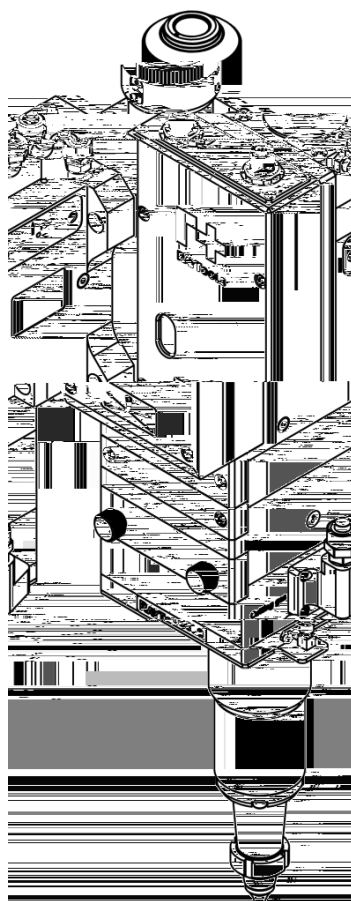
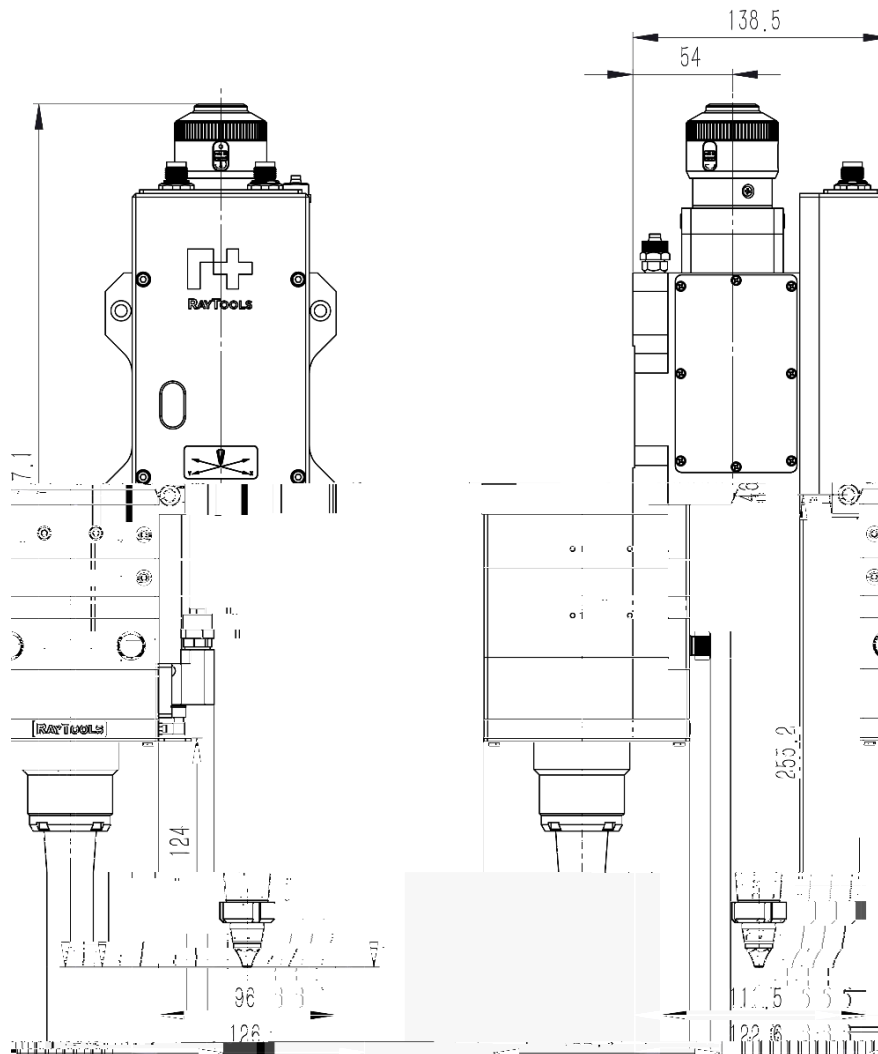


