336 338 338 338	
3.1 INTI 3.1.1 3.1.2 3.1.3 3.1.4 3.1.5 3.2 DES 3.3 INTI 3.4 DES 3.4.1 3.4.2 3.4.3 3.4.3 3.4.4 3.5 DEV	GRATION OF THE LASER SYSTEM. Power Supply. Optical Resonator – output coupler, back mirror. Discharge Charnels and Electrodes. Cooling System and Gar Recirculating System. Vacuum Pump. GRO OF THE FRAME STRUCTURE AND THE IIG GRATION OF THE HYBRID POSITIONING SYSTEM. GRATION OF THE BEAM TRANSPORT SYSTEM AND AUXILLARY COMPONENTS. Beam Folding Mirror. Beam Shutter and Beam Absorber. Laser Head and Assist Gas. 1. Focusing Lens. 2. Assist Gas. Parallelism and Beam Alignment. ELOPMENT OF THE CONTROLLING SOFTWARE: LASERCAM.	36 333 334 336 336 338 338 338 338	
3.1 INTI 3.1.1 3.1.2 3.1.3 3.1.4 3.1.5 3.2 DES 3.3 INTI 3.4 DES 3.4.1 3.4.2 3.4.3 3.4.3 3.4.4 3.5.5 DES	GRATION OF THE LASER SYSTEM	30 31 32 33 34 36 36 37 38 38 38 38 38 38 38 38 38 38 38 38 38	
3.1 INTI 3.1.1 3.1.2 3.1.3 3.1.4 3.1.5 3.2 DES 3.3 INTI 3.4.2 3.4.3 3.4.3 3.4.3 3.4.3 3.4.3 3.5.2 DES	GRATION OF THE LASER SYSTEM Power Supply. Optical Resonator – output coupler, back mirror Discharge Channels and Electrodes Cooling System and Gas Recirculating System Vacuum Piump IGN OF THE FRAME STRUCTURE AND THE HIG GRATION OF THE HYBRID POSITIONING SYSTEM IGN OF THE BEAM TRANSPORT SYSTEM AND AUXILIARY COMPONENTS Beam Flolding Mirror Beam Shutter and Beam Absorber Laser Head and Assist Gas 1. Focusing Lens 2. Assist Gas Parallelism and Beam Alignment ELOPMENT OF THE CONTROLLING SOFTWARE: LASERCAM RS232 Protocol.	30 31 32 33 34 36 36 37 38 38 38 38 38 38 38 38 38 38 38 38 38	
3.1 INTI 3.1.1 3.1.2 3.1.3 3.1.4 3.1.5 3.2 DES 3.3 INTI 3.4 DES 3.4.1 3.4.2 3.4.3 3.4.3 3.4.3 3.5.5 3.5.1 3.5.1 3.5.2	GRATION OF THE LASER SYSTEM Power Supply Optical Resonator – output coupler, back mirror Discharge Chamnels and Electrodes Cooling System and Gas Recirculating System Vacuum Pump IGN OF THE FRAME STRUCTURE AND THE JIG IGRATION OF THE FRAME STRUCTURE AND THE JIG IGNATION OF THE HYBRID POSITIONING SYSTEM IGN OF THE BEAM TRANSPORT SYSTEM AND AUXILIARY COMPONENTS Beam Folding Mirror Beam Folding Mirror Beam Shutter and Beam Absorber Laser Head and Assist Gas 1. Focusing Lens 2. Assist Gas Parallelism and Beam Alignment ELOPMENT OF THE CONTROLLING SOFTWARE: LASERCAM RS232 Protocol Terminal Emulation Conversion Filter (PLIT to MINT)	30 31 32 32 32 32 32 32 32 32 32 32 32 32 32	
3.1 INTI 3.1.2 3.1.3 3.1.4 3.1.5 3.2 DES 3.3 INTI 3.4 DES 3.4.1 3.4.2 3.4.3 3.4.3 3.4.4 3.5 DEV 3.5.1 3.5.2 3.5.3	GRATION OF THE LASER SYSTEM Power Supply. Optical Resonator – output coupler, back mirror Discharge Channels and Electrodes Cooling System and Gas Recirculating System Vacuum Pimp KON OF THE FRAME STRUCTURE AND THE HIG GRATION OF THE HYBRID POSITIONING SYSTEM KON OF THE FRAME STRUCTURE AND THE HIG GRATION OF THE HYBRID POSITIONING SYSTEM KON OF THE BEAM TRANSPORT SYSTEM AND AUXILIARY COMPONENTS Beam Folding Mirror Beam Folding Mirror Beam Shatter and Beam Absorber Laser Head and Assist Gas 1 Focusing Icens 2. Assist Gas Parallelism and Beam Alignment ELOPMENT OF THE CONTROLLING SOFTWARE: LASERCAM RS332 Protocol Terminal Emulation Conversion Filter (PLI to MINT) Code Editing	30 32 33 33 34 36 36 37 38 38 38 38 38 38 38 40 41 41 41	