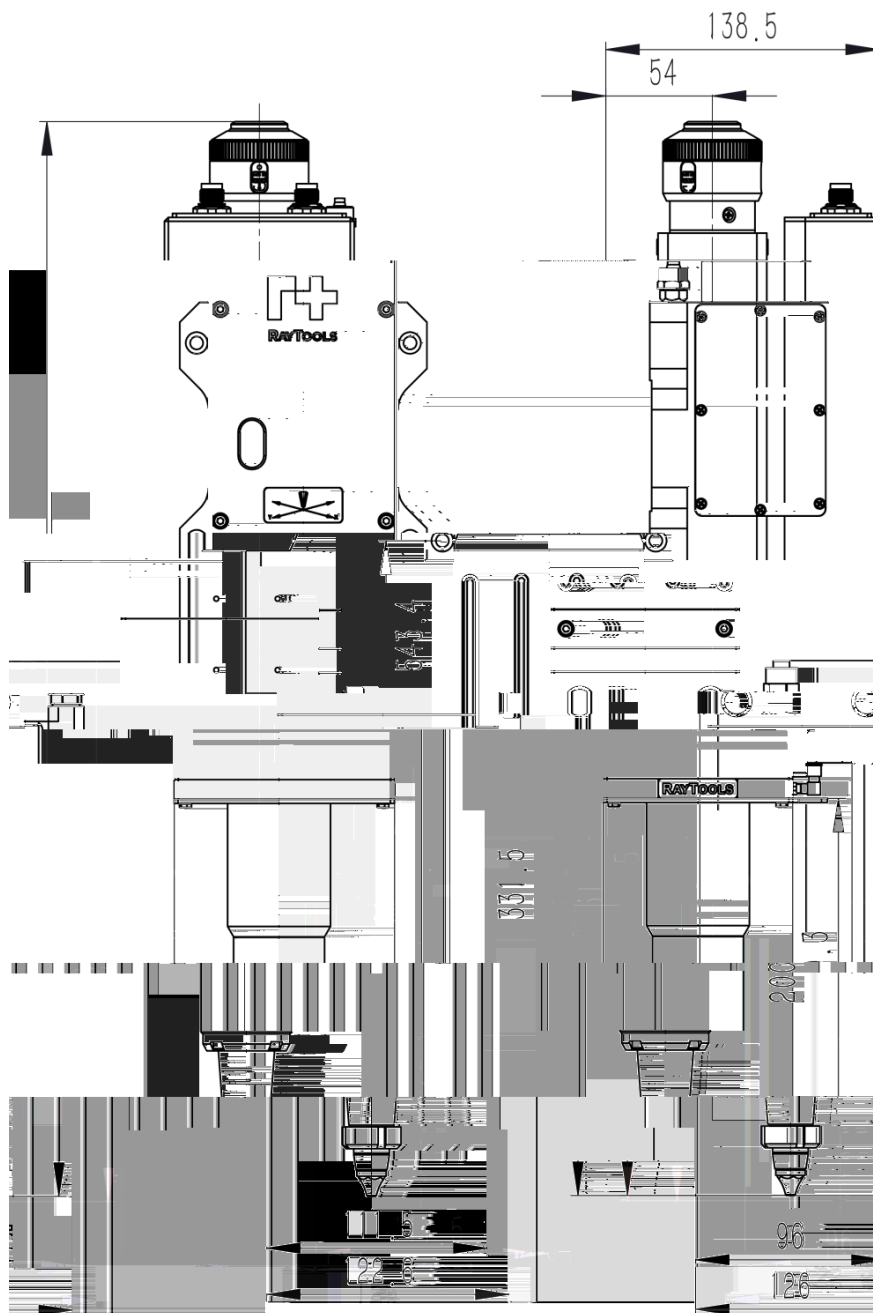
RAYTOOLS



Edit date	Version	Topic, revision, action taken

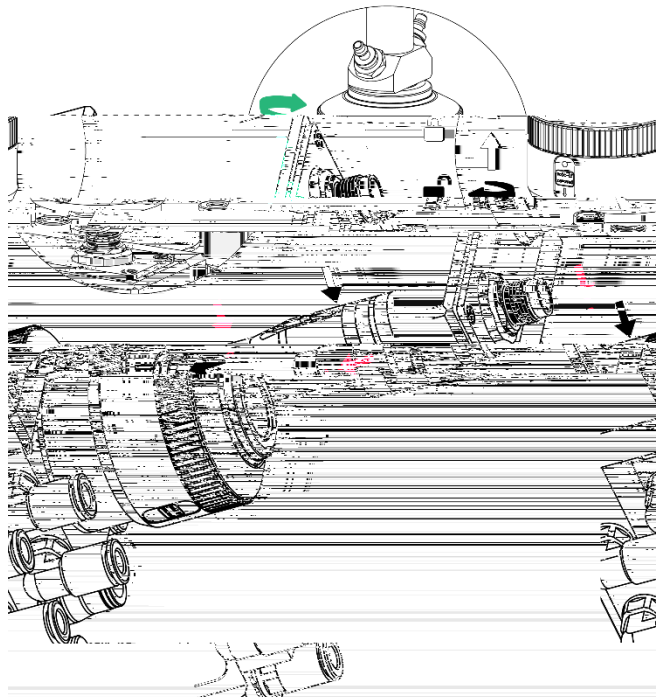


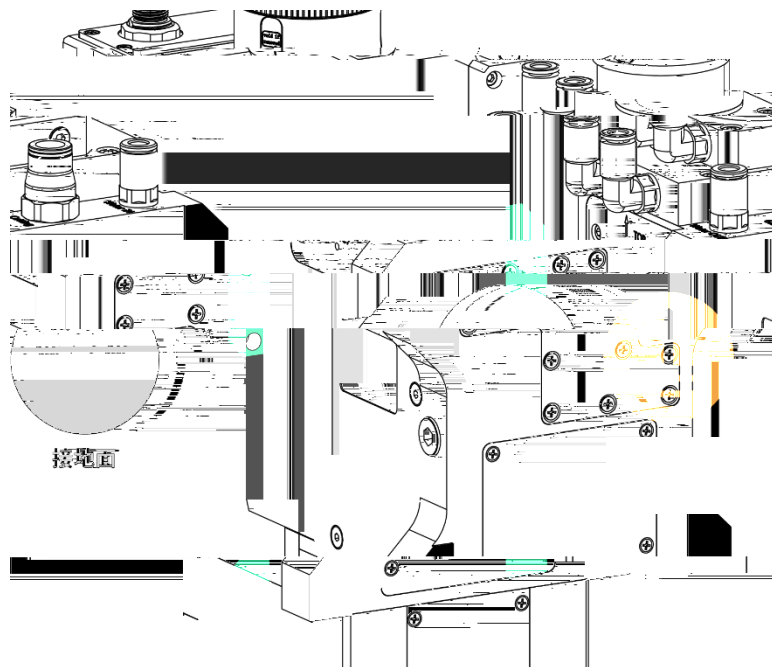


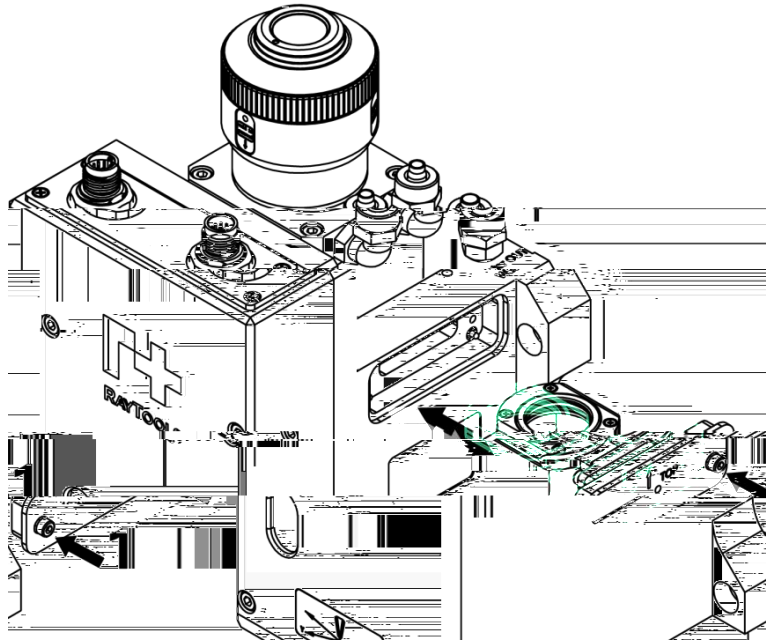


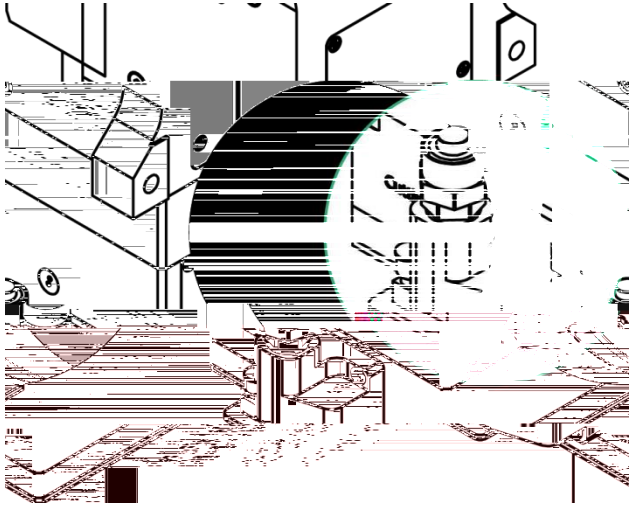
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2 Mechanical Installation