3.1 INTI 3.1.2 3.1.3 3.1.4 3.1.5 3.2 DES 3.4 DES 3.4.1 3.4.2 3.4.3 3.4.3 3.4.4 3.5 DEV 3.5.1 3.5.2 3.5.3 3.5.3 3.5.4	GRATION OF THE LASER SYSTEM Power Supply Optical Resonator – output coupler, back mirror Discharge Charmels and Electrodes Cooling System and Gas Recirculating System Vacuum Pump IGN OF THE FRAME STRUCTURE AND THE JIG GRATION OF THE HYBRID POSITIONING SYSTEM IGN OF THE HYBRID POSITIONING SYSTEM IGN OF THE BEAM TRANSPORT SYSTEM AND AUXILLARY COMPONENTS Beam Folding Mirror Beam Folding Mirror Beam Shutter and Beam Absorber Laser Head and Assist Gas 1. Focusing Lens 2. Assist Gas Parallelism and Beam Alignment ELOPMENT OF THE CONTROLLING SOFTWARE: LASERCAM RS322 Protocol Terminal Emulation Coversion Filter (PLT to MINT) Code Editing Debugging and Simulation	30 31 32 33 34 36 36 37 38 38 38 38 38 38 38 40 41 41 42 42 42	
3.1 INTI 3.1.2 3.1.3 3.1.4 3.1.5 3.2 DES 3.3 INTI 3.4 DES 3.4.1 3.4.2 3.4.3 3.4.3 3.4.3 3.4.3 3.4.3 3.5.5 3.5.5 3.5.5 3.5.5 3.5.5 3.5.5 3.5.5 3.5.5	GRATION OF THE LASER SYSTEM Power Supply Optical Resonator – output coupler, back mirror Discharge Chamnels and Electrodes Cooling System and Gas Recirculating System Vacuum Pump IGN OF THE FRAME STRUCTURE AND THE JIG IGN OF THE FRAME STRUCTURE AND THE JIG IGN OF THE FRAME STRUCTURE AND THE JIG IGN OF THE BEAM TRANSPORT SYSTEM AND AUXILIARY COMPONENTS Beam Folding Mirror Beam Folding Mirror Beam Shutter and Beam Absorber Laser Head and Assist Gas 1. Focusing Lens 2. Assist Gas Parallelism and Beam Alignment ELOPMENT OF THE CONTROLLING SOFTWARE: LASERCAM RS232 Protocol Terminal Emulation Coversion Filter (PLT to MINT) Code Editing Pobugging and Simulation CAD (AutoCAD)	30 31 32 33 33 34 36 37 38 38 38 38 39 40 41 41 42 42 42	
3.1 INTI 3.1.2 3.1.3 3.1.4 3.1.5 3.2 DES 3.3 INTI 3.4 DES 3.4.1 3.4.2 3.4.3 3.4.3 3.4.3 3.4.3 3.4.3 3.5.5 3.5.5 3.5.5 3.5.5 3.5.5 3.5.5 3.5.5 3.5.5	GRATION OF THE LASER SYSTEM Power Supply Optical Resonator – output coupler, back mirror Discharge Charmels and Electrodes Cooling System and Gas Recirculating System Vacuum Pump IGN OF THE FRAME STRUCTURE AND THE JIG GRATION OF THE HYBRID POSITIONING SYSTEM IGN OF THE HYBRID POSITIONING SYSTEM IGN OF THE BEAM TRANSPORT SYSTEM AND AUXILLARY COMPONENTS Beam Folding Mirror Beam Folding Mirror Beam Shutter and Beam Absorber Laser Head and Assist Gas 1. Focusing Lens 2. Assist Gas Parallelism and Beam Alignment ELOPMENT OF THE CONTROLLING SOFTWARE: LASERCAM RS322 Protocol Terminal Emulation Coversion Filter (PLT to MINT) Code Editing Debugging and Simulation	30 31 32 33 33 34 36 37 38 38 38 38 39 40 41 41 42 42 42	
3.1 INTI 3.1.2 3.1.3 3.1.4 3.1.5 3.2 DES 3.3 INTI 3.4 DES 3.4.1 3.4.2 3.4.3 3.4.3 3.4.3 3.4.3 3.4.3 3.5.5 DEV 3.5.5 3.5.5 3.5.5 3.5.5 3.5.6 EXPERIME	GRATION OF THE LASER SYSTEM Power Supply Optical Resonator – output coupler, back mirror Discharge Chamnels and Electrodes Cooling System and Gas Recirculating System Vacuum Pump IGN OF THE FRAME STRUCTURE AND THE JIG IGN OF THE FRAME STRUCTURE AND THE JIG IGN OF THE FRAME STRUCTURE AND THE JIG IGN OF THE BEAM TRANSPORT SYSTEM AND AUXILIARY COMPONENTS Beam Folding Mirror Beam Folding Mirror Beam Shutter and Beam Absorber Laser Head and Assist Gas 1. Focusing Lens 2. Assist Gas Parallelism and Beam Alignment ELOPMENT OF THE CONTROLLING SOFTWARE: LASERCAM RS232 Protocol Terminal Emulation Coversion Filter (PLT to MINT) Code Editing Pobugging and Simulation CAD (AutoCAD)	30 31 32 32 32 32 32 32 32 32 32 32 32 32 32	

4.1.2		4
4.1	3 Gas Composition	4
4.1.	4 Beam Mode	4
4.2 P	POSITION SYSTEM	4
4.2.	1 PIVF Tuning	4
4.2.2		5
4.3 C	CUT QUALITY	5
4.3.		
4.3.2		
4.3	3 Glass	6
4.3.4	4 Softwood (Pinewood)	6
4.3.	5 Plastic (Acrylic)	64
4.4 P	PROFILE CUTTING	6
SHMMAI	RY, CONCLUSION AND SUGGESTIONS FOR FURTHER STUDIES	60
5.1 S	SUMMARY OF RESULT	6
5.2 C	CONCLUSION	7
5.3 S	SUGGESTIONS FOR FURTHER STUDIES	7
	NOR	_