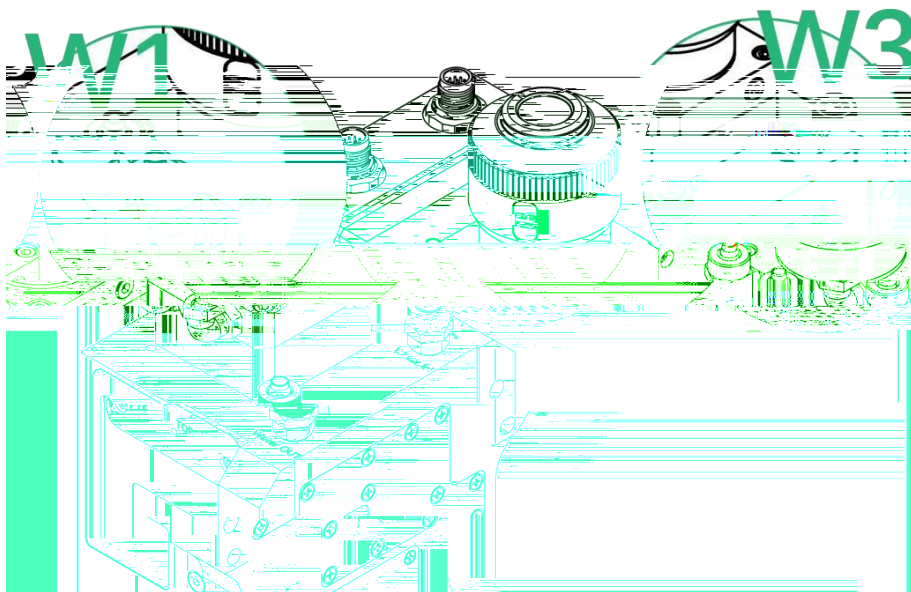






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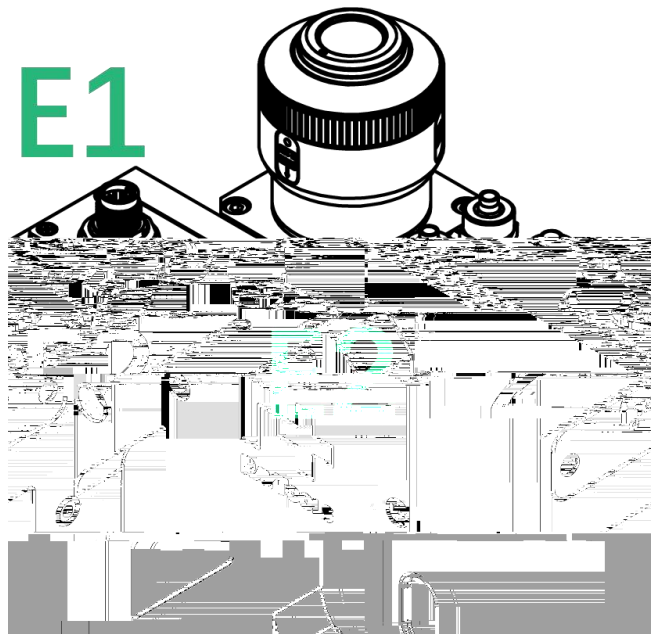




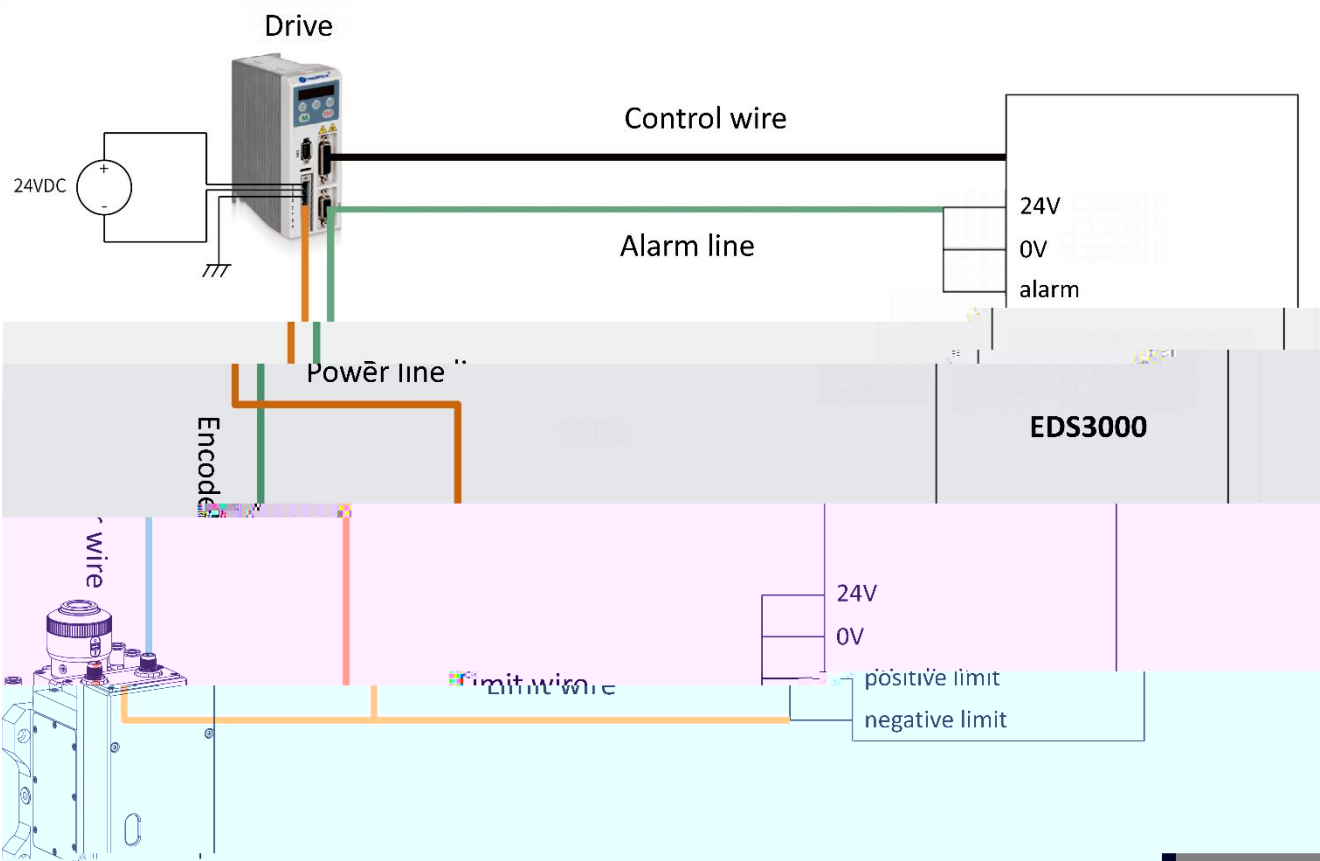
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3 Connection and Commissioning



Raytools





-NC



NPN-NC,

Laser head

Brand Raytools	Focus adjmt Servo Parameter Motor direction: Negative	Return to Origin Parameter Homing mode: Incremental Mode
Model BM06K 100:200	Return origin direction a...: Negative Limit Return origin speed: 0.3m/min Back Distance: 44mm Coordinate aft backward...: 0	Height sensor signal port: Node 4:Height Sensor Capacitance Focus control port/servo: Node 4:Focus Axis (EDS Onboard) ☐ Use Other Driver
Pulse number: 4000 Pitch: 8.8mm Max follow-up offset: 10mm	Positive hard limit...: Node 4:DI_12 NC Negative hard limit...: Node 4:DI_11 NC Soft limit range: -32 ~ 32 mm Cutting head alarm: Node 4:DI_16 ☒ Shield cutting he...	Restore default data

Manual Speed Manual slow: 0.3m/min Manual fast: 0.6m/min Auto Speed Speed: 6m/min Acceleration: 1500mm/s ² Acc time: 100ms	Axis point and limit configuration Positive hard limit...: Node 4:DI_12 NC Negative hard limit...: Node 4:DI_11 NC Soft limit range: -32 ~ 32 mm Cutting head alarm: Node 4:DI_16 ☒ Shield cutting he...
---	--

Restore default model list

Laser head

Brand Raytools	Focus adjmt Servo Parameter Motor direction: Negative	Return to Origin Parameter Homing mode: Incremental Mode
Model BM06K 100:200	Return origin direction a...: Negative Limit Return origin speed: 0.5m/min Back Distance: 72mm Coordinate aft backward...: 0	Height sensor signal port: Node 4:Height Sensor Capacitance Focus control port/servo: Node 4:Focus Axis (EDS Onboard) ☐ Use Other Driver
Pulse number: 4000 Pitch: 15mm Max follow-up offset: 10mm	Positive hard limit...: Node 4:DI_12 NC Negative hard limit...: Node 4:DI_11 NC Soft limit range: -72 ~ 72 mm Cutting head alarm: Node 4:DI_16 ☒ Shield cutting he...	Restore default data

Manual Speed Manual slow: 0.3m/min Manual fast: 0.6m/min Auto Speed Speed: 6m/min Acceleration: 1500mm/s ² Acc time: 100ms	Axis point and limit configuration Positive hard limit...: Node 4:DI_12 NC Negative hard limit...: Node 4:DI_11 NC Soft limit range: -72 ~ 72 mm Cutting head alarm: Node 4:DI_16 ☒ Shield cutting he...
---	--

Restore default model list



Please set pulse number as 10000 when applying EtherCAT driver.

SR

Focus Control

☒ Enable

☒ The fourth
 ☐ Precitec
 ☐ HighYAG
 ☐ Procutter-Zoom
 ☐ Ecot Ext Board[No Co:

Range: From to

Focus position at Or:

Pulse equivalent Move: need pulse

High Speed: Origin Dir: ☐ Pos ☒ Neg

Low Speed: ORG signal:

Rollback distance:

Jog speed:

Locate Speed:

Acceleration:

Servo Alarm Logic:

Negative Limit Logic:

Positive Limit Logic:

Focus Control

☐ Precitec
 ☐ HighYAG
 ☐ Procutter-Zoom
 ☐ Ecot Ext Board[No Co:

☒ Enable
 ☒ The fourth
 ☐ Pro

Range: From to

Focus position at

Pulse equivalent Move: need pulse

High Speed: Origin Dir: ☐ Pos ☒ Neg

Low Speed: ORG signal:

Rollback distance:

Jog speed:

Locate Speed:

Acceleration:

Servo Alarm Logic:

Negative Limit Logic:

Positive Limit Logic:



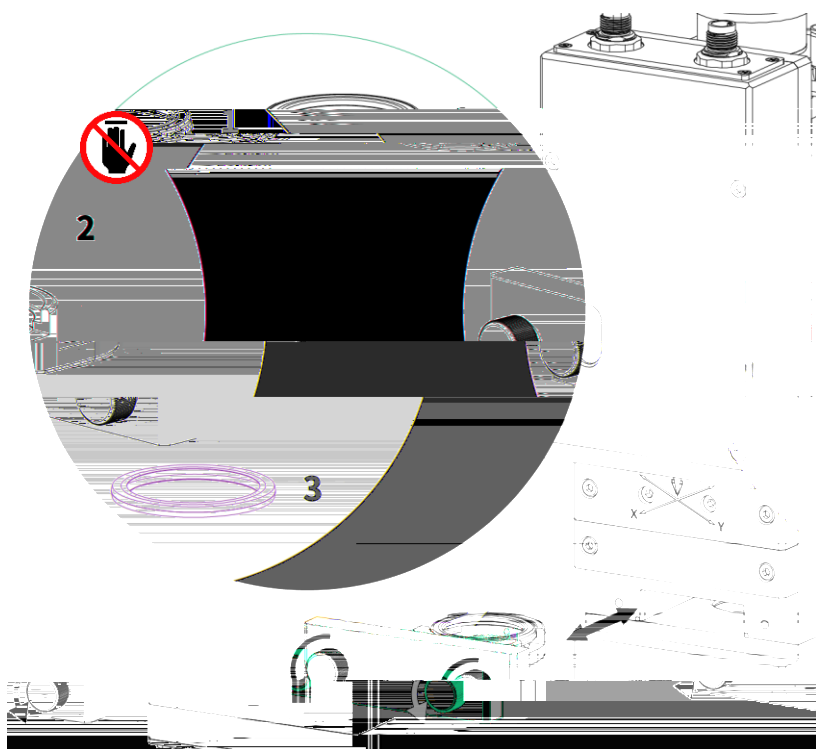
The connections and settings may differ from one CNC control system to another. Once the setting is modified, the corresponding wiring method may need to be changed.

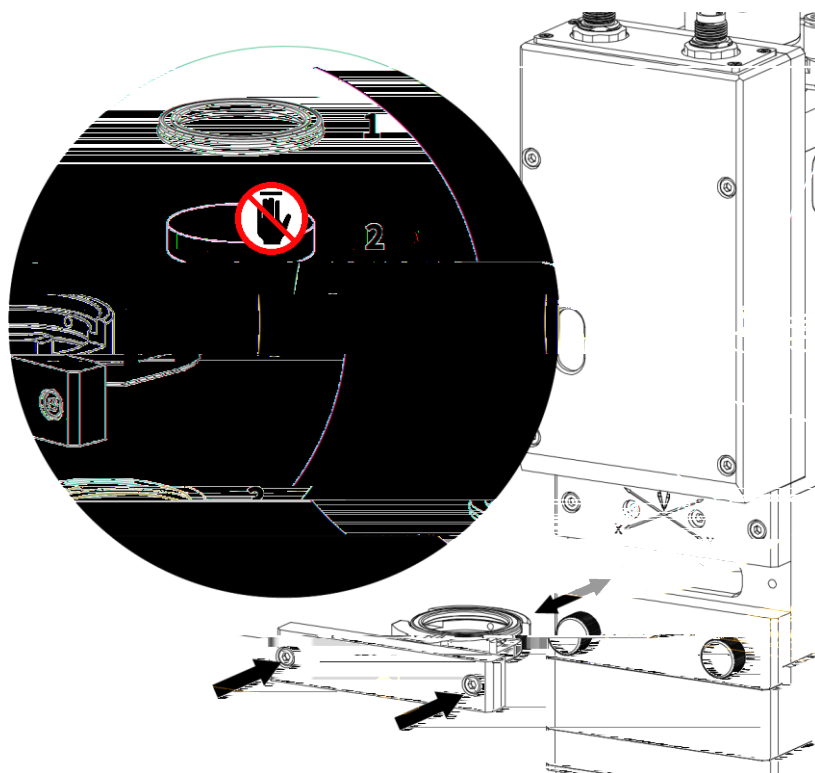
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4 Beam Alignment and Zero Focus Correction

4.1 Beam Alignment and Zero Focus Correction

- 1.
 - 2.
 - 3.
 - 4.
 - 5.
 - 6.
 - 7.
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Consumables